

SPEED & FEED GUIDE

Optimum Performance



Series 2235

537

	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
P	Carbon Steel 10XX, 11XX, 12XX, 13XX	1 x D	.3 x D	220	6723	17	3362	17	2241	20	1681	21	1345	20	1121	19
		1.25 x D	.2 x D	264	8068	24	4034	24	2689	29	2017	30	1614	29	1345	27
		1.5 x D	.08 x D	317	9681	48	4841	48	3227	56	2420	59	1936	57	1614	52
		1.5 x D	.05 x D	380	11618	76	5809	64	3873	74	2904	77	2324	74	1936	68
	Alloy Steel 4140, 8620	1 x D	.3 x D	180	5501	14	2750	19	1834	17	1375	17	1100	17	917	15
		1.25 x D	.2 x D	225	6876	21	3438	29	2292	25	1719	26	1375	25	1146	23
		1.5 x D	.08 x D	270	8251	41	4126	57	2750	48	2063	51	1650	49	1375	44
		1.5 x D	.05 x D	297	9076	59	4538	68	3025	57	2269	60	1815	58	1513	53
	Tool Steel A2, A3, D2, H11, H13	.5 x D	.3 x D	160	4890	12	2445	17	1630	15	1222	15	978	15	815	14
		1.0 x D	.2 x D	200	6112	18	3056	26	2037	22	1528	23	1222	22	1019	20
		1.5 x D	.08 x D	240	7334	37	3667	51	2445	43	1834	45	1467	43	1222	40
		1.5 x D	.05 x D	264	8068	52	4034	61	2689	51	2017	54	1614	52	1345	47
M	SS 300 & 400 Series 303, 304, 316, 420, 417	.75 x D	.3 x D	140	4278	11	2139	9	1426	13	1070	13	856	13	713	12
		1.25 x D	.2 x D	185	5654	17	2827	14	1885	20	1413	21	1131	21	942	19
		1.5 x D	.08 x D	230	7039	35	3519	28	2346	41	1760	43	1408	41	1173	38
		1.5 x D	.05 x D	276	8446	55	4223	42	2815	53	2112	56	1689	54	1408	49
	Precipitation SS 15-5, 16-6, 17-4, 17-6	.5 x D	.3 x D	115	3514	9	1757	7	1171	8	879	9	703	8	586	8
		1.25 x D	.2 x D	180	5501	17	2750	14	1834	15	1375	15	1100	15	917	14
		1.5 x D	.08 x D	250	7640	38	3820	31	2547	33	1910	35	1528	33	1273	31
		1.5 x D	.05 x D	300	9168	60	4584	46	3056	55	2292	58	1834	55	1528	51
S	High Temp Alloys Inconel 718, Hastalloy, A286, Waspalloy, CoCr	.25 x D	.3 x D	70	2139	5	1070	4	713	5	535	5	428	5	357	5
		1 x D	.2 x D	80	2445	7	1222	6	815	7	611	7	489	7	407	6
		1.25 x D	.08 x D	125	3820	19	1910	15	1273	17	955	17	764	17	637	15
		1.5 x D	.05 x D	160	4890	32	2445	24	1630	29	1222	31	978	30	815	27

