

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.

Material					Recommended Cutting Speed
Group		Description	Hardness (HB)	Hardness (HRC)	Cutting Speed
ISO	VDI 3323				
P	2	Non-Alloy Steel	190	13	15-20
	4		270	28	10-15
	6	Low Alloy Steel	180	10	10-15
	7		275	29	10-15
M	12	Stainless Steel	200	15	7-10
	13		240	23	5-8
	14		180	10	4-6
N	28	Copper and Copper Alloys (Bronze/Brass)	100		15-20