

Solid Carbide - Coated

| MATERIAL GROUP | TIN | TICN | TIALN | HARDNESS (Bhn) | SURFACE SPEED METRES/MIN | FEED (mm/TOOTH) END MILL DIAMETER | | | | | | | | | | |
|-----------------------------------|-----|------|-------|----------------|--------------------------|-----------------------------------|------|------|------|------|------|------|------|------|------|--|
| | | | | | | 3mm | 4mm | 5mm | 6mm | 8mm | 10mm | 12mm | 16mm | 20mm | 25mm | |
| Aluminium Low <8% Silicon | 3 | 1 | 2 | - | max avail. | 0.02 | 0.03 | 0.04 | 0.06 | 0.07 | 0.10 | 0.15 | 0.15 | 0.20 | 0.20 | |
| Aluminium High >8% Silicon | 3 | 1 | 2 | - | 200-600 | 0.02 | 0.02 | 0.03 | 0.05 | 0.06 | 0.10 | 0.10 | 0.10 | 0.15 | 0.15 | |
| Brass and Bronze | 1 | 2 | 3 | - | 80-365 | 0.02 | 0.02 | 0.03 | 0.04 | 0.05 | 0.07 | 0.08 | 0.09 | 0.10 | 0.10 | |
| Copper and Copper Alloys | 1 | 2 | 3 | - | 130-330 | 0.03 | 0.04 | 0.04 | 0.05 | 0.06 | 0.07 | 0.09 | 0.09 | 0.10 | 0.10 | |
| Cast Iron (Soft) | 3 | 1 | 2 | 120-200 | 100-225 | 0.03 | 0.03 | 0.04 | 0.05 | 0.06 | 0.07 | 0.07 | 0.08 | 0.09 | 0.10 | |
| Cast Iron (Hard) | 3 | 1 | 2 | 210-320 | 60-120 | 0.02 | 0.03 | 0.03 | 0.04 | 0.05 | 0.05 | 0.05 | 0.06 | 0.08 | 0.10 | |
| Low Carbon Steels | 3 | 1 | 2 | 100-200 | 100-240 | 0.02 | 0.03 | 0.03 | 0.05 | 0.05 | 0.06 | 0.07 | 0.08 | 0.08 | 0.10 | |
| Medium Carbon Steels | 3 | 2 | 1 | 175-425 | 60-100 | 0.15 | 0.02 | 0.04 | 0.04 | 0.04 | 0.05 | 0.05 | 0.06 | 0.10 | 0.10 | |
| Hardened Steels | 3 | 2 | 1 | 45Rc-60Rc | 30-60 | 0.01 | 0.01 | 0.02 | 0.02 | 0.03 | 0.03 | 0.04 | 0.04 | 0.05 | 0.06 | |
| Tool Steel | 1 | 2 | 3 | 100-250 | 30-100 | 0.02 | 0.02 | 0.03 | 0.03 | 0.04 | 0.05 | 0.05 | 0.06 | 0.06 | 0.08 | |
| Stainless Steel Soft (300 series) | 3 | 2 | 1 | < 275 | 60-120 | 0.02 | 0.03 | 0.03 | 0.04 | 0.04 | 0.05 | 0.05 | 0.06 | 0.06 | 0.08 | |
| Stainless Steel Hard (400 series) | 1 | 2 | 3 | < 275 | 90-180 | 0.02 | 0.03 | 0.03 | 0.04 | 0.05 | 0.05 | 0.06 | 0.06 | 0.07 | 0.08 | |
| Stainless Steel (PH) | 2 | 3 | 1 | < 325 | 80-175 | 0.02 | 0.02 | 0.03 | 0.05 | 0.05 | 0.06 | 0.06 | 0.07 | 0.07 | 0.08 | |
| Titanium (Soft) | 3 | 2 | 1 | 110-275 | 60-105 | 0.01 | 0.02 | 0.02 | 0.04 | 0.04 | 0.05 | 0.05 | 0.06 | 0.06 | 0.07 | |
| Titanium (Hard) | 3 | 2 | 1 | 300-440 | 30-60 | 0.01 | 0.02 | 0.03 | 0.03 | 0.04 | 0.05 | 0.05 | 0.06 | 0.07 | 0.08 | |
| Monel/High Nickel Steels | 3 | 2 | 1 | - | 45-75 | 0.01 | 0.03 | 0.03 | 0.04 | 0.04 | 0.05 | 0.05 | 0.06 | 0.08 | 0.10 | |
| Hi-Temperature Alloys | 3 | 2 | 1 | - | 15-35 | 0.01 | 0.02 | 0.02 | 0.02 | 0.03 | 0.04 | 0.04 | 0.05 | 0.06 | 0.07 | |

