

# SPEED & FEED GUIDE



Optimum Performance

## Series 2215

738 7 FLUTE

Material	Axial ↓	Radial →	SFM	1/8		1/4		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
<b>P</b>	<b>Carbon Steel</b> 10XX, 11XX, 12XX, 13XX	1 x D	1 x D	<b>220</b>	6723	24	3362	24	2241	28	1681	30	1345	28	1121	26
		1.25 x D	.3 x D	<b>264</b>	8068	34	4034	34	2689	41	2017	43	1614	41	1345	38
		1.5 x D	.1 x D	<b>343</b>	10488	73	5244	73	3496	88	2622	93	2098	89	1748	81
	<b>Alloy Steel</b> 4140, 8620	1 x D	1 x D	<b>180</b>	5501	37	2750	27	1834	22	1375	23	1100	22	917	20
		1.25 x D	.3 x D	<b>225</b>	6876	55	3438	41	2292	33	1719	35	1375	33	1146	30
		1.5 x D	.1 x D	<b>270</b>	8251	110	4126	82	2750	66	2063	69	1650	66	1375	61
	<b>Tool Steel</b> A2 ,A3, D2, H11, H13	1 x D	.5 x D	<b>180</b>	5501	18	2750	18	1834	22	1375	23	1100	22	917	20
		1.25 x D	.3 x D	<b>225</b>	6876	27	3438	27	2292	33	1719	35	1375	33	1146	30
		1.5 x D	.1 x D	<b>270</b>	8251	55	4126	55	2750	66	2063	69	1650	66	1375	61
<b>M</b>	<b>SS</b> 300 & 400 Series 303, 304, 316, 420, 416	.75 x D	1 x D	<b>140</b>	4278	12	2139	12	1426	15	1070	15	856	15	713	14
		1.25 x D	.3 x D	<b>185</b>	5654	19	2827	19	1885	23	1413	24	1131	23	942	21
		1.5 x D	.1 x D	<b>230</b>	7039	40	3519	40	2346	48	1760	51	1408	49	1173	44
	<b>Precipitation SS</b> 15-5, 16-6, 17-4, 17-5	0.5	1 x D	<b>115</b>	3514	10	1757	10	1171	11	879	12	703	12	586	11
		1.25 x D	.3 x D	<b>180</b>	5501	18	2750	18	1834	21	1375	23	1100	22	917	20
		1.5 x D	.1 x D	<b>250</b>	7640	41	3820	41	2547	50	1910	52	1528	50	1273	46
<b>K</b>	<b>Cast Iron - Grey,</b> GG-10 to GG-40	1 x D	1 x D	<b>100</b>	3056	10	1528	10	1019	12	764	12	611	12	509	11
		1.25 x D	.3 x D	<b>125</b>	3820	14	1910	14	1273	17	955	18	764	18	637	16
		1.5 x D	.1 x D	<b>163</b>	4966	31	2483	31	1655	38	1242	40	993	38	828	35
	<b>Cast Iron - Ductile</b> GGG-40, to GGG-70	.75 x D	1 x D	<b>155</b>	4737	14	2368	14	1579	17	1184	18	947	17	789	16
		1.25 x D	.3 x D	<b>180</b>	5501	20	2750	20	1834	24	1375	25	1100	24	917	22
		1.5 x D	.1 x D	<b>216</b>	6601	40	3300	40	2200	48	1650	50	1320	48	1100	44
<b>S</b>	<b>High Temp Alloys</b> Inconel 718, Hastalloy, Waspalloy, A286, CoCr	.25 x D	.4 x D	<b>70</b>	2139	6	1070	6	713	7	535	7	428	7	357	6
		1.25 x D	.2 x D	<b>80</b>	2445	8	1222	8	815	9	611	10	489	9	407	8
		1.5 x D	.07 x D	<b>125</b>	3820	20	1910	20	1273	24	955	25	764	24	637	22
	<b>Titanium Alloy</b> Ti-6Al4V Grades (5-38)	0.5	1 x D	<b>180</b>	5501	13	2750	13	1834	16	1375	17	1100	16	917	15
		1.25 x D	.3 x D	<b>225</b>	6876	20	3438	20	2292	24	1719	25	1375	24	1146	22
		1.5 x D	.1 x D	<b>360</b>	11002	54	5501	54	3667	65	2750	68	2200	65	1834	60

