IPT7/IPC7 Application Guide – Speed & Feed (inch)

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	No. of Flutes	Speed (SFM)	Feed (Inches per Tooth) 3/16	1/4	3/8	1/2	5/8	3/4	1
K	Gray ASTM-A48 Class 20, 25, 30, 35 & 40	Peripheral - HEM	≤ 3 x D	.1 x D	7	400	.0027	.0036	.0054	.0072	.0090	.0108	.0144
		Peripheral - HEM	> 3 x D - 4 x D	.08 x D	7	400	.0024	.0032	.0049	.0065	.0081	.0097	.0130
		Peripheral - HEM	> 4 x D - 5 x D	.08 x D	7	390	.0022	.0029	.0043	.0058	.0072	.0086	.0115
		Finish	3 x D	.015 x D	7	450	.0010	.0013	.0020	.0026	.0033	.0039	.0052
	Cast Iron Malleable	Peripheral - HEM	≤ 3 x D	.08 x D	7	390	.0022	.0029	.0044	.0058	.0073	.0087	.0116
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	390	.0020	.0026	.0039	.0052	.0065	.0078	.0104
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	375	.0017	.0023	.0035	.0046	.0058	.0070	.0093
		Finish	3 x D	.015 x D	7	350	.0008	.0011	.0016	.0021	.0026	.0032	.0042
P	Low Carbon Steels ≤ 38 Rc 1018, 1020, 12L14, 5120, 8620	Peripheral - HEM	≤ 3 x D	.08 x D	7	485	.0028	.0038	.0056	.0075	.0094	.0113	.0150
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	485	.0025	.0034	.0051	.0068	.0084	.0101	.0135
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	465	.0023	.0030	.0045	.0060	.0075	.0090	.0120
		Finish	3 x D	.015 x D	7	420	.0011	.0014	.0021	.0028	.0035	.0042	.0056
	Medium Carbon Steels ≤ 48 HRC 1045, 4140, 4340, 5140	Peripheral - HEM	≤ 3 x D	.08 x D	7	450	.0027	.0036	.0053	.0071	.0089	.0107	.0142
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	450	.0024	.0032	.0048	.0064	.0080	.0096	.0128
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	425	.0021	.0028	.0043	.0057	.0071	.0085	.0114
		Finish	3 x D	.015 x D	7	390	.0009	.0013	.0019	.0025	.0031	.0038	.0050
	Tool and Die Steels ≤ 48 Rc A2, D2, O1, S7, P20, H13	Peripheral - HEM	≤ 3 x D	.08 x D	7	420	.0024	.0032	.0048	.0064	.0080	.0096	.0128
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	420	.0022	.0029	.0043	.0058	.0072	.0086	.0115
		Peripheral - HEM	> 4 - 5 xD	.08 x D	7	395	.0019	.0026	.0038	.0051	.0064	.0077	.0102
		Finish	3 x D	.015 x D	7	365	.0008	.0011	.0016	.0021	.0026	.0032	.0042
M	Martensitic & Ferritic Stainless Steels 410, 416, 440	Peripheral - HEM	≤ 3 x D	.08 x D	7	450	.0028	.0038	.0056	.0075	.0094	.0113	.0150
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	450	.0025	.0034	.0051	.0068	.0084	.0101	.0135
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	425	.0023	.0030	.0045	.0060	.0075	.0090	.0120
		Finish	3 x D	.015 x D	7	390	.0009	.0013	.0019	.0025	.0031	.0038	.0050
	Austenitic Stainless Steels, FeNi Alloys 303, 304, 316, Invar, Kovar	Peripheral - HEM	≤ 3 x D	.08 x D	7	450	.0024	.0032	.0048	.0064	.0080	.0096	.0128
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	440	.0022	.0029	.0043	.0058	.0072	.0086	.0115
		Peripheral - HEM	> 4 - 5 x D	.07 x D	7	425	.0019	.0026	.0038	.0051	.0064	.0077	.0102
		Finish	3 x D	.015 x D	7	390	.0009	.0012	.0018	.0024	.0030	.0036	.0048
	Precipitation Hardening Stainless Steels 17-4, 15-5	Peripheral - HEM	≤ 3 x D	.08 x D	7	440	.0023	.0031	.0047	.0062	.0078	.0093	.0124
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	440	.0021	.0028	.0042	.0056	.0070	.0084	.0112
		Peripheral - HEM	> 4 - 5 x D	.07 x D	7	415	.0019	.0025	.0037	.0050	.0062	.0074	.0099
		Finish	3 x D	.015 x D	7	380	.0008	.0010	.0015	.0020	.0025	.0030	.0040
S	Titanium Alloys 6Al-4V, 6-2-4	Peripheral - HEM	≤ 3 x D	.1 x D	7	405	.0015	.0021	.0031	.0041	.0051	.0062	.0082
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	405	.0014	.0018	.0028	.0037	.0046	.0055	.0074
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	390	.0012	.0016	.0025	.0033	.0041	.0049	.0066
		Finish	3 x D	.015 x D	7	350	.0006	.0008	.0012	.0016	.0020	.0024	.0032
	Difficult-to-Machine Titanium Alloys 10-2-3 Precipitation Hardening Stainless Steel M 13-8	Peripheral - HEM	≤ 2.5 x D	.08 x D	7	335	.0015	.0020	.0030	.0040	.0050	.0060	.0080
		Peripheral - HEM	> 2.5 - 3.5 x D	.07 x D	7	325	.0014	.0018	.0027	.0036	.0045	.0054	.0072
		Peripheral - HEM	> 3.5 - 4 x D	.06 x D	7	305	.0012	.0016	.0024	.0032	.0040	.0048	.0064
		Finish	3 x D	.01 x D	7	290	.0005	.0007	.0011	.0014	.0018	.0021	.0028
	Hastalloy, Waspalloy	Peripheral - HEM	≤ 1.5 x D	.08 x D	7	100	.0035	.0047	.0071	.0094	.0118	.0141	.0188
		Peripheral - HEM	> 1.5 - 2.5 x D	.08 x D	7	95	.0032	.0042	.0063	.0085	.0106	.0127	.0169
		Peripheral - HEM	> 2.5 - 3.5 x D	.06 x D	7	85	.0028	.0038	.0056	.0075	.0094	.0113	.0150
		Finish	2 x D	.01 x D	7	90	.0019	.0025	.0038	.0050	.0063	.0075	.0100
	Inconel 718, Rene 88	Peripheral - HEM	≤ 1.5 x D	.07 x D	7	95	.0035	.0047	.0070	.0093	.0116	.0140	.0186
		Peripheral - HEM	> 1.5 - 2.5 x D	.06 x D	7	90	.0031	.0042	.0063	.0084	.0105	.0126	.0167
		Peripheral - HEM	> 2.5 - 3 x D	.06 x D	7	85	.0028	.0037	.0056	.0074	.0093	.0112	.0149
		Finish	2 x D	.01 x D	7	85	.0018	.0024	.0036	.0048	.0060	.0072	.0096

