

Speeds and Feeds



ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Side Cutting					
						1/4	5/16	3/8	1/2	5/8	3/4
K	15	Grey cast iron	0.050	1.50	SFM	665	665	665	665	665	665
					IPT	.0029	.0049	.0061	.0074	.0086	.0096
					RPM	10180	8140	6780	5090	4070	3390
					IPM	176	241	249	224	210	260
	16	Grey cast iron	0.050	1.50	SFM	665	665	665	665	665	665
					IPT	.0029	.0049	.0061	.0074	.0086	.0096
					RPM	10180	8140	6780	5090	4070	3390
					IPM	176	241	249	224	210	260
	17	Nodular cast iron	0.050	1.50	SFM	665	665	665	665	665	665
					IPT	.0029	.0049	.0061	.0074	.0086	.0096
					RPM	10180	8140	6780	5090	4070	3390
					IPM	176	241	249	224	210	260
18	Nodular cast iron	0.050	1.50	SFM	665	665	665	665	665	665	
				IPT	.0029	.0049	.0061	.0074	.0086	.0096	
				RPM	10180	8140	6780	5090	4070	3390	
				IPM	176	241	249	224	210	260	
19	Malleable cast iron	0.050	1.50	SFM	665	665	665	665	665	665	
				IPT	.0029	.0049	.0061	.0074	.0086	.0096	
				RPM	10180	8140	6780	5090	4070	3390	
				IPM	176	241	249	224	210	260	
20	Malleable cast iron	0.050	1.50	SFM	665	665	665	665	665	665	
				IPT	.0029	.0049	.0061	.0074	.0086	.0096	
				RPM	10180	8140	6780	5090	4070	3390	
				IPM	176	241	249	224	210	260	
H	38.1	Hardened steel	0.050	1.50	SFM	295	295	295	295	295	295
					IPT	.0014	.0025	.0031	.0037	.0044	.0049
					RPM	4540	3630	3030	2270	1820	1510
					IPM	39	55	57	51	47	59
	38.2	Hardened steel	0.050	1.50	SFM	150	150	150	150	150	150
					IPT	.0014	.0025	.0031	.0037	.0044	.0049
					RPM	2270	1820	1510	1130	910	760
					IPM	20	27	28	25	24	29
	40	Chilled Cast Iron	0.050	1.50	SFM	295	295	295	295	295	295
					IPT	.0014	.0025	.0031	.0037	.0044	.0049
					RPM	4540	3630	3030	2270	1820	1510
					IPM	39	55	57	51	47	59
41	Hardened Cast Iron	0.050	1.50	SFM	150	150	150	150	150	150	
				IPT	.0014	.0025	.0031	.0037	.0044	.0049	
				RPM	2270	1820	1510	1130	910	760	
				IPM	20	27	28	25	24	29	

