




List 410: Stub Length - 3 Flute - Regular Pitch

List 490: Multiple Flute - Regular Pitch - General Purpose - Center Hole

Side Milling

Hardness	<20 HRC		20-30 HRC		30-40 HRC		40-50 HRC		-										
Work Material	Medium Tensile Steels (up to 115x103 Lb/in ²) Mild Steel Forgings Cast Iron Brass and Bronze Copper		High Tensile Steels (115x103~145x103 Lb/in ²) Unalloyed Titanium Heat Resistant Ferritic Low Alloys		High Tensile Steels (145x103~200x103 Lb/in ²) Tool Steels Medium Strength Stainless Steels Titanium Alloys		Heat Resistant High Alloys High Strength Stainless Steels Titanium Alloys		Aluminum Alloyed Aluminum Plastics Woods										
Cutting Speed	80-100 SFM		60-75 SFM		40-55 SFM		26-40 SFM		195-330 SFM										
Depth of Cut	<table border="1"> <thead> <tr> <th>Dia</th> <th>aa</th> <th>ar</th> </tr> </thead> <tbody> <tr> <td>1/2 ≤ D ≤ 1-1/8</td> <td>1.5D</td> <td>0.5D</td> </tr> <tr> <td>1-1/4 ≤ D ≤ 2</td> <td>1D</td> <td>0.5D</td> </tr> </tbody> </table> 										Dia	aa	ar	1/2 ≤ D ≤ 1-1/8	1.5D	0.5D	1-1/4 ≤ D ≤ 2	1D	0.5D
											Dia	aa	ar						
1/2 ≤ D ≤ 1-1/8	1.5D	0.5D																	
1-1/4 ≤ D ≤ 2	1D	0.5D																	
Mill Dia.	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min									
1/4	1,320	2.6	1,000	1.6	750	1.0	500	0.6	4,000	11.1									
5/16	1,060	3.0	800	1.9	600	1.1	400	0.8	3,150	12.4									
3/8	950	3.1	710	2.0	530	1.0	355	0.8	2,800	13.0									
1/2	670	3.8	500	2.4	375	1.5	250	0.9	2,000	15.8									
5/8	600	4.8	400	2.6	300	1.6	200	1.0	1,600	17.6									
3/4	475	4.5	355	2.8	265	1.8	180	1.0	1,400	18.5									
7/8	375	4.5	280	2.8	212	1.8	140	1.0	1,120	18.8									
1	335	4.1	250	2.6	190	1.6	125	1.0	1,000	17.8									
1-1/8	300	4.0	224	2.5	170	1.6	112	0.9	900	16.9									
1-1/4	265	4.6	200	3.0	150	1.9	100	1.0	800	19.9									
1-1/2	212	4.1	160	2.6	118	1.6	80	1.0	630	17.6									
1-3/4	190	4.0	140	2.5	106	1.5	71	1.0	560	16.5									
2	170	3.5	125	2.3	95	1.4	63	0.9	500	14.8									