

Series *TC5F* — The Tomcat

Cutting Parameters

Suggested Starting Speeds & Feed Rates

Material Group	ISO Code	Material Examples	High Feed	
			.1D Radial x 3D Axial	
			SFM	IPM
Steel	P	1018 thru 1095, 12L14, A-36, Hot Rolled	800	150
Steel Alloys	P	4140 thru 8820	700	120
		Steel Alloys <45 HRC, Cobalt Chrome	500	100
Tool & Mold Steels	P	H-13, O-1, A-2, D-2, S7, P20	600	100
Stainless Steel	M	303,304, 316	500	50
		410, 420, 440, 13-8, 15-5, 17-4 Ph	600	60
Cast Iron	K	Gray Cast, Malleable and Ductile Iron	800	150

Recommended Chip Loads

Material Group	ISO Code	Material Examples	Cutting Diameter					
			1/4	3/8	1/2	5/8	3/4	1
Steel	P	1018 thru 1095, 12L14, A-36, Hot Rolled	0.0025	0.0037	0.0050	0.0062	0.0075	0.0090
Steel Alloys	P	4140 thru 8820	0.0025	0.0037	0.0050	0.0062	0.0075	0.0090
		Steel Alloys <45 HRC, Cobalt Chrome	0.0025	0.0037	0.0050	0.0062	0.0075	0.0090
Tool & Mold Steels	P	H-13, O-1, A-2, D-2, S7, P20	0.0025	0.0037	0.0050	0.0062	0.0075	0.0090
Stainless Steel	M	303,304, 316	0.0013	0.0020	0.0026	0.0033	0.0040	0.0052
		410, 420, 440, 13-8, 15-5, 17-4 Ph	0.0013	0.0020	0.0026	0.0033	0.0040	0.0052
Cast Iron	K	Gray Cast, Malleable and Ductile Iron	0.0025	0.0037	0.0050	0.0062	0.0075	0.0090