

Speeds and Feeds



- 1) Select your material in the ISO colored chart.
- 2) Start with the recommended cutting speed, v_c (m/min). Adjust the cutting speed based on your cutting conditions.

Material			Recommended Cutting Speed		
Group	Description	Hardness (HB)	Hardness (HRC)	Cutting Speed	
ISO					VDI 3323
P	2	Non-Alloy Steel	190	13	15 - 20
	3		250	25	12 - 18
	4		270	28	10 - 15
	6	Low-Alloy Steel	180	10	10 - 15
	7		275	29	10 - 15
K	17	Nodular Cast Iron	160	3	10 - 15
	18		250	25	5 - 8
N	21	Aluminum-Wrought Alloy	60		10 - 15
	22		100		10 - 15
	23	Aluminum-Cast Alloy	75		15 - 20
	24		90		15 - 20
	25		130		10 - 15
	26		90		23 - 35
	27	Copper and Copper Alloys (Bronze/Brass)	100		8 - 12