

Speeds and Feeds



How To Use This Chart:

- 1) Select your material in the ISO colored chart
- 2) Start with the recommended SFM (Vc) and feed (inch/tooth)
 - Adjust the SFM and/or feed rate based on your cutting conditions.

HSLPP - Haas Slot Mill

Workpiece Material		Condition	Insert Grade Hardness HB	Cutting Data						Slot Milling Feed Rates		
				HMP20		HMP35		HK25				
				Recommended Starting SFM	SFM Range	Recommended Starting SFM	SFM Range	Recommended Starting SFM	SFM Range	Recommended Feed Per Tooth (inch/tooth)	Feed Per Tooth Range (inch/tooth)	
P Steel	Unalloyed Steel	0.15% C annealed	125	500	300 to 650	530	300 to 650		0.005	0.004 to 0.012		
		0.45% C annealed	190	428		459						
		0.45% C tempered	250	408		428						
		0.75% C annealed	270	357		377						
		0.75% C tempered	300	326		347						
	Low-alloyed Steel	annealed	180	400	260 to 650	428	260 to 650		0.005	0.004 to 0.012		
		tempered	275	333		352						
		tempered	300	305		324						
		tempered	350	257		276						
	High-Alloyed Steel and Tool Steel	annealed	200	320		332						
hardened and tempered		325	230	244								
M Stainless Steel	Stainless Steel	Ferritic/Martensitic	200	320	260 to 650	332	260 to 650		0.003	0.002 to 0.006		
		Martensitic	240	268		282						
		Austenitic	180	332		358						
		Austenitic/Ferritic	240	268		282						
K Cast Iron	Grey Cast Iron	Pearlitic/Ferritic	180					300 to 800	0.005	0.004 to 0.012		
		Pearlitic/Martensitic	260				500				296	
	Ductile Cast Iron	Ferritic	160									343
		Pearlitic	250									231
	Malleable Cast Iron	Ferritic	130									416
		Pearlitic	230									278

