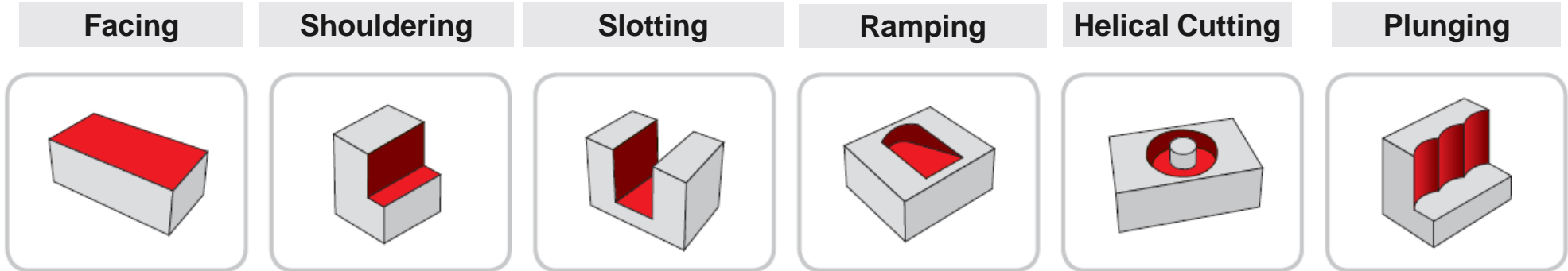


# Speeds and Feeds



## How To Use This Chart:

- 1) Select your material in the ISO colored chart
- 2) Start with the middle range of the recommended sfm (vc) and feed (inch/rev)
  - Adjust the sfm and/or feed rate based on your cutting conditions.



Workpiece Material	Recommended Grade	TNCT06T308-A		TNKT06T308-L		TNKT06T308-M		(maximum) ap
		vc (sfm)	fz (ipt)	vc (sfm)	HS Chip Breaker fz (ipt)	vc (sfm)	MHS Chip Breaker fz (ipt)	
P - Steels	HP25	-	-	524 - 885	0.002 - 0.008	524 - 885	0.002 - 0.010	0.217
	HU30	-	-	492 - 787	0.002 - 0.010	492 - 787	0.002 - 0.010	
	HU40	-	-	426 - 688	0.002 - 0.010	426 - 688	0.002 - 0.010	
M - Stainless Steels	HU30	-	-	295 - 492	0.002 - 0.006	295 - 492	0.002 - 0.008	
	HU40	-	-	229 - 393	0.002 - 0.006	229 - 393	0.002 - 0.008	
K - Cast Iron	HU30	-	-	393 - 656	0.003 - 0.010	393 - 656	0.003 - 0.012	
N - Aluminum	HN25A	1000 - 1800	0.003 - 0.008	-	-	-	-	

\* When surface and shoulder milling, the data refers to general cutting conditions and can be adjustable up to 1148 SFM and .020 IPT depending on user environment.

\* Please be sure to use cutting oil or air for ramping and helical machining.  $L_{min} = a_p / \tan(\alpha^\circ)$

