

Recommended Speeds and Feeds

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Material	Carbide Series			HSS Series		
	SFM	Feed	(IPR)	SFM	Feed	(IPR)
Free Machining	230 - 260	0.008 - 0.015		75 - 126	.003 - .010	
Aluminum	230 - 260	0.008 - 0.015		90 - 150	.003 - .008	
Cast Iron	230 - 260	0.008 - 0.015		40 - 60	.003 - .010	
Low Carbon	230 - 260	0.008 - 0.015		60 - 100	.004 - .011	
Med Carbon	200 - 230	0.006 - 0.012		45 - 80	.003 - .010	
Stainless	180 - 220	0.004 - 0.008		20 - 40	.003 - .010	
High Alloy Steel	180 - 220	0.006 - 0.012		25 - 50	.003 - .010	

The speeds and feeds above are intended as guidelines only.

Terms

IPM = Inches Per Minute
 IPR = Inches Per Revolution
 RPM = Revolutions Per Minute
 SFM = Surface Feet Per Minute
 DIA = Tool Diameter

Formula

Inches (decimal)	mm (metric)
$RPM = \frac{SFM \times 3.82}{DIA}$	$RPM = \frac{M/min \times 318.47}{DIA}$
$IPM = RPM \times IPR$	$mm/min = RPM \times mm/REV$
$SFM = \frac{RPM \times DIA}{3.82}$	$M/min = \frac{RPM \times DIA}{318.47}$

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