

Speeds and Feeds



02-0961			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
HK20C	K1	Grey Cast Iron	◊								365	1200	
	K2	Ductile, Compacted Graphite, Malleable Cast Irons (<600 MPa tensile strength)	◊								280	919	

02-0961		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	0.002 - 0.007	0.004 - 0.039	0.05 - 0.180	0.100 - 1.000