D = Tool Diameter HEM = High-efficiency machining (chip thinning calculations have already been applied to HEM parameters)

≈ Approximately Equals
≤ Less Than or Equal To
≥ Greater Than or Equal To
× Multiply
< Less Than
> Greater Than
= Equals

Common Machining Formulas

$$RPM = \frac{SFM \times 3.82}{D}$$

$$SFM = RPM \times D \times .262$$

$$IPM = RPM \times IPT \times Z$$

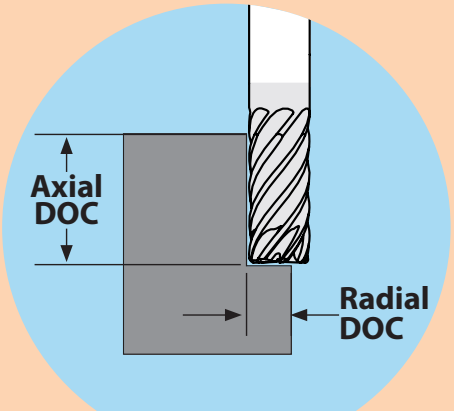
$$MRR = RDOC \times ADOC \times IPM$$

$$RPM = \frac{M/min \times 318.3}{D}$$

$$M/min = RPM \times D \times .00314$$

$$MMPM = RPM \times MMPT \times Z$$

$$MRR = RDOC \times ADOC \times MMPM$$



IPT7/IPC7 Application Guide – Speed & Feed (metric)

