

Speeds and Feeds



Carbide Grade C3

ISO	VDI 3323	Material Description	Composition/Structure/Heat Treatment	HB	HRC	Speed(SFM)	Feed (IPR)				
							3/8 ~ 1/2	33/64 ~ 11/16	45/64 ~ 15/16	31/32 ~ 1-3/8	1-13/32 ~ 1-7/8
K	15	Grey cast iron	Pearlitic/Ferritic	180	10	449	0.007	0.010	0.013	0.017	0.021
	16		Pearlitic(Martensitic)	260	26	305	0.005	0.007	0.009	0.011	0.013
	17	Nodular cast iron	Ferritic	160	3	410	0.007	0.010	0.013	0.017	0.021
	18		Pearlitic	250	25	259	0.005	0.006	0.011	0.013	0.015
	19	Malleable cast iron	Ferritic	130		449	0.007	0.012	0.015	0.018	0.022
	20		Pearlitic	230	21	259	0.005	0.006	0.011	0.013	0.015