Coating 1 - First Choice
 2 - Second Choice
 3 - Third Choice

Solid Carbide - Uncoated

| MATERIAL GROUP | SURFACE SPEED METRES/MIN | HARDNESS (Bhn) | FEED (mm/TOOTH) END MILL DIAMETER | | | | | | | | | | |
|-----------------------------------|--------------------------|----------------|-----------------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|--|
| | | | 3mm | 4mm | 5mm | 6mm | 8mm | 10mm | 12mm | 16mm | 20mm | 25mm | |
| Aluminium Low <8% Silicon | max available | - | 0.013 | 0.025 | 0.035 | 0.050 | 0.070 | 0.080 | 0.100 | 0.120 | 0.150 | 0.200 | |
| Aluminium High >8% Silicon | 200-400 | - | 0.013 | 0.025 | 0.030 | 0.040 | 0.060 | 0.070 | 0.080 | 0.100 | 0.120 | 0.150 | |
| Brass and Bronze | 70-120 | - | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.075 | 0.090 | 0.100 | 0.130 | |
| Copper and Copper Alloys | 120-250 | - | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.075 | 0.090 | 0.100 | 0.150 | |
| Cast Iron (Soft) | 70-180 | 120-200 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.075 | 0.120 | 0.150 | 0.020 | |
| Cast Iron (Hard) | 30-90 | 120-200 | 0.010 | 0.140 | 0.017 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.100 | |
| Magnesium and Magnesium Alloys | 300-460 | - | 0.025 | 0.030 | 0.040 | 0.050 | 0.070 | 0.080 | 0.100 | 0.130 | 0.150 | 0.250 | |
| Plastics-Glass Filled | 100-185 | - | 0.038 | 0.045 | 0.055 | 0.076 | 0.090 | 0.095 | 0.100 | 0.130 | 0.150 | 0.300 | |
| Plastics | 240-490 | - | 0.038 | 0.050 | 0.070 | 0.080 | 0.110 | 0.130 | 0.150 | 0.200 | 0.250 | 0.380 | |
| Low Carbon Steels | 70-125 | - | 0.013 | 0.017 | 0.020 | 0.025 | 0.040 | 0.060 | 0.075 | 0.100 | 0.150 | 0.180 | |
| Medium Carbon Steels | 35-90 | 275-425 | 0.015 | 0.020 | 0.030 | 0.040 | 0.043 | 0.047 | 0.050 | 0.075 | 0.100 | 0.150 | |
| Hardened Steels | 9-30 | 48-52 Rc "C" | 0.005 | 0.007 | 0.010 | 0.013 | 0.017 | 0.020 | 0.025 | 0.035 | 0.050 | 0.075 | |
| Stainless Steel Soft (300 series) | 60-125 | 135-275 | 0.013 | 0.017 | 0.020 | 0.025 | 0.035 | 0.040 | 0.050 | 0.075 | 0.010 | 0.150 | |
| Stainless Steel Hard (400 series) | 18-80 | 135-275 | 0.005 | 0.007 | 0.010 | 0.013 | 0.017 | 0.020 | 0.025 | 0.050 | 0.075 | 0.130 | |
| Titanium (Soft) | 15-125 | - | 0.013 | 0.017 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.075 | 0.100 | 0.150 | |
| Titanium (Hard) | 15-60 | - | 0.007 | 0.100 | 0.012 | 0.015 | 0.020 | 0.022 | 0.025 | 0.035 | 0.050 | 0.100 | |
| Monel/High Nickel Steels | 60-80 | - | 0.013 | 0.017 | 0.020 | 0.025 | 0.031 | 0.040 | 0.050 | 0.060 | 0.076 | 0.100 | |
| Hi-Temperature Alloys | 8-30 | - | 0.010 | 0.014 | 0.017 | 0.020 | 0.022 | 0.023 | 0.025 | 0.030 | 0.035 | 0.050 | |