

10mm Series Recommended Parameters

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Style	Edge	Grade	Coating	Speed / Feed / DOC	Low-Carbon Steel	Alloy Steel	Tool Steels	Medium Hardened Steel (36-48 Rc)	Hardened Steel (> 48 Rc)	Austenitic Stainless	Ferritic / Martensitic Stainless	Tough PH Stainless	Gray Cast Iron	Ductile / Malleable	Copper Alloys	Ni Co-Based Alloys	9 Series Inconel	Titanium		
RF-10	D	DMK30	TCI	Speed	450-700	350-600	300-500			250-500	350-600	250-450	400-750	300-600	400-600					
				Feed*	.015-.050	.015-.050	.015-.040			.015-.040	.015-.040	.010-.035	.015-.045	.015-.040	.015-.045					
				DOC	< 3xD	.020-.060	.020-.060	.020-.050			.010-.035	.015-.040	.010-.030	.015-.040	.015-.040	.015-.040				
			> 3xD	.010-.030	.010-.030	.010-.025			.010-.025	.010-.025	.010-.020	.010-.025	.010-.025	.010-.025	.010-.025					
			GLH / TS	Speed	550-800	450-700	350-550			250-550	400-700	250-500	500-800	450-700	400-600	50-150	35-90	120-180		
				Feed*	.015-.050	.015-.050	.015-.040			.015-.040	.015-.040	.010-.035	.015-.045	.015-.040	.015-.045	.008-.025	.008-.025	.010-.030		
				DOC	< 3xD	.020-.060	.020-.060	.020-.050			.010-.035	.015-.040	.010-.030	.015-.040	.015-.040	.015-.040	.010-.030	.010-.025	.010-.035	
			> 3xD	.010-.030	.010-.030	.010-.025			.010-.025	.010-.025	.010-.020	.010-.025	.010-.025	.010-.025	.010-.025	.010-.020	.010-.020	.010-.025		
			HM	Speed			350-550			250-550	400-700	250-500	500-800	450-700		50-150	35-90	120-180		
		Feed*				.015-.040			.015-.040	.015-.040	.010-.035	.015-.045	.015-.040		.008-.025	.008-.025	.010-.030			
		DOC		< 3xD		.020-.050			.010-.035	.015-.040	.010-.030	.015-.040	.015-.040		.010-.030	.010-.025	.010-.035			
		> 3xD			.010-.025			.010-.025	.010-.025	.010-.020	.010-.025	.010-.025		.010-.020	.010-.020	.010-.025				
		DMK35	HM	Speed									250-500				50-150	35-90	120-180	
				Feed*									.010-.035				.008-.025	.008-.025	.010-.030	
				DOC	< 3xD								.010-.030				.010-.030	.010-.025	.010-.035	
			> 3xD									.010-.020				.010-.020	.010-.020	.010-.025		
			IN	Speed										250-500				50-150	35-90	120-180
				Feed*										.010-.035				.008-.025	.008-.025	.010-.030
				DOC	< 3xD									.010-.030				.010-.030	.010-.025	.010-.035
			> 3xD										.010-.020				.010-.020	.010-.020	.010-.025	
			TS	Speed																120-180
		Feed*																	.010-.030	
		DOC		< 3xD															.010-.035	
		> 3xD																.010-.025		
DMK25	HM	Speed								250-500	350-600	250-450	400-750	300-600	400-600					
		Feed*								.015-.030	.015-.030	.010-.025	.015-.040	.015-.035	.015-.040					
		DOC	< 3xD							.015-.030	.015-.035	.015-.030	.015-.040	.015-.040	.015-.040					
	> 3xD								.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025						
	GLH / TS	Speed	450-800	400-700	300-550			250-550	400-700	250-500	500-800	450-700	400-700			400-700				
		Feed*	.015-.040	.015-.040	.015-.030			.015-.030	.015-.030	.010-.025	.015-.040	.015-.035	.015-.040							
		DOC	< 3xD	.015-.050	.015-.050	.015-.045			.015-.030	.015-.035	.015-.030	.015-.040	.015-.040	.015-.040						
	> 3xD	.010-.025	.010-.025	.010-.025			.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025								
	DMP25	TCI	Speed	400-700	350-650									400-750	300-600	400-600				
Feed*			.015-.040	.015-.040										.015-.040	.015-.035	.015-.040				
DOC			< 3xD	.020-.060	.020-.060									.015-.040	.015-.040	.015-.040				
> 3xD		.010-.030	.010-.030										.010-.025	.010-.025	.010-.025					
GLH / TS		Speed	450-800	400-700	300-550									500-800	450-700	400-700				
		Feed*	.015-.040	.015-.040	.015-.030									.015-.040	.015-.035	.015-.040				
		DOC	< 3xD	.020-.060	.020-.060	.020-.050								.015-.040	.015-.040	.015-.040				
> 3xD		.010-.030	.010-.030	.010-.025									.010-.025	.010-.025	.010-.025					
HM		Speed	450-800	400-700	300-550									500-800	450-700					
	Feed*	.015-.040	.015-.040	.015-.030									.015-.040	.015-.035						
	DOC	< 3xD	.020-.060	.020-.060	.020-.050								.015-.040	.015-.040						
> 3xD	.010-.030	.010-.030	.010-.025									.010-.025	.010-.025							

* Feed Rate Compensation for DOC:
 DOC < .035" Feed = 100%
 DOC > .035" Feed = 75%

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- › The parameters provided are suggested starting operating parameters.
- › See page IM-155 for insert grade and coating selection.

