

FMT

ISO Standard	Materials	Cutting Speed m/min	Feed mm/tooth Cutting Diameter = D				
			Ø5	Ø6	Ø8	Ø10	Ø12
P	Low and Medium Carbon Steels < 0.55%C	100-250	0.03	0.06	0.07	0.08	0.09
	High Carbon Steels ≥ 0.55%C	110-180	0.03	0.05	0.06	0.07	0.08
	Alloy Steels, Treated Steels	90- 60	0.02	0.03	0.04	0.05	0.05
M	Stainless Steel - Free Cutting	60-160	0.03	0.04	0.05	0.06	0.06
	Stainless Steel - Austenitic	60-120	0.01	0.03	0.04	0.05	0.05
	Cast Steels	130-170	0.02	0.03	0.04	0.05	0.05
K	Cast Iron	70-150	0.04	0.06	0.07	0.08	0.09
N	Aluminum ≤ 12%Si, Copper	150-350	0.04	0.06	0.07	0.08	0.09
	Aluminum > 12%Si	100-250	0.03	0.03	0.04	0.05	0.05
	Synthetics, Duroplastics, Thermoplastics	100-400	0.06	0.08	0.10	0.11	0.12
S	Nickel Alloys, Titanium Alloys.	20- 80	0.02	0.03	0.03	0.03	0.03
H	Hardened Steel, 45-50HRc	60- 70	0.02	0.03	0.03	0.03	0.03