PERFORMANCE

Premium Carbide End Mills for Ferrous Materials



Series 265 537 | 5FL | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Radius	EDP
1/4	1/4	3/8	2-1/2	-	316835
1/4	1/4	3/8	2-1/2	0.020	316837
1/4	1/4	3/8	2-1/2	0.030	316841
1/4	1/4	3/4	2-1/2	-	316844
1/4	1/4	3/4	2-1/2	0.010	316848
1/4	1/4	3/4	2-1/2	0.020	316852
1/4	1/4	3/4	2-1/2	0.030	316855
1/4	1/4	3/4	4	-	316859
1/4	1/4	3/4	4	0.010	316862
1/4	1/4	3/4	4	0.020	316864
1/4	1/4	3/4	4	0.030	316868
5/16	5/16	13/16	2-1/2	-	316870
5/16	5/16	13/16	2-1/2	0.030	316873
1/2	1/2	5/8	3	-	316875
1/2	1/2	5/8	3	0.020	316878
1/2	1/2	5/8	3	0.030	316880
1/2	1/2	5/8	3	0.060	316883
1/2	1/2	5/8	3	0.090	316885
1/2	1/2	5/8	3	0.120	316887
1/2	1/2	1-1/4	3	-	316891
1/2	1/2	1-1/4	3	0.020	316893
1/2	1/2	1-1/4	3	0.030	316896
1/2	1/2	1-1/4	3	0.060	316898
1/2	1/2	1-1/4	3	0.090	316901
1/2	1/2	1-1/4	3	0.120	316903
1/2	1/2	1-1/4	4	-	316906
1/2	1/2	1-1/4	4	0.020	316910
1/2	1/2	1-1/4	4	0.030	316913
1/2	1/2	1-1/4	4	0.060	316915
1/2	1/2	1-1/4	4	0.090	316918
1/2	1/2	1-1/4	4	0.120	316921
5/8	5/8	3/4	3	-	316923
5/8	5/8	3/4	3	0.030	316927
5/8	5/8	3/4	3	0.060	316929
5/8	5/8	3/4	3	0.090	316931
5/8	5/8	3/4	3	0.120	316933
5/8	5/8	1-5/8	3-1/2	-	316937
5/8	5/8	1-5/8	3-1/2	0.030	316939
5/8	5/8	1-5/8	3-1/2	0.060	316942
5/8	5/8	1-5/8	3-1/2	0.090	316946



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More About the Series 265

Special edge preparation makes this an ideal tool for exotic materials

Features a variable index design with 38 degree helix that reduces chatter and enables more aggressive and stable milling



PERFORMANCE

Premium Carbide End Mills for Ferrous Materials



Series 265 537 | 5FL | Square & Radius

Diameter	Shank Dia.	LOC	OAL	Radius	EDP
5/8	5/8	1-5/8	3-1/2	0.120	316948
3/4	3/4	1	4	-	316952
3/4	3/4	1	4	0.030	316954
3/4	3/4	1	4	0.060	316956
3/4	3/4	1	4	0.090	316960
3/4	3/4	1	4	0.120	316963
3/4	3/4	1	4	0.156	316965
3/4	3/4	1	4	0.190	316969
3/4	3/4	1-5/8	4	-	316973
3/4	3/4	1-5/8	4	0.030	316977
3/4	3/4	1-5/8	4	0.060	316980
3/4	3/4	1-5/8	4	0.090	316983
3/4	3/4	1-5/8	4	0.120	316985
3/4	3/4	1-5/8	4	0.156	316987
3/4	3/4	1-5/8	4	0.190	316991
3/4	3/4	1-5/8	6	-	316994
3/4	3/4	1-5/8	6	0.030	316997
3/4	3/4	1-5/8	6	0.060	316999
3/4	3/4	1-5/8	6	0.090	317003
3/4	3/4	1-5/8	6	0.120	317005
3/4	3/4	1-5/8	6	0.156	317009
3/4	3/4	1-5/8	6	0.190	317012
1	1	1-1/4	4	-	317015
1	1	1-1/4	4	0.030	317018
1	1	1-1/4	4	0.060	317020
1	1	1-1/4	4	0.090	317023
1	1	1-1/4	4	0.120	317025
1	1	1-1/4	4	0.156	317029
1	1	1-1/4	4	0.190	317032
1	1	2	4	-	317036
1	1	2	4	0.030	317038
1	1	2	4	0.060	317041
1	1	2	4	0.090	317045
1	1	2	4	0.120	317047
1	1	2	4	0.156	317049
1	1	2	4	0.190	317053

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Diameter	Shank Dia.	LOC	OAL	Radius	EDP
1	1	3-1/4	6	-	317057
1	1	3-1/4	6	0.030	317060
1	1	3-1/4	6	0.060	317063
1	1	3-1/4	6	0.090	317066
1	1	3-1/4	6	0.120	317069
1	1	3-1/4	6	0.156	317072
1	1	3-1/4	6	0.190	317076

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