

SPEED & FEED GUIDE



Optimum Performance

Series 2225

540V 5-FLUTE

Material	Axial ↓	Radial →	SFM	1/4		1/8		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
P	Carbon Steel 10XX, 11XX, 12XX, 13XX	1 x D	1 x D	220	3362	17	2689	20	2241	30	1681	32	1345	30	1121	28
		1.25 x D	.3 x D	264	4034	24	3227	29	2689	44	2017	46	1614	44	1345	40
		1.5 x D	.1 x D	343	5244	52	4195	63	3496	94	2622	99	2098	95	1748	87
	Alloy Steel 4140, 8620	1 x D	1 x D	180	2750	13	2200	16	1834	24	1375	25	1100	24	917	22
		1.25 x D	.3 x D	225	3438	20	2750	24	2292	35	1719	37	1375	36	1146	33
		1.5 x D	.1 x D	270	4126	39	3300	47	2750	71	2063	74	1650	71	1375	65
	Tool Steel A2, A3, D2, H11, H13	1 x D	.5 x D	180	2445	6	1956	7	1630	10	1222	11	978	10	815	9
		1.25 x D	.3 x D	225	3056	10	2445	13	2037	18	1528	19	1222	18	1019	17
		1.5 x D	.1 x D	270	3667	17	2934	20	2445	29	1834	30	1467	29	1222	26
M	SS 300 & 400 Series 303, 304, 316, 420, 416	.75 x D	1 x D	140	2139	9	1711	10	1426	16	1070	16	856	16	713	14
		1.25 x D	.3 x D	185	2827	14	2261	17	1885	25	1413	26	1131	25	942	23
		1.5 x D	.1 x D	230	3519	29	2815	34	2346	52	1760	54	1408	52	1173	48
	Precipitation SS 15-5, 16-6, 17-4, 17-5	0.5	1 x D	115	1757	7	1406	8	1171	12	879	13	703	12	586	11
		1.25 x D	.3 x D	180	2750	13	2200	15	1834	23	1375	24	1100	23	917	21
		1.5 x D	.1 x D	250	3820	30	3056	35	2547	53	1910	56	1528	54	1273	49
K	Cast Iron - Grey GG-10 to GG-40	1 x D	1 x D	100	1528	7	1222	8	1019	12	764	13	611	13	509	11
		1.25 x D	.3 x D	125	1910	10	1528	12	1273	19	955	20	764	19	637	17
		1.5 x D	.1 x D	163	2483	22	1986	27	1655	40	1242	42	993	41	828	37
	Cast Iron- Ductile GGG-40, to GGG-70	.75 x D	1 x D	155	2368	10	1895	12	1579	18	1184	19	947	18	789	17
		1.25 x D	.3 x D	180	2750	14	2200	17	1834	25	1375	27	1100	26	917	24
		1.5 x D	.1 x D	216	3300	28	2640	34	2200	51	1650	53	1320	51	1100	47
S	High Temp Alloys Inconel 718, Hastalloy, Waspalloy, A286, CoCr	.25 x D	.4 x D	70	1070	4	856	5	713	7	535	7	428	7	357	7
		1.25 x D	.2 x D	80	1222	5	978	6	815	10	611	10	489	10	407	9
		1.5 x D	.07 x D	125	1910	14	1528	17	1273	25	955	27	764	25	637	23
	Titanium Alloy Ti-6Al4V Grades (5-38)	0.5	1 x D	180	2750	10	2200	12	1834	17	1375	18	1100	17	917	16
		1.25 x D	.3 x D	225	3438	14	2750	17	2292	26	1719	27	1375	26	1146	24
		1.5 x D	.1 x D	360	5501	38	4401	46	3667	69	2750	73	2200	70	1834	64

PERFORMANCE

Premium Carbide End Mills for Ferrous Materials



Series 255 | 540V | 4FL | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Radius	EDP
1/4	1/4	3/8	2	-	316380
1/4	1/4	3/8	2	0.020	316384
1/4	1/4	3/4	2-1/2	-	316386
1/4	1/4	3/4	2-1/2	0.020	316388
1/4	1/4	1-1/4	3	-	316392
1/4	1/4	1-1/4	3	0.020	316396
5/16	5/16	7/16	2	-	316400
5/16	5/16	7/16	2	0.020	316404
5/16	5/16	13/16	2-1/2	-	316406
5/16	5/16	13/16	2-1/2	0.020	316408
5/16	5/16	1-3/8	3	-	316410
5/16	5/16	1-3/8	3	0.020	316413
3/8	3/8	1/2	2	-	316416
3/8	3/8	1/2	2	0.020	316420
3/8	3/8	1/2	2	0.030	316422
3/8	3/8	1	2-1/2	-	316425
3/8	3/8	1	2-1/2	0.020	316428
3/8	3/8	1	2-1/2	0.030	316432
3/8	3/8	1-1/2	2-1/2	-	316435
3/8	3/8	1-1/2	2-1/2	0.020	316438
3/8	3/8	1-1/2	2-1/2	0.030	316441
1/2	1/2	5/8	2-1/2	-	316445
1/2	1/2	5/8	2-1/2	0.030	316448
1/2	1/2	5/8	2-1/2	0.060	316451
1/2	1/2	1-1/4	3	-	316453
1/2	1/2	1-1/4	3	0.030	316455
1/2	1/2	1-1/4	3	0.060	316457
1/2	1/2	2	4	-	316460
1/2	1/2	2	4	0.030	316463
1/2	1/2	2	4	0.060	316465
5/8	5/8	3/4	3	-	316468
5/8	5/8	3/4	3	0.030	316470
5/8	5/8	3/4	3	0.060	316473
5/8	5/8	1-5/8	3-1/2	-	316476
5/8	5/8	1-5/8	3-1/2	0.030	316479
5/8	5/8	1-5/8	3-1/2	0.060	316483
5/8	5/8	2-1/4	5	-	316486
5/8	5/8	2-1/4	5	0.030	316488
5/8	5/8	2-1/4	5	0.060	316492
3/4	3/4	1	3	-	316495

More About the Series 255

Performance edge treatment

Features a variable helix design that reduces chatter and enables more aggressive and stable milling



★ Best ☆ Good

PERFORMANCE

Premium Carbide End Mills for Ferrous Materials



Series 255		540V 4FL Square & Radius			
Diameter	Shank Dia.	LOC	OAL	Radius	EDP
3/4	3/4	1	3	0.030	316499
3/4	3/4	1	3	0.060	316502
3/4	3/4	1-5/8	4	-	316504
3/4	3/4	1-5/8	4	0.030	316508
3/4	3/4	1-5/8	4	0.060	316511
3/4	3/4	2-1/4	5	-	316515
3/4	3/4	2-1/4	5	0.030	316519
3/4	3/4	2-1/4	5	0.060	316523
1	1	1-1/4	3	-	316525
1	1	1-1/4	3	0.030	316527
1	1	1-1/4	3	0.060	316531
1	1	2	4	-	316533
1	1	2	4	0.030	316537
1	1	2	4	0.060	316541
1	1	3-1/4	5	-	316544
1	1	3-1/4	5	0.030	316548
1	1	3-1/4	5	0.060	316551

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