

**Spherical Ball End Mill    Speeds & Feeds**  
**ISO-H Pre-Hardened Steels from 25Rc - 45Rc Hardness**

TYPE OF CUT	TYPE OF MACHINING	AXIAL DOC	RADIAL DOC	SURFACE SPEED (SFM)	FEED PER TOOTH BY END MILL DIAMETER						
					1/16"	3/32"	1/8"	3/16"	1/4"	3/8"	1/2"
Roughing	Standard	≤ .06 x D	≤ .30 x D	60-180	.0008	.001	.002	.003	.004	.006	.007
	High Speed			250-340							
Finishing	Standard	≤ .07 x D	≤ .02-.60 x D	60-200	.002	.002	.003	.004	.004	.005	.006
	High Speed			250-350							