# ULTIMATE PERFORMANCE

Premium High Performance Carbide End Mills for Ferrous Materials



## Series 2215 | 738 | 7FL | Square & Radius | PYSTL

Diameter	Shank Dia.	LOC	OAL	Radius	EDP
3/8	3/8	1/2	2	-	312575
3/8	3/8	1/2	2	0.030	312577
3/8	3/8	1/2	2	0.060	312581
3/8	3/8	1	2-1/2	-	312585
3/8	3/8	1	2-1/2	0.030	312589
3/8	3/8	1	2-1/2	0.060	312591
3/8	3/8	1-1/4	3	-	312595
3/8	3/8	1-1/4	3	0.030	312597
3/8	3/8	1-1/4	3	0.060	312599
3/8	3/8	1-1/2	4	-	312603
3/8	3/8	1-1/2	4	0.030	312606
3/8	3/8	1-1/2	4	0.060	312608
3/8	3/8	2-1/2	6	-	312610
3/8	3/8	2-1/2	6	0.030	312612
3/8	3/8	2-1/2	6	0.060	312614
1/2	1/2	3/4	2-1/2	-	312616
1/2	1/2	3/4	2-1/2	0.030	312620
1/2	1/2	3/4	2-1/2	0.060	312624
1/2	1/2	3/4	2-1/2	0.090	312628
1/2	1/2	1-1/4	3	-	312632
1/2	1/2	1-1/4	3	0.030	312636
1/2	1/2	1-1/4	3	0.060	312638
1/2	1/2	1-1/4	3	0.090	312642
1/2	1/2	2	4	-	312645
1/2	1/2	2	4	0.030	312649
1/2	1/2	2	4	0.060	312652
1/2	1/2	2	4	0.090	312654
1/2	1/2	3-1/4	6	-	312657
1/2	1/2	3-1/4	6	0.030	312659
1/2	1/2	3-1/4	6	0.060	312662
1/2	1/2	3-1/4	6	0.090	312664
5/8	5/8	3/4	3	-	312666
5/8	5/8	3/4	3	0.030	312669
5/8	5/8	3/4	3	0.060	312672
5/8	5/8	3/4	3	0.090	312674
5/8	5/8	3/4	3	0.120	312676
5/8	5/8	1-5/8	3-1/2	-	312679
5/8	5/8	1-5/8	3-1/2	0.030	312681
5/8	5/8	1-5/8	3-1/2	0.060	312684
5/8	5/8	1-5/8	3-1/2	0.090	312688

# PYSTL<sub>series</sub>

### More About the Series 2215

Special edge preparation makes this an ideal tool for a broad spectrum of work materials

PYSTL features a 38 degree helix that reduces chatter and enables more aggressive and stable milling



