

Speeds and Feeds



Haas Micro Turn			◎ : Excellent	Metric	
			○ : Good	Boring, Profiling and Grooving	
ISO	VDI 3323	Material Description	Recommend	Parameter	
P	1~5	Non-alloy steel	◎	Vc (m/min)	170 ~ 200
				f (mm/rev)	0.015~0.025
	6~9	Low alloy steel	◎	Vc (m/min)	95 ~ 160
				f (mm/rev)	0.015~0.025
	10~11	High-Alloyed Steel	◎	Vc (m/min)	85 ~ 95
				f (mm/rev)	0.015~0.025
M	12~13	Ferritic & Martensitic	○	Vc (m/min)	105 ~ 140
				f (mm/rev)	0.015~0.025
	14	Austenitic Stainless Steel	○	Vc (m/min)	95 ~ 130
				f (mm/rev)	0.015~0.025
K	15~16	Grey cast iron	◎	Vc (m/min)	140 ~ 190
				f (mm/rev)	0.015~0.025
	17~18	Nodular cast iron	◎	Vc (m/min)	140 ~ 190
				f (mm/rev)	0.015~0.025
N	21~30	Non-Ferrous Metals (Al)		Vc (m/min)	
				f (mm/rev)	
S	31~37	Superalloys & Titanium	○	Vc (m/min)	10 ~ 75
				f (mm/rev)	0.015~0.025
H	38~41	Hard Materials		Vc (m/min)	
				f (mm/rev)	

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Haas Micro Turn			◎ : Excellent ○ : Good	Inch	
				Boring, Profiling and Grooving	
ISO	VDI 3323	Material Description	Recommend	Parameter	
P	1~5	Non-alloy steel	◎	SFM (ft/min)	558 ~ 656
				Fn (inch/rev)	0.0006~0.0010
	6~9	Low alloy steel	◎	SFM (ft/min)	312 ~ 525
				Fn (inch/rev)	0.0006~0.0010
	10~11	High-Alloyed Steel	◎	SFM (ft/min)	279 ~ 312
				Fn (inch/rev)	0.0006~0.0010
M	12~13	Ferritic & Martensitic	○	SFM (ft/min)	344 ~ 459
				Fn (inch/rev)	0.0006~0.0010
	14	Austenitic Stainless Steel	○	SFM (ft/min)	312 ~ 427
				Fn (inch/rev)	0.0006~0.0010
K	15~16	Grey cast iron	◎	SFM (ft/min)	459 ~ 623
				Fn (inch/rev)	0.0006~0.0010
	17~18	Nodular cast iron	◎	SFM (ft/min)	459 ~ 623
				Fn (inch/rev)	0.0006~0.0010
N	21~30	Non-Ferrous Metals (Al)		SFM (ft/min)	
				Fn (inch/rev)	
S	31~37	Superalloys & Titanium	○	SFM (ft/min)	33 ~ 246
				Fn (inch/rev)	0.0006~0.0010
H	38~41	Hard Materials		SFM (ft/min)	
				Fn (inch/rev)	