

Speeds and Feeds



02-0959			Speed - m/min (SFM)									Starting Conditions	
Grade	Material Group	Material Description	30 (100)	60 (200)	90 (300)	120 (400)	150 (500)	180 (600)	210 (700)	240 (800)	270 (900)	m/min	sfm
HM25C	M2	Ferritic / Martenistic Stainless Steel Mixture (Duplex) (200 HB)							◇			210	689
	M3	Martenistic Stainless Steel (240 HB)						◇				180	591
	S1	Iron-Based, Heat-Resistant Alloys (135–320 HB) (≤34 HRC)	◇									40	131
	S2	Cobalt-Based, Heat-Resistant Alloys (150–425 HB) (≤45 HRC)	◇									40	131

02-0959		Feed and Depth of Cut Ranges			
Chip Breaker	Insert Size Code	Inches		Metric	
HM	1.81.51	0.002 - 0.007	0.004 - 0.039	0.05 - 0.180	0.100 - 1.000