

# 1/2" Series Recommended Parameters

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Style	Edge	Grade	Coating	Speed / Feed	Low-Carbon Steel	Alloy Steel	Tool Steels	Medium Hardened Steel (36-48 Rc)	Hardened Steel (> 48 Rc)	Austenitic Stainless	Ferritic / Martensitic Stainless	Tough PH Stainless	Gray Cast Iron	Ductile / Malleable	Ni Co-Based Alloys	9 Series Inconel	Titanium	Copper Alloys	Aluminum / Non-Ferrous		
SNGX-1206ANN	D	DMK30	GLH	Speed	700-1000	500-900	250-550				300-600	500-900		600-1000	500-900	55-90	35-65	120-180	400-900		
				Feed	.003-.014	.003-.012	.003-.010				.003-.010	.003-.012		.003-.014	.003-.013	.002-.007	.002-.006	.003-.008	.003-.010		
			IN	Speed								<b>300-600</b>	<b>500-900</b>				<b>55-90</b>	<b>35-65</b>	<b>120-180</b>		
				Feed								<b>.003-.010</b>	<b>.003-.012</b>				<b>.002-.007</b>	<b>.002-.006</b>	<b>.003-.008</b>		
SNMX-1206ANN	N	DMK35	GLH	Speed	700-1000	500-900	250-550				300-600	500-900		600-1000	500-900	55-90	35-65	120-180	400-900		
				Feed	.004-.014	.004-.013	.004-.010				.004-.012	.004-.014		.004-.014	.004-.013	.004-.007	.003-.006	.004-.008	.005-.012		
			IN	Speed								<b>300-600</b>	<b>500-900</b>				<b>55-90</b>	<b>35-65</b>			
				Feed								<b>.004-.012</b>	<b>.004-.014</b>				<b>.004-.007</b>	<b>.003-.006</b>			
		DMP25	TCI	Speed	<b>600-1100</b>	<b>400-800</b>	<b>300-600</b>	250-450						250-500	600-1000	450-800					
				Feed	<b>.005-.015</b>	<b>.005-.015</b>	<b>.005-.013</b>	.004-.012							.003-.010	.005-.015	.005-.015				
	GLH	TCI	Speed	700-1200	500-900	<b>350-650</b>	<b>250-450</b>						<b>250-500</b>	<b>600-1000</b>	<b>500-900</b>						
			Feed	.005-.015	.005-.015	<b>.005-.013</b>	<b>.004-.012</b>							<b>.003-.010</b>	<b>.005-.015</b>	<b>.005-.015</b>					
	T	DMP25	TCI	Speed	<b>600-1100</b>	<b>400-800</b>	<b>300-600</b>	250-450							600-1000	450-800					
				Feed	<b>.005-.015</b>	<b>.005-.015</b>	<b>.005-.013</b>	.004-.012								.005-.015	.005-.015				
			GLH	Speed	700-1200	500-900	<b>350-650</b>	<b>250-450</b>								<b>600-1000</b>	<b>500-900</b>				
				Feed	.005-.015	.005-.015	<b>.005-.013</b>	<b>.004-.012</b>								<b>.005-.015</b>	<b>.005-.015</b>				
SNGX-120612	N	DMP25	TCI	Speed	<b>600-1100</b>	<b>400-800</b>	<b>300-600</b>	250-450						250-500	600-1000	450-800					
				Feed	<b>.005-.015</b>	<b>.005-.015</b>	<b>.005-.013</b>	.004-.012							.004-.010	.005-.015	.005-.015				
			GLH	Speed	700-1200	500-900	<b>350-650</b>	<b>250-450</b>								<b>250-500</b>	<b>600-1000</b>	<b>500-900</b>			
				Feed	.005-.015	.005-.015	<b>.005-.013</b>	<b>.004-.012</b>								<b>.004-.010</b>	<b>.005-.015</b>	<b>.005-.015</b>			

- › **Bold text** indicates best choice for material shown.
- › The parameters provided are suggested starting operating parameters.

## Insert Grade & Coating Selection

Grade	Materials	Machining Conditions			Coating		Coolant	
		Roughing	Medium	Light	1st Choice	2nd Choice		
		Severe	Moderate	Rigid				
<b>DMK35</b>	High-Temp. Alloys	S20-S40	■	■	■	IN	GLH	●
	Tough Stainless Steel	M20-M40	■	■	■	IN	GLH	●
<b>DMK30</b>	Steel	P30-P40	□	□	□	GLH	IN	★
	Iron	K30-K40	□	□	□	GLH	IN	★
	High-Temp. Alloys	S20-S35	■	■	■	IN	GLH	●
	Stainless Steel	M25-M35	■	■	■	GLH	IN	◆
	Titanium	S20-S35	■	■	■	IN	GLH	●
<b>DMP25</b>	Steel	P25-P35	■	■	■	TCI	GLH	★
	Iron	K20-K30	■	■	■	GLH	TCI	★
	PH Stainless Steel	M20-M30	■	■	■	GLH	TCI	★
	Hardened Steel (< 52 Rc)	H20-H30	■	■	■	GLH	TCI	★ ○

Highly Recommended    
  Recommended    
  Not Recommended

Coolant Beneficial    
  Coolant Optional    
  Coolant Detrimental

Air Preferred

› **Bold text** indicates preferred material.