★ Best ☆ Good

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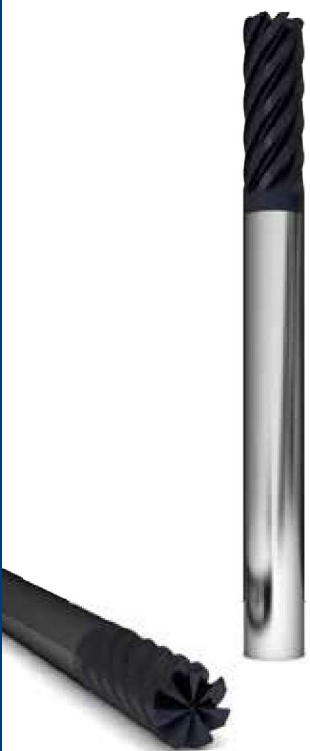
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Diameter	Shank Dia.	LOC	OAL	Radius	EDP
5/8	5/8	1-5/8	3-1/2	0.120	312692
5/8	5/8	2	5	-	312695
5/8	5/8	2	5	0.030	312697
5/8	5/8	2	5	0.060	312699
5/8	5/8	2	5	0.090	312701
5/8	5/8	2	5	0.120	312705
5/8	5/8	3-1/4	6	-	312708
5/8	5/8	3-1/4	6	0.030	312710
5/8	5/8	3-1/4	6	0.060	312714
5/8	5/8	3-1/4	6	0.090	312718
5/8	5/8	3-1/4	6	0.120	312720
3/4	3/4	1	3	-	312724
3/4	3/4	1	3	0.030	312726
3/4	3/4	1	3	0.060	312728
3/4	3/4	1	3	0.090	312730
3/4	3/4	1	3	0.120	312732
3/4	3/4	1-5/8	4	-	312736
3/4	3/4	1-5/8	4	0.030	312739
3/4	3/4	1-5/8	4	0.060	312742
3/4	3/4	1-5/8	4	0.090	312744
3/4	3/4	1-5/8	4	0.120	312746
3/4	3/4	2-1/4	5	-	312749
3/4	3/4	2-1/4	5	0.030	312753
3/4	3/4	2-1/4	5	0.060	312757
3/4	3/4	2-1/4	5	0.090	312759
3/4	3/4	2-1/4	5	0.120	312761
3/4	3/4	3-1/4	6	-	312764
3/4	3/4	3-1/4	6	0.030	312766
3/4	3/4	3-1/4	6	0.060	312770
3/4	3/4	3-1/4	6	0.090	312773
3/4	3/4	3-1/4	6	0.120	312777
1	1	1-1/4	4	-	312781
1	1	1-1/4	4	0.030	312783
1	1	1-1/4	4	0.060	312787
1	1	1-1/4	4	0.090	312791
1	1	1-1/4	4	0.120	312793
1	1	2	5	-	312795
1	1	2	5	0.030	312798
1	1	2	5	0.060	312800
1	1	2	5	0.090	312802



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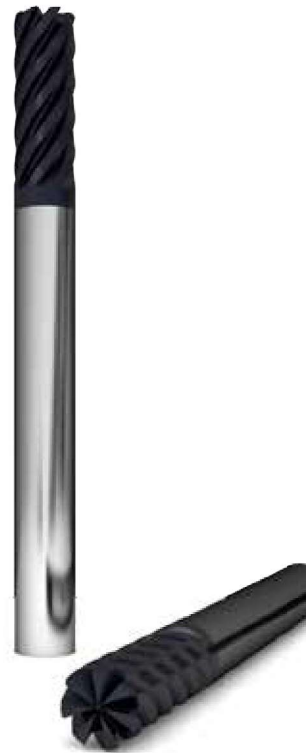
Diameter	Shank Dia.	LOC	OAL	Radius	EDP
1	1	2	5	0.120	312804
1	1	3-1/4	6	-	312807
1	1	3-1/4	6	0.030	312809
1	1	3-1/4	6	0.060	312811
1	1	3-1/4	6	0.090	312815
1	1	3-1/4	6	0.120	312818
1	1	4-1/8	7	-	312821
1	1	4-1/8	7	0.030	312824
1	1	4-1/8	7	0.060	312828
1	1	4-1/8	7	0.090	312830
1	1	4-1/8	7	0.120	312834
1-1/4	1-1/4	2	4-1/2	-	312836
1-1/4	1-1/4	2	4-1/2	0.030	312839
1-1/4	1-1/4	2	4-1/2	0.060	312842
1-1/4	1-1/4	2	4-1/2	0.090	312846
1-1/4	1-1/4	2	4-1/2	0.120	312848
1-1/4	1-1/4	2-5/8	6	-	312851
1-1/4	1-1/4	2-5/8	6	0.030	312855
1-1/4	1-1/4	2-5/8	6	0.060	312858
1-1/4	1-1/4	2-5/8	6	0.090	312861
1-1/4	1-1/4	2-5/8	6	0.120	312863
1-1/4	1-1/4	3-1/4	6	-	312867
1-1/4	1-1/4	3-1/4	6	0.030	312869
1-1/4	1-1/4	3-1/4	6	0.060	312871
1-1/4	1-1/4	3-1/4	6	0.090	312874
1-1/4	1-1/4	3-1/4	6	0.120	312877
1-1/4	1-1/4	5	7-1/2	-	312880
1-1/4	1-1/4	5	7-1/2	0.030	312884
1-1/4	1-1/4	5	7-1/2	0.060	312887
1-1/4	1-1/4	5	7-1/2	0.090	312889
1-1/4	1-1/4	5	7-1/2	0.120	312893

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