



Quinco Tool Products Speed & Feed Chart

High Speed/Cobalt Endmills		Feed (Inch/Tooth) End Mill Diameter							
Materials	Speed SFPM	1/8"	3/16"	1/4"	3/8"	1/2"	5/8"	3/4"	+1"
NONFERROUS MATERIALS									
Aluminum + Aluminum Alloys	500-1500	0.0010	0.0020	0.0020	0.0030	0.0040	0.0050	0.0060	0.0070
Copper	200-800	0.0010	0.0010	0.0020	0.0025	0.0030	0.0040	0.0040	0.0050
Copper Alloys	100-300	0.0010	0.0010	0.0020	0.0025	0.0030	0.0040	0.0040	0.0050
STAINLESS STEEL									
Martansitic	30-150	0.0001	0.0002	0.0005	0.0005	0.0010	0.0010	0.0030	0.0040
Austentic	30-150	0.0005	0.0005	0.0010	0.0010	0.0020	0.0020	0.0040	0.0060
Precipitation	30-150	0.0001	0.0002	0.0005	0.0010	0.0015	0.0020	0.0030	0.0040
HIGH TEMP ALLOYS									
Cobalt Base	5-25	0.0004	0.0005	0.0010	0.0010	0.0010	0.0010	0.0015	0.0020
Nickel Base	10-35	0.0005	0.0005	0.0010	0.0010	0.0020	0.0025	0.0030	0.0040
Iron Base	10-30	0.0005	0.0005	0.0010	0.0015	0.0020	0.0025	0.0030	0.0040
STEELS									
Low Alloy Steels Maraging	50-200	0.0005	0.0010	0.0150	0.0020	0.0030	0.0040	0.0050	0.0060
Medium Alloy Steels	50-250	0.0005	0.0005	0.0010	0.0020	0.0025	0.0035	0.0040	0.0050
High Alloy Steels Mold & Die	35-150	0.0005	0.0005	0.0010	0.0010	0.0010	0.0015	0.0020	0.0040
High Strength Steels	30-150	0.0005	0.0005	0.0010	0.0010	0.0010	0.0015	0.0020	0.0040
CAST IRON									
Ductile Iron	50-250	0.0005	0.0005	0.0010	0.0020	0.0025	0.0035	0.0040	0.0050
Cast Iron	50-250	0.0005	0.0005	0.0010	0.0020	0.0025	0.0035	0.0040	0.0050
TITANIUM									
Titanium Alloys	30-150	0.0005	0.0005	0.0005	0.0010	0.0010	0.0015	0.0020	0.0040

Carbide End Mills		Feed (Inch/Tooth) End Mill Diameter							
Materials	Speed SFPM	1/8"	3/16"	1/4"	3/8"	1/2"	5/8"	3/4"	+1"
NONFERROUS MATERIALS									
Aluminum + Aluminum Alloys	800-2000	0.0010	0.0020	0.0020	0.0030	0.0040	0.0050	0.0060	0.0070
Copper	800-1500	0.0010	0.0010	0.0020	0.0025	0.0030	0.0040	0.0040	0.0050
Copper Alloys	800-1000	0.0010	0.0010	0.0020	0.0025	0.0030	0.0040	0.0040	0.0050
Magnesium	1000	0.0010	0.0020	0.0020	0.0030	0.0040	0.0060	0.0080	0.0090
Plastics, Acrylics, Phenolics	200-600	0.0010	0.0020	0.0030	0.0040	0.0060	0.0080	0.0100	0.0150
Carbon, Graphites	200-400	0.0040	0.0040	0.0060	0.0080	0.0100	0.0100	0.0150	0.0200
STAINLESS STEEL									
Precipitation	80-250	0.0005	0.0005	0.0010	0.0010	0.0020	0.0020	0.0040	0.0060
Austentic	100-350	0.0001	0.0002	0.0005	0.0010	0.0015	0.0020	0.0030	0.0040
Martansitic	80-200	0.0001	0.0002	0.0005	0.0005	0.0010	0.0010	0.0030	0.0040
HIGH TEMP ALLOYS									
Cobalt Base	60-100	0.0004	0.0005	0.0010	0.0010	0.0010	0.0010	0.0015	0.0020
Nickel Base	45-100	0.0005	0.0005	0.0010	0.0010	0.0020	0.0025	0.0030	0.0040
Iron Base	80-100	0.0005	0.0005	0.0010	0.0015	0.0020	0.0025	0.0030	0.0040
STEELS									
High Strength Steels	50-250	0.0005	0.0005	0.0010	0.0010	0.0010	0.0015	0.0020	0.0040
High Alloy Steels Mold & Die	80-250	0.0005	0.0005	0.0010	0.0010	0.0010	0.0015	0.0020	0.0040
Medium Alloy Steels	150-350	0.0005	0.0005	0.0010	0.0020	0.0025	0.0035	0.0040	0.0050
Low Alloy Steels Maraging	100-300	0.0005	0.0010	0.0150	0.0020	0.0030	0.0040	0.0050	0.0060
CAST IRON									
Ductile Iron	100-400	0.0005	0.0010	0.0015	0.0020	0.0020	0.0030	0.0040	0.0060
Cast Iron	100-400	0.0005	0.0010	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080
TITANIUM									
Titanium Alloys	50-250	0.0005	0.0005	0.0005	0.0010	0.0010	0.0015	0.0020	0.0040

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