

Speeds and Feeds for **1010** style end mills. Solid carbide 4 flute fine pitch rougher with TIALN coating. End Mills are made in the USA.

Hardness				Fee	d Per	Tooth	
Bhn	SFM	1/8"dia	1⁄4"	3/8"	1⁄2"	3⁄4"	1"
*	*	.*					
80-150	550	.0006	.0015	.0022	.004	.005	.0055
125-175	500	.0006	.0014	.002	.003	.004	.0045
200-280	400	.0005	.0012	.0018	.0025	.0035	.004
300-400	240	.0004	.001	.0016	.0022	.0032	.0035
120-175	500	.0005	.0014	.002	.0035	.005	.0052
160-200	375	.0005	.0014	.002	.0035	.005	.0052
180-260	200	.0004	.0013	.0018	.0032	.0045	.0046
160-200	230	.0005	.0015	.002	.0035	.005	.0052
320-380	300	.0005	.001	.0016	.0022	.0035	.004
280-320	60	.0002	.0006	.0014	.0018	.0028	.0032
120-160	400	.0006	.0015	.0022	.004	.005	.0055
*	*	*					
	Bhn * 80-150 125-175 200-280 300-400 120-175 160-200 180-260 160-200 320-380 280-320 120-160	Bhn SFM * * 80-150 550 125-175 500 200-280 400 300-400 240 120-175 500 120-175 500 160-200 375 180-260 200 320-380 300 280-320 60 120-160 400	Bhn SFM 1/8"dia * * .* 80-150 550 .0006 125-175 500 .0006 200-280 400 .0005 300-400 240 .0004 120-175 500 .0005 160-200 375 .0005 180-260 200 .0004 160-200 375 .0005 320-380 300 .0005 280-320 60 .0002 120-160 400 .0006	Bhn SFM 1/8"dia 1/4" * .* .* .* 80-150 550 .0006 .0015 125-175 500 .0006 .0014 200-280 400 .0005 .0012 300-400 240 .0004 .001 120-175 500 .0005 .0014 160-200 375 .0005 .0014 180-260 200 .0004 .0013 160-200 375 .0005 .0014 180-260 200 .0005 .0015 320-380 300 .0005 .0015 280-320 60 .0002 .0006 120-160 400 .0006 .0015	Bhn SFM 1/8"dia 1/4" 3/8" * * .* .* . . 80-150 550 .0006 .0015 .0022 125-175 500 .0006 .0014 .002 200-280 400 .0005 .0012 .0018 300-400 240 .0004 .001 .0016 120-175 500 .0005 .0014 .002 160-200 375 .0005 .0014 .002 180-260 200 .0004 .0013 .0018 160-200 375 .0005 .0014 .002 320-380 300 .0005 .0015 .0016 320-380 300 .0005 .0015 .0014 280-320 60 .0002 .0006 .0014 120-160 400 .0006 .0015 .0022	Bhn SFM 1/8"dia 1/4" 3/8" 1/2" * * .* .* Image: Constraint of the state of the	Bhn SFM 1/8"dia 1/4" 3/8" 1/2" 3/4" * * .* .* Image: Section of the section o

* please use our 3 flute rougher with high helix series 1011

Feed Per Tooth is based on.....

slotting depth of 1.0 x Cutting Diameter, for deeper slotting reduce feed and speed profiling with Axial depth up to 2x Cutting Diameter and Radial Depth of .25 x Cutting Diameter, when profiling less than .25 cutting diameter increase feed and speed

When using long flute length roughers reduce SFM and Feed Per Tooth accordingly. Normally SFM only 10-20%, but Feed Per Tooth should be reduced 30-60%.

6 guidelines for best cutting results

keep overall gage length short	keep tool concentricity low	climb milling is generally best
workpiece rigidity is important	avoid double cutting chips	avoid thermal shock

Note: Cutting speeds, feeds, and lubrication data are given as starting values only. Parameters should be varied to suite your particular conditions. MariTool is constantly improving products, tolerances, and reliability. As such, these speeds and feeds are subject to change without prior notice. Cutting tools may shatter and or produce dangerous fumes when being used. Appropriate protection is advised. Rev. A