

8mm 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	Copper Alloys	Ni Co-Based Alloys	9 Series Inconel	Titanium			
RF-08	D	DMK30	TCI	Speed	450-700	350-600	250-450				250-550	350-600	250-450	400-750	300-600	400-600					
				Feed*	.012-.032	.012-.032	.010-.030			.010-.030	.010-.030	.010-.025	.012-.032	.012-.032	.012-.032						
				DOC	< 3xD	.010-.025	.010-.025	.010-.025			.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025			
				> 3xD	.010-.015	.010-.015	.010-.015			.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015			
			GLH / TS	Speed	550-800	450-700	250-450	250-450				300-600	400-700	250-550	500-800	450-700	400-600	50-150	35-90	120-180	
				Feed*	.012-.032	.012-.032	.010-.030	.010-.025				.010-.030	.010-.030	.010-.025	.012-.032	.012-.032	.012-.032	.008-.020	.008-.020	.010-.030	
				DOC	< 3xD	.010-.025	.010-.025	.010-.025	.010-.020			.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.020	.010-.020	.010-.020	
				> 3xD	.010-.015	.010-.015	.010-.015	.010-.015			.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	
			HM	Speed			250-450	250-450				300-600	400-700	250-550	500-800	450-700		50-150	35-90	120-180	
		Feed*				.010-.030	.010-.025				.010-.030	.010-.030	.010-.025	.012-.032	.012-.032		.008-.020	.008-.020	.010-.030		
		DOC		< 3xD		.010-.025	.010-.020				.010-.025	.010-.025	.010-.025	.010-.025	.010-.025		.010-.020	.010-.020	.010-.020		
			> 3xD		.010-.015	.010-.015				.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015		.010-.015	.010-.015	.010-.015		
		DMK35	HM	Speed										250-500				50-150	35-90	120-180	
				Feed*										.010-.025				.008-.025	.008-.025	.010-.030	
				DOC	< 3xD									.010-.025				.010-.020	.010-.020	.010-.020	
				> 3xD									.010-.015				.010-.015	.010-.015	.010-.015		
			IN	Speed											250-500				50-150	35-90	120-180
				Feed*											.010-.025				.008-.025	.008-.025	.010-.030
				DOC	< 3xD										.010-.025				.010-.020	.010-.020	.010-.020
				> 3xD										.010-.015				.010-.015	.010-.015	.010-.015	
			TS	Speed																	120-180
		Feed*																		.010-.030	
		DOC		< 3xD																.010-.020	
			> 3xD																	.010-.015	
DMK25	HM	Speed								300-700	400-850	250-600	500-900	400-800	400-650						
		Feed*								.010-.030	.010-.030	.010-.030	.010-.030	.010-.030	.010-.030						
		DOC	< 3xD							.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025						
		> 3xD							.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015							
	GLH / TS	Speed	450-800	400-700	300-600					300-600	400-700	250-600	400-800	350-700	400-650						
		Feed*	.010-.030	.010-.030	.010-.030					.010-.030	.010-.030	.010-.030	.010-.030	.010-.030	.010-.030						
DOC		< 3xD	.010-.025	.010-.025	.010-.025				.010-.025	.010-.025	.010-.025	.010-.025	.010-.025	.010-.025							
	> 3xD	.010-.015	.010-.015	.010-.015				.010-.015	.010-.015	.010-.015	.010-.015	.010-.015	.010-.015								
DMP25	TCI	Speed	400-700	350-600									450-800	300-750	400-600						
		Feed*	.012-.032	.012-.032										.012-.032	.012-.032	.012-.032					
		DOC	< 3xD	.010-.025	.010-.025									.010-.025	.010-.025	.010-.025					
		> 3xD	.010-.015	.010-.015									.010-.015	.010-.015	.010-.015						
	GLH / TS	Speed	450-800	400-700	300-600	300-500	250-400							450-800	300-750	400-600					
		Feed*	.012-.032	.012-.032	.010-.030	.010-.025	.007-.020							.012-.032	.012-.032	.012-.032					
		DOC	< 3xD	.010-.025	.010-.025	.010-.025	.010-.020	.005-.015						.010-.025	.010-.025	.010-.025					
		> 3xD	.010-.015	.010-.015	.010-.015	.010-.015	.005-.010						.010-.015	.010-.015	.010-.015						
	HM	Speed	450-800	400-700	300-600	300-500	250-400							450-800	300-750						
Feed*		.012-.032	.012-.032	.010-.030	.010-.025	.007-.020							.012-.032	.012-.032							
DOC		< 3xD	.010-.025	.010-.025	.010-.025	.010-.020	.005-.015						.010-.025	.010-.025							
	> 3xD	.010-.015	.010-.015	.010-.015	.010-.015	.005-.010						.010-.015	.010-.015								

* Feed Rate Compensation for DOC:
 DOC < .025" Feed = 100%
 DOC > .025" 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.