



PERFORMANCE YOU CAN TRUST, QUALITY YOU CAN MEASURE

# SFPM / Chipload Chart

Materials	Aluminum	Carbon Steels	Alloy Steel	Stainless			Cast Iron		High Temp Alloys			Tool Steels		Mold Steel	
				303	304, 304L, 316, 316L	410, 416, 420, 430F, 440C	13-8PH, 15-4PH, 16-6PH, 17-4PH	Gray	Ductile	Inconel 600 / 718, A286, Haynes	Pure Titanium	Wrought/ Cast 6AL4, ASTM 1, 2 & 3 Alpha - Beta	A2, S7, H1, H13		D2
SFPM <32RC	800-2000	200-450	150-300	150-350	200-450	80-250	250-450	120-350	70-120	140-220	140-200	90-140	250-450	150-250	
	SFM >32RC	100-250	80-200	80-200	100-250	90-125	130-300	80-140	40-90	90-160	90-160	80-120	100-160	80-160	
1/4"	S	.0014	.0012	.0013	.0012	.0012	.0012	.0012	.0008	.0012	.0012	.0008	.0008	.0010	
	HP	.0017	.0012	.0013	.0012	.0010	.0013	.0014	.0009	.0014	.0012	.0010	.0010	.0012	
	LP	.0019	.0012	.0013	.0012	.0013	.0013	.0015	.0012	.0014	.0014	.0012	.0015	.0013	
3/8"	S	.0018	.0016	.0016	.0015	.0015	.0015	.0018	.0014	.0016	.0015	.0015	.0012	.0015	
	HP	.0018	.0016	.0018	.0015	.0015	.0016	.0018	.0014	.0016	.0016	.0016	.0012	.0016	
	LP	.0025	.0022	.0022	.0016	.0016	.0016	.0018	.0015	.0022	.0018	.0018	.0015	.0018	
1/2"	S	.0030	.0025	.0032	.0030	.0028	.0028	.0030	.0022	.0025	.0025	.0026	.0020	.0025	
	HP	.0030	.0030	.0032	.0030	.0028	.0028	.0030	.0022	.0025	.0025	.0026	.0020	.0025	
	LP	.0120	.0035	.0035	.0035	.0038	.0035	.0038	.0040	.0025	.0030	.0030	.0025	.0030	
5/8"	S	.0035	.0030	.0030	.0030	.0030	.0030	.0035	.0025	.0035	.0030	.0030	.0025	.0030	
	HP	.0038	.0035	.0030	.0030	.0030	.0035	.0035	.0028	.0028	.0030	.0030	.0025	.0030	
	LP	.0150	.0040	.0040	.0040	.0040	.0040	.0044	.0030	.0040	.0038	.0038	.0030	.0035	
3/4"	S	.0040	.0040	.0040	.0035	.0035	.0035	.0040	.0028	.0040	.0038	.0038	.0032	.0035	
	HP	.0150	.0050	.0043	.0040	.0040	.0040	.0045	.0035	.0040	.0040	.0040	.0035	.0040	
	LP	.0200	.0060	.0050	.0045	.0040	.0040	.0045	.0040	.0050	.0045	.0050	.0045	.0050	
1"	S	.0100	.0040	.0040	.0040	.0040	.0040	.0050	.0038	.0050	.0042	.0042	.0040	.0045	
	HP	.0150	.0060	.0050	.0050	.0045	.0045	.0050	.0040	.0050	.0045	.0045	.0040	.0045	
	LP	.0200	.0070	.0065	.0060	.0060	.0060	.0070	.0055	.0070	.0060	.0060	.0050	.0055	
Stub and Regular Length				S = Slotting Axial Depth up to .5 X Diameter				HP = Heavy Peripheral Axial DOC = LOC Radial DOC = .5 X Diameter				LP = Light Profile Axial DOC = LOC Radial WOC = .15 X Diameter			
Medium Length				S = Slotting Not Recommended				HP = Heavy Peripheral Axial DOC = up to 1 X Diameter Radial DOC = .2 X Diameter				LP = Light Profile Axial DOC = up to 1.5 X Diameter Radial WOC = .1 X Diameter			