

Speeds and Feeds



02-0958			Speed - m/min (SFM)									Starting Conditions	
Grade	Material Group	Material Description	135 (450)	180 (600)	225 (800)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	sfm
HP25C/ HTP25C	P0/P1	Low-Carbon Steels (<0.3% C)	◊									295	968
	P2	Medium-High Carbon Steels (>0.3% C)	◊									260	853

02-0958		Feed and Depth of Cut Ranges			
Chip Breaker	Insert Size Code	Inches		Metric	
		fn (ipr)	ap (inch)	fn (mmpr)	ap (mm)
HM	1.81.52	0.003 - 0.008	0.004 - 0.047	0.075 - 0.200	0.100 - 1.200

