

Speeds and Feeds



Material	Speed SFM	Feed (IPR)			SMPM	Feed (MMPR)		
		.1250	.2500	.5000		3.00mm	6.00mm	12.00mm
High Si Aluminum >10%	75-200	.0040	.0080	.0120	22-60	.1016	.2032	.3048
Low Si Aluminum <10%	100-300	.0050	.0100	.0150	30-91	.1270	.2540	.3810
Composites	-	-	-	-	-	-	-	-
Plastics	-	-	-	-	-	-	-	-
Brass & Copper	75-150	.0030	.0040	.0060	22-45	.0762	.1016	.1524
Graphite	-	-	-	-	-	-	-	-
Cast Iron								
Soft	75-150	.0050	.0080	.0120	22-45	.1270	.2032	.3048
Medium	60-100	.0050	.0080	.0120	18-30	.1270	.2032	.3048
Malleable	40-100	.0030	.0060	.0100	12-30	.0762	.1524	.2540
Bronze	65-125	.0030	.0040	.0060	19-38	.0762	.1016	.1524
Hardened Steels	30-90	.0020	.0020	.0040	9-27	.0508	.0508	.1016
Steels								
Low Carbon	60-125	.0030	.0060	.0100	18-28	.0762	.1524	.2540
Medium Carbon	100-150	.0030	.0050	.0080	30-45	.0762	.1270	.2032
Stainless Steels								
Free Machining	50-90	.0050	.0080	.0120	15-27	.1270	.2032	.3048
Work Hardening	30-75	.0030	.0060	.0100	9-22	.0762	.1524	.2540
Super Alloys	40-80	.0025	.0035	.0055	12-24	.0635	.0889	.1397
Titanium								
Soft	50-125	.0030	.0060	.0100	15-38	.0762	.1524	.2540
Hard	20-60	.0020	.0040	.0080	6-18	.0508	.1016	.2032