

**RUSHMORE USA 2 FLUTE DOUBLE END CORNER ROUNDING CARBIDE
END MILLS**

Speed & Feed Data- Application on Various Materials					
Material	SFM	1/8"	1/4"	1/2"	1"
Aluminum Alloys	600-1200	.0010"	.0020"	.0040"	.0080"
Brass	200-350	.0010"	.0020"	.0030"	.0050"
Bronze	200-350	.0010"	.0020"	.0030"	.0050"
Carbon Steel	100-600	.0010"	.0015"	.0030"	.0060"
Cast Iron	80-350	.0010"	.0015"	.0030"	.0060"
Cast Steel	200-350	.0005"	.0010"	.0020"	.0040"
Cobalt Base Alloys	20-80	.0005"	.0008"	.0010"	.0020"
Copper	350-900	.0010"	.0020"	.0030"	.0060"
Die Steel	50-300	.0005"	.0010"	.0020"	.0040"
Graphite	600-1000	.0020"	.0050"	.0080"	.0100"
Incone/Monel	30-50	.0005"	.0010"	.0015"	.0030"
Magnesium	900-1300	.0010"	.0020"	.0040"	.0080"
Malleable Iron	200-500	.0005"	.0010"	.0030"	.0070"
Nickel Base Alloys	50-100	.0002"	.0008"	.0010"	.0020"
Plastic	600-1200	.0010"	.0030"	.0060"	.0100"
Stainless Steel - Free Machining	100-300	.0005"	.0010"	.0020"	.0030"
Stainless Steel - Other	50-250	.0005"	.0010"	.0020"	.0030"
Steel - Annealed	100-350	.0010"	.0020"	.0030"	.0050"
Steel - Rc 18-24	100-500	.0004"	.0008"	.0015"	.0045"
Steel - Rc 25-37	25-120	.0003"	.0005"	.0010"	.0030"
Titanium	100-200	.0005"	.0008"	.0015"	.0030"