



Milling - Inch

Date compiled **Nov. 10 2016**

APKT 100305 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.005	0.010	0.008	625	1085	820	0.020	0.354	0.080
	Low Alloy	200	0.004	0.008	0.006	490	785	655	0.020	0.354	0.080
	High Alloy	220	0.003	0.007	0.005	295	490	395	0.020	0.252	0.060
M	Austenitic	190	0.004	0.008	0.006	625	820	720	0.020	0.354	0.080
K	Grey Cast Iron	140	0.005	0.010	0.008	490	785	655	0.020	0.354	0.080
S	Heat resistant and super alloys	240	0.003	0.006	0.005	80	150	115	0.020	0.252	0.060
H	Hardened material	45HRc	0.003	0.006	0.004	130	260	195	0.020	0.126	0.040

APKT 100308 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.005	0.010	0.008	625	1085	820	0.020	0.354	0.080
	Low Alloy	200	0.004	0.008	0.006	490	785	655	0.020	0.354	0.080
	High Alloy	220	0.003	0.007	0.005	295	490	395	0.020	0.252	0.060
M	Austenitic	190	0.004	0.008	0.006	625	820	720	0.020	0.354	0.080
K	Grey Cast Iron	140	0.005	0.010	0.008	490	785	655	0.020	0.354	0.080
S	Heat resistant and super alloys	240	0.003	0.006	0.005	80	150	115	0.020	0.252	0.060
P	Non Alloy	120	0.006	0.012	0.009	625	1085	820	0.020	0.591	0.160
S	Heat resistant and super alloys	240	0.004	0.007	0.006	80	150	115	0.020	0.421	0.120
H	Hardened material	45HRc	0.004	0.007	0.005	130	260	195	0.020	0.213	0.080

APKT 160408 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.013	0.010	625	1085	820	0.020	0.591	0.160
	Low Alloy	200	0.006	0.010	0.008	490	785	640	0.020	0.591	0.160
	High Alloy	220	0.005	0.009	0.007	295	490	395	0.020	0.421	0.160
M	Austenitic	190	0.006	0.010	0.008	625	820	720	0.020	0.591	0.120
K	Grey Cast Iron	140	0.007	0.013	0.010	490	785	640	0.020	0.591	0.160
S	Heat resistant and super alloys	240	0.005	0.007	0.006	80	150	115	0.020	0.421	0.120
H	Hardened material	45HRc	0.004	0.007	0.006	130	260	195	0.020	0.213	0.080

APMT 160408 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.006	0.012	0.009	625	1085	820	0.020	0.591	0.160
	Low Alloy	200	0.006	0.009	0.007	490	785	655	0.020	0.591	0.160
	High Alloy	220	0.004	0.008	0.006	295	490	395	0.020	0.421	0.160
M	Austenitic	190	0.006	0.009	0.007	625	820	720	0.020	0.591	0.160
K	Grey Cast Iron	140	0.006	0.012	0.009	490	785	655	0.020	0.591	0.160
S	Heat resistant and super alloys	240	0.004	0.007	0.006	80	150	115	0.020	0.421	0.120
H	Hardened material	45HRc	0.004	0.007	0.005	130	260	195	0.020	0.213	0.080

APMT 113504 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.005	0.009	0.007	625	1085	820	0.020	0.394	0.080
	Low Alloy	200	0.004	0.007	0.006	490	785	655	0.020	0.394	0.080
	High Alloy	220	0.003	0.006	0.005	295	490	395	0.020	0.283	0.060
M	Austenitic	190	0.004	0.007	0.006	625	820	720	0.020	0.394	0.080
K	Grey Cast Iron	140	0.005	0.009	0.007	490	785	655	0.020	0.394	0.080
S	Heat resistant and super alloys	240	0.003	0.005	0.004	80	150	115	0.020	0.283	0.060
H	Hardened material	45HRc	0.003	0.005	0.003	130	260	195	0.020	0.142	0.040



