

Technical Section

Cutting Data

ISO	Materials	Cutting Speed ft/min	Recommended feed rate inch/rev
P	Low and Medium Carbon Steels <0.55%C	80-230	Grooving: .0004 - .001 Back turning: .001 - .004 Face grooving: .0004 - .003 Chamfering: .001 - .003
	High Carbon Steels ≥0.55%C	65-165	
	Alloy Steels, Treated Steels	50-100	
M	Stainless Steels - Free Cutting	80-230	
	Stainless Steels - Austenitic	65-130	
	Cast Steels	100-230	
K	Cast Iron	50-100	
N	Aluminum ≤12%Si, Copper	100-300	
	Aluminum >12% Si	65-230	
	Synthetics, Duroplastics, Thermoplastics	65-230	
S	Nickel Alloys, Titanium Alloys	65-165	
H	Hardened Steel 45 - 50HRc	30-130	

Threading Passes

Pitch:	mm	0.5	0.7	0.8	1.0	1.25	1.5	2-5
	TPI	48	36	32	24	20	16	
Number of Passes		6-12	7-14	7-16	8-18	8-20	10-22	20-38