ISO Code	Work Material	Type of Cut	Axial DOC	Radial DOC	No. of Flutes	Speed (M/min)	Feed (MM per Tooth) 6.0	8.0	10.0	12.0	16.0	20.0	25.0
K	Gray ASTM-A48 Class 20, 25, 30, 35 & 40	Peripheral - HEM	≤ 3 x D	.1 x D	7	122	.0864	.1152	.1434	.1728	.2298	.2868	.3456
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	122	.0778	.1037	.1291	.1555	.2068	.2581	.3110
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	119	.0691	.0922	.1147	.1382	.1838	.2295	.2765
		Finish	3 x D	.015 x D	7	137	.0312	.0416	.0518	.0624	.0830	.1036	.1248
	Cast Iron Malleable	Peripheral - HEM	≤ 3 x D	.08 x D	7	119	.0696	.0928	.1155	.1392	.1851	.2311	.2784
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	119	.0626	.0835	.1040	.1253	.1666	.2079	.2505
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	114	.0557	.0742	.0924	.1114	.1481	.1848	.2227
		Finish	3 x D	.015 x D	7	107	.0252	.0336	.0418	.0504	.0670	.0837	.1008
P	Low Carbon Steels ≤ 38 Rc 1018, 1020, 12L14, 5120, 8620	Peripheral - HEM	≤ 3 x D	.08 x D	7	148	.0900	.1200	.1494	.1800	.2394	.2988	.3600
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	148	.0810	.1080	.1344	.1620	.2154	.2689	.3240
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	142	.0720	.0960	.1195	.1440	.1915	.2390	.2880
		Finish	3 x D	.015 x D	7	128	.0336	.0448	.0558	.0672	.0894	.1115	.1344
	Medium Carbon Steels ≤ 48 HRC 1045, 4140, 4340, 5140	Peripheral - HEM	≤ 3 x D	.08 x D	7	137	.0852	.1136	.1414	.1704	.2266	.2828	.3408
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	137	.0767	.1022	.1273	.1533	.2040	.2546	.3067
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	130	.0682	.0909	.1131	.1363	.1813	.2263	.2726
		Finish	3 x D	.015 x D	7	119	.0300	.0400	.0498	.0600	.0798	.0996	.1200
	Tool and Die Steels ≤ 48 Rc A2, D2, O1, S7, P20, H13	Peripheral - HEM	≤ 3 x D	.08 x D	7	128	.0768	.1024	.1275	.1536	.2043	.2550	.3072
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	128	.0691	.0922	.1147	.1382	.1838	.2295	.2765
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	120	.0614	.0819	.1020	.1229	.1634	.2040	.2457
		Finish	3 x D	.015 x D	7	111	.0252	.0336	.0418	.0504	.0670	.0837	.1008
M	Martensitic & Ferritic Stainless Steels 410, 416, 440	Peripheral - HEM	≤ 3 x D	.08 x D	7	137	.0900	.1200	.1494	.1800	.2394	.2988	.3600
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	137	.0810	.1080	.1344	.1620	.2154	.2689	.3240
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	130	.0720	.0960	.1195	.1440	.1915	.2390	.2880
		Finish	3 x D	.015 x D	7	119	.0300	.0400	.0498	.0600	.0798	.0996	.1200
	Austenitic Stainless Steels, FeNi Alloys 303, 304, 316, Invar, Kovar	Peripheral - HEM	≤ 3 x D	.08 x D	7	137	.0768	.1024	.1275	.1536	.2043	.2550	.3072
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	134	.0691	.0922	.1147	.1382	.1838	.2295	.2765
