

# 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	6	Low-Alloyed Steel	180	10	10 - 15
	7		275	29	10 - 15
	8		300	32	6 - 10
	9		350	38	3 - 5
S	31	Heat Resistant Super Alloys	200	15	10 - 15
	32		280	30	10 - 15
	33		250	25	2 - 4
	34		350	38	2 - 4
	35		320	34	2 - 4
	37	Titanium Alloys	1050 Rm		4 - 6
H	40	Chilled Cast Iron	400	42	3 - 5