APMT 113508 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.005	0.009	0.007	625	1085	820	0.020	0.394	0.080
	Low Alloy	200	0.004	0.007	0.006	490	785	655	0.020	0.394	0.080
	High Alloy	220	0.003	0.006	0.005	295	490	395	0.020	0.283	0.060
M	Austenitic	190	0.004	0.007	0.006	625	820	720	0.020	0.394	0.080
K	Grey Cast Iron	140	0.005	0.009	0.007	490	785	655	0.020	0.394	0.080
S	Heat resistant and super alloys	240	0.003	0.005	0.004	80	150	115	0.020	0.283	0.060
H	Hardened material	45HRc	0.003	0.005	0.003	130	260	195	0.020	0.142	0.040

ODMT 060508											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.009	0.021	0.015	625	1085	820	0.020	0.157	0.100
	Low Alloy	200	0.007	0.017	0.012	490	785	640	0.020	0.157	0.100
	High Alloy	220	0.006	0.015	0.010	295	490	395	0.020	0.114	0.070
M	Austenitic	190	0.007	0.015	0.011	625	820	720	0.020	0.157	0.100
K	Grey Cast Iron	140	0.009	0.021	0.015	490	785	640	0.020	0.157	0.100
S	Heat resistant and super alloys	240	0.006	0.012	0.009	80	150	115	0.020	0.114	0.070
H	Hardened material	45HRc	0.005	0.012	0.008	130	260	195	0.016	0.055	0.050

ODMW 060508											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.009	0.023	0.016	625	1085	820	0.020	0.157	0.120
	Low Alloy	200	0.007	0.018	0.012	490	785	640	0.020	0.157	0.120
	High Alloy	220	0.006	0.016	0.011	295	490	395	0.020	0.114	0.090
K	Grey Cast Iron	140	0.009	0.023	0.016	490	785	640	0.020	0.157	0.120
H	Hardened material	45HRc	0.005	0.013	0.009	130	260	195	0.016	0.055	0.050

OFMT 05T308											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.009	0.020	0.014	625	1085	820	0.020	0.138	0.100
	Low Alloy	200	0.007	0.016	0.011	490	785	640	0.020	0.138	0.100
	High Alloy	220	0.006	0.014	0.010	295	490	395	0.020	0.098	0.070
	Austenitic	190	0.007	0.014	0.010	625	820	720	0.020	0.138	0.100
K	Grey Cast Iron	140	0.009	0.020	0.014	490	785	640	0.020	0.138	0.100
S	Heat resistant and super alloys	240	0.006	0.011	0.008	80	150	115	0.020	0.098	0.070
H	Hardened material	45HRc	0.005	0.011	0.008	130	260	195	0.016	0.051	0.050



RDKT 0802 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.030
	Low Alloy	200	0.006	0.020	0.012	490	785	640	0.020	0.098	0.030
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.020
M	Austenitic	190	0.006	0.020	0.012	625	820	720	0.020	0.098	0.030
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	640	0.020	0.098	0.030
S	Heat resistant and super alloys	240	0.005	0.013	0.009	80	150	115	0.020	0.059	0.020
H	Hardened material	45HRc	0.004	0.013	0.009	130	260	195	0.012	0.028	0.020

RDKT 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.040
	Low Alloy	200	0.006	0.020	0.012	490	785	655	0.020	0.098	0.040
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.030
M	Austenitic	190	0.006	0.020	0.012	625	820	720	0.020	0.098	0.040
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	655	0.020	0.098	0.040
S	Heat resistant and super alloys	240	0.005	0.014	0.009	80	150	115	0.020	0.079	0.020
H	Hardened material	45HRc	0.004	0.014	0.009	130	260	195	0.012	0.035	0.020

RDKT 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.050
	Low Alloy	200	0.006	0.020	0.012	490	785	655	0.020	0.098	0.050
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.040
M	Austenitic	190	0.006	0.020	0.012	625	820	720	0.020	0.098	0.050
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	655	0.020	0.098	0.050
S	Heat resistant and super alloys	240	0.007	0.016	0.011	80	150	115	0.020	0.094	0.040
H	Hardened material	45HRc	0.006	0.016	0.011	130	260	195	0.012	0.043	0.030

