Speeds and Feeds

1) Select your material in the ISO colored chart.
2) Start with the recommended cutting speed, v_c (ft/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	1	Non-Alloy Steel	125		50 - 80
	2		190	13	50 - 80
	3		250	25	50 - 80
	5		300	32	10 - 35
M	12	Stainless Steel	200	15	20 - 50
	13		240	23	20 - 50
	14		180	10	12 - 15
N	21	Aluminum-Wrought Alloy	60		50 - 65
	22		100		50 - 65
	23	Aluminum-Cast, Alloy	75		45 - 90
	24		90		45 - 90
	27	Copper and Copper Alloys (Bronze/Brass)	90		30 - 65
	28		100		30 - 65