

Speeds and Feeds



ISO	VDI 3323	Material Description	HB	HRC		Vc (ft/min)
P	1	Non-alloy steel	125		○	50-80
P	2		190	13		50-80
P	3		250	25		50-80
P	4		270	28		10-35
P	5		300	32		10-35
P	6	Low alloy steel	180	10		10-35
P	7		275	29		10-35
P	8		300	32		10-35
P	9		350	38		10-35
P	10		200	15	○	10-35
P	11	High alloyed steel, and tool steel	325	35		
M	12	Stainless steel	200	15		20-50
M	13		240	23		20-50
M	14		180	10		12-15
K	15	Grey cast iron	180	10		50-65
K	16		260	26		50-65

K	17	Nodular cast iron	160	3		25-55
K	18		250	25		25-55
K	19	Malleable cast iron	130			
K	20		230	21		
N	21	Aluminum-wrought alloy	60			
N	22		100			
N	23	Aluminum-cast, alloyed	75			45-90
N	24		90			
N	25		130			
N	26	Copper and Copper Alloys (Bronze / Brass)	110			30-65
N	27		90			30-65
N	28		100			30-65
N	29	Non Metallic Materials				
N	30					
S	31	Heat Resistant Super Alloys	200	15		
S	32		280	30		
S	33		250	25		
S	34		350	38		
S	35		320	34		
S	36	Titanium Alloys	400 Rm			
S	37		1050 Rm			
H	38	Hardened steel	550	55		
H	39.1		630	60		
H	40	Chilled Cast Iron	400	42		
H	41	Hardened Cast Iron	550	55		