RDKW 0802 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.016	625	1085	855	0.020	0.098	0.030
	Low Alloy	200	0.006	0.020	0.013	490	785	640	0.020	0.098	0.030
	High Alloy	220	0.005	0.017	0.011	295	490	395	0.020	0.071	0.020
K	Grey Cast Iron	140	0.007	0.025	0.016	490	785	640	0.020	0.098	0.030
H	Hardened material	45HRc	0.004	0.013	0.009	130	260	195	0.012	0.028	0.020

RDKW 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.040
	Low Alloy	200	0.006	0.020	0.012	490	785	655	0.020	0.098	0.040
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.030
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	655	0.020	0.098	0.040
H	Hardened material	45HRc	0.004	0.014	0.009	130	260	195	0.012	0.035	0.020

RDKW 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.050
	Low Alloy	200	0.006	0.020	0.012	490	785	655	0.020	0.098	0.050
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.040
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	655	0.020	0.098	0.050
H	Hardened material	45HRc	0.006	0.016	0.011	130	260	195	0.012	0.043	0.030



RPMT 08T2 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.016	625	1085	820	0.020	0.098	0.030
	Low Alloy	200	0.006	0.020	0.013	490	785	640	0.020	0.098	0.030
	High Alloy	220	0.005	0.017	0.011	295	490	395	0.020	0.071	0.020
M	Austenitic	190	0.006	0.020	0.013	625	820	720	0.020	0.098	0.030
K	Grey Cast Iron	140	0.007	0.025	0.016	490	785	640	0.020	0.098	0.030
S	Heat resistant and super alloys	240	0.005	0.013	0.009	80	150	115	0.020	0.059	0.020
H	Hardened material	45HRc	0.004	0.013	0.008	130	260	195	0.012	0.028	0.020

RPMT 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.040
	Low Alloy	200	0.006	0.020	0.012	490	785	655	0.020	0.098	0.040
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.030
M	Austenitic	190	0.006	0.020	0.012	625	820	720	0.020	0.098	0.040
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	655	0.020	0.098	0.040
S	Heat resistant and super alloys	240	0.005	0.014	0.009	80	150	115	0.020	0.079	0.030
H	Hardened material	45HRc	0.004	0.014	0.009	130	260	195	0.012	0.035	0.020

RPMT 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.050
	Low Alloy	200	0.006	0.020	0.012	490	785	640	0.020	0.098	0.050
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.040
M	Austenitic	190	0.006	0.020	0.012	625	820	720	0.020	0.098	0.050
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	640	0.020	0.098	0.050
S	Heat resistant and super alloys	240	0.005	0.012	0.011	80	165	125	0.020	0.094	0.060
H	Hardened material	45HRc	0.020	0.009	0.011	165	330	245	0.020	0.075	0.070

RPMW 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.040
	Low Alloy	200	0.006	0.020	0.012	490	785	655	0.020	0.098	0.040
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.030
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	655	0.020	0.098	0.040
H	Hardened material	45HRc	0.004	0.014	0.009	130	260	195	0.012	0.035	0.020

RPMW 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.025	0.014	625	1085	820	0.020	0.098	0.050
	Low Alloy	200	0.006	0.020	0.012	490	785	655	0.020	0.098	0.050
	High Alloy	220	0.005	0.017	0.010	295	490	395	0.020	0.071	0.040
K	Grey Cast Iron	140	0.007	0.025	0.014	490	785	655	0.020	0.098	0.050
H	Hardened material	45HRc	0.006	0.016	0.011	130	260	195	0.012	0.043	0.030

