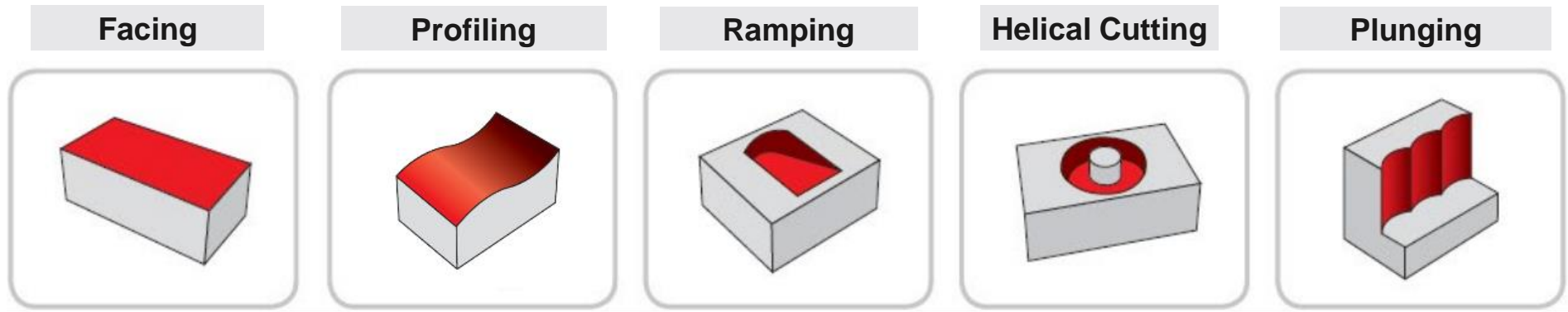


Speeds and Feeds



How To Use This Chart:

- 1) Select your material in the ISO colored chart
- 2) Start with the middle range of the recommended sfm (vc) and feed (inch/rev)
 - Adjust the sfm and/or feed rate based on your cutting conditions.



Workpiece Material	Sub Group	vc (sfm)	Recommended Grade	02-0659	02-0660	Maximum Ap
				General fz(ipt)	Reinforced Edge fz(ipt)	
P - Steels	Non-Alloyed Steel	460-1250	HU30A	0.0117 - 0.0780	0.0117 - 0.0975	0.035
	Low-Alloyed Steel	390-980				
	High-Alloyed Steel	230-490				
K - Cast Iron	Grey Cast Iron	390-820				
	Nodular Cast Iron	430-720				



*Units in Inch