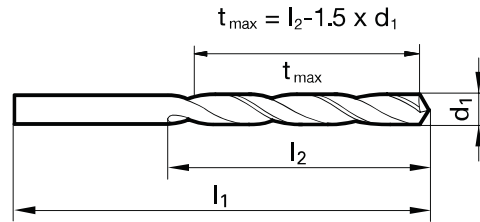


<b>P</b>	Steel	●	web thinning ≥ Ø 14.700 • relieved cone
<b>M</b>	Stainless steel		
<b>K</b>	Cast iron	●	
<b>N</b>	Aluminum	○	
<b>S</b>	Titanium alloys		
<b>H</b>	Hardened steel		

●=Optimal  
○=Limited

alloyed/unalloyed steel and cast steel • grey cast iron, malleable and spheroidal iron • sintered powder metal, German silver and graphite



Speeds and feeds information on pg. 477

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	mm				
0.0094	#88	0.24	19.00	2.14	2.50	9002080002400
0.0114	#84	0.29	19.00	2.57	3.00	9002080002900
0.0118		0.30	19.00	2.55	3.00	9002080003000
0.0134	#80	0.34	19.00	3.49	4.00	9002080003400
0.0138		0.35	19.00	3.48	4.00	9002080003500
0.0142		0.36	19.00	3.46	4.00	9002080003600
0.0146	#79	0.37	19.00	3.45	4.00	9002080003700
0.0157	1/64	0.40	20.00	4.40	5.00	9002080004000
0.0161	#78	0.41	20.00	4.39	5.00	9002080004100
0.0165		0.42	20.00	4.37	5.00	9002080004200
0.0169		0.43	20.00	4.36	5.00	9002080004300
0.0173		0.44	20.00	4.34	5.00	9002080004400
0.0177		0.45	20.00	4.33	5.00	9002080004500
0.0181	#77	0.46	20.00	4.31	5.00	9002080004600
0.0185		0.47	20.00	4.30	5.00	9002080004700
0.0189		0.48	20.00	4.28	5.00	9002080004800
0.0197		0.50	22.00	5.25	6.00	9002080005000
0.0201	#76	0.51	22.00	5.24	6.00	9002080005100
0.0205		0.52	22.00	5.22	6.00	9002080005200
0.0209	#75	0.53	22.00	5.21	6.00	9002080005300
0.0213		0.54	24.00	6.19	7.00	9002080005400
0.0217		0.55	24.00	6.18	7.00	9002080005500
0.0220		0.56	24.00	6.16	7.00	9002080005600
0.0224	#74	0.57	24.00	6.15	7.00	9002080005700
0.0228		0.58	24.00	6.13	7.00	9002080005800
0.0236		0.60	24.00	6.10	7.00	9002080006000
0.0240	#73	0.61	26.00	7.09	8.00	9002080006100
0.0244		0.62	26.00	7.07	8.00	9002080006200
0.0248		0.63	26.00	7.06	8.00	9002080006300
0.0252	#72	0.64	26.00	7.04	8.00	9002080006400
0.0256		0.65	26.00	7.03	8.00	9002080006500
0.0260	#71	0.66	26.00	7.01	8.00	9002080006600
0.0264		0.67	26.00	7.00	8.00	9002080006700
0.0268		0.68	28.00	7.98	9.00	9002080006800
0.0276		0.70	28.00	7.95	9.00	9002080007000
0.0280	#70	0.71	28.00	7.94	9.00	9002080007100
0.0283		0.72	28.00	7.92	9.00	9002080007200
0.0287		0.73	28.00	7.91	9.00	9002080007300
0.0295		0.75	28.00	7.88	9.00	9002080007500
0.0303		0.77	30.00	8.85	10.00	9002080007700
0.0307		0.78	30.00	8.83	10.00	9002080007800
0.0311	1/32 #68	0.79	30.00	8.82	10.00	9002080007900
0.0315		0.80	30.00	8.80	10.00	9002080008000
0.0319	#67	0.81	30.00	8.79	10.00	9002080008100

