

Insert Speeds & Feeds

Material		TURNING		MILLING		DRILLING	
		SFM	Inch/ Rev	SFM	Inch/ Rev	SFM	Inch/ Rev
<b>P</b>	Mild Steel	490-1200	.004-.031	250-800	.003-.015	225-650	.0022-.006
	Annealed Alloy Steel	490-980		200-725		200-650	
	Hardened Alloy Steel	180-500		200-600		100-300	
	Cast Steel	180-650		200-600		150-550	
<b>M</b>	Stainless Steel	280-810	.004-.015	200-600	.003-.015	250-430	.002-.006
<b>K</b>	Low Cast Iron	590-1240	.004-.024	325-600	.004-.016	300-600	.0025-.009
	High Cast Iron	360-700		325-600		300-600	
	Cast Iron (CBN INSERTS)	400-600	.002-.020				
<b>N</b>	Alum. Alloy Un-heat Treated	850-1980	.004-.018	860-1800	.007-.018	600-1100	.0038-.011
	Alum. Alloy Heat Treated	550-1650		575-1230		315-790	
	Cast Alum. & Copper Alloy	360-950		280-930		250-760	
<b>H</b>	Hardened Material (CBN INSERTS)	450-950	.002-.011				
<b>S</b>	Heat Resistant Steels	100-300	.002-.006	100-300	.0024-.008	60-150	.0028-.008

Chipbreaker Designation

ISO	FINISHING	Medium	Roughing
<b>P</b>	CX2, LX6, SP1, SP2, SX1, ZX3 CM1, CM3, CX2, LX6, ZM1	CX1, LX3, ZP1 CM1, CM2, LX3	CP2, LX2 LX2
<b>M</b>			
<b>K</b>	ZX3	ZK1, ZK2 CS1	
<b>N</b>	SX1, ZN1	CN1, LX2, LX3	
<b>S</b>	ZX3	ZK1, ZK2 CS1	