

# 6mm 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	Ni Co-Based Alloys	9 Series Inconel	Titanium		
DTM-06	T	DMK30	GLH	Speed	<b>550-800</b>	<b>400-700</b>	400-550						500-800	500-700					
				Feed*	<b>.020-.040</b>	<b>.020-.040</b>	.020-.035				.020-.040	.020-.040							
				DOC	< 3xD	<b>.015-.030</b>	<b>.015-.030</b>	.015-.030			.015-.030	.015-.030							
			> 3xD	<b>.010-.025</b>	<b>.010-.025</b>	.010-.020			.010-.025	.010-.025									
			HM	Speed	550-800	450-750	400-600								500-800	500-700			
				Feed*	.020-.040	.020-.040	.020-.035				.020-.040	.020-.040							
		DOC		< 3xD	.015-.030	.015-.030	.015-.030			.015-.030	.015-.030								
		> 3xD	.010-.025	.010-.025	.010-.020				.010-.025	.010-.025									
		DMP25	GLH	Speed	<b>550-800</b>	<b>400-700</b>	<b>400-550</b>	<b>300-500</b>		250-400					500-800	<b>500-700</b>			
				Feed*	<b>.020-.040</b>	<b>.020-.040</b>	<b>.020-.035</b>	<b>.015-.030</b>		.015-.030					.020-.040	<b>.020-.040</b>			
				DOC	< 3xD	<b>.015-.030</b>	<b>.015-.030</b>	<b>.015-.030</b>	<b>.010-.030</b>		.010-.020				.015-.030	<b>.015-.030</b>			
			> 3xD	<b>.010-.025</b>	<b>.010-.025</b>	<b>.010-.020</b>	<b>.010-.020</b>		.010-.015					.010-.025	<b>.010-.025</b>				
			HM	Speed	550-800	450-750	<b>400-600</b>	<b>300-500</b>		250-400					500-800	<b>500-700</b>			
				Feed*	.020-.040	.020-.040	<b>.020-.035</b>	<b>.015-.030</b>		.015-.030					.020-.040	<b>.020-.040</b>			
		DOC		< 3xD	.015-.030	.015-.030	<b>.015-.030</b>	<b>.010-.030</b>		.010-.020				.015-.030	<b>.015-.030</b>				
		> 3xD	.010-.025	.010-.025	<b>.010-.020</b>	<b>.010-.020</b>		.010-.015					.010-.025	<b>.010-.025</b>					
		DMK15	GLH	Speed	550-800	400-700	400-550	<b>300-500</b>		<b>250-400</b>					<b>500-800</b>	<b>500-700</b>			
				Feed*	.015-.035	.015-.035	.015-.030	<b>.015-.030</b>		<b>.015-.030</b>					<b>.020-.040</b>	<b>.020-.040</b>			
				DOC	< 3xD	.015-.030	.015-.030	.015-.030	<b>.010-.030</b>		<b>.010-.020</b>				<b>.015-.030</b>	<b>.015-.030</b>			
			> 3xD	.010-.025	.010-.025	.010-.020	<b>.010-.020</b>		<b>.010-.015</b>					<b>.010-.025</b>	<b>.010-.025</b>				
			HM	Speed	550-800	450-750	400-600	<b>300-500</b>		<b>250-400</b>					<b>500-800</b>	<b>500-700</b>			
				Feed*	.015-.035	.015-.035	.015-.030	<b>.015-.030</b>		<b>.015-.030</b>					<b>.020-.040</b>	<b>.020-.040</b>			
		DOC		< 3xD	.015-.030	.015-.030	.015-.030	<b>.010-.030</b>		<b>.010-.020</b>				<b>.015-.030</b>	<b>.015-.030</b>				
		> 3xD	.010-.025	.010-.025	.010-.020	<b>.010-.020</b>		<b>.010-.015</b>					<b>.010-.025</b>	<b>.010-.025</b>					

\* Feed Rate Compensation for DOC:  
 DOC < .030" Feed = 100%  
 DOC > .030" Feed = 75%  
 Max. DOC .040" Feed = 60%

- › **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.

## Feed per Tooth & Depth of Cut Comparison

(Typical parameters for Alloyed Steel)

Ap (DOC)

