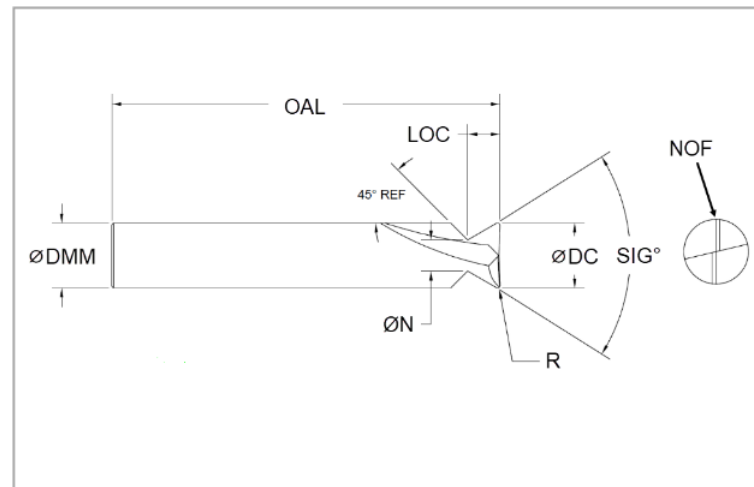


# Speeds and Feeds



		Cutting Speed (SMPM)			[Ø] Neck Diameter	1.73	1.85	2.41	3.18	4.75	6.35	7.92	9.53
		min	-	max									
Metric	P - Steel	120	-	180	MMPT	0.005	0.007	0.008	0.011	0.017	0.022	0.027	0.033
	M - Stainless Steel	60	-	135	MMPT	0.005	0.007	0.008	0.011	0.017	0.022	0.027	0.033
	K - Cast Iron	70	-	120	MMPT	0.014	0.018	0.021	0.028	0.042	0.056	0.070	0.084
	S - Titanium	30	-	45	MMPT	0.003	0.004	0.005	0.007	0.010	0.014	0.017	0.021
	S - High Temp Alloys	20	-	30	MMPT	0.003	0.004	0.005	0.007	0.010	0.014	0.017	0.021
	H - Hardened Steels	25	-	30	MMPT	0.003	0.003	0.004	0.006	0.008	0.011	0.014	0.017



	RPM - Speed	SMM - Cutting Speed
Find:	(RPM) Revolutions per Minute	(SMM) Surface Meters per Minute [m/min]
Given:	(D <sub>Tool</sub> ) Tool Diameter (SMM) Cutting Speed / Surface Meters per Minute	(RPM) Revolutions per Minute (D <sub>Tool</sub> ) Tool Diameter
Equation:	$RPM = \frac{SMM \times 1,000}{\pi \times D_{Tool}}$	$SMM = \frac{RPM \times \pi \times D_{Tool}}{1,000}$