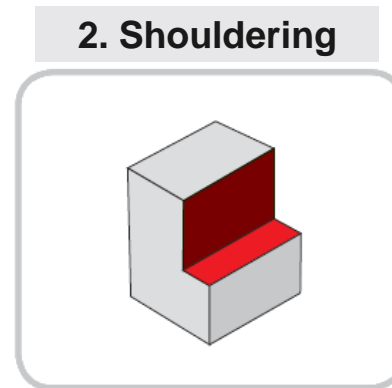
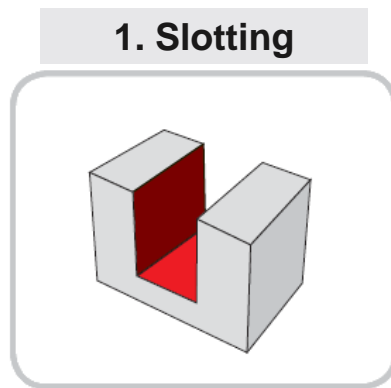


Speeds and Feeds



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(m/min) and feed (mm/t)
 - Adjust the cutting speed and/or feed per tooth based on your cutting conditions



(mm)

Workpiece	Recommended Grade	Maximum Ap	Figure	Tool Diameter			
				Ø12, 16		Ø20	
				vc (m/min)	fz (mm/t)	vc (m/min)	fz (mm/t)
Mild Steel, Low carbon steel	HU30	5	1	45~60	0.05~0.08	60~80	0.05~0.08
			2	60~90	0.08~0.1	80~120	0.08~0.1
High carbon steel, Alloy steel	HU30	5	1	40~60	0.05	50~80	0.05
			2	50~80	0.05~0.08	80~100	0.05~0.08
Alloy Tool Steel	HU30	5	1	35~50	0.05	50~70	0.05
			2	45~70	0.05~0.08	70~100	0.05~0.08
Stainless Steel	HU30	5	1	35~50	0.05	50~70	0.05
			2	45~70	0.05~0.08	70~100	0.05~0.08
Cast Iron	HU30	5	1	50~80	0.08~0.12	80~100	0.08~0.12
			2	65~90	0.12~0.15	100~120	0.12~0.15
Aluminium Alloy	HN25A	5	1	200~600	0.15~0.2	250~800	0.15~0.2
			2	200~650	0.2~0.25	250~900	0.2~0.25
Hardened Steel	HU30	5	1	35~50	0.03	50~70	0.03
			2	45~65	0.05~0.08	60~80	0.05~0.08



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

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