

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	1	Non-Alloy Steel	125		15 - 24
	2		190	13	15 - 24
	3		250	25	15 - 24
	5		300	32	3 - 11
M	12	Stainless Steel	200	15	6 - 15
	13		240	23	6 - 15
	14		180	10	4 - 5
N	21	Aluminum-Wrought Alloy	60		15 - 20
	22	Aluminum-Wrought Alloy	100		15 - 20
	23	Aluminum-Cast, Alloy	75		14 - 27
	24	Aluminum-Cast, Alloy	90		14 - 27
	27	Copper and Copper Alloys (Bronze/Brass)	90		9 - 20
	28		100		9 - 20