

Speeds and Feeds



How To Use This Chart:

- 1) Select your material in the ISO colored chart
- 2) Start with the recommended smm (vc) and feed (mm/rev)
 - Adjust the smm and/or feed rate based on your cutting conditions.

ISO	Material Description	Hardness	Insert Number	Insert Grade	
			02-0519	HN25A	
N	Aluminum wrought, alloyed Not curable (2024, 6061)	≤ 60 HB	●	Cutting Speed (vc = smm)	1200
				Feed (fz = mmpt)	0.30
N	Aluminum wrought, alloyed Curable, hardened (7075)	≤ 100 HB	●	Cutting Speed (vc = smm)	1005
				Feed (fz = mmpt)	0.25
N	Aluminum Cast, alloyed. ≤12% Si, Not curable	≤ 75 HB	●	Cutting Speed (vc = smm)	1005
				Feed (fz = mmpt)	0.25
N	Aluminum, alloyed >12% Si & Li alloys	≤ 130 HB	●	Cutting Speed (vc = smm)	302
				Feed (fz = mmpt)	0.23
N	Copper alloy Long chipping	≤ 110 HB	●	Cutting Speed (vc = smm)	402
				Feed (fz = mmpt)	0.20
N	Thermo Plastic		●	Cutting Speed (vc = smm)	350
				Feed (fz = mmpt)	0.15
N	Copper alloy Short chipping	≤ 100 HB	●	Cutting Speed (vc = smm)	503
				Feed (fz = mmpt)	0.20
N	Magnesium alloy	≤ 30 HB	●	Cutting Speed (vc = smm)	451
				Feed (fz = mmpt)	0.20
N	Duroplastics		●	Cutting Speed (vc = smm)	207
				Feed (fz = mmpt)	0.15