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.0323		0.82	30.00	8.77	10.00	9002080008200
0.0327		0.83	30.00	8.76	10.00	9002080008300
0.0331	#66	0.84	30.00	8.74	10.00	9002080008400
0.0335		0.85	30.00	8.73	10.00	9002080008500
0.0339		0.86	32.00	9.71	11.00	9002080008600
0.0343		0.87	32.00	9.70	11.00	9002080008700
0.0346		0.88	32.00	9.68	11.00	9002080008800
0.0350	#65	0.89	32.00	9.67	11.00	9002080008900
0.0354		0.90	32.00	9.65	11.00	9002080009000
0.0358	#64	0.91	32.00	9.64	11.00	9002080009100
0.0362		0.92	32.00	9.62	11.00	9002080009200
0.0366		0.93	32.00	9.61	11.00	9002080009300
0.0374		0.95	32.00	9.58	11.00	9002080009500
0.0378		0.96	34.00	10.56	12.00	9002080009600
0.0382	#62	0.97	34.00	10.55	12.00	9002080009700
0.0386		0.98	34.00	10.53	12.00	9002080009800
0.0390	#61	0.99	34.00	10.52	12.00	9002080009900
0.0394		1.00	34.00	10.50	12.00	9002080010000
0.0402	#60	1.02	34.00	10.47	12.00	9002080010200
0.0409	#59	1.04	34.00	10.44	12.00	9002080010400
0.0413		1.05	34.00	10.43	12.00	9002080010500
0.0421	#58	1.07	36.00	12.40	14.00	9002080010700
0.0425		1.08	36.00	12.38	14.00	9002080010800
0.0429	#57	1.09	36.00	12.37	14.00	9002080010900
0.0433		1.10	36.00	12.35	14.00	9002080011000
0.0441		1.12	36.00	12.32	14.00	9002080011200
0.0445		1.13	36.00	12.31	14.00	9002080011300
0.0453		1.15	36.00	12.28	14.00	9002080011500
0.0461		1.17	36.00	12.25	14.00	9002080011700
0.0465	#56	1.18	36.00	12.23	14.00	9002080011800
0.0469	3/64	1.19	38.00	14.22	16.00	9002080011900
0.0472		1.20	38.00	14.20	16.00	9002080012000
0.0476		1.21	38.00	14.19	16.00	9002080012100
0.0480		1.22	38.00	14.17	16.00	9002080012200
0.0488		1.24	38.00	14.14	16.00	9002080012400
0.0492		1.25	38.00	14.13	16.00	9002080012500
0.0500		1.27	38.00	14.10	16.00	9002080012700
0.0512		1.30	38.00	14.05	16.00	9002080013000
0.0520	#55	1.32	38.00	14.02	16.00	9002080013200
0.0531		1.35	40.00	15.98	18.00	9002080013500
0.0543		1.38	40.00	15.93	18.00	9002080013800
0.0547		1.39	40.00	15.92	18.00	9002080013900
0.0551	#54	1.40	40.00	15.90	18.00	9002080014000
0.0559		1.42	40.00	15.87	18.00	9002080014200

