

Speeds and Feeds



02-0962			Speed - m/min (SFM)									Starting Conditions	
Grade	Material Group	Material Description	152 (500)	275 (900)	400 (1300)	520 (1700)	650 (2100)	750 (2500)	880 (2900)	1000 (3400)	1125 (3700)	m/min	sfm
HN25A/ HN25H	N1	Wrought Aluminum		◀▶								655	2150
	N2	Low-Silicon Aluminum Alloys and Magnesium		◀▶								655	2150
	N4	Copper-, Brass-, Zinc-Based on Machinability		◀▶								400	1350

02-0962		Feed and Depth of Cut Ranges			
Chip Breaker	Insert Size Code	Inches		Metric	
		fn (ipr)	ap (inch)	fn (mmpr)	ap (mm)
AL	1.81.51	0.001 - 0.005	0.004 - 0.118	.025 - 0.125	0.100 - 3.000