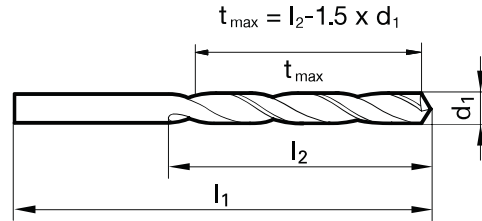


Tool material **HSS**

Surface

- P** Steel web thinning ≥ Ø 14.500 • relieved cone
  - M** Stainless steel
  - K** Cast iron hard and crumbly materials • brass, magnesium alloys • bronze, phosphor bronze • slate, mica, perlinax
  - N** Aluminum ●
  - S** Titanium alloys
  - H** Hardened steel
- =Optimal  
○=Limited



Jobber Length

Speeds and feeds information on pg. 476

Shank diameter = cut diameter

Diameter (d <sub>1</sub> )		l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #	
inch	wire/ltr					
0.0079	#92	0.20	19.00	2.20	2.50	9002060002000
0.0094	#88	0.24	19.00	2.14	2.50	9002060002400
0.0098	#87	0.25	19.00	2.63	3.00	9002060002500
0.0118		0.30	19.00	2.55	3.00	9002060003000
0.0134	#80	0.34	19.00	3.49	4.00	9002060003400
0.0138		0.35	19.00	3.48	4.00	9002060003500
0.0157	1/64	0.40	20.00	4.40	5.00	9002060004000
0.0161	#78	0.41	20.00	4.39	5.00	9002060004100
0.0177		0.45	20.00	4.33	5.00	9002060004500
0.0181	#77	0.46	20.00	4.31	5.00	9002060004600
0.0197		0.50	22.00	5.25	6.00	9002060005000
0.0201	#76	0.51	22.00	5.24	6.00	9002060005100
0.0209	#75	0.53	22.00	5.21	6.00	9002060005300
0.0217		0.55	24.00	6.18	7.00	9002060005500
0.0224	#74	0.57	24.00	6.15	7.00	9002060005700
0.0236		0.60	24.00	6.10	7.00	9002060006000
0.0244		0.62	26.00	7.07	8.00	9002060006200
0.0256		0.65	26.00	7.03	8.00	9002060006500
0.0260	#71	0.66	26.00	7.01	8.00	9002060006600
0.0276		0.70	28.00	7.95	9.00	9002060007000
0.0283		0.72	28.00	7.92	9.00	9002060007200
0.0287		0.73	28.00	7.91	9.00	9002060007300
0.0291	#69	0.74	28.00	7.89	9.00	9002060007400
0.0295		0.75	28.00	7.88	9.00	9002060007500
0.0299		0.76	30.00	8.86	10.00	9002060007600
0.0303		0.77	30.00	8.85	10.00	9002060007700
0.0311	1/32 #68	0.79	30.00	8.82	10.00	9002060007900
0.0315		0.80	30.00	8.80	10.00	9002060008000
0.0319	#67	0.81	30.00	8.79	10.00	9002060008100
0.0327		0.83	30.00	8.76	10.00	9002060008300
0.0331	#66	0.84	30.00	8.74	10.00	9002060008400
0.0335		0.85	30.00	8.73	10.00	9002060008500
0.0339		0.86	32.00	9.71	11.00	9002060008600
0.0343		0.87	32.00	9.70	11.00	9002060008700
0.0346		0.88	32.00	9.68	11.00	9002060008800
0.0350	#65	0.89	32.00	9.67	11.00	9002060008900
0.0354		0.90	32.00	9.65	11.00	9002060009000
0.0358	#64	0.91	32.00	9.64	11.00	9002060009100
0.0366		0.93	32.00	9.61	11.00	9002060009300
0.0374		0.95	32.00	9.58	11.00	9002060009500
0.0378		0.96	34.00	10.56	12.00	9002060009600
0.0382	#62	0.97	34.00	10.55	12.00	9002060009700
0.0390	#61	0.99	34.00	10.52	12.00	9002060009900
0.0394		1.00	34.00	10.50	12.00	9002060010000

