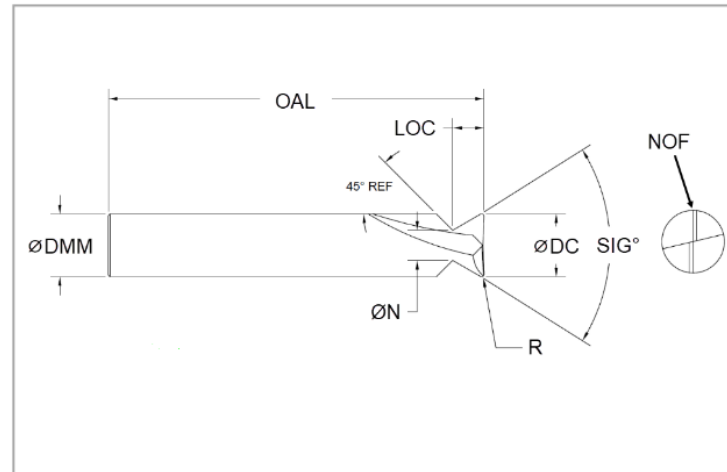


# Speeds and Feeds



		Cutting Speed (SFM)			[Ø] Neck Diameter	0.068	0.073	0.095	0.125	0.187	0.25	0.312	0.375
		min	-	max									
Inch	P - Steel	400	-	600	IPT	0.0002	0.0003	0.0003	0.0004	0.0007	0.0009	0.0011	0.0013
	M - Stainless Steel	200	-	450	IPT	0.0002	0.0003	0.0003	0.0004	0.0007	0.0009	0.0011	0.0013
	K - Cast Iron	225	-	400	IPT	0.0006	0.0007	0.0008	0.0011	0.0017	0.0022	0.0028	0.0033
	S - Titanium	100	-	150	IPT	0.0001	0.0002	0.0002	0.0003	0.0004	0.0005	0.0007	0.0008
	S - High Temp Alloys	70	-	90	IPT	0.0001	0.0002	0.0002	0.0003	0.0004	0.0005	0.0007	0.0008
	H - Hardened Steels	80	-	100	IPT	0.0001	0.0001	0.0002	0.0002	0.0003	0.0004	0.0005	0.0007



	RPM - Speed	SFM - Cutting Speed
Find:	(RPM) Revolutions per Minute	(SFM) Surface Feet per Minute [ft/min]
Given:	(D <sub>Tool</sub> ) Tool Diameter (SFM) Cutting Speed / Surface Feet per Minute	(RPM) Revolutions per Minute (D <sub>Tool</sub> ) Tool Diameter
Equation:	$RPM = \frac{SFM \times 3.82}{D_{Tool}}$	$SFM = \frac{RPM \times D_{Tool}}{3.82}$