

Speeds and Feeds



Material				Parameter	
Tool	GROUP		Description	Speeds / Feeds	Carbide Specialty Profile Cutters*
	ISO	VDI 3323			
AlTiN Coated	P	1 - 5	Steel - Non-Alloy, Cast & Free Cutting	Vc, SFM	350
				Fz, IPT	0.0002 - 0.0005
	M	12 - 14.4	Stainless Steel	Vc, SFM	225
				Fz, IPT	0.0002 - 0.0005
	S	36 - 37	Titanium & Ti Alloys	Vc, SFM	125
				Fz, IPT	0.0002 - 0.0005
Uncoated*	N	21 - 25	Aluminum Wrought / Cast Alloys	Vc, SFM	1000
				Fz, IPT	0.0003 - 0.003

*Reduce the displayed speeds by 25% when using uncoated tools on P-steel, M-stainless steel, and S-high temp. alloys

*For slot/chamfer cutters, allowable chip load/feed is 50% of the maximum limits shown to prevent chip packing, especially on 4 flute tools