Diameter (d <sub>1</sub> )		l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #	
inch	wire/ltr					
0.0402	#60	1.02	34.00	10.47	12.00	9002060010200
0.0409	#59	1.04	34.00	10.44	12.00	9002060010400
0.0413		1.05	34.00	10.43	12.00	9002060010500
0.0433		1.10	36.00	12.35	14.00	9002060011000
0.0453		1.15	36.00	12.28	14.00	9002060011500
0.0465	#56	1.18	36.00	12.23	14.00	9002060011800
0.0469	3/64	1.19	38.00	14.22	16.00	9002060011900
0.0472		1.20	38.00	14.20	16.00	9002060012000
0.0480		1.22	38.00	14.17	16.00	9002060012200
0.0492		1.25	38.00	14.13	16.00	9002060012500
0.0500		1.27	38.00	14.10	16.00	9002060012700
0.0504		1.28	38.00	14.08	16.00	9002060012800
0.0512		1.30	38.00	14.05	16.00	9002060013000
0.0520	#55	1.32	38.00	14.02	16.00	9002060013200
0.0524		1.33	40.00	16.01	18.00	9002060013300
0.0531		1.35	40.00	15.98	18.00	9002060013500
0.0539		1.37	40.00	15.95	18.00	9002060013700
0.0551	#54	1.40	40.00	15.90	18.00	9002060014000
0.0563		1.43	40.00	15.86	18.00	9002060014300
0.0567		1.44	40.00	15.84	18.00	9002060014400
0.0571		1.45	40.00	15.83	18.00	9002060014500
0.0579		1.47	40.00	15.80	18.00	9002060014700
0.0591		1.50	40.00	15.75	18.00	9002060015000
0.0602		1.53	43.00	17.71	20.00	9002060015300
0.0606		1.54	43.00	17.69	20.00	9002060015400
0.0610		1.55	43.00	17.68	20.00	9002060015500
0.0626	1/16	1.59	43.00	17.62	20.00	9002060015900
0.0630		1.60	43.00	17.60	20.00	9002060016000
0.0638		1.62	43.00	17.57	20.00	9002060016200
0.0650		1.65	43.00	17.53	20.00	9002060016500
0.0657		1.67	43.00	17.50	20.00	9002060016700
0.0669	#51	1.70	43.00	17.45	20.00	9002060017000
0.0677		1.72	46.00	19.42	22.00	9002060017200
0.0681		1.73	46.00	19.41	22.00	9002060017300
0.0689		1.75	46.00	19.38	22.00	9002060017500
0.0701	#50	1.78	46.00	19.33	22.00	9002060017800
0.0709		1.80	46.00	19.30	22.00	9002060018000
0.0728	#49	1.85	46.00	19.23	22.00	9002060018500
0.0748		1.90	46.00	19.15	22.00	9002060019000
0.0756		1.92	49.00	21.12	24.00	9002060019200
0.0768		1.95	49.00	21.08	24.00	9002060019500
0.0780	5/64	1.98	49.00	21.03	24.00	9002060019800
0.0787		2.00	49.00	21.00	24.00	9002060020000
0.0795		2.02	49.00	20.97	24.00	9002060020200

