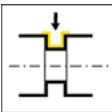
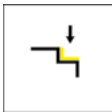
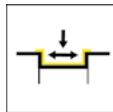
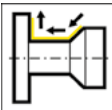
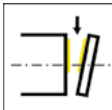
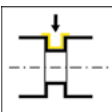
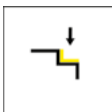
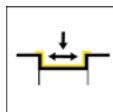
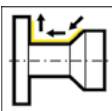
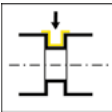
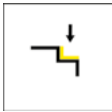
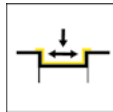
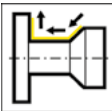
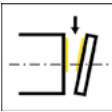
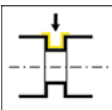
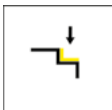
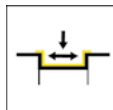
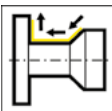
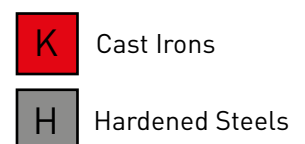
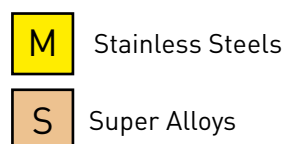
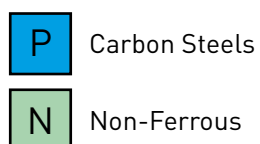
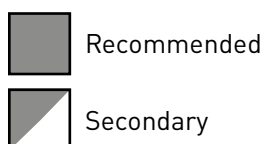


Geometry/Chipbreaker	Material	Feed Rate (in/rev), (mm/rev) Direction of cut	Operation
.3 	P M K N S H	↓ .0059-.0098 in/rev 0.15-0.25 mm/rev ↔ .0059-.0157 in/rev 0.15-0.40 mm/rev	    
.5 	P M K N S H	↓ .0039-.0177 in/rev 0.10-0.45 mm/rev ↔ .0059-.0236 in/rev 0.15-0.60 mm/rev	   
.A 	P M K N S H	↓ .0019-.0118 in/rev 0.05-0.30 mm/rev ↔ .0039-.0118 in/rev 0.10-0.30 mm/rev	   
.C 	P M K N S H	↓ .0008-.0039 in/rev 0.02-0.10 mm/rev	
.D 	P M K N S H	↓ .0011-.0059 in/rev 0.03-0.15 mm/rev ↔ .0019-.0078 in/rev 0.05-0.20 mm/rev	   



Geometry/Chipbreaker	Material	Feed Rate (in/rev), (mm/rev) Direction of cut	Operation
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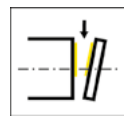
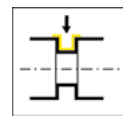
.E



P	M	K
N	S	H



.0031-.0011 in/rev
0.08-0.30 mm/rev



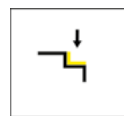
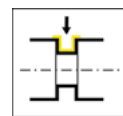
.EN



P	M	K
N	S	H



.0039-.0177 in/rev
0.10-0.45 mm/rev



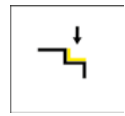
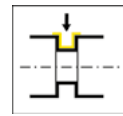
.EH



P	M	K
N	S	H



.0098-.0157 in/rev
0.25-0.40 mm/rev



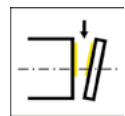
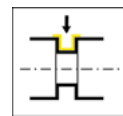
.F



P	M	K
N	S	H



.0011-.0059 in/rev
0.03-0.15 mm/rev



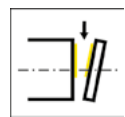
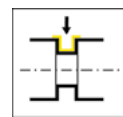
.FY



P	M	K
N	S	H



.0011-.0059 in/rev
0.03-0.15 mm/rev



Recommended



Carbon Steels



Stainless Steels



Cast Irons



Secondary



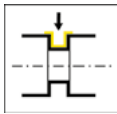
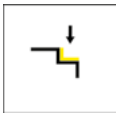
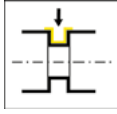
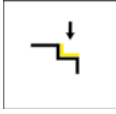
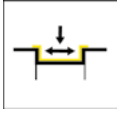
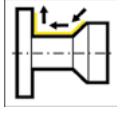
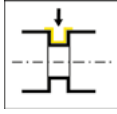
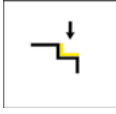
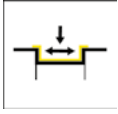
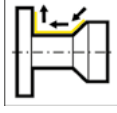
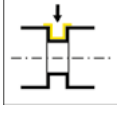
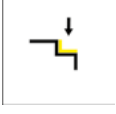
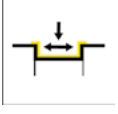
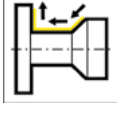
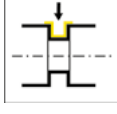
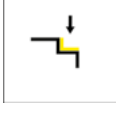
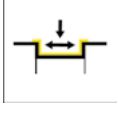
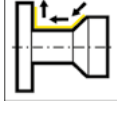
Non-Ferrous