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.0571		1.45	40.00	15.83	18.00	9002080014500
0.0579		1.47	40.00	15.80	18.00	9002080014700
0.0591		1.50	40.00	15.75	18.00	9002080015000
0.0594	#53	1.51	43.00	17.74	20.00	9002080015100
0.0602		1.53	43.00	17.71	20.00	9002080015300
0.0610		1.55	43.00	17.68	20.00	9002080015500
0.0614		1.56	43.00	17.66	20.00	9002080015600
0.0626	1/16	1.59	43.00	17.62	20.00	9002080015900
0.0630		1.60	43.00	17.60	20.00	9002080016000
0.0634	#52	1.61	43.00	17.59	20.00	9002080016100
0.0638		1.62	43.00	17.57	20.00	9002080016200
0.0642		1.63	43.00	17.56	20.00	9002080016300
0.0650		1.65	43.00	17.53	20.00	9002080016500
0.0654		1.66	43.00	17.51	20.00	9002080016600
0.0661		1.68	43.00	17.48	20.00	9002080016800
0.0669	#51	1.70	43.00	17.45	20.00	9002080017000
0.0677		1.72	46.00	19.42	22.00	9002080017200
0.0681		1.73	46.00	19.41	22.00	9002080017300
0.0689		1.75	46.00	19.38	22.00	9002080017500
0.0693		1.76	46.00	19.36	22.00	9002080017600
0.0709		1.80	46.00	19.30	22.00	9002080018000
0.0717		1.82	46.00	19.27	22.00	9002080018200
0.0720		1.83	46.00	19.26	22.00	9002080018300
0.0724		1.84	46.00	19.24	22.00	9002080018400
0.0728	#49	1.85	46.00	19.23	22.00	9002080018500
0.0748		1.90	46.00	19.15	22.00	9002080019000
0.0760	#48	1.93	49.00	21.11	24.00	9002080019300
0.0764		1.94	49.00	21.09	24.00	9002080019400
0.0768		1.95	49.00	21.08	24.00	9002080019500
0.0776		1.97	49.00	21.05	24.00	9002080019700
0.0780	5/64	1.98	49.00	21.03	24.00	9002080019800
0.0787		2.00	49.00	21.00	24.00	9002080020000
0.0803		2.04	49.00	20.94	24.00	9002080020400
0.0807		2.05	49.00	20.93	24.00	9002080020500
0.0811	#46	2.06	49.00	20.91	24.00	9002080020600
0.0819	#45	2.08	49.00	20.88	24.00	9002080020800
0.0827		2.10	49.00	20.85	24.00	9002080021000
0.0835		2.12	49.00	20.82	24.00	9002080021200
0.0846		2.15	53.00	23.78	27.00	9002080021500
0.0858	#44	2.18	53.00	23.73	27.00	9002080021800
0.0866		2.20	53.00	23.70	27.00	9002080022000
0.0886		2.25	53.00	23.63	27.00	9002080022500
0.0890	#43	2.26	53.00	23.61	27.00	9002080022600
0.0898		2.28	53.00	23.58	27.00	9002080022800
0.0906		2.30	53.00	23.55	27.00	9002080023000
0.0913		2.32	53.00	23.52	27.00	9002080023200
0.0925		2.35	53.00	23.48	27.00	9002080023500
0.0933	#42	2.37	57.00	26.45	30.00	9002080023700
0.0937	3/32	2.38	57.00	26.43	30.00	9002080023800
0.0945		2.40	57.00	26.40	30.00	9002080024000
0.0961	#41	2.44	57.00	26.34	30.00	9002080024400
0.0965		2.45	57.00	26.33	30.00	9002080024500
0.0980	#40	2.49	57.00	26.27	30.00	9002080024900
0.0984		2.50	57.00	26.25	30.00	9002080025000
0.0996	#39	2.53	57.00	26.21	30.00	9002080025300
0.1004		2.55	57.00	26.18	30.00	9002080025500
0.1016	#38	2.58	57.00	26.13	30.00	9002080025800
0.1024		2.60	57.00	26.10	30.00	9002080026000
0.1039	#37	2.64	57.00	26.04	30.00	9002080026400
0.1043		2.65	57.00	26.03	30.00	9002080026500
0.1063		2.70	61.00	28.95	33.00	9002080027000
0.1075		2.73	61.00	28.91	33.00	9002080027300
0.1083		2.75	61.00	28.88	33.00	9002080027500
0.1094	7/64	2.78	61.00	28.83	33.00	9002080027800

