E520B Application Guide – Speed & Feed (inch)

ISO Code	Work Material Hardness	Type of Cut	Axial DOC	Radial DOC	No. of Flutes	Speed (SFM)	Feed (Inches per Tooth) 1/8	1/4	3/8	1/2
P	≤ 48 HRC	Rough	.2 x D	.2 x D	2	400	.0013	.0025	.0038	.0050
		Finish	.02 x D	.02 x D	2	275	.0015	.0030	.0045	.0060
H	49 to 57 HRC	Rough	.2 x D	.2 x D	2	375	.0008	.0017	.0025	.0033
		Finish	.02 x D	.02 x D	2	250	.0010	.0020	.0030	.0040
	58 to 62 HRC	Rough	.1 x D	.1 x D	2	250	.0007	.0014	.0021	.0028
		Finish	.01 x D	.01 x D	2	150	.0005	.0011	.0016	.0021

≈ Approximately Equals
≤ Less Than or Equal To
≥ Greater Than or Equal To
× Multiply
< Less Than
> Greater Than
= Equals