

Speeds and Feeds



How To Use This Chart:

- 1) Select your material in the ISO colored chart
- 2) Select Inch or Metric Parameters
- 3) Start with the recommended cutting feed and Depth of Cut

Broaching

ISO	ANSI	Material Description	● Optimal		Secondary		
			Cutting Feed Recommended	Depth of Cut Recommended	Depth of Cut Min	Depth of Cut Max	
P1	P1-P3	Non-alloy steel	● Inch (ipm)	320	0.004	0.002	0.006
			Metric (mm/min.)	8,000	0.11	0.06	0.15
P4	P4-P6	Low alloy steel	● Inch (ipm)	240	0.003	0.002	0.005
			Metric (mm/min.)	6,000	0.08	0.04	0.12
M	M1-M3	Stainless steel	● Inch (ipm)	200	0.002	0.001	0.003
			Metric (mm/min.)	5,000	0.06	0.03	0.08
K	K1-K3	Grey cast iron	● Inch (ipm)	240	0.005	0.002	0.008
			Metric (mm/min.)	6,000	0.13	0.06	0.2
N1	N1-N2	Non-ferrous metals (Aluminum)	● Inch (ipm)	400	0.008	0.004	0.010
			Metric (mm/min.)	10,000	0.2	0.1	0.25
N4	N4	Non-ferrous metals (Copper, Brass)	● Inch (ipm)	280	0.004	0.002	0.006
			Metric (mm/min.)	7,000	0.1	0.06	0.15
N5	N5	Non-ferrous metals (Plastic)	● Inch (ipm)	400	0.010	0.008	0.012
			Metric (mm/min.)	10,000	0.25	0.2	0.3
S	S1-S3	Super Alloys	● Inch (ipm)	200	0.002	0.001	0.003
			Metric (mm/min.)	5,000	0.06	0.03	0.08
H	H1-H4	Hardened	● Inch (ipm)	200	0.002	0.001	0.003
			Metric (mm/min.)	5,000	0.06	0.03	0.08

