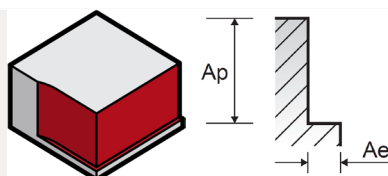


# Speeds and Feeds



ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Side Cutting					
						6	8	10	12	16	20
P	1	Non-alloy steel	0.05D	1.5D	m/min	270	270	270	270	270	270
					mm/tooth	.0610	.1041	.1295	.1549	.1829	.2032
					RPM	14310	10730	8590	7160	5370	4290
					mm/min	5234	6705	6676	6656	5892	6974
					m/min	270	270	270	270	270	270
					mm/tooth	.0610	.1041	.1295	.1549	.1829	.2032
			RPM	14310	10730	8590	7160	5370	4290		
			mm/min	5234	6705	6676	6656	5892	6974		
			m/min	270	270	270	270	270	270		
			mm/tooth	.0610	.1041	.1295	.1549	.1829	.2032		
			RPM	14310	10730	8590	7160	5370	4290		
			mm/min	5234	6705	6676	6656	5892	6974		
	5	0.05D	1.5D	m/min	183	183	183	183	183	183	
				mm/tooth	.0457	.0787	.0965	.1143	.1346	.1499	
				RPM	9700	7280	5820	4850	3640	2910	
				mm/min	2661	3439	3370	3326	2940	3489	
				m/min	270	270	270	270	270	270	
				mm/tooth	.0610	.1041	.1295	.1549	.1829	.2032	
	6	Low alloy steel	0.05D	1.5D	m/min	270	270	270	270	270	270
					mm/tooth	.0610	.1041	.1295	.1549	.1829	.2032
					RPM	14310	10730	8590	7160	5370	4290
					mm/min	5234	6705	6676	6656	5892	6974
					m/min	270	270	270	270	270	270
					mm/tooth	.0610	.1041	.1295	.1549	.1829	.2032
			RPM	14310	10730	8590	7160	5370	4290		
			mm/min	5234	6705	6676	6656	5892	6974		
			m/min	183	183	183	183	183	183		
			mm/tooth	.0457	.0787	.0965	.1143	.1346	.1499		
			RPM	9700	7280	5820	4850	3640	2910		
			mm/min	2661	3439	3370	3326	2940	3489		
9	0.05D	1.5D	m/min	183	183	183	183	183	183		
			mm/tooth	.0457	.0787	.0965	.1143	.1346	.1499		
			RPM	9700	7280	5820	4850	3640	2910		
			mm/min	2661	3439	3370	3326	2940	3489		
			m/min	270	270	270	270	270	270		
			mm/tooth	.0610	.1041	.1295	.1549	.1829	.2032		
10	High alloyed steel, and tool steel	0.05D	1.5D	m/min	270	270	270	270	270	270	
				mm/tooth	.0610	.1041	.1295	.1549	.1829	.2032	
				RPM	14310	10730	8590	7160	5370	4290	
				mm/min	5234	6705	6676	6656	5892	6974	
				m/min	90	90	90	90	90	90	
				mm/tooth	.0356	.0635	.0813	.0940	.1092	.1245	
		RPM	4770	3580	2860	2390	1790	1430			
		mm/min	1018	1364	1395	1348	1173	1424			
		m/min	90	90	90	90	90	90			
		mm/tooth	.0356	.0635	.0813	.0940	.1092	.1245			
		RPM	4770	3580	2860	2390	1790	1430			
		mm/min	1018	1364	1395	1348	1173	1424			



# Speeds and Feeds



ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Side Cutting					
						6	8	10	12	16	20
<b>K</b>	15	Grey cast iron	0.05D	1.5D	m/min	203	203	203	203	203	203
					mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413
					RPM	10750	8070	6450	5380	4030	3230
					mm/min	4751	6149	5996	6067	5282	6235
					m/min	203	203	203	203	203	203
					mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413
	16	Grey cast iron	0.05D	1.5D	RPM	10750	8070	6450	5380	4030	3230
					mm/min	4751	6149	5996	6067	5282	6235
					m/min	203	203	203	203	203	203
					mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413
					RPM	10750	8070	6450	5380	4030	3230
					mm/min	4751	6149	5996	6067	5282	6235
	17	Nodular cast iron	0.05D	1.5D	m/min	203	203	203	203	203	203
					mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413
					RPM	10750	8070	6450	5380	4030	3230
					mm/min	4751	6149	5996	6067	5282	6235
					m/min	203	203	203	203	203	203
					mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413
	18	Nodular cast iron	0.05D	1.5D	RPM	10750	8070	6450	5380	4030	3230
					mm/min	4751	6149	5996	6067	5282	6235
					m/min	203	203	203	203	203	203
					mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413
					RPM	10750	8070	6450	5380	4030	3230
					mm/min	4751	6149	5996	6067	5282	6235
19	Malleable cast iron	0.05D	1.5D	m/min	203	203	203	203	203	203	
				mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413	
				RPM	10750	8070	6450	5380	4030	3230	
				mm/min	4751	6149	5996	6067	5282	6235	
				m/min	203	203	203	203	203	203	
				mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413	
20	Malleable cast iron	0.05D	1.5D	RPM	10750	8070	6450	5380	4030	3230	
				mm/min	4751	6149	5996	6067	5282	6235	
				m/min	203	203	203	203	203	203	
				mm/tooth	.0737	.1270	.1549	.1880	.2184	.2413	
				RPM	10750	8070	6450	5380	4030	3230	
				mm/min	4751	6149	5996	6067	5282	6235	
<b>H</b>	38.1	Hardened steel	0.05D	1.5D	m/min	90	90	90	90	90	90
					mm/tooth	.0356	.0635	.0813	.0940	.1092	.1245
					RPM	4770	3580	2860	2390	1790	1430
					mm/min	1018	1364	1395	1348	1173	1424
					m/min	46	46	46	46	46	46
					mm/tooth	.0356	.0635	.0813	.0940	.1092	.1245
	38.2	Hardened steel	0.05D	1.5D	RPM	2430	1820	1460	1210	910	730
					mm/min	518	693	712	682	596	727
					m/min	90	90	90	90	90	90
					mm/tooth	.0356	.0635	.0813	.0940	.1092	.1245
					RPM	4770	3580	2860	2390	1790	1430
					mm/min	1018	1364	1395	1348	1173	1424
	40	Chilled Cast Iron	0.05D	1.5D	m/min	46	46	46	46	46	46
					mm/tooth	.0356	.0635	.0813	.0940	.1092	.1245
					RPM	2430	1820	1460	1210	910	730
					mm/min	518	693	712	682	596	727
					m/min	90	90	90	90	90	90
					mm/tooth	.0356	.0635	.0813	.0940	.1092	.1245
	41	Hardened Cast Iron	0.05D	1.5D	RPM	4770	3580	2860	2390	1790	1430
					mm/min	1018	1364	1395	1348	1173	1424
					m/min	46	46	46	46	46	46
					mm/tooth	.0356	.0635	.0813	.0940	.1092	.1245
					RPM	2430	1820	1460	1210	910	730
					mm/min	518	693	712	682	596	727

