

12mm Series Recommended Cutting 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			
DTB-12	D	DMK30	TCI	Speed	500-800	400-700	250-450			300-500	400-800	250-450	500-800	400-700					400-900		
				Feed	.007-.020	.005-.015	.005-.012			.005-.015	.005-.020	.003-.012	.004-.020	.003-.015						.004-.015	
			GLH	Speed	700-1000	500-800	250-600			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180	400-900			
				Feed	.007-.020	.005-.015	.005-.012			.005-.015	.005-.020	.003-.012	.004-.020	.003-.015	.002-.006	.002-.005	.003-.007	.004-.015			
			HM	Speed	700-1000	500-800	250-600			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180				
				Feed	.007-.020	.005-.015	.005-.012			.005-.015	.005-.020	.003-.012	.004-.020	.003-.015	.002-.006	.002-.005	.003-.007				
		TS	Speed	700-1000	500-800	250-600			300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180					
			Feed	.007-.020	.005-.015	.005-.012			.005-.015	.005-.020	.003-.012	.004-.020	.003-.015	.002-.006	.002-.005	.003-.007					
		T	DMK30	TCI	Speed	500-800	400-700	250-600							500-800	400-700					
					Feed	.007-.020	.007-.020	.005-.015									.007-.020	.006-.020			
				GLH	Speed	700-1000	500-800	250-600									600-1000	500-900			
					Feed	.007-.020	.007-.020	.005-.015									.007-.020	.006-.020			
	HM			Speed	700-1000	500-800	250-600									600-1000	500-900				
				Feed	.007-.020	.007-.020	.005-.015									.007-.020	.006-.020				
	TS		Speed	700-1000	500-800	250-600									600-1000	500-900					
			Feed	.007-.020	.007-.020	.005-.015									.007-.020	.006-.020					
	DMP25		TCI	Speed	500-900	400-800	350-550	300-450							600-900	500-800					
				Feed	.007-.020	.007-.020	.005-.015	.004-.012							.007-.020	.006-.020					
			GLH	Speed	700-1200	500-900	350-650	300-500								600-1000	500-900				
				Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020				
		HM	Speed	700-1200	500-900	350-650	300-500								600-1000	500-900					
			Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020					
	TS	Speed	700-1200	500-900	350-650	300-500								600-1000	500-900						
		Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.020						
DMK15	TCI	Speed	500-900	400-800	350-550	300-450							600-1000	600-900							
		Feed	.007-.020	.007-.020	.005-.015	.004-.012								.007-.020	.006-.015						
	GLH	Speed	700-1200	500-900	350-650	300-500	250-450							700-1200	600-900						
		Feed	.007-.020	.007-.020	.005-.015	.004-.012	.003-.012							.007-.020	.006-.015						
	HM	Speed	700-1200	500-900	350-650	300-500	250-450							700-1200	600-900						
		Feed	.007-.020	.007-.020	.005-.015	.004-.012	.003-.012							.007-.020	.006-.015						
TS	Speed	700-1200	500-900	350-650	300-500	250-450							700-1200	600-900							
	Feed	.007-.020	.007-.020	.005-.015	.004-.012	.003-.012							.007-.020	.006-.015							

- › **Bold text** indicates best choice for material shown.
- › The parameters provided are suggested starting operating parameters.
- › See page IM-155 for insert grade and coating selection.