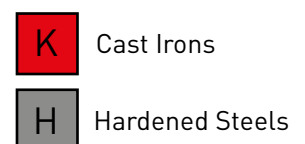
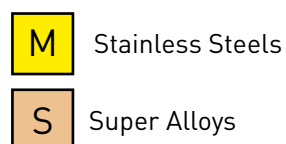
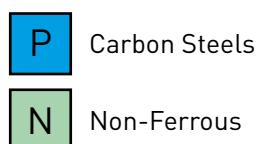
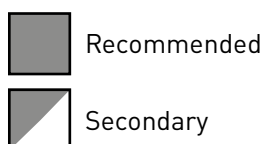


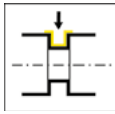
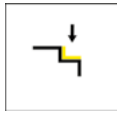
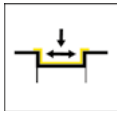
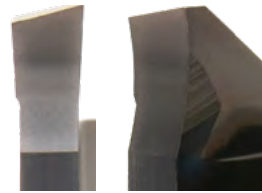
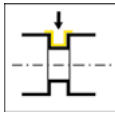
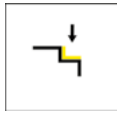
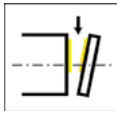
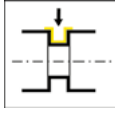
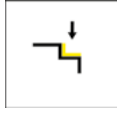
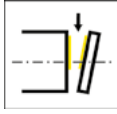
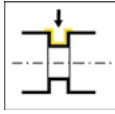
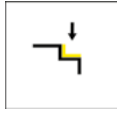
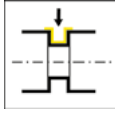
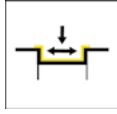
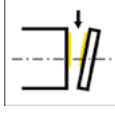
Super Alloys



Hardened Steels

Geometry/Chipbreaker	Material	Feed Rate (in/rev), (mm/rev) Direction of cut	Operation
.H 	P M K N S H	↓ .0059-.0098 in/rev 0.15-0.25 mm/rev ↔ .0039-.0098 in/rev 0.10-0.25 mm/rev	 
.K 	P M K N S H	↓ .0019-.0098 in/rev 0.05-0.25 mm/rev ↔ .0019-.0098 in/rev 0.05-0.25 mm/rev	   
.KF 	P M K N S H	↓ .0039-.0177 in/rev 0.10-0.45 mm/rev ↔ .0019-.0098 in/rev 0.05-0.25 mm/rev	   
.KR 	P M K N S H	↓ .0098-.0196 in/rev 0.25-0.5 mm/rev ↔ .0098-.0196 in/rev 0.25-0.5 mm/rev	   
.L 	P M K N S H	↓ .0039-.0086 in/rev 0.10-0.22 mm/rev ↔ .0019-.0078 in/rev 0.05-0.20 mm/rev	   



Geometry/Chipbreaker	Material	Feed Rate (in/rev), (mm/rev) Direction of cut	Operation
.ZG 	P M K N S H	↓ .0039-.0086 in/rev 0.10-0.22 mm/rev ↔ .0019-.0078 in/rev 0.05-0.20 mm/rev	   
.10 	P M K N S H	↓ .0019-.0059 in/rev 0.05-0.15 mm/rev	  
.20 	P M K N S H	↓ .0027-.0098 in/rev 0.07-0.25 mm/rev	  
.HR 	P M K N S H	↓ .0078-.0118 in/rev 0.20-0.30 mm/rev	 
.N 	P M K N S H	↓ .0019-.0098 in/rev 0.05-0.25 mm/rev ↔ .0019-.0098 in/rev 0.05-0.25 mm/rev	   



