

Recommended Cutting Speeds/Feeds

Recommended Cutting Speeds for Dapra DTB Cutters

		1018, 12L14, 1041, 1045	4140, 4150, 4340, H13, P20, A2, D2	4140, 4150, 4340, H13, P20, A2, D2 (40s Rc)	4140, 4150, 4340, H13, P20, A2, D2	303, 304 LOW 400 SERIES	316, 347, PH STAINLESS	GRAY, MALLEABLE, DUCTILE	AMPCO, WEARITE	INCONEL, WASPALOY, MONEL	Ti-6AL-4V	
		LOW-TO-MEDIUM CARBON STEELS	TOOL STEELS, HIGH-ALLOY STEELS (SOFT)	TOOL STEELS, HIGH-ALLOY STEELS (MID-HARDNESS)	TOOL STEELS, HIGH-ALLOY STEELS (HARDENED)	FREE MACHINING STAINLESS	TOUGHER STAINLESS	CAST IRONS	COPPER ALLOYS	HIGH-TEMP. ALLOYS	TITANIUM	
LOWER TEMPS >>	TOUGHEST Shock Resistance	DMK30-TCI	450-700	350-600	250-400		250-550	250-450	400-750	300-550		
		DMK30-GLH	550-800	450-700	250-400		300-600	300-550	500-800	400-600	50-120	120-180
		DMK30-HM	550-800	450-700	250-400		300-600	300-550	500-800	400-600	50-120	120-180
<< HIGHER TEMPS	MEDIUM Shock & Wear	DMP25-TCI	400-700	350-600	300-500			300-650 DUCTILE	300-600			
		DMP25-GLH	450-800	400-700	350-550	200-400			300-750 DUCTILE	400-650		
		DMP25-HM			350-550	200-400			300-750 DUCTILE	400-650		
<< HIGHER TEMPS	HARDEST Wear Resistance	DMK15-TCI	500-800	450-750	300-500	< 52 Rc 250-450		300-750 GRAY				
		DMK15-GLH	550-900	450-800	350-550	> 44 Rc 250-450		400-800 GRAY				
		DMK15-HM	550-900	450-800	350-550	> 44 Rc 250-450		400-800 GRAY				
1ST CHOICE GEOMETRY		T	T	T	T	D	D	T	D	D	D	
RECOMMENDED FPT RANGE		.005-.015"	.005-.012"	.005-.009"	.002-.006"	.004-.012"	.003-.010"	.005-.015"	.005-.012"	.002-.006"	.002-.006"	

** First choice grade shown in **bold text**.

The parameters provided are suggested operating parameters. Actual speeds and feeds will depend on many variables, such as rigidity, workpiece hardness, tool extension, machine accuracy, Depth of Cut, etc. Start at the middle of the SFM range and the low end of the FPT range. Next, increase FPT to optimize productivity and tool life. Higher SFM will provide higher output but may reduce tool life. Try different combinations to find the parameters that best suit your needs.

- The -TCI coatings are best suited for low-to-medium operating speeds (temperatures) and softer materials.
- The -GLH and -HM coatings are best suited for high operating speeds (temperatures) and harder materials.

