



# 5<sup>th</sup> AXIS<sup>®</sup>

## Dovetail Cutter Speeds & Feeds

Stock	Speed	Feed
Mild Steel	1300 RPM	15-20 IPM @ .070 - .100 Radial
Medium Steel	900-1200 RPM	9-12 IPM @ .050 - .080 Radial
Hard Steel	400-700 RPM	5-8 IPM @ .040 - .060 Radial
Aluminum	8,000-12,000 RPM	80-120 IPM @ .100 Radial
Titanium	80-100 Surface Feet	@ .005 Chip Load @ .030 - .050 Radial