Jobber Length

Diameter (d <sub>1</sub> )		l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #	
inch	wire/ltr					
0.0807		2.05	49.00	20.93	24.00	9002060020500
0.0811	#46	2.06	49.00	20.91	24.00	9002060020600
0.0815		2.07	49.00	20.90	24.00	9002060020700
0.0827		2.10	49.00	20.85	24.00	9002060021000
0.0846		2.15	53.00	23.78	27.00	9002060021500
0.0858	#44	2.18	53.00	23.73	27.00	9002060021800
0.0866		2.20	53.00	23.70	27.00	9002060022000
0.0886		2.25	53.00	23.63	27.00	9002060022500
0.0894		2.27	53.00	23.60	27.00	9002060022700
0.0906		2.30	53.00	23.55	27.00	9002060023000
0.0925		2.35	53.00	23.48	27.00	9002060023500
0.0937	3/32	2.38	57.00	26.43	30.00	9002060023800
0.0945		2.40	57.00	26.40	30.00	9002060024000
0.0965		2.45	57.00	26.33	30.00	9002060024500
0.0972		2.47	57.00	26.30	30.00	9002060024700
0.0984		2.50	57.00	26.25	30.00	9002060025000
0.0996	#39	2.53	57.00	26.21	30.00	9002060025300
0.1004		2.55	57.00	26.18	30.00	9002060025500
0.1012		2.57	57.00	26.15	30.00	9002060025700
0.1024		2.60	57.00	26.10	30.00	9002060026000
0.1035		2.63	57.00	26.06	30.00	9002060026300
0.1039	#37	2.64	57.00	26.04	30.00	9002060026400
0.1043		2.65	57.00	26.03	30.00	9002060026500
0.1063		2.70	61.00	28.95	33.00	9002060027000
0.1067	#36	2.71	61.00	28.94	33.00	9002060027100
0.1083		2.75	61.00	28.88	33.00	9002060027500
0.1094	7/64	2.78	61.00	28.83	33.00	9002060027800
0.1102		2.80	61.00	28.80	33.00	9002060028000
0.1110	#34	2.82	61.00	28.77	33.00	9002060028200
0.1122		2.85	61.00	28.73	33.00	9002060028500
0.1142		2.90	61.00	28.65	33.00	9002060029000
0.1150		2.92	61.00	28.62	33.00	9002060029200
0.1161	#32	2.95	61.00	28.58	33.00	9002060029500
0.1181		3.00	61.00	28.50	33.00	9002060030000
0.1201	#31	3.05	65.00	31.43	36.00	9002060030500
0.1220		3.10	65.00	31.35	36.00	9002060031000
0.1240		3.15	65.00	31.28	36.00	9002060031500
0.1248	1/8	3.17	65.00	31.25	36.00	9002060031700
0.1260		3.20	65.00	31.20	36.00	9002060032000
0.1268		3.22	65.00	31.17	36.00	9002060032200
0.1280		3.25	65.00	31.13	36.00	9002060032500
0.1299		3.30	65.00	31.05	36.00	9002060033000
0.1319		3.35	65.00	30.98	36.00	9002060033500
0.1339		3.40	70.00	33.90	39.00	9002060034000
0.1358	#29	3.45	70.00	33.83	39.00	9002060034500
0.1378		3.50	70.00	33.75	39.00	9002060035000
0.1398		3.55	70.00	33.68	39.00	9002060035500
0.1406	9/64 #28	3.57	70.00	33.65	39.00	9002060035700
0.1417		3.60	70.00	33.60	39.00	9002060036000
0.1437		3.65	70.00	33.53	39.00	9002060036500
0.1457		3.70	70.00	33.45	39.00	9002060037000
0.1476		3.75	70.00	33.38	39.00	9002060037500
0.1496	#25	3.80	75.00	37.30	43.00	9002060038000
0.1508		3.83	75.00	37.26	43.00	9002060038300
0.1516		3.85	75.00	37.23	43.00	9002060038500
0.1524		3.87	75.00	37.20	43.00	9002060038700
0.1535		3.90	75.00	37.15	43.00	9002060039000
0.1539	#23	3.91	75.00	37.14	43.00	9002060039100
0.1555		3.95	75.00	37.08	43.00	9002060039500
0.1563	5/32	3.97	75.00	37.05	43.00	9002060039700
0.1575		4.00	75.00	37.00	43.00	9002060040000
0.1583		4.02	75.00	36.97	43.00	9002060040200
0.1591	#21	4.04	75.00	36.94	43.00	9002060040400
0.1594		4.05	75.00	36.93	43.00	9002060040500
0.1614		4.10	75.00	36.85	43.00	9002060041000

