

			Speed - m/min (SFM)									Starting Conditions	
Grade	Material Group	Material Description	135 (450)	180 (600)	225 (800)	275 (900)	320 (1050)	360 (1200)	410 (1350)	455 (1500)	495 (1650)	m/min	sfm
HCP10C	P0/P1	Low-Carbon Steels ($<0.3\% \text{ C}$)		◊								350	1148
	P2	Medium-High Carbon Steels ($>0.3\% \text{ C}$)		◊								300	984
	P3	Alloy and Tool Steels ($<330\text{HB}$) ($<35 \text{ HRC}$)		◊								270	886
	K1	Cast Iron		◊								270	886

