

Speeds and Feeds for MelBran Solid Carbide Endmills					
Material	SFM	Chip Load/tooth			
		3/8	1/2	5/8	3/4
Mild Steel > 32Rc	150-600 (325)	.0008-.002 (.001)	.001-.003 (.002)	.001-.0035 (.0025)	.001-.006 (.0035)
Alloy Steel <32Rc - 50Rc	60-300 (185)	.0005-.001 (.0007)	.0007-.0015 (.001)	.0007-.002 (.0015)	.0007-.003 (.002)
Alloy Steel <50Rc - 65Rc	50-150 (90)	.0002-.0005 (.0003)	.0005-.001 (.0005)	.0005-.0015 (.001)	.0005-.002 (.0015)
Stainless Steel 200- 300 series	125-400 (275)	.0005-.002 (.001)	.0007-.003 (.0015)	.001-.0035 (.002)	.002-.005 (.003)
Stainless Steel 400, 15-5, 17-4	85-300 (150)	.0003-.001 (.0005)	.0005-.0015 (.001)	.0005-.002 (.0015)	.0007-.003 (.002)
Cast & Ductile Iron	100-700 (500)	.0007-.002 (.001)	.001-.003 (.002)	.001-.004 (.002)	.002-.007 (.005)
Nickle & High Temp Alloys	50-200 (125)	.0002-.0007 (.0003)	.0003-.001 (.0005)	.0005-.0015 (.001)	.0007-.003 (.002)
Titanium	30-150 (90)	.0003-.0005 (.0004)	.0005-.0015 (.001)	.0007-.002 (.0015)	.001-.003 (.002)
Aluminum 6000/7000 series	600-2500 (2000)	.001 - .003 (.002)	.001-.004 (.003)	.002-.007 (.005)	.003-.010 (008)
Copper	250-800 (500)	.0007-.0015 (.001)	.001-.003 (.002)	.001-.004 (.003)	.002-.005 (.004)
Bronze / Brass (+Red Brass)	500-900 (700)	.0008-.002 (.001)	.001-.003 (.002)	.001-.005 (.003)	.002-.006 (.005)
(Red Brass: Reduce SFM x25%)					
Plastics	800-1600 (1000)	.002-.004 (.003)	.004-.006 (.005)	.005-.007 (.006)	.008-.010 (.008)
(PERIPHERAL MILLING) STANDARD CUTTING: AXIAL DOC 1.0xDIA, RADIAL DOC .3xDIA FOR SLOTTING APPLICATIONS REDUCE SFM 30%, FOR LONG FLUTE MILLS REDUCE FEED/TOOTH 50% AND SFM 20%					

* Speeds & Feeds for MelBran ALU-MINATOR 3/8" & 1/2" Endmills *					
Material	SFM	Chip Load/tooth			
		3/8" dia.	1/2" dia.		
Aluminum 6000/7000 series	600-2500 (2000)	.002 - .005 (.0035)	.002 - .007 (.005)		

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