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Style	Edge	Grade	Coating	Speed / Feed / DOC	Low-Carbon Steel	Alloy Steel	Tool Steels	Medium Hardened Steel (36-48 Rc)	Hardened Steel (> 48 Rc)	Austenitic Stainless	Ferritic / Martensitic Stainless	Tough PH Stainless	Gray Cast Iron	Ductile / Malleable	Copper Alloys	Ni Co-Based Alloys	9 Series Inconel	Titanium			
RF-10	T	DMK30	TCI	Speed	450-700	350-600	300-500	250-450					400-750	300-600							
				Feed*	.020-.050	.020-.050	.020-.045	.020-.040				.020-.050	.020-.050								
				DOC	< 3xD	.015-.040	.015-.040	.015-.035	.010-.030				.015-.040	.015-.040							
			> 3xD	.010-.025	.010-.025	.010-.025	.010-.020				.010-.025	.010-.025									
			GLH / TS	Speed	550-800	450-700	350-550	250-450							500-800	450-700					
				Feed*	.020-.050	.020-.050	.020-.045	.020-.040					.020-.050	.020-.050							
		DOC		< 3xD	.015-.040	.015-.040	.015-.035	.010-.020				.015-.040	.015-.040								
		> 3xD	.010-.025	.010-.025	.010-.025	.010-.015					.010-.025	.010-.025									
		HM	Speed			350-550	250-450							500-800	450-700						
			Feed*				.020-.045	.020-.040						.020-.050	.020-.050						
			DOC	< 3xD			.015-.035	.010-.020						.015-.040	.015-.040						
		> 3xD				.010-.025	.010-.015						.010-.025	.010-.025							
	DMP25	TCI	GLH / TS	Speed	400-700	350-650								400-750	300-600						
				Feed*	.020-.050	.020-.050									.020-.050	.020-.045					
				DOC	< 3xD	.015-.040	.015-.040								.015-.040	.015-.040					
			> 3xD	.010-.025	.010-.025									.010-.025	.010-.025						
			HM	Speed	450-800	400-700	300-550	300-500	250-400						500-800	450-700					
				Feed*	.020-.050	.020-.050	.020-.045	.020-.040	.010-.025						.020-.050	.020-.045					
		DOC		< 3xD	.015-.040	.015-.040	.015-.035	.010-.025	.005-.020					.015-.040	.015-.040						
		> 3xD	.010-.025	.010-.025	.010-.025	.010-.015	.005-.015						.010-.025	.010-.025							
		DMK15	TCI	GLH / TS	Speed	450-800	400-700	300-600	300-500	250-450					450-800	300-750					
					Feed*	.020-.040	.020-.040	.020-.040	.015-.040	.010-.025						.020-.050	.020-.045				
					DOC	< 3xD	.015-.040	.015-.040	.015-.035	.010-.025	.005-.020					.015-.040	.015-.040				
			> 3xD	.010-.025	.010-.025	.010-.025	.010-.015	.005-.015						.010-.025	.010-.025						
HM	Speed		450-800	400-700	300-600	300-500	250-400						450-800	300-750							
	Feed*		.020-.050	.020-.050	.020-.040	.015-.040	.010-.025						.020-.050	.020-.045							
	DOC	< 3xD	.015-.040	.015-.040	.015-.035	.010-.025	.005-.020					.015-.040	.015-.040								
> 3xD	.010-.025	.010-.025	.010-.025	.010-.015	.005-.015						.010-.025	.010-.025									
F	DMK30	TCI	Speed	450-700	350-600	300-500	250-450						400-750	300-600							
			Feed*	.020-.055	.020-.055	.020-.050	.020-.040							.020-.050	.020-.045						
			DOC	< 3xD	.015-.040	.015-.040	.015-.035	.010-.030						.015-.040	.015-.040						
		> 3xD	.010-.025	.010-.025	.010-.025	.010-.020							.010-.025	.010-.025							
		GLH / TS	Speed	550-800	450-700	350-550	250-450							500-800	450-700						
			Feed*	.020-.055	.020-.055	.020-.050	.020-.040							.020-.050	.020-.045						
DOC	< 3xD		.015-.040	.015-.040	.015-.035	.010-.030						.015-.040	.015-.040								
> 3xD	.010-.025	.010-.025	.010-.025	.010-.020							.010-.025	.010-.025									

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