

12mm Series Recommended Parameters

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Style	Edge	Grade	Coating	Speed / Feed	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	Ni Co-Based Alloys	9 Series Inconel	Titanium	Copper Alloys		
DSS-1208 DSS-1216	D	DMK35	HM	Speed						250-500		250-500			55-90	35-65	120-180			
				Feed							.003-.007		.002-.006			.002-.005	.002-.004	.003-.006		
			IN	Speed								250-500		250-500			55-90	35-65	120-180	
				Feed								.003-.007		.002-.006			.002-.005	.002-.004	.003-.006	
			TS	Speed								250-500		250-500			55-90	35-65	120-180	
				Feed								.003-.007		.002-.006			.002-.005	.002-.004	.003-.006	
		DMK30	HM	Speed	700-1000	500-900	300-550					300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180	400-800
				Feed	.003-.008	.003-.007	.003-.007					.003-.007	.003-.008	.002-.006	.003-.009	.003-.008	.002-.005	.002-.004	.003-.006	.003-.008
			IN	Speed	700-1000	500-900	300-550					300-600	500-900	250-500			55-90	35-65	120-180	400-800
				Feed	.003-.008	.003-.007	.003-.007					.003-.007	.003-.008	.002-.006			.002-.005	.002-.004	.003-.006	.003-.008
			TS	Speed	700-1000	500-900	300-550					300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180	400-800
				Feed	.003-.008	.003-.007	.003-.007					.003-.007	.003-.008	.002-.006	.003-.009	.003-.008	.002-.005	.002-.004	.003-.006	.003-.008
	T	DMK30	HM	Speed	700-1000	500-800	250-550							600-1000	500-900					
				Feed	.004-.010	.004-.009	.004-.008								.004-.010	.004-.008				
			TS	Speed	700-1000	500-800	250-550								600-1000	500-900				
				Feed	.004-.010	.004-.009	.004-.008								.004-.010	.004-.008				
		DMP25	HM	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900				
				Feed	.004-.009	.004-.008	.004-.007	.003-.007							.004-.010	.004-.008				
TS	HM	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900						
		Feed	.004-.009	.004-.008	.004-.007	.003-.007							.004-.010	.004-.008						
DMK15	HM	HM	Speed	700-1200	500-900	350-650	300-500		250-450				700-1200	600-900						
			Feed	.004-.008	.004-.007	.003-.006	.003-.006				.002-.005			.004-.010	.004-.008					
	TS	HM	Speed	700-1200	500-900	350-650	300-500		250-450				700-1200	600-900						
			Feed	.004-.008	.004-.007	.003-.006	.003-.006				.002-.005			.004-.010	.004-.008					

- › **Bold text** indicates best choice for material shown.
- › The parameters provided are suggested starting operating parameters.
- › See page IM-155 for insert grade and coating selection.