Recommended



Carbon Steels



Stainless Steels



Cast Irons



Secondary



Non-Ferrous



Super Alloys



Hardened Steels

Geometry/Chipbreaker		Material	Feed Rate (in/rev), (mm/rev) Direction of cut	Operation
.00		P M K N S H	↓ .0008-.0047 in/rev 0.02-0.12 mm/rev	
.1A		P M K N S H	↓ .0011-.0047 in/rev 0.03-0.12 mm/rev	
.M0		P M K N S H	↓ .0008-.0039 in/rev 0.02-0.10 mm/rev ↔ .0008-.0059 in/rev 0.02-0.15 mm/rev	
.M		P M K N S H	↓ .0008-.0047 in/rev 0.02-0.12 mm/rev	
.P		P M K N S H	↓ .0008-.0031 in/rev 0.02-0.08 mm/rev ↔ .0008-.0015 in/rev 0.02-0.04 mm/rev	

Recommended
 Secondary

P Carbon Steels
 N Non-Ferrous

M Stainless Steels
 S Super Alloys

K Cast Irons
 H Hardened Steels

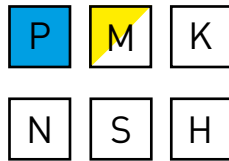
Geometry/Chipbreaker

Material

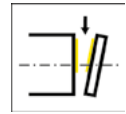
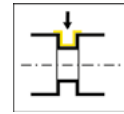
Feed Rate (in/rev), (mm/rev)
Direction of cut

Operation

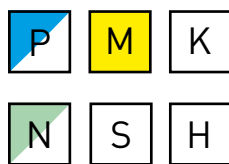
.V



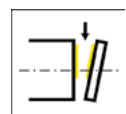
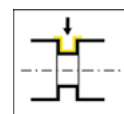
.0016-.0059 in/rev
0.04-0.15 mm/rev



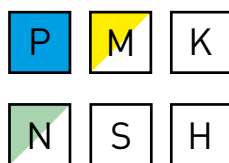
.3V



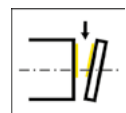
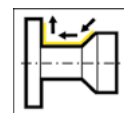
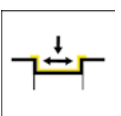
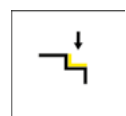
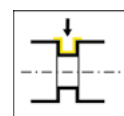
.0019-.0078 in/rev
0.05-0.20 mm/rev



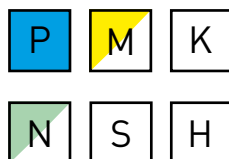
.FL



.0011-.0059 in/rev
0.03-0.15 mm/rev



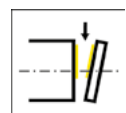
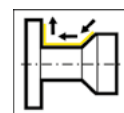
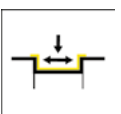
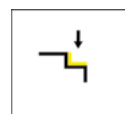
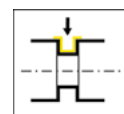
.DL



.0019-.0059 in/rev
0.05-0.15 mm/rev



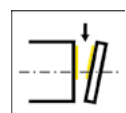
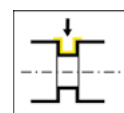
.0019-.0078 in/rev
0.05-0.20 mm/rev



.WA



.0027-.0098 in/rev
0.07-0.25 mm/rev



Recommended



Carbon Steels



Stainless Steels



Cast Irons



Secondary



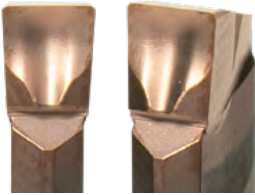
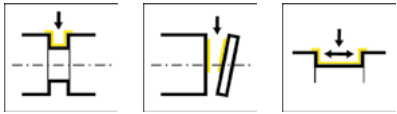
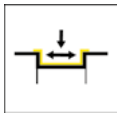
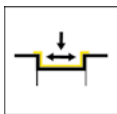
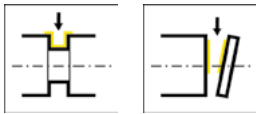
Non-Ferrous



Super Alloys



Hardened Steels

Geometry/Chipbreaker	Material	Feed Rate (in/rev), (mm/rev) Direction of cut	Operation
.WT 	P M K N S H	↓ .0024-.003 in/rev 0.06-0.08 mm/rev ↔ .0024-.003 in/rev 0.06-0.08 mm/rev	
.NC 	P M K N S H	↓ .0008-.0039 in/rev 0.02-0.10 mm/rev ↔ .0008-.0059 in/rev 0.02-0.15 mm/rev	
.FB 	P M K N S H	↓ .0008-.0039 in/rev 0.02-0.10 mm/rev ↔ .00006-.0027 in/rev 0.0015-0.07 mm/rev	
.S 	P M K N S H	↓ .0008-.003 in/rev 0.02-0.08 mm/rev	
.PT 	P M K N S H	↔ .0019-.0078 in/rev 0.05-0.2 mm/rev	