SDKN 42 AETN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.018	0.013	625	1085	820	0.020	0.276	0.120
	Low Alloy	200	0.006	0.014	0.010	490	785	640	0.020	0.276	0.120
	High Alloy	220	0.005	0.013	0.009	295	490	395	0.020	0.197	0.090
K	Grey Cast Iron	140	0.007	0.018	0.013	490	785	640	0.020	0.276	0.120
H	Hardened material	45HRc	0.004	0.009	0.007	130	260	195	0.020	0.098	0.060

SDKN 53 AETN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.017	0.012	625	1085	820	0.020	0.354	0.160
	Low Alloy	200	0.006	0.013	0.010	490	785	640	0.020	0.354	0.160
	High Alloy	220	0.005	0.012	0.008	295	490	395	0.020	0.256	0.120
K	Grey Cast Iron	140	0.007	0.017	0.012	490	785	640	0.020	0.354	0.160
H	Hardened material	45HRc	0.004	0.009	0.007	130	260	195	0.020	0.126	0.080



SEKN 42 AFTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.018	0.013	625	1085	820	0.020	0.276	0.120
	Low Alloy	200	0.006	0.014	0.010	490	785	640	0.020	0.276	0.120
	High Alloy	220	0.005	0.013	0.009	295	490	395	0.020	0.197	0.090
M	Austenitic	190	0.006	0.013	0.009	625	820	720	0.020	0.276	0.120
K	Grey Cast Iron	140	0.007	0.018	0.013	490	785	640	0.020	0.276	0.120
S	Heat resistant and super alloys	240	0.004	0.010	0.007	80	150	115	0.020	0.197	0.090
H	Hardened material	45HRc	0.004	0.010	0.007	130	260	195	0.020	0.098	0.040

SEKR 42 AFTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.018	0.013	625	1085	820	0.020	0.276	0.120
	Low Alloy	200	0.006	0.014	0.010	490	785	640	0.020	0.276	0.120
	High Alloy	220	0.005	0.013	0.009	295	490	395	0.020	0.197	0.090
M	Austenitic	190	0.006	0.013	0.009	625	820	720	0.020	0.276	0.120
K	Grey Cast Iron	140	0.007	0.018	0.013	490	785	640	0.020	0.276	0.120
S	Heat resistant and super alloys	240	0.005	0.010	0.007	80	150	115	0.020	0.197	0.090
H	Hardened material	45HRc	0.004	0.010	0.007	130	260	195	0.020	0.098	0.060

SEKT 1204 AFTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.018	0.012	625	1085	820	0.020	0.276	0.120
	Low Alloy	200	0.006	0.014	0.010	490	785	655	0.020	0.276	0.120
	High Alloy	220	0.005	0.013	0.009	295	490	395	0.020	0.197	0.080
M	Austenitic	190	0.006	0.013	0.010	625	820	720	0.020	0.276	0.120
K	Grey Cast Iron	140	0.007	0.018	0.012	490	785	655	0.020	0.276	0.120
S	Heat resistant and super alloys	240	0.005	0.010	0.007	80	150	115	0.020	0.197	0.090
H	Hardened material	45HRc	0.004	0.010	0.007	130	260	195	0.020	0.098	0.060

SEKT 12T3 AGTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.018	0.012	625	1085	820	0.020	0.276	0.120
	Low Alloy	200	0.006	0.014	0.010	490	785	655	0.020	0.276	0.120
	High Alloy	220	0.005	0.013	0.009	295	490	395	0.020	0.197	0.080
M	Austenitic	190	0.006	0.013	0.010	625	820	720	0.020	0.276	0.120
K	Grey Cast Iron	140	0.007	0.018	0.012	490	785	655	0.020	0.276	0.120
S	Heat resistant and super alloys	240	0.005	0.010	0.007	80	150	115	0.020	0.197	0.090
H	Hardened material	45HRc	0.004	0.010	0.007	130	260	195	0.020	0.098	0.060

SPKN 42 EDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.017	0.012	625	1085	820	0.020	0.276	0.120
	Low Alloy	200	0.006	0.013	0.010	490	785	655	0.020	0.276	0.120
	High Alloy	220	0.005	0.012	0.008	295	490	395	0.020	0.197	0.100
K	Grey Cast Iron	140	0.007	0.017	0.012	490	785	655	0.020	0.276	0.120
H	Hardened material	45HRc	0.004	0.009	0.007	130	260	195	0.020	0.098	0.060