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.1102		2.80	61.00	28.80	33.00	9002080028000
0.1110	#34	2.82	61.00	28.77	33.00	9002080028200
0.1122		2.85	61.00	28.73	33.00	9002080028500
0.1130	#33	2.87	61.00	28.70	33.00	9002080028700
0.1142		2.90	61.00	28.65	33.00	9002080029000
0.1161	#32	2.95	61.00	28.58	33.00	9002080029500
0.1169		2.97	61.00	28.55	33.00	9002080029700
0.1181		3.00	61.00	28.50	33.00	9002080030000
0.1201	#31	3.05	65.00	31.43	36.00	9002080030500
0.1209		3.07	65.00	31.40	36.00	9002080030700
0.1220		3.10	65.00	31.35	36.00	9002080031000
0.1240		3.15	65.00	31.28	36.00	9002080031500
0.1248	1/8	3.17	65.00	31.25	36.00	9002080031700
0.1260		3.20	65.00	31.20	36.00	9002080032000
0.1268		3.22	65.00	31.17	36.00	9002080032200
0.1280		3.25	65.00	31.13	36.00	9002080032500
0.1283	#30	3.26	65.00	31.11	36.00	9002080032600
0.1299		3.30	65.00	31.05	36.00	9002080033000
0.1319		3.35	65.00	30.98	36.00	9002080033500
0.1327		3.37	70.00	33.95	39.00	9002080033700
0.1339		3.40	70.00	33.90	39.00	9002080034000
0.1358	#29	3.45	70.00	33.83	39.00	9002080034500
0.1378		3.50	70.00	33.75	39.00	9002080035000
0.1398		3.55	70.00	33.68	39.00	9002080035500
0.1406	9/64 #28	3.57	70.00	33.65	39.00	9002080035700
0.1417		3.60	70.00	33.60	39.00	9002080036000
0.1437		3.65	70.00	33.53	39.00	9002080036500
0.1457		3.70	70.00	33.45	39.00	9002080037000
0.1476		3.75	70.00	33.38	39.00	9002080037500
0.1496	#25	3.80	75.00	37.30	43.00	9002080038000
0.1516		3.85	75.00	37.23	43.00	9002080038500
0.1535		3.90	75.00	37.15	43.00	9002080039000
0.1539	#23	3.91	75.00	37.14	43.00	9002080039100
0.1555		3.95	75.00	37.08	43.00	9002080039500
0.1563	5/32	3.97	75.00	37.05	43.00	9002080039700
0.1575		4.00	75.00	37.00	43.00	9002080040000
0.1594		4.05	75.00	36.93	43.00	9002080040500
0.1614		4.10	75.00	36.85	43.00	9002080041000
0.1626		4.13	75.00	36.81	43.00	9002080041300
0.1634		4.15	75.00	36.78	43.00	9002080041500
0.1654		4.20	75.00	36.70	43.00	9002080042000
0.1673		4.25	75.00	36.63	43.00	9002080042500
0.1693	#18	4.30	80.00	40.55	47.00	9002080043000
0.1713		4.35	80.00	40.48	47.00	9002080043500
0.1720	11/64	4.37	80.00	40.45	47.00	9002080043700
0.1728	#17	4.39	80.00	40.42	47.00	9002080043900
0.1732		4.40	80.00	40.40	47.00	9002080044000
0.1752		4.45	80.00	40.33	47.00	9002080044500
0.1772	#16	4.50	80.00	40.25	47.00	9002080045000
0.1791		4.55	80.00	40.18	47.00	9002080045500
0.1799	#15	4.57	80.00	40.15	47.00	9002080045700
0.1811		4.60	80.00	40.10	47.00	9002080046000
0.1831		4.65	80.00	40.03	47.00	9002080046500
0.1850	#13	4.70	80.00	39.95	47.00	9002080047000
0.1870		4.75	80.00	39.88	47.00	9002080047500
0.1874	3/16	4.76	86.00	44.86	52.00	9002080047600
0.1890	#12	4.80	86.00	44.80	52.00	9002080048000
0.1909	#11	4.85	86.00	44.73	52.00	9002080048500
0.1929		4.90	86.00	44.65	52.00	9002080049000
0.1937	#10	4.92	86.00	44.62	52.00	9002080049200
0.1949		4.95	86.00	44.58	52.00	9002080049500
0.1961	#9	4.98	86.00	44.53	52.00	9002080049800
0.1969		5.00	86.00	44.50	52.00	9002080050000
0.1992	#8	5.06	86.00	44.41	52.00	9002080050600

