

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Cutting speed Vc (sfm)	Feed: <i>f</i> (ipr)		
			øDc (in)		
			1.024" - 1.177"	1.181" - 1.403"	1.417" - 1.614"
P	Low carbon steels 1015, etc.	262 - 459	0.008 - 0.02	0.008 - 0.02	0.01 - 0.022
	Carbon steels, Alloy steels 1055, 44140, etc.	262 - 427	0.008 - 0.02	0.008 - 0.02	0.01 - 0.022
	Prehardened steels NAK80, PX5, etc.	164 - 328	0.008 - 0.02	0.008 - 0.02	0.01 - 0.022
M	Stainless steels S30400, etc.	131 - 262	0.006 - 0.012	0.006 - 0.012	0.008 - 0.014
K	Gray cast irons No.250B, No.300B, etc.	262 - 591	0.01 - 0.022	0.01 - 0.022	0.012 - 0.024
	Ductile cast irons 60-40-18, 80-55-06, etc.	262 - 459	0.01 - 0.022	0.01 - 0.022	0.012 - 0.024
N	Non ferrous materials	328 - 722	0.016 - 0.024	0.016 - 0.024	0.02 - 0.028
S	Heat-resistant alloy Inconel718, etc.	66 - 164	0.004 - 0.008	0.004 - 0.008	0.004 - 0.01
	Titanium alloys Ti-6Al-4V, etc.	98 - 197	0.004 - 0.008	0.004 - 0.008	0.004 - 0.01
H	Hardened materials	66 - 197	0.004 - 0.008	0.004 - 0.008	0.004 - 0.01