

Speeds and Feeds



- 1) Select your material in the ISO colored chart.
- 2) Start with the recommended cutting speed, v_c (ft/min). Adjust the cutting speed based on your cutting conditions.

Group		Description	Hardness (HB)	Hardness (HRC)	Recommended Cutting Speed	
ISO	VDI 3323				Cutting Speed	
P	1	Non-Alloyed Steel	125		66-82	
	2		190	13	66-82	
	3		250	25	59-79	
	4		270	28	49-66	
	5		300	32		
	6	Low-Alloyed Steel	180	10	49-66	
	7		275	29		
	8		300	32		
	9		350	38		
	10		High-Alloyed Steel, and Tool Steel	200	15	
	11			325	35	
M	12	Stainless Steel	200	15	33-43	
	13		240	23	26-36	
	14		180	10	20-26	
S	31	Heat Resistant Super Alloys	200	15	49-66	
	32		280	30		
	33		250	25		
	34		350	38		
	35		320	34		
	36	Titanium Alloys	400 Rm		49-66	
	37		1050 Rm			

