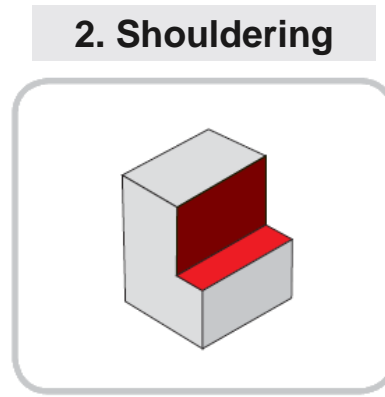
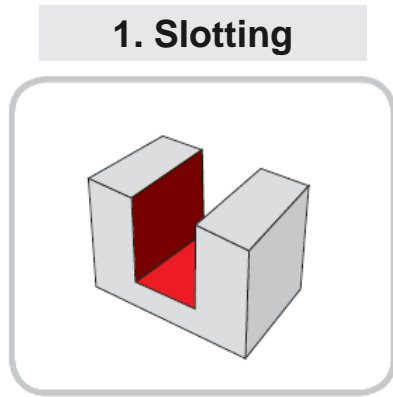


Speeds and Feeds



How To Use This Chart:

- 1) Select your material in the ISO colored chart
- 2) Use recommended insert grade
- 3) Choose cutting application using the figures below
- 4) Start with the middle range of the recommended vc(sfm) and fz(ipt)
 - Adjust the cutting speed and/or feed per tooth based on your cutting conditions



(inch)

Workpiece	Recommended Grade	Maximum Ap	Figure	Tool Diameter			
				Ø0.50, 0.625		Ø0.75	
				vc(sfm)	fz(ipt)	vc(sfm)	fz(ipt)
Mild Steel, Low carbon steel	HU30	0.22	1	150~200	0.002~0.003	200~260	0.002~0.003
			2	200~295	0.003~0.004	260~390	0.003~0.004
High carbon steel, Alloy steel	HU30	0.22	1	130~200	0.002	160~260	0.002~0.002
			2	160~260	0.002~0.003	260~330	0.002~0.003
Alloy Tool Steel	HU30	0.22	1	115~160	0.002	160~230	0.002~0.002
			2	150~230	0.002~0.003	230~330	0.002~0.003
Stainless Steel	HU30	0.22	1	115~160	0.002	160~230	0.002~0.002
			2	150~230	0.002~0.003	230~330	0.002~0.003
Cast Iron	HU30	0.22	1	160~260	0.003~0.005	260~330	0.003~0.005
			2	210~295	0.005~0.006	330~390	0.005~0.006
Aluminium Alloy	HN25A	0.22	1	650~1970	0.006~0.008	820~2,620	0.006~0.008
			2	650~2130	0.008~0.01	820~2,950	0.008~0.010
Hardened Steel	HU30	0.22	1	115~160	0.003	160~230	0.001~0.001
			2	150~210	0.002~0.003	200~260	0.002~0.003



D = cutting diameter (in) Z = # of teeth/flutes
 Ap = depth of cut (in) vc = cutting speed (surface feet / minute)
 Ae = width of cut (in) fz = feed per tooth (inches / tooth)
 N = Spindle Speed (rpm) vf = feed rate (inches / minute)