

Speeds and Feeds



			Speed - m/min (SFM)													Starting Conditions				
Grade	Group	Material Description	0 (0)	75 (250)	150 (490)	225 (740)	300 (980)	375 (1230)	450 (1480)	525 (1720)	600 (1970)	675 (2220)	750 (2460)	825 (2710)	900 (2950)	m/min	SFM			
HP15A/ HTP15C	P0/P1	Low-Carbon Steels (<0.3% C)	◇					170 ~ 350 (558 ~ 1148)								295	968			
HMSH10	M1	Austenitic Stainless Steel	◇					110 ~ 210 (361 ~ 689)								160	525			
	K1	Gray Cast Iron	◇					95 ~ 180 (312 ~ 591)								135	443			
	K2	Low- and Medium Strength Ductile Iron (Nodular) and Compacted Graphite Iron	◇					95 ~ 180 (312 ~ 591)								135	443			
	S1	Iron-Based, Heat-Resistant Alloys	◇	35 ~ 65 (115 ~ 213)													50	164		
	H1	Hardened Materials	◇	70 ~ 130 (230 ~ 427)													100	328		
HK10A/ HK10C	K1	Gray Cast Iron	◇							300 ~ 549 (984 ~ 1800)								380	1247	
HN25A	K1	Gray Cast Iron	◇	60 ~ 140 (197 ~ 459)													105	344		
	N1	Wrought Aluminum	◇								450 ~ 750 (1476 ~ 2461)								600	1969
	S1	Iron-Based, Heat-Resistant Alloys	◇	40 ~ 70 (131 ~ 230)													55	180		
	H1	Hardened Materials	◇	55 ~ 105 (180 ~ 344)													80	262		



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Insert				Recommended Feed & DOC			
Part Number	Description	IC Size		Feed Per Revolution, fn		Depth of Cut, ap	
		in	mm	in/rev	mm/rev	in	mm
02-0650	TPGH 1.51.51L	0.187	4.76	0.001 - 0.006	0.03 - 0.15	0.003 - 0.067	0.08 - 1.7
02-0651		0.187	4.76	0.001 - 0.006	0.03 - 0.15	0.003 - 0.067	0.08 - 1.7
02-0652		0.187	4.76	0.001 - 0.006	0.03 - 0.15	0.003 - 0.067	0.08 - 1.7
02-0653		0.187	4.76	0.001 - 0.006	0.03 - 0.15	0.003 - 0.067	0.08 - 1.7
02-0654	TPGH 221L	0.25	6.35	0.0004 - 0.006	0.01 - 0.15	0.003 - 0.079	0.08 - 2
02-0655		0.25	6.35	0.0004 - 0.006	0.01 - 0.15	0.003 - 0.079	0.08 - 2
02-0656		0.25	6.35	0.0004 - 0.006	0.01 - 0.15	0.003 - 0.079	0.08 - 2
02-0657		0.25	6.35	0.0004 - 0.006	0.01 - 0.15	0.003 - 0.079	0.08 - 2