

Speeds and Feeds



02-0960			Speed - m/min (SFM)								Starting Conditions		
Grade	Material Group	Material Description	15 (50)	40 (125)	60 (200)	100 (325)	140 (450)	175 (575)	210 (700)	251 (825)	290 (950)	m/min	sfm
HMSH20P	M1	Austenitic Stainless Steel (180 HB)					◊					160	525
	M2	Ferritic / Martenistic Stainless Steel Mixture (Duplex) (200HB)					◊					150	492
	K1	Grey Cast Iron				◊					135	443	
	K2	Ductile, Compacted Graphite, Malleable Cast Irons (<600 MPa tensile strength)				◊					100	344	
	S1	Iron-Based, Heat-Resistant Alloys (135–320 HB) (≤34 HRC)	◊								50	164	
	S2	Cobalt-Based, Heat-Resistant Alloys (150–425 HB) (≤45 HRC)	◊								45	148	
	H1	Hardened (<48Rc)				◊					100	328	
	H2	Hardened (48-55Rc)				◊					90	295	

02-0960		Feed and Depth of Cut Ranges			
Chip Breaker	Insert Size Code	Inches		Metric	
		fn (ipr)	ap (inch)	fn (mmpr)	ap (mm)
HM	1.81.51	0.002 - 0.007	0.004 - 0.039	0.05 - 0.180	0.100 - 1.000

