




M725/M726 Application Guide – Speed & Feed (inch)

		INCH								METRIC						
	No. of Flutes	Type of Cut	Tool Dia.	Axial Max	Radial Max	Speed				Tool Dia.	Axial Max	Radial Max	Speed			
						(SFM)	RPM	IPT	IPM				(M/Min)	RPM	MMPT	MM/Min
	5	Rough Rough < 10,000 Finish	1/8	.1250	.0075	350	10,696	.00035	18.7	3.0	3.0	.18	106	11,318	.0089	5039
				.1250	.0075	325	9,932	.00035	17.4		94	9,973	.0089	443		
				.2500	.001	300	9,168	.00030	13.7		91	9,701	.0075	363		
	5	Rough Finish	3/16	.1875	.0130	250	5,093	.00070	17.8	4.0	4.0	.275	64	5,093	.0180	458
				.3750	.0015	300	6,112	.00040	12.2		91	7,241	.0097	351		
	6	Rough Finish	1/4	.2500	.0150	400	6,112	.00100	36.6	5.0	5.0	.345	80	5,093	.0200	509
				.5000	.0020	300	4,584	.00050	13.8		91	5,793	.0107	309		
	6	Rough Finish	5/16	.3125	.0220	400	4,890	.00125	36.6	6.0	6.0	.380	122	6,472	.0254	986
				.6250	.0020	300	3,667	.00060	13.2		91	4,828	.0127	367		
	6	Rough Finish	3/8	.3750	.0300	400	4,074	.00150	36.6	8.0	8.0	.558	121	4,814	.0330	953
.7500				.0030	300	3,056	.00070	12.8	91		3,621	.0152	330			
6	Rough Finish	1/2	.5000	.0400	400	3,056	.00200	36.6	10.0	10.0	.800	121	3,851	.0400	924	
			1.000	.0030	300	2,292	.00100	13.7		91	2,897	.0200	347			
6	Rough Finish	5/8	.6250	.0500	400	2,445	.00250	36.6	12.0	12.0	.960	121	3,210	.0480	924	
			1.250	.0050	300	1,833	.00130	14.3		91	2,414	.0240	347			
6	Rough Finish	3/4	.750	.0600	400	2,037	.00300	36.6	16.0	16.0	1.270	121	2,407	.0635	917	
			1.500	.0050	300	1,528	.00150	13.7		91	1,810	.0330	358			
6	Rough Finish	1	1.000	.0800	400	1,528	.00400	36.6	20.0	20.0	1.524	121	1,926	.0760	878	
			2.000	.0080	300	1,146	.00200	13.7		91	1,448	.0380	330			
	5	Rough Rough < 10,000 Finish Finish < 10,000	1/8	.1250	.010	500	15,280	.0006	45.8	3.0	3.0	.254	152	16,127	.0152	1225
				.1250	.010	325	9,932	.0006	29.8		94	9,973	.0152	758		
				.2500	.001	400	12,224	.0003	18.3		121	12,838	.0076	487		
				.2500	.001	325	9,932	.0003	14.9		94	9,973	.0076	379		
	5	Rough Rough < 10,000 Finish	3/16	.1875	.015	500	10,186	.0009	45.8	4.0	4.0	.320	152	12,095	.0192	1161
				.1875	.015	480	9,780	.0009	44.0		125	9,947	.0192	954		
	6	Rough Finish	1/4	.2500	.020	500	7,640	.0012	55.0	5.0	5.0	.400	152	9,676	.0239	1156
				.5000	.003	400	6,112	.0007	25.7		121	7,703	.0132	508		
	6	Rough Finish	5/16	.3125	.025	500	6,112	.0014	51.3	6.0	6.0	.480	152	8,064	.0305	1475
				.6250	.003	400	4,889	.0007	20.5		121	6,419	.0170	654		
6	Rough Finish	3/8	.7500	.030	500	5,093	.0017	52.0	8.0	8.0	.640	152	6,048	.0355	1288	
			.7500	.005	400	4,074	.0010	24.4		121	4,814	.0175	505			
6	Rough Finish	1/2	.5000	.040	500	3,820	.0023	52.7	10.0	10.0	.800	152	4,838	.0453	1315	
			1.0000	.007	400	3,056	.0014	25.6		121	3,851	.0266	614			
6	Rough Finish	5/8	.6250	.050	500	3,056	.0029	53.2	12.0	12.0	.970	152	4,032	.0552	1335	
			1.2500	.008	400	2,445	.0018	26.4		121	3,210	.0336	647			
6	Rough Finish	3/4	.7500	.060	500	2,547	.0034	52.0	16.0	16.0	1.280	152	3,024	.0736	1335	
			1.5000	.009	400	2,037	.0020	24.4		121	2,407	.0455	657			
6	Rough Finish	1	1.0000	.080	500	1,910	.0046	52.7	20.0	20.0	1.600	152	2,419	.0863	1252	
			2.0000	.010	400	1,528	.0023	21.0		121	1,926	.0508	587			
	5	Rough Rough < 10,000 Finish Finish < 10,000	1/8	.1250	.0100	600	18,336	.0010	91.7	3.0	3.0	.240	182	19,310	.0254	2452
				.1250	.0100	325	9,932	.0010	49.6		94	9,973	.0254	1266		
				.2500	.0015	450	13,752	.0005	34.4		137	14,536	.0127	923		
				.2500	.0015	325	9,932	.0005	24.8		94	9,973	.0127	633		
	5	Rough Rough < 10,000 Finish	3/16	.1875	.0150	600	12,224	.0013	79.5	4.0	4.0	.320	182	14,483	.0280	2027
				.1875	.0150	475	9,677	.0013	63.0		125	9,947	.0280	1392		
	6	Rough Rough < 10,000 Finish	1/4	.2500	.0250	600	9,168	.0020	110.0	5.0	5.0	.400	182	11,586	.0345	1998
				-	-	-	-	-	-		157	9,995	.0345	1724		
	6	Rough Finish	5/16	.3125	.0310	600	7,334	.0025	110.0	6.0	6.0	.600	183	9,708	.0510	2970
				.6250	.0030	500	6,112	.0013	47.6		152	8,064	.0254	1228		
6	Rough Finish	3/8	.3750	.0370	600	6,112	.0030	110.0	8.0	8.0	.800	183	7,281	.0635	2774	
			.7500	.0030	500	5,093	.0015	45.8		152	6,048	.0330	1197			
6	Rough Finish	1/2	.5000	.0500	600	4,584	.0040	110.0	10.0	10.0	1.000	183	5,825	.0800	2795	
			1.0000	.0050	500	3,820	.0020	45.8		152	4,838	.0400	1161			
6	Rough Finish	5/8	.6250	.0625	600	3,667	.0050	110.0	12.0	12.0	1.200	183	4,854	.0960	2795	
			1.2500	.0050	500	3,056	.0025	45.8		152	4,032	.0480	1161			
6	Rough Finish	3/4	.7500	.0750	600	3,056	.0060	110.0	16.0	16.0	1.600	183	3,641	.1270	2774	
			1.5000	.0050	500	2,546	.0030	45.8		152	3,024	.0635	1152			
6	Rough Finish	1	1.0000	.1000	600	2,292	.0080	110.0	20.0	20.0	2.000	183	2,912	.1524	2663	
			2.0000	.0070	500	1,910	.0040	45.8		152	2,419	.0762	1106			

D = Tool Diameter