

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	6	Low-Alloyed Steel	180	10	33 - 49
	7		275	29	33 - 49
	8		300	32	20 - 33
	9		350	38	10 - 16
S	31	Heat Resistant Super Alloys	200	15	33 - 49
	32		280	30	33 - 49
	33		250	25	7 - 13
	34		350	38	7 - 13
	35		320	34	7 - 13
	37	Titanium Alloys	1050 Rm		13 - 20
H	40	Chilled Cast Iron	400	42	10 - 16