		Peripheral - HEM	> 4 - 5 x D	.07 x D	7	130	.0614	.0819	.1020	.1229	.1634	.2040	.2457
		Finish	3 x D	.015 x D	7	119	.0288	.0384	.0478	.0576	.0766	.0956	.1152
	Precipitation Hardening Stainless Steels 17-4, 15-5	Peripheral - HEM	≤ 3 x D	.08 x D	7	134	.0744	.0992	.1235	.1488	.1979	.2470	.2976
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	134	.0670	.0893	.1111	.1339	.1781	.2223	.2678
		Peripheral - HEM	> 4 - 5 x D	.07 x D	7	126	.0595	.0794	.0988	.1190	.1583	.1976	.2381
		Finish	3 x D	.015 x D	7	116	.0240	.0320	.0398	.0480	.0638	.0797	.0960
S	Titanium Alloys 6Al-4V, 6-2-4	Peripheral - HEM	≤ 3 x D	.1 x D	7	123	.0492	.0656	.0817	.0984	.1309	.1633	.1968
		Peripheral - HEM	> 3 - 4 x D	.08 x D	7	123	.0443	.0590	.0735	.0886	.1178	.1470	.1771
		Peripheral - HEM	> 4 - 5 x D	.08 x D	7	119	.0394	.0525	.0653	.0787	.1047	.1307	.1574
		Finish	3 x D	.015 x D	7	107	.0192	.0256	.0319	.0384	.0511	.0637	.0768
	Difficult-to-Machine Titanium Alloys 10-2-3 Precipitation Hardening Stainless Steel M 13-8	Peripheral - HEM	≤ 2.5 x D	.08 x D	7	102	.0480	.0640	.0797	.0960	.1277	.1593	.1920
		Peripheral - HEM	> 2.5 - 3.5 x D	.07 x D	7	99	.0432	.0576	.0717	.0864	.1149	.1434	.1728
		Peripheral - HEM	> 3.5 - 4 x D	.06 x D	7	93	.0384	.0512	.0637	.0768	.1021	.1275	.1536
		Finish	3 x D	.01 x D	7	88	.0168	.0224	.0279	.0336	.0447	.0558	.0672
	Hastalloy, Waspalloy	Peripheral - HEM	≤ 1.5 x D	.08 x D	7	30	.1128	.1504	.1872	.2256	.3000	.3745	.4512
		Peripheral - HEM	> 1.5 - 2.5 x D	.08 x D	7	29	.1015	.1353	.1685	.2030	.2700	.3370	.4060
		Peripheral - HEM	> 2.5 - 3.5 x D	.06 x D	7	26	.0902	.1203	.1498	.1805	.2400	.2996	.3609
		Finish	2 x D	.01 x D	7	27	.0600	.0800	.0996	.1200	.1596	.1992	.2400
	Inconel 718, Rene 88	Peripheral - HEM	≤ 1.5 x D	.07 x D	7	29	.1116	.1488	.1852	.2232	.2968	.3705	.4464
		Peripheral - HEM	> 1.5 - 2.5 x D	.06 x D	7	27	.1004	.1339	.1667	.2009	.2671	.3334	.4017
		Peripheral - HEM	> 2.5 - 3 x D	.06 x D	7	26	.0893	.1190	.1482	.1785	.2375	.2964	.3571
		Finish	2 x D	.01 x D	7	26	.0576	.0768	.0956	.1152	.1532	.1912	.2304

D = Tool Diameter HEM = High-efficiency machining (chip thinning calculations have already been applied to HEM parameters shown)

D Tool Diameter
Z Number of Flutes
RPM Revolutions per Minute
SFM Surface Feet per Minute
M/min Surface Meters per Minute
IPM Inches per Minute
MMPM Millimeters per Minute
IPT Inch per Tooth
MMPT Millimeters per Tooth
MRR Metal Removal Rate
RDOC Radial Depth of Cut
ADOC Axial Depth of Cut

Technical Resources

Information on tips and adjustments for the following milling operations can be found in our Technical Resources section beginning on page 134.

- HEM slotting
- Face milling
- Helical entry ramping
- Straight line ramping
- Long tool projection adjustments
- Ball nose milling adjustments
- Other helpful tips and calculations