


TECHNICAL INFORMATION - SERIES 48A

Workpiece Material	Diameter (Inch)	aP	aR	Cutting Speed SFM	Feed Per Tooth APT (Inch)
Unalloyed steel P	0.312	.045xD	.7xD	500 - 850	0.015-0.025
	0.375	.045xD	.7xD	500 - 850	0.018-0.028
	0.500	.045xD	.7xD	500 - 850	0.018-0.028
	0.625	.045xD	.7xD	500 - 850	0.020-0.030
	0.750	.045xD	.7xD	500 - 850	0.020-0.030
	1.000	.045xD	.7xD	500 - 850	0.025-0.035
High Carbon steel P	0.312	.045xD	.7xD	450 - 750	0.015-0.025
	0.375	.045xD	.7xD	450 - 750	0.018-0.028
	0.500	.045xD	.7xD	450 - 750	0.018-0.028
	0.625	.045xD	.7xD	450 - 750	0.020-0.030
	0.750	.045xD	.7xD	450 - 750	0.020-0.030
	1.000	.045xD	.7xD	450 - 750	0.025-0.035
Alloyed / Tool steel P	0.312	.04xD	.6xD	400 - 600	0.015-0.025
	0.375	.04xD	.6xD	400 - 600	0.018-0.028
	0.500	.04xD	.6xD	400 - 600	0.018-0.028
	0.625	.04xD	.6xD	400 - 600	0.020-0.030
	0.750	.04xD	.6xD	400 - 600	0.020-0.030
	1.000	.04xD	.6xD	400 - 600	0.025-0.035
Gray cast iron K	0.312	apmx	.7xD	500 - 850	0.015-0.025
	0.375	apmx	.7xD	500 - 850	0.018-0.028
	0.500	apmx	.7xD	500 - 850	0.018-0.028
	0.625	apmx	.7xD	500 - 850	0.020-0.030
	0.750	apmx	.7xD	500 - 850	0.020-0.030
	1.000	apmx	.7xD	500 - 850	0.025-0.035
Nodular K	0.312	apmx	.7xD	450 - 650	0.015-0.025
	0.375	apmx	.7xD	450 - 650	0.018-0.028
	0.500	apmx	.7xD	450 - 650	0.018-0.028
	0.625	apmx	.7xD	450 - 650	0.020-0.030
	0.750	apmx	.7xD	450 - 650	0.020-0.030
	1.000	apmx	.7xD	450 - 650	0.025-0.035
Hardened steel < 50 HRC H	0.312	.03xD	.3xD	250 - 400	0.012-0.022
	0.375	.03xD	.3xD	250 - 400	0.015-0.025
	0.500	.03xD	.3xD	250 - 400	0.015-0.025
	0.625	.03xD	.3xD	250 - 400	0.020-0.030
	0.750	.03xD	.3xD	250 - 400	0.020-0.030
	1.000	.03xD	.3xD	250 - 400	0.020-0.030
Hardened steel < 58 HRC H	0.312	.02xD	.25xD	150 - 250	0.008-0.018
	0.375	.02xD	.25xD	150 - 250	0.012-0.022
	0.500	.02xD	.25xD	150 - 250	0.012-0.022
	0.625	.02xD	.25xD	150 - 250	0.015-0.025
	0.750	.02xD	.25xD	150 - 250	0.015-0.025
	1.000	.02xD	.25xD	150 - 250	0.018-0.028