

12mm Series Recommended Parameters

Continued on next page

Visit dapra.com/HFref for technical reference & application information



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-12	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-.050	.015-.050	.015-.050						
				DOC	< 3xD	.020-.060	.020-.060	.020-.050			.020-.050	.020-.060	.020-.050	.020-.060	.020-.060	.020-.060	.020-.060				
			> 3xD	.010-.030	.010-.030	.010-.025			.010-.025	.010-.030	.010-.025	.010-.030	.010-.030	.010-.030	.010-.030	.010-.030					
			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-.050	.015-.050	.015-.050	.008-.030	.008-.025	.010-.035			
				DOC	< 3xD	.020-.060	.020-.060	.020-.050			.020-.050	.020-.060	.020-.050	.020-.060	.020-.060	.020-.060	.010-.030	.010-.030	.010-.035		
			> 3xD	.010-.030	.010-.030	.010-.025			.010-.025	.010-.030	.010-.025	.010-.030	.010-.030	.010-.030	.010-.030	.010-.030					
			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-.050	.015-.050		.008-.030	.008-.025	.010-.035				
		DOC		< 3xD		.020-.050			.020-.050	.020-.060	.020-.050	.020-.060	.020-.060		.010-.030	.010-.030	.010-.035				
		> 3xD			.010-.025			.010-.025	.010-.030	.010-.025	.010-.030	.010-.030		.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-.035	
				DOC	< 3xD										.020-.050			.010-.030	.010-.030	.010-.035	
			> 3xD											.010-.025			.010-.020	.010-.020	.010-.025		
			IN	Speed											250-500				50-150	35-90	120-180
				Feed*											.010-.035				.008-.025	.008-.025	.010-.035
				DOC	< 3xD										.020-.050				.010-.030	.010-.030	.010-.035
			> 3xD											.010-.025				.010-.020	.010-.020	.010-.025	
			TS	Speed																	120-180
		Feed*																		.010-.035	
		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							.020-.030	.020-.035	.020-.030	.020-.050	.020-.050	.020-.060						
	> 3xD								.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.030							
	GLH / TS	Speed	450-800	400-700	300-550			250-550	400-700	250-500	500-800	450-700	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			.020-.030	.020-.035	.020-.030	.020-.050	.020-.050	.020-.060							
	> 3xD	.010-.025	.010-.025	.010-.025			.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.030								
	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									.020-.050	.020-.050	.020-.060					
> 3xD		.010-.030	.010-.030										.010-.025	.010-.025	.010-.030						
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								.020-.050	.020-.050	.020-.060					
> 3xD		.010-.030	.010-.030	.010-.025									.010-.025	.010-.025	.010-.030						
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								.020-.050	.020-.050							
> 3xD	.010-.030	.010-.030	.010-.025									.010-.025	.010-.025								

* Feed Rate Compensation for DOC:
 DOC < .050" Feed = 100%
 DOC > .050" Feed = 75%

- › **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.

12mm Series Recommended Parameters

Visit dapra.com/HFref for technical reference & application information



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-12	T	DMK30	TCI	Speed	450-700	350-600	300-500	250-450						400-750	300-600						
				Feed*	.020-.060	.020-.060	.020-.050	.020-.040								.020-.060	.020-.060				
				DOC	< 3xD	.020-.060	.020-.060	.020-.050	.015-.050							.020-.060	.020-.060				
			> 3xD	.015-.030	.015-.030	.015-.030	.015-.030								.010-.030	.010-.030					
			GLH / TS	Speed	550-800	450-700	350-550	250-450								500-800	450-700				
				Feed*	.020-.060	.020-.060	.020-.050	.020-.040								.020-.060	.020-.060				
		DOC		< 3xD	.020-.060	.020-.060	.020-.050	.015-.050							.020-.060	.020-.060					
		> 3xD	.015-.030	.015-.030	.015-.030	.015-.030								.010-.030	.010-.030						
		HM	Speed			350-550	250-450								500-800	450-700					
			Feed*			.020-.050	.020-.040								.020-.060	.020-.060					
			DOC	< 3xD		.020-.050	.015-.050								.020-.060	.020-.060					
		> 3xD			.015-.030	.015-.030								.010-.030	.010-.030						
	DMP25	TCI	GLH / TS	Speed	400-700	350-650									400-750	300-600					
				Feed*	.020-.060	.020-.060										.020-.060	.020-.060				
				DOC	< 3xD	.020-.060	.020-.060									.020-.060	.020-.060				
			> 3xD	.015-.030	.015-.030										.010-.030	.010-.030					
			HM	Speed	450-800	400-700	300-550	300-500	250-400							500-800	450-700				
				Feed*	.020-.060	.020-.060	.020-.050	.020-.040	.010-.030							.020-.060	.020-.060				
		DOC		< 3xD	.020-.060	.020-.060	.020-.050	.015-.050	.005-.030						.020-.060	.020-.060					
		> 3xD	.015-.030	.015-.030	.015-.030	.015-.030	.005-.020							.010-.030	.010-.030						
		DMK15	GLH / TS	Speed	450-800	400-700	300-600	300-500	250-450						500-800	450-700					
				Feed*	.020-.050	.020-.050	.020-.040	.015-.040	.010-.030							.020-.060	.020-.060				
				DOC	< 3xD	.020-.050	.020-.050	.020-.050	.015-.050	.005-.030						.020-.060	.020-.060				
			> 3xD	.015-.030	.015-.030	.015-.030	.015-.030	.005-.015							.010-.030	.010-.030					
HM	Speed		450-800	400-700	300-600	300-500	250-400							500-800	450-700						
	Feed*		.020-.050	.020-.050	.020-.040	.015-.040	.010-.030							.020-.060	.020-.060						
	DOC	< 3xD	.020-.050	.020-.050	.020-.050	.015-.050	.005-.030						.020-.060	.020-.060							
> 3xD	.015-.030	.015-.030	.015-.030	.015-.030	.005-.015							.010-.030	.010-.030								
F	DMK30	TCI	Speed	450-700	350-600	300-500	250-450							400-750	300-600						
			Feed*	.020-.065	.020-.065	.020-.060	.020-.045								.020-.065	.020-.065					
			DOC	< 3xD	.020-.060	.020-.060	.020-.050	.015-.050							.020-.060	.020-.060					
	> 3xD	.015-.030	.015-.030	.015-.030	.015-.030								.010-.030	.010-.030							
	GLH / TS	Speed	550-800	450-700	350-550	250-450								500-800	450-700						
		Feed*	.020-.065	.020-.065	.020-.060	.020-.045								.020-.065	.020-.065						
DOC		< 3xD	.020-.060	.020-.060	.020-.050	.015-.050							.020-.060	.020-.060							
> 3xD	.015-.030	.015-.030	.015-.030	.015-.030								.010-.030	.010-.030								

* Feed Rate Compensation for DOC:
 DOC < .050" Feed = 100%
 DOC > .050" Feed = 75%

- › **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.