

3/4" 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	Aluminum / Non-Ferrous	
OPMH-644	N	DMK30	GLH	Speed	700-1000	500-800	250-550				500-900	250-500	600-1000	500-900						
				Feed	.005-.015	.005-.015	.005-.013			.003-.013	.003-.010	.005-.015	.005-.015							
		DMK25	GLH	Speed	700-1000	500-900	250-650			500-900	250-500	600-1000	500-900							
				Feed	.003-.012	.003-.010	.003-.010			.003-.012	.003-.009	.003-.013	.003-.012							
		DMK15	GLH	Speed	700-1200	500-900	350-650	300-500	250-450					700-1200	600-900					
				Feed	.004-.014	.004-.013	.004-.012	.003-.010	.003-.008					.005-.015	.005-.015					
	T	DMK30	GLH	Speed	700-1000	500-800	250-550							600-1000	500-900					
				Feed	.005-.015	.005-.015	.005-.013								.005-.015	.005-.015				
		DMP25	GLH	Speed	700-1200	500-900	350-650	300-500							600-1000	500-900				
				Feed	.005-.015	.005-.015	.005-.013	.004-.012								.005-.015	.005-.015			
DMK15	GLH	Speed	700-1200	500-900	350-650	300-500	250-450						700-1200	600-900						
		Feed	.004-.014	.004-.013	.004-.012	.003-.010	.003-.008						.005-.015	.005-.015						
OXCH-634	T	DMK15	GLH	Speed	700-1200	500-900	350-650	300-500	250-450				700-1200	600-900						
				Feed	.004-.014	.004-.013	.004-.012	.003-.010	.003-.008					.005-.015	.005-.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.

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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													
RPMH-64	N	DMK25	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															
		DMP25	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															
	T	DMK30	GLH	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															

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