

5/8" Series Recommended Cutting Parameters

Continued on next page

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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-544	D	DMK30	TCI	Speed	500-800	400-700	250-450			300-500	400-800	250-450	500-800	400-700					400-900			
				Feed	.003-.014	.003-.013	.003-.010			.003-.012	.003-.014	.003-.010	.003-.014	.003-.013							.003-.010	
		GLH	Speed	700-1000	500-900	250-550					300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180		400-900		
			Feed	.003-.014	.003-.013	.003-.010					.003-.012	.003-.014	.003-.010	.003-.014	.003-.013	.002-.007	.002-.006	.003-.008		.003-.010		
		DMP25	GLH	Speed	700-1200	500-900	350-650	300-500						600-1000	500-900							
				Feed	.003-.013	.003-.012	.003-.010	.003-.009							.003-.013	.003-.012						
	DMK15	GLH	Speed											600-1000	500-900					400-900	1000+ (Cast)	
			Feed											.003-.013	.003-.012					.003-.013	.007-.020	
	N	DMK30	TCI	Speed	500-800	400-700	250-550					400-800	250-450	500-800	400-700							
				Feed	.005-.015	.005-.015	.005-.013						.003-.013	.003-.010	.005-.015	.005-.015						
		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							
		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	DMP25	TCI	Speed	500-900	400-800	350-550	300-450						600-900	500-800							
				Feed	.005-.015	.005-.015	.005-.013	.004-.012							.005-.015	.005-.015						
		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							
HM		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-543	D	DMK30	TCI	Speed	500-800	400-700	250-450			300-500	400-800	250-450	500-800	400-700					400-900			
				Feed	.003-.014	.003-.013	.003-.010					.003-.012	.003-.014	.003-.010	.003-.014	.003-.013				.003-.010		
			GLH	Speed	700-1000	500-900	250-550					300-600	500-900	250-500	600-1000	500-900	55-90	35-65	120-180		400-900	1000+ (Cast)
				Feed	.003-.014	.003-.013	.003-.010					.003-.012	.003-.014	.003-.010	.003-.014	.003-.013	.002-.007	.002-.006	.003-.008		.003-.010	.007-.020
			Uncoated	Speed																		1500+
				Feed																		.007-.020

- › **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-54	D	DMK30	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	
		DMK25	GLH	Speed	700-1200	500-900	350-650											600-1000	500-900			120-180	400-900		
				Feed	.007-.020	.005-.015	.005-.012												.004-.020	.003-.015			.003-.007	.004-.015	
	N	DMK30	TCI	Speed	500-800	400-700	250-600								400-800	250-450	500-800	400-700							
				Feed	.007-.020	.007-.020	.005-.015										.005-.020	.003-.012	.007-.020	.006-.020					
			GLH	Speed	700-1000	500-800	250-600										500-900	250-500	600-1000	500-900					
				Feed	.007-.020	.007-.020	.005-.015										.005-.020	.003-.012	.007-.020	.006-.020					
		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						
			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						
		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						
			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						
	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						
		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								

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