Jobber Length

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	mm				
0.2008		5.10	86.00	44.35	52.00	9002080051000
0.2012	#7	5.11	86.00	44.34	52.00	9002080051100
0.2031	13/64	5.16	86.00	44.26	52.00	9002080051600
0.2039	#6	5.18	86.00	44.23	52.00	9002080051800
0.2047		5.20	86.00	44.20	52.00	9002080052000
0.2055	#5	5.22	86.00	44.17	52.00	9002080052200
0.2067		5.25	86.00	44.13	52.00	9002080052500
0.2087		5.30	86.00	44.05	52.00	9002080053000
0.2126		5.40	93.00	48.90	57.00	9002080054000
0.2165		5.50	93.00	48.75	57.00	9002080055000
0.2189	7/32	5.56	93.00	48.66	57.00	9002080055600
0.2205		5.60	93.00	48.60	57.00	9002080056000
0.2209	#2	5.61	93.00	48.59	57.00	9002080056100
0.2244		5.70	93.00	48.45	57.00	9002080057000
0.2264		5.75	93.00	48.38	57.00	9002080057500
0.2283		5.80	93.00	48.30	57.00	9002080058000
0.2303		5.85	93.00	48.23	57.00	9002080058500
0.2323		5.90	93.00	48.15	57.00	9002080059000
0.2339	A	5.94	93.00	48.09	57.00	9002080059400
0.2343	15/64	5.95	93.00	48.08	57.00	9002080059500
0.2362		6.00	93.00	48.00	57.00	9002080060000
0.2382		6.05	101.00	53.93	63.00	9002080060500
0.2402		6.10	101.00	53.85	63.00	9002080061000
0.2441		6.20	101.00	53.70	63.00	9002080062000
0.2461	D	6.25	101.00	53.63	63.00	9002080062500
0.2480		6.30	101.00	53.55	63.00	9002080063000
0.2500	1/4	6.35	101.00	53.48	63.00	9002080063500
0.2520		6.40	101.00	53.40	63.00	9002080064000
0.2559		6.50	101.00	53.25	63.00	9002080065000
0.2598		6.60	101.00	53.10	63.00	9002080066000
0.2638		6.70	101.00	52.95	63.00	9002080067000
0.2657	17/64	6.75	109.00	58.88	69.00	9002080067500
0.2677		6.80	109.00	58.80	69.00	9002080068000
0.2717	I	6.90	109.00	58.65	69.00	9002080069000
0.2756		7.00	109.00	58.50	69.00	9002080070000
0.2768	J	7.03	109.00	58.46	69.00	9002080070300
0.2795		7.10	109.00	58.35	69.00	9002080071000
0.2811	9/32	7.14	109.00	58.29	69.00	9002080071400
0.2835		7.20	109.00	58.20	69.00	9002080072000
0.2874		7.30	109.00	58.05	69.00	9002080073000
0.2913		7.40	109.00	57.90	69.00	9002080074000
0.2953		7.50	109.00	57.75	69.00	9002080075000
0.2969	19/64	7.54	117.00	63.69	75.00	9002080075400
0.2992		7.60	117.00	63.60	75.00	9002080076000
0.3031		7.70	117.00	63.45	75.00	9002080077000
0.3051		7.75	117.00	63.38	75.00	9002080077500
0.3071		7.80	117.00	63.30	75.00	9002080078000
0.3091		7.85	117.00	63.23	75.00	9002080078500
0.3110		7.90	117.00	63.15	75.00	9002080079000
0.3126	5/16	7.94	117.00	63.09	75.00	9002080079400
0.3150		8.00	117.00	63.00	75.00	9002080080000
0.3189		8.10	117.00	62.85	75.00	9002080081000
0.3228	P	8.20	117.00	62.70	75.00	9002080082000
0.3268		8.30	117.00	62.55	75.00	9002080083000
0.3280	21/64	8.33	117.00	62.51	75.00	9002080083300
0.3307		8.40	117.00	62.40	75.00	9002080084000
0.3319	Q	8.43	117.00	62.36	75.00	9002080084300
0.3346		8.50	117.00	62.25	75.00	9002080085000

