

3/8" Series Recommended Cutting 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	Aluminum / Non-Ferrous		
RPMH-33	D	DMK30	TCI	Speed	500-800	400-700	250-450				300-500	400-800	250-450	500-800	400-700				400-900		
				Feed	.003-.015	.003-.015	.003-.012				.004-.012	.004-.015	.003-.012	.004-.020	.003-.015					.004-.015	
			GLH	Speed	700-1000	500-800	250-600					300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180	400-900	1200+ (cast)
				Feed	.003-.015	.003-.015	.003-.012					.004-.012	.004-.015	.003-.012	.004-.020	.003-.015	.002-.006	.002-.005	.003-.007	.004-.015	.007-.020
	T	DMK30	GLH	Speed	700-1000	500-800	250-600							600-1000	500-900						
				Feed	.003-.020	.003-.015	.003-.012								.004-.020	.003-.015					
			DMP25	TCI	Speed	500-900	400-800	350-550	300-450							500-800	400-700				
					Feed	.004-.020	.004-.015	.004-.012	.003-.012								.004-.020	.003-.015			
		DMK15	GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900					
				Feed	.004-.020	.004-.015	.004-.012	.003-.012								.004-.020	.003-.015				
			GLH	Speed	700-1200	500-900	350-650	300-500	250-450							600-1000	500-900				
				Feed	.004-.020	.004-.015	.004-.012	.003-.012	.003-.010							.004-.020	.003-.015				
RDCH-32	D	DMK15	Uncoated	Speed															1500+		
				Feed																.007-.020	
	T	DMK15	TCI	Speed	700-1200	500-900	350-650	300-500	250-450					600-1000	500-900						
				Feed	.004-.020	.004-.015	.004-.012	.003-.012	.003-.010						.004-.020	.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.