

Speeds and Feeds



02-0955			Speed - m/min (SFM)									Starting Conditions	
Grade	Material Group	Material Description	90 (300)	120 (400)	150 (500)	180 (600)	210 (700)	240 (800)	270 (900)	300 (1000)	330 (1100)	m/min	sfm
HM15C	M1	Austenitic Stainless Steel (180 HB)	◊									240	787
	M2	Ferritic / Martenistic Stainless Steel Mixture (Duplex) (200HB)	◊									210	689

02-0955		Feed and Depth of Cut Ranges			
Chip Breaker	Insert Size Code	Inches		Metric	
		fn (ipr)	ap (inch)	fn (mmpr)	ap (mm)
HM	1.81.51	0.002 - 0.007	0.004 - 0.039	0.05 - 0.180	0.100 - 1.000