Diameter (d <sub>1</sub> )		l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #	
inch	wire/ltr					
0.1634		4.15	75.00	36.78	43.00	9002060041500
0.1654		4.20	75.00	36.70	43.00	9002060042000
0.1661	#19	4.22	75.00	36.67	43.00	9002060042200
0.1673		4.25	75.00	36.63	43.00	9002060042500
0.1693	#18	4.30	80.00	40.55	47.00	9002060043000
0.1720	11/64	4.37	80.00	40.45	47.00	9002060043700
0.1732		4.40	80.00	40.40	47.00	9002060044000
0.1752		4.45	80.00	40.33	47.00	9002060044500
0.1772	#16	4.50	80.00	40.25	47.00	9002060045000
0.1811		4.60	80.00	40.10	47.00	9002060046000
0.1831		4.65	80.00	40.03	47.00	9002060046500
0.1850	#13	4.70	80.00	39.95	47.00	9002060047000
0.1870		4.75	80.00	39.88	47.00	9002060047500
0.1874	3/16	4.76	86.00	44.86	52.00	9002060047600
0.1890	#12	4.80	86.00	44.80	52.00	9002060048000
0.1909	#11	4.85	86.00	44.73	52.00	9002060048500
0.1929		4.90	86.00	44.65	52.00	9002060049000
0.1949		4.95	86.00	44.58	52.00	9002060049500
0.1969		5.00	86.00	44.50	52.00	9002060050000
0.1988		5.05	86.00	44.43	52.00	9002060050500
0.2008		5.10	86.00	44.35	52.00	9002060051000
0.2031	13/64	5.16	86.00	44.26	52.00	9002060051600
0.2047		5.20	86.00	44.20	52.00	9002060052000
0.2067		5.25	86.00	44.13	52.00	9002060052500
0.2087		5.30	86.00	44.05	52.00	9002060053000
0.2091	#4	5.31	93.00	49.04	57.00	9002060053100
0.2126		5.40	93.00	48.90	57.00	9002060054000
0.2165		5.50	93.00	48.75	57.00	9002060055000
0.2189	7/32	5.56	93.00	48.66	57.00	9002060055600
0.2205		5.60	93.00	48.60	57.00	9002060056000
0.2244		5.70	93.00	48.45	57.00	9002060057000
0.2264		5.75	93.00	48.38	57.00	9002060057500
0.2283		5.80	93.00	48.30	57.00	9002060058000
0.2323		5.90	93.00	48.15	57.00	9002060059000
0.2343	15/64	5.95	93.00	48.08	57.00	9002060059500
0.2362		6.00	93.00	48.00	57.00	9002060060000
0.2382		6.05	101.00	53.93	63.00	9002060060500
0.2402		6.10	101.00	53.85	63.00	9002060061000
0.2421	C	6.15	101.00	53.78	63.00	9002060061500
0.2441		6.20	101.00	53.70	63.00	9002060062000
0.2461	D	6.25	101.00	53.63	63.00	9002060062500
0.2480		6.30	101.00	53.55	63.00	9002060063000
0.2500	1/4 E	6.35	101.00	53.48	63.00	9002060063500
0.2520		6.40	101.00	53.40	63.00	9002060064000
0.2539		6.45	101.00	53.33	63.00	9002060064500
0.2559		6.50	101.00	53.25	63.00	9002060065000
0.2571		6.53	101.00	53.21	63.00	9002060065300
0.2579		6.55	101.00	53.18	63.00	9002060065500
0.2598		6.60	101.00	53.10	63.00	9002060066000
0.2638		6.70	101.00	52.95	63.00	9002060067000
0.2657	17/64 H	6.75	109.00	58.88	69.00	9002060067500
0.2677		6.80	109.00	58.80	69.00	9002060068000
0.2717	I	6.90	109.00	58.65	69.00	9002060069000
0.2756		7.00	109.00	58.50	69.00	9002060070000
0.2795		7.10	109.00	58.35	69.00	9002060071000
0.2811	9/32 K	7.14	109.00	58.29	69.00	9002060071400
0.2835		7.20	109.00	58.20	69.00	9002060072000
0.2854		7.25	109.00	58.13	69.00	9002060072500
0.2874		7.30	109.00	58.05	69.00	9002060073000
0.2894		7.35	109.00	57.98	69.00	9002060073500
0.2913		7.40	109.00	57.90	69.00	9002060074000
0.2953		7.50	109.00	57.75	69.00	9002060075000
0.2969	19/64	7.54	117.00	63.69	75.00	9002060075400
0.2992		7.60	117.00	63.60	75.00	9002060076000
0.3031		7.70	117.00	63.45	75.00	9002060077000

