

# 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.

ISO	Material Description	Hardness	Insert Number	Insert Grade	
			02-0519	HN25A	
N	Aluminum wrought, alloyed Not curable (2024, 6061)	≤ 60 HB	●	Cutting Speed (vc = sfm)	3936
				Feed (fz = ipt)	0.012
N	Aluminum wrought, alloyed Curable, hardened (7075)	≤ 100 HB	●	Cutting Speed (vc = sfm)	3300
				Feed (fz = ipt)	0.01
N	Aluminum Cast, alloyed. ≤12% Si, Not curable	≤ 75 HB	●	Cutting Speed (vc = sfm)	3300
				Feed (fz = ipt)	0.01
N	Aluminum, alloyed >12% Si & Li alloys	≤ 130 HB	●	Cutting Speed (vc = sfm)	990
				Feed (fz = ipt)	0.009
N	Copper alloy Long chipping	≤ 110 HB	●	Cutting Speed (vc = sfm)	1320
				Feed (fz = ipt)	0.008
N	Thermo Plastic		●	Cutting Speed (vc = sfm)	1150
				Feed (fz = ipt)	0.006
N	Copper alloy Short chipping	≤ 100 HB	●	Cutting Speed (vc = sfm)	1650
				Feed (fz = ipt)	0.008
N	Magnesium alloy	≤ 30 HB	●	Cutting Speed (vc = sfm)	1480
				Feed (fz = ipt)	0.008
N	Duroplastics		●	Cutting Speed (vc = sfm)	680
				Feed (fz = ipt)	0.006

