



Speeds and Feeds for **2300** Series Keyseat Cutters.  
 Straight tooth M42 cobalt.  
 Keyseat cutters are made in the USA.

Material	Hardness	
	Bhn	SFM
Aluminum 2011,2024,6061,7075	*	<b>350</b>
Free Machining 12L14, 1215,11L17	80-150	<b>100</b>
Low Carbon Steel 1008, 1018, 1020	125-175	<b>70</b>
Medium Carbon Steel 4140, 8620	200-280	<b>60</b>
Tool Steel, H.S.S A2,D2,M2,M42	300-400	<b>50</b>
Cast Iron	120-175	<b>85</b>
Stainless Steel 300 Series	160-200	<b>60</b>
Stainless Steel 400 Series	180-260	<b>50</b>
Stainless Steel 15-5, 17-4	160-200	<b>40</b>
Titanium 6AL-4V	320-380	<b>20</b>
Inconel 625, 718	280-320	<b>20</b>
Copper, Bronze	120-160	<b>200</b>
Brass (360 half hard)	*	<b>300</b>

General starting point for feed per tooth is .002-.005 inches. Reduce FPT and SFM with deep slots and or long overhangs. Flood coolant is always helpful and helps clear the chips from the teeth.

### 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.