

Recommended Cutting Speeds/Feeds

Recommended Cutting Speeds for Dapra RHINO-FEED 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		
		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	250-450		250-450	400-750	400-600			
		DMK30-GLH	550-800	450-700	250-450		300-600	250-550	500-800	400-600	50-150	120-180
		DMK30-TS	550-800	450-700	250-450			250-550				
		DMK30-HM			250-450		300-600	250-550	500-800		50-150	120-180
	TOUGH Shock & Wear	DMK35-HM						250-500			50-150 INCONEL	
		DMK35-IN						250-500			50-150 INCONEL	
	MEDIUM Shock Resistance	DMK25-GLH	450-800	400-700			300-700	250-600	300-750	400-650	50-150	120-180
		DMK25-HM					300-700	250-600	300-750	400-650	50-150	120-180
MEDIUM Shock & Wear	DMP25-TCI	400-700	350-600					300-650 DUCTILE	400-600			
	DMP25-GLH	450-800	400-700	300-500	200-400			300-750 DUCTILE	400-600			
	DMP25-TS			300-500	200-400			300-750 DUCTILE				
	DMP25-HM			300-500	200-400			300-750 DUCTILE				
HIGHER TEMPS <<	HARDEST Wear Resistance	DMK15-TCI	400-800	450-750	250-450	> 42 Rc 250-450				300-750 GRAY		
		DMK15-GLH	550-900	450-800	300-500	> 42 Rc 250-450				400-800 GRAY		
		DMK15-TS			300-500							
		DMK15-HM			300-500	> 42 Rc 250-450				400-800 GRAY		
1ST CHOICE GEOMETRY		T/D	T/F	T	T	D	D	T/F	D	D	D	

NOTE: High-feed milling does a tremendous amount of work in a short period of time. This line's high production rate can create more heat than typical milling tools. Strong air blast is recommended (multiple lines if possible).

** 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 and -TS 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.