Diameter (d <sub>1</sub> )		l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #	
inch	wire/ltr					
0.3051		7.75	117.00	63.38	75.00	9002060077500
0.3071		7.80	117.00	63.30	75.00	9002060078000
0.3110		7.90	117.00	63.15	75.00	9002060079000
0.3126	5/16	7.94	117.00	63.09	75.00	9002060079400
0.3150		8.00	117.00	63.00	75.00	9002060080000
0.3169		8.05	117.00	62.93	75.00	9002060080500
0.3189		8.10	117.00	62.85	75.00	9002060081000
0.3228	P	8.20	117.00	62.70	75.00	9002060082000
0.3248		8.25	117.00	62.63	75.00	9002060082500
0.3268		8.30	117.00	62.55	75.00	9002060083000
0.3280	21/64	8.33	117.00	62.51	75.00	9002060083300
0.3307		8.40	117.00	62.40	75.00	9002060084000
0.3319	Q	8.43	117.00	62.36	75.00	9002060084300
0.3346		8.50	117.00	62.25	75.00	9002060085000
0.3386		8.60	125.00	68.10	81.00	9002060086000
0.3425		8.70	125.00	67.95	81.00	9002060087000
0.3437	11/32	8.73	125.00	67.91	81.00	9002060087300
0.3465		8.80	125.00	67.80	81.00	9002060088000
0.3504		8.90	125.00	67.65	81.00	9002060089000
0.3543		9.00	125.00	67.50	81.00	9002060090000
0.3583		9.10	125.00	67.35	81.00	9002060091000
0.3594	23/64	9.13	125.00	67.31	81.00	9002060091300
0.3622		9.20	125.00	67.20	81.00	9002060092000
0.3642		9.25	125.00	67.13	81.00	9002060092500
0.3661		9.30	125.00	67.05	81.00	9002060093000
0.3701		9.40	125.00	66.90	81.00	9002060094000
0.3740		9.50	125.00	66.75	81.00	9002060095000
0.3748	3/8	9.52	133.00	72.72	87.00	9002060095200
0.3780		9.60	133.00	72.60	87.00	9002060096000
0.3819		9.70	133.00	72.45	87.00	9002060097000
0.3839		9.75	133.00	72.38	87.00	9002060097500
0.3858	W	9.80	133.00	72.30	87.00	9002060098000
0.3898		9.90	133.00	72.15	87.00	9002060099000
0.3906	25/64	9.92	133.00	72.12	87.00	9002060099200
0.3937		10.00	133.00	72.00	87.00	9002060100000
0.3976		10.10	133.00	71.85	87.00	9002060101000
0.4016		10.20	133.00	71.70	87.00	9002060102000
0.4035		10.25	133.00	71.63	87.00	9002060102500

Diameter (d <sub>1</sub> )		l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #	
inch	wire/ltr					
0.4055		10.30	133.00	71.55	87.00	9002060103000
0.4063	13/32	10.32	133.00	71.52	87.00	9002060103200
0.4134		10.50	133.00	71.25	87.00	9002060105000
0.4173		10.60	133.00	71.10	87.00	9002060106000
0.4220	27/64	10.72	142.00	77.92	94.00	9002060107200
0.4252		10.80	142.00	77.80	94.00	9002060108000
0.4291		10.90	142.00	77.65	94.00	9002060109000
0.4331		11.00	142.00	77.50	94.00	9002060110000
0.4370		11.10	142.00	77.35	94.00	9002060111000
0.4374	7/16	11.11	142.00	77.34	94.00	9002060111100
0.4409		11.20	142.00	77.20	94.00	9002060112000
0.4449		11.30	142.00	77.05	94.00	9002060113000
0.4488		11.40	142.00	76.90	94.00	9002060114000
0.4528		11.50	142.00	76.75	94.00	9002060115000
0.4531	29/64	11.51	142.00	76.74	94.00	9002060115100
0.4567		11.60	142.00	76.60	94.00	9002060116000
0.4606		11.70	142.00	76.45	94.00	9002060117000
0.4646		11.80	142.00	76.30	94.00	9002060118000
0.4685		11.90	151.00	83.15	101.00	9002060119000
0.4689	15/32	11.91	151.00	83.14	101.00	9002060119100
0.4724		12.00	151.00	83.00	101.00	9002060120000
0.4764		12.10	151.00	82.85	101.00	9002060121000
0.4803		12.20	151.00	82.70	101.00	9002060122000
0.4843	31/64	12.30	151.00	82.55	101.00	9002060123000
0.4921		12.50	151.00	82.25	101.00	9002060125000
0.5000	1/2	12.70	151.00	81.95	101.00	9002060127000
0.5039		12.80	151.00	81.80	101.00	9002060128000
0.5118		13.00	151.00	81.50	101.00	9002060130000
0.5197		13.20	151.00	81.20	101.00	9002060132000
0.5315		13.50	160.00	87.75	108.00	9002060135000
0.5512		14.00	160.00	87.00	108.00	9002060140000
0.5709		14.50	169.00	92.25	114.00	9002060145000
0.5906		15.00	169.00	91.50	114.00	9002060150000
0.6299		16.00	178.00	96.00	120.00	9002060160000
0.6693		17.00	184.00	99.50	125.00	9002060170000
0.7087		18.00	191.00	103.00	130.00	9002060180000
0.7480		19.00	198.00	106.50	135.00	9002060190000
0.7874		20.00	205.00	110.00	140.00	9002060200000