SPKN 53 EDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.017	0.012	625	1085	855	0.020	0.354	0.160
	Low Alloy	200	0.006	0.013	0.010	490	785	640	0.020	0.354	0.160
	High Alloy	220	0.005	0.012	0.008	295	490	395	0.020	0.256	0.120
K	Grey Cast Iron	140	0.007	0.017	0.012	490	785	640	0.020	0.354	0.160
H	Hardened material	45HRc	0.004	0.009	0.007	130	260	195	0.020	0.126	0.080



SPKR 42 EDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.015	0.010	625	1085	820	0.020	0.276	0.120
	Low Alloy	200	0.006	0.012	0.008	490	785	655	0.020	0.276	0.120
	High Alloy	220	0.005	0.010	0.007	295	490	395	0.020	0.197	0.100
M	Austenitic	190	0.006	0.010	0.008	625	820	720	0.020	0.276	0.120
K	Grey Cast Iron	140	0.007	0.015	0.012	490	785	655	0.020	0.276	0.120
S	Heat resistant and super alloys	240	0.005	0.009	0.007	80	150	115	0.020	0.197	0.090
H	Hardened material	45HRc	0.004	0.009	0.006	130	260	195	0.020	0.098	0.060

TPKN 32 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.006	0.011	0.008	625	1085	855	0.020	0.472	0.120
	Low Alloy	200	0.005	0.008	0.006	490	785	640	0.020	0.472	0.120
	High Alloy	220	0.004	0.007	0.006	295	490	395	0.020	0.339	0.100
K	Grey Cast Iron	140	0.006	0.011	0.008	490	785	640	0.020	0.472	0.120
H	Hardened material	45HRc	0.003	0.006	0.005	130	260	195	0.020	0.169	0.060

TPKN 43 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.006	0.011	0.008	625	1085	855	0.020	0.709	0.160
	Low Alloy	200	0.006	0.008	0.007	490	785	640	0.020	0.709	0.160
	High Alloy	220	0.004	0.007	0.006	295	490	395	0.020	0.508	0.120
K	Grey Cast Iron	140	0.006	0.011	0.008	490	785	640	0.020	0.709	0.160
H	Hardened material	45HRc	0.004	0.006	0.005	130	260	195	0.020	0.252	0.080

TPKR 32 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.006	0.009	0.007	625	1085	855	0.020	0.472	0.120
	Low Alloy	200	0.006	0.007	0.006	490	785	640	0.020	0.472	0.120
	High Alloy	220	0.004	0.006	0.005	295	490	395	0.020	0.339	0.100
M	Austenitic	190	0.006	0.006	0.006	625	820	720	0.020	0.472	0.120
K	Grey Cast Iron	140	0.006	0.009	0.007	490	785	640	0.020	0.472	0.120
S	Heat resistant and super alloys	240	0.004	0.005	0.005	80	150	115	0.020	0.339	0.090
H	Hardened material	45HRc	0.004	0.005	0.004	130	260	195	0.020	0.134	0.060

TPKR 43 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (Inch/Tooth)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.006	0.009	0.007	625	1085	855	0.020	0.709	0.160
	Low Alloy	200	0.006	0.007	0.006	490	785	640	0.020	0.709	0.160
	High Alloy	220	0.004	0.006	0.005	295	490	395	0.020	0.508	0.120
M	Austenitic	190	0.006	0.006	0.006	625	820	720	0.020	0.709	0.160
K	Grey Cast Iron	140	0.006	0.009	0.007	490	785	640	0.020	0.709	0.160
S	Heat resistant and super alloys	240	0.004	0.005	0.005	80	150	115	0.020	0.508	0.120
H	Hardened material	45HRc	0.004	0.005	0.004	130	260	195	0.020	0.252	0.080