

12mm Series Recommended Parameters

Continued on next page

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



Style	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	Aluminum Alloys / Non-Ferrous		
APET	DMP35	TCI	Speed	500-800	400-700	250-550						500-800	400-700							
			Feed	.004-.010	.004-.009	.004-.008								.004-.010	.004-.009					
		GLH	Speed	700-1000	500-800	250-550								600-1000	500-900					
			Feed	.004-.010	.004-.009	.004-.008								.004-.010	.004-.009					
		HM	Speed	700-1000	500-800	250-550								600-1000	500-900					
			Feed	.004-.010	.004-.009	.004-.008								.004-.010	.004-.009					
	DMP30	TCI	Speed	500-900	400-800	350-550	300-450						600-900	500-800						
			Feed	.004-.010	.004-.009	.004-.008	.003-.007							.004-.010	.004-.009					
		GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900					
			Feed	.004-.010	.004-.009	.004-.008	.003-.007							.004-.010	.004-.009					
		HM	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900					
			Feed	.004-.010	.004-.009	.004-.008	.003-.007							.004-.010	.004-.009					
DMK25	TCI	Speed	500-900	400-800	350-550	300-450						600-1000	600-900							
		Feed	.004-.008	.004-.007	.003-.006	.003-.006							.004-.010	.004-.009						
	GLH	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-.009						
	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-.009						

- › **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/SSref for technical reference & application information



Style	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	Aluminum Alloys / Non-Ferrous	
XPET	DMK35	HM	Speed						250-500		250-500			55-90	35-65	120-180			
			Feed						.003-.007		.003-.006				.002-.005	.002-.004	.003-.006		
		IN	Speed							300-600		250-500			55-90	35-65	120-180		
			Feed							.003-.007		.003-.006				.002-.005	.002-.004	.003-.006	
		TS	Speed							300-600		250-500			55-90	35-65	120-180		
			Feed							.003-.007		.003-.006				.002-.005	.002-.004	.003-.006	
	DMP35	TCI	Speed	500-800	400-700	250-450				300-500	400-800	250-450	500-800	400-700					400-900
			Feed	.003-.008	.003-.008	.003-.007				.003-.007	.003-.008	.002-.006	.003-.009	.003-.008					.003-.009
		GLH	Speed	700-1000	500-900	250-550				300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180		400-900
			Feed	.003-.008	.003-.008	.003-.007				.003-.007	.003-.008	.002-.006	.003-.009	.003-.008	.002-.005	.002-.004	.003-.006		.003-.009
		HM	Speed	700-1000	500-900	250-550				300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180		
			Feed	.003-.008	.003-.008	.003-.007				.003-.007	.003-.008	.002-.006	.003-.009	.003-.008	.002-.005	.002-.004	.003-.006		
	DMP30	TCI	Speed	500-900	400-800	350-550	300-450						500-900	500-800					
			Feed	.003-.008	.003-.008	.003-.007	.002-.006						.003-.009	.003-.008					
		GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900				
			Feed	.003-.008	.003-.008	.003-.007	.002-.006							.003-.009	.003-.008				
		HM	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900				
			Feed	.003-.008	.003-.008	.003-.007	.002-.006							.003-.009	.003-.008				
	DMK25	TCI	Speed										500-900	500-800				400-900	
			Feed										.003-.009	.003-.008				.003-.009	
		GLH	Speed										600-1000	500-900				400-900	1000+ (cast)
			Feed										.003-.009	.003-.008				.003-.009	.007-.015
		HM	Speed										600-1000	500-900					
			Feed										.003-.009	.003-.008					
XPET-ALU	DMK25	GLH	Speed															1500+	
			Feed															.010-.020	
		DL	Speed																1500+
			Feed																.010-.020
	Uncoated	Speed																1500+	
		Feed																.010-.020	
	PCD150	Diamond-Tipped	Speed																1500+
			Feed																.003-.015

- › **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.