

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.

Material			Recommended Cutting Speed		
Group		Description	Hardness (HB)	Hardness (HRC)	Cutting Speed
ISO	VDI 3323				
K	15	Grey Cast Iron	180	10	15 - 20
	16		260	26	8 - 11
	17	Nodular Cast Iron	160	3	15 - 20
	18		250	25	8 - 11
	19	Malleable Cast Iron	130		15 - 20
	20		230	21	8 - 11
N	27	Copper and Copper Alloys (Bronze/Brass)	90		12 - 16