Diameter (d <sub>1</sub> )			l <sub>1</sub> mm	t <sub>max</sub> mm	l <sub>2</sub> mm	EDP #
inch	wire/ltr	mm				
0.3386		8.60	125.00	68.10	81.00	9002080086000
0.3425		8.70	125.00	67.95	81.00	9002080087000
0.3465		8.80	125.00	67.80	81.00	9002080088000
0.3504		8.90	125.00	67.65	81.00	9002080089000
0.3543		9.00	125.00	67.50	81.00	9002080090000
0.3583		9.10	125.00	67.35	81.00	9002080091000
0.3622		9.20	125.00	67.20	81.00	9002080092000
0.3661		9.30	125.00	67.05	81.00	9002080093000
0.3701		9.40	125.00	66.90	81.00	9002080094000
0.3740		9.50	125.00	66.75	81.00	9002080095000
0.3748	3/8	9.52	133.00	72.72	87.00	9002080095200
0.3780		9.60	133.00	72.60	87.00	9002080096000
0.3819		9.70	133.00	72.45	87.00	9002080097000
0.3839		9.75	133.00	72.38	87.00	9002080097500
0.3858	W	9.80	133.00	72.30	87.00	9002080098000
0.3898		9.90	133.00	72.15	87.00	9002080099000
0.3906	25/64	9.92	133.00	72.12	87.00	9002080099200
0.3937		10.00	133.00	72.00	87.00	9002080100000
0.3976		10.10	133.00	71.85	87.00	9002080101000
0.4016		10.20	133.00	71.70	87.00	9002080102000
0.4035		10.25	133.00	71.63	87.00	9002080102500
0.4055		10.30	133.00	71.55	87.00	9002080103000
0.4063	13/32	10.32	133.00	71.52	87.00	9002080103200
0.4094		10.40	133.00	71.40	87.00	9002080104000
0.4134		10.50	133.00	71.25	87.00	9002080105000
0.4173		10.60	133.00	71.10	87.00	9002080106000
0.4213		10.70	142.00	77.95	94.00	9002080107000
0.4220	27/64	10.72	142.00	77.92	94.00	9002080107200
0.4232		10.75	142.00	77.88	94.00	9002080107500
0.4331		11.00	142.00	77.50	94.00	9002080110000
0.4374	7/16	11.11	142.00	77.34	94.00	9002080111100
0.4409		11.20	142.00	77.20	94.00	9002080112000
0.4449		11.30	142.00	77.05	94.00	9002080113000
0.4528		11.50	142.00	76.75	94.00	9002080115000
0.4531	29/64	11.51	142.00	76.74	94.00	9002080115100
0.4646		11.80	142.00	76.30	94.00	9002080118000
0.4685		11.90	151.00	83.15	101.00	9002080119000
0.4689	15/32	11.91	151.00	83.14	101.00	9002080119100
0.4724		12.00	151.00	83.00	101.00	9002080120000
0.4764		12.10	151.00	82.85	101.00	9002080121000
0.4803		12.20	151.00	82.70	101.00	9002080122000
0.4823		12.25	151.00	82.63	101.00	9002080122500
0.4843	31/64	12.30	151.00	82.55	101.00	9002080123000
0.4882		12.40	151.00	82.40	101.00	9002080124000
0.4921		12.50	151.00	82.25	101.00	9002080125000
0.4961		12.60	151.00	82.10	101.00	9002080126000
0.5000	1/2	12.70	151.00	81.95	101.00	9002080127000
0.5118		13.00	151.00	81.50	101.00	9002080130000
0.5217		13.25	160.00	88.13	108.00	9002080132500
0.5276		13.40	160.00	87.90	108.00	9002080134000
0.5669		14.40	169.00	92.40	114.00	9002080144000
0.5787		14.70	169.00	91.95	114.00	9002080147000
0.5827		14.80	169.00	91.80	114.00	9002080148000
0.6004		15.25	178.00	97.13	120.00	9002080152500
0.6102		15.50	178.00	96.75	120.00	9002080155000
0.6248	5/8	15.87	178.00	96.20	120.00	9002080158700
0.6299		16.00	178.00	96.00	120.00	9002080160000

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	-	≤ 150											
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											
Copper, low-alloyed	-	≤ 150	100	0.0015	0.004	0.0065	0.0080	0.0100	0.0100	0.0110			
Brass, short-chipping long-chipping	- -	≤ 180 ≤ 180											
Bronze, short-chipping	-	≤ 180											
Bronze, long-chipping	≤ 25 ≤ 32	≤ 255 ≤ 301											
Duroplastics Thermoplastics Reinforced plastics - Kevlar Reinforced plastics - GFK / CFK			80	0.0015	0.00400	0.0065	0.0080	0.0100	0.0100	0.0110			

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	-	≤ 150	100	0.0017	0.0050	0.0080	0.0100	0.0125					
Free-cutting steels	≤ 25 ≤ 32	≤ 255 ≤ 301	100 80	0.0017 0.0015	0.0050 0.0040	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100					
Unalloyed heat-treatable steels	≤ 20 ≤ 25 ≤ 32	≤ 220 ≤ 255 ≤ 301	100 80	0.0015 0.0015	0.0040 0.0040	0.0065 0.0065	0.0080 0.0080	0.0100 0.0100					
Alloyed heat-treatable steels	≤ 32 ≤ 43	≤ 301 ≤ 402											
Unalloyed case hardened steels	≤ 25	≤ 255	100	0.0017	0.0050	0.008	0.0100	0.0125					
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					
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					
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					
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	205 160	0.0020 0.0017	0.0065 0.0050	0.0100 0.0080	0.0125 0.0100	0.0160 0.0125					
Magnesium alloys	-	≤ 120	260	0.0017	0.0050	0.0080	0.0100	0.0125					
Copper, low-alloyed	-	≤ 150	100	0.0015	0.0040	0.0065	0.0080	0.0100					
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					
Bronze, short-chipping	-	≤ 180	100	0.0012	0.0030	0.0050	0.0065	0.0080					
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					
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					