



Material		Feed IPR	Speed -SFM (Carbide-TIN)
Aluminum	150<Bn<250	.001-.003	300-400
Low Carbon Steel	100<Bn<225	.001-.003	200-260
Med. Carbon Steel	150<Bn<250	.001-.003	100-240
Free Machining Alloy	150<Bn<250	.001-.003	140-200
High Alloy Steel	200<Bn<350	.001-.003	100-130
Stainless Steel	150<Bn<250	.001-.003	100-150
Gray Cast Iron	150<Bn<220 200<Bn<330	.001-.003	180-240 140-210
Nodular Cast Iron	150<Bn<250 200<Bn<300	.001-.003	180-250 140-210
Nickel Base Alloy*	14<Rc<22 22<Rc<32	.0008-.0015	30-80 20-50
Titanium Alloy	14<Rc<22 22<Rc<32	.0008-.0015	60-90