

Power-Carb™ Speed and Feed Recommendations – Fractional and Metric



Slotting		Steels 30–45 Rc		Steels 45–55 Rc		Steels 55–60 Rc		Steels 60–65 Rc	
		Rw 1 x D Ad ≤.3 x D		Rw 1 x D Ad ≤.2 x D		Rw 1 x D Ad ≤.1 x D		Rw 1 x D Ad ≤.1 x D	
		Speed		Speed		Speed		Speed	
		215 sfm	65 m / min	145 sfm	45 m / min	100 sfm	30 m / min	65 sfm	20 m / min
Diameter (D)		Feed per Tooth		Feed per Tooth		Feed per Tooth		Feed per Tooth	
in	mm	in	mm	in	mm	in	mm	in	mm
1/4	6	.0014	.035	.0013	.033	.0012	.030	.0011	.028
5/16	8	.0016	.040	.0015	.040	.0014	.035	.0012	.030
3/8	10	.0020	.050	.0018	.045	.0016	.040	.0014	.035
1/2	12	.0024	.060	.0022	.055	.0020	.050	.0018	.045

Profiling		Steels 30–45 Rc		Steels 45–55 Rc		Steels 55–60 Rc		Steels 60–65 Rc	
		Rw ≤.1 x D Ad ≤1.5 x D		Rw ≤.05 x D Ad ≤1.5 x D		Rw ≤.05 x D Ad ≤1.5 x D		Rw ≤.05 x D Ad ≤1.5 x D	
		Speed		Speed		Speed		Speed	
		330 sfm	100 m / min	300 sfm	90 m / min	260 sfm	80 m / min	200 sfm	60 m / min
Diameter (D)		Feed per Tooth		Feed per Tooth		Feed per Tooth		Feed per Tooth	
in	mm	in	mm	in	mm	in	mm	in	mm
1/4	6	.0018	.045	.0015	.040	.0014	.035	.0012	.030
5/16	8	.0022	.055	.0020	.050	.0018	.045	.0015	.040
3/8	10	.0024	.065	.0024	.060	.0022	.055	.0020	.050
1/2	12	.0030	.075	.0027	.070	.0026	.065	.0024	.060

High Speed Profiling		Steels 30–45 Rc		Steels 45–55 Rc		Steels 55–60 Rc		Steels 60–65 Rc	
		Rw ≤.04 x D Ad ≤1.5 x D		Rw ≤.04 x D Ad ≤1.5 x D		Rw ≤.01 x D Ad ≤1.5 x D		Rw ≤.01 x D Ad ≤1.5 x D	
		Speed		Speed		Speed		Speed	
		825 sfm	250 m / min	825 sfm	250 m / min	425 sfm	130 m / min	425 sfm	130 m / min
Diameter (D)		Feed per Tooth		Feed per Tooth		Feed per Tooth		Feed per Tooth	
in	mm	in	mm	in	mm	in	mm	in	mm
1/4	6	.0040	.100	.0035	.090	.0030	.070	.0025	.060
5/16	8	.0045	.110	.0040	.100	.0035	.090	.0030	.070
3/8	10	.0050	.130	.0047	.120	.0040	.100	.0035	.090
1/2	12	.0055	.140	.0050	.130	.0047	.120	.0045	.110



Radial Width of Cut (Rw)
Axial Depth of Cut (Ad)



Ancho radial del corte (Rw)
Profundidad axial del corte (Ad)



Largeur radiale de taille (Rw)
Profondeur axiale de taille (Ad)