

Speeds and Feeds



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

ISO	P	P	P	P	P	P	P	P	P	P	P	M	M	M	K	K	K	K	K	K	N	N	N	N	N	N	N	N	N			
VDI 3323	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30		
Material Description	Non-alloy steel					Low alloy steel					High alloyed steel, and tool steel		Stainless steel			Grey cast iron		Nodular cast iron		Malleable cast iron		Aluminum-wrought			Aluminum-cast, alloyed			Copper and Copper Alloys (Bronze / Brass)			Non Metallic Materials	
HB	125	190	250	270	300	180	275	300	350	200	325	200	240	180	180	260	160	250	130	230	60	100	75	90	130	110	90	100				
HRC		13	25	28	32	10	29	32	38	15	35	15	23	10	10	26	3	25		21												
	o	⊖	⊖	⊖	⊖	⊖	⊖	⊖	⊖	o		⊖	⊖	⊖	⊖	⊖	⊖	⊖					⊖			⊖	⊖	⊖				
Vc (m/min)	15-24	15-24	15-24	3-11	3-11	3-11	3-11	3-11	3-11	3-11		6-24	6-24	4-5	15-20	15-20	8-17	8-17							13-27			14-20	14-20	14-20		

