

## STANDARD CUTTING CONDITIONS

### Counter boring

ISO	Workpiece materials	Cutting speed $V_c$ (m/min)	Feed : $f$ (mm/rev)	
			$\phi 10 - 12$ ( $z = 1$ )	$\phi 13 - 59$ ( $z = 2$ )
<b>P</b>	Carbon steel	80 - 200	0.03 - 0.08	0.1 - 0.3
<b>M</b>	Stainless steel	80 - 150	0.03 - 0.05	0.06 - 0.15
<b>K</b>	Grey cast iron	80 - 200	0.05 - 0.1	0.1 - 0.4
<b>N</b>	Non-ferrous	100 - 300	0.05 - 0.2	0.1 - 0.4
<b>S</b>	Superalloys	50 - 80	0.03 - 0.05	0.06 - 0.15
<b>H</b>	Hard materials	50 - 80	0.03 - 0.05	0.06 - 0.15

### Milling

ISO	Workpiece materials	Cutting speed $V_c$ (m/min)	Feed per tooth $f_z$ (mm/t)
<b>P</b>	Carbon steel	80 - 200	0.05 - 0.15
<b>M</b>	Stainless steel	80 - 150	0.05 - 0.1
<b>K</b>	Grey cast iron	80 - 200	0.05 - 0.2
<b>N</b>	Non-ferrous	100 - 300	0.1 - 0.2
<b>S</b>	Superalloys	50 - 80	0.05 - 0.08
<b>H</b>	Hard materials	50 - 80	0.05 - 0.08

### Internal boring (With one cutting edge)

ISO	Workpiece materials	Cutting speed $V_c$ (m/min)	Depth of cut $a_p$ (mm)	Feed $f$ (mm/rev)
<b>P</b>	Carbon steel	80 - 200	0.5 -	0.05 - 0.15
<b>M</b>	Stainless steel	80 - 150	0.5 -	0.05 - 0.1
<b>K</b>	Grey cast iron	80 - 200	0.5 -	0.05 - 0.2
<b>N</b>	Non-ferrous	100 - 300	0.5 -	0.1 - 0.2
<b>S</b>	Superalloys	50 - 80	0.5 -	0.05 - 0.08
<b>H</b>	Hard materials	50 - 80	0.5 -	0.05 - 0.08