Jobber Length

Series # 205

Material group	Hardness		SFM	Feed Rate - IPR									
	HRc	Bhn		1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	- 32	150 301	100 80	0.0017 0.0015	0.005 0.004	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100	0.0125 0.0100	0.0140 0.0110			
Free-cutting steels	25 32	255 301	100 80	0.0017 0.0015	0.005 0.004	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100	0.0125 0.0100	0.0140 0.0110			
Unalloyed heat-treatable steels	20 25 32	220 255 301	100 80	0.0015 0.0015	0.004 0.004	0.0065 0.0065	0.0080 0.0080	0.0100 0.0100	0.0100 0.0100	0.0110 0.0110			
Alloyed heat-treatable steels	32 43	301 402											
Unalloyed case hardened steels	25	255	100	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140			
Alloyed case hardened steels	32 43	301 402											
Nitriding steels	32 43	301 402											
Tool steels	25 43	255 402	50	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	0.0090			
High speed steels	43	402											
Spring steels	38	354											
Hardened steels	48 66	460 -											
Stainless steels, sulphured austenitic martensitic	28 36 46	273 337 435											
Cast iron	23 38	242 354	100 80	0.0017 0.0017	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125	0.0125 0.0125	0.0140 0.0140			
Spheroidal graphite iron and malleable cast iron	23 38	242 354	90 65	0.0017 0.0017	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125	0.0125 0.0125	0.0140 0.0140			
Chilled cast iron	38	354											
New cast materials GGV	20 32	220 301											
New cast materials ADI	32 43	301 402											
Special alloys	54	549											
Ti and Ti-alloys	25 43	255 402											
Aluminium and Al-alloys	-	120											
Al wrought alloys	-	200											
Al cast alloys ≤ 10 % Si ≤ 24 % Si	-	180 180	205 130	0.0020 0.0017	0.0065 0.0050	0.0100 0.0080	0.0125 0.0100	0.0160 0.0125	0.0160 0.0125	0.0180 0.0140			
Magnesium alloys	-	120	260	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140			
Copper, low-alloyed	-	150	100	0.0015	0.0040	0.0065	0.0080	0.0100	0.0100	0.0110			
Brass, short-chipping long-chipping	- -	180 180	205 130	0.0015 0.0015	0.0040 0.0040	0.0065 0.0065	0.0080 0.0080	0.0100 0.0100	0.0100 0.0100	0.0110 0.0110			
Bronze, short-chipping	-	180	100	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	0.0090			
Bronze, long-chipping	25 32	255 301	90 80	0.0012 0.0012	0.0030 0.0030	0.0050 0.0050	0.0065 0.0065	0.0080 0.0080	0.0080 0.0080	0.0090 0.0090			
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK			50 80	0.0012 0.0015	0.0030 0.0040	0.0050 0.0065	0.0065 0.0080	0.0080 0.0100	0.0080 0.0100	0.0090 0.0110			

Series # 206

Material group	Hardness		SFM	Feed Rate - IPR									
	HRc	Bhn		1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	- 32	150 301											
Free-cutting steels	25 32	255 301											
Unalloyed heat-treatable steels	20 25 32	220 255 301											
Alloyed heat-treatable steels	32 43	301 402											
Unalloyed case hardened steels	25	255											
Alloyed case hardened steels	32 43	301 402											
Nitriding steels	32 43	301 402											
Tool steels	25 43	255 402											
High speed steels	43	402											
Spring steels	38	354											
Hardened steels	48 66	460 -											
Stainless steels, sulphured austenitic martensitic	28 36 46	273 337 435											
Cast iron	23 38	242 354											
Spheroidal graphite iron and malleable cast iron	23 38	242 354											
Chilled cast iron	38	354											
New cast materials GGV	20 32	220 301											
New cast materials ADI	32 43	301 402											
Special alloys	54	549											
Ti and Ti-alloys	25 43	255 402											
Aluminium and Al-alloys	-	120	260	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180			
Al wrought alloys	-	200	260	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180			
Al cast alloys ≤ 10 % Si ≤ 24 % Si	-	180 180	205	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	0.0180			
Magnesium alloys	-	120	260	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140			
Copper, low-alloyed	-	150											
Brass, short-chipping long-chipping	- -	180 180	205	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	0.0140			
Bronze, short-chipping	-	180	100	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	0.0090			
Bronze, long-chipping	25 32	255 301											
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK			50 80	0.0012 0.0015	0.0030 0.0040	0.0050 0.0065	0.0065 0.0080	0.0080 0.0100	0.0080 0.0100	0.0090 0.0110			