



Series 57	Fractional	Hardness	Ae x DC	Ap x DC	Vc (sfm)	DC • in			
						1/4	5/16	3/8	1/2
TOOL STEELS MOLD AND DIE STEEL 300M, 4340, 52100, HP-9-4-20, M50, A2, D2, H13, L2, M2, P20, S7, T15, W2	Slot	1	≤ 0.3	215	RPM	3285	2628	2190	1643
					Fz	0.0013	0.0019	0.0025	0.0031
					Feed (ipm)	26	30	33	31
	Profile	≤ 0.1	≤ 1.5	265	RPM	4049	3239	2699	2025
					Fz	0.0018	0.0026	0.0035	0.0044
					Feed (ipm)	44	51	57	53
	HSM	≤ 0.04	≤ 1.5	560	RPM	8557	6845	5705	4278
					Fz	0.0022	0.0033	0.0044	0.0055
					Feed (ipm)	113	136	151	141
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					Fz	0.0010	0.0015	0.0020	0.0025
					Feed (ipm)	11	13	15	14
	Profile	≤ 0.1	≤ 1.5	150	RPM	2292	1834	1528	1146
					Fz	0.0014	0.0021	0.0028	0.0035
					Feed (ipm)	19	23	26	24
	HSM	≤ 0.04	≤ 1.5	490	RPM	7487	5990	4991	3744
					Fz	0.0018	0.0026	0.0035	0.0044
					Feed (ipm)	81	93	105	99
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					Fz	0.0008	0.0011	0.0015	0.0019
					Feed (ipm)	5	5	6	6
	Profile	≤ 0.1	≤ 1.5	80	RPM	1222	978	815	611
					Fz	0.0011	0.0016	0.0021	0.0026
					Feed (ipm)	8	9	10	10
	HSM	≤ 0.04	≤ 1.5	250	RPM	3820	3056	2547	1910
					Fz	0.0013	0.0019	0.0025	0.0031
					Feed (ipm)	30	35	38	36

Bhn (Brinell) Hrc (Rockwell C) HSM (High Speed Machining)
 rpm = Vc x 3.82 / DC
 ipm = Fz x 6 x rpm
 reduce speed and feed for materials harder than listed
 reduce feed and Ae when finish milling (.02 x DC maximum)
 feed rates listed have chip thinning adjustments included where applicable
 refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)