

This chart includes recommended application values only. Recommended speed and feed rates may be increased up to 25% with TiN coated boring tools. The approximate feed rate depends on factors like tool size, overhang, cutting material, and surface requirements.

MATERIAL	CUTTING SPEED Meter per Minute V m/min.	CUTTING SPEED Feed per Minute V=f/min.	FEED RATE mm per Revolution mm/r	FEED RATE Inch per Revolution inch/r
Aluminum 6061	610	2000	0.025 – 0.125	0.001 – 0.005
Aluminum 7075	610	2000	0.025 – 0.125	0.001 – 0.005
Cast Iron, Soft	140 – 150	470 – 480	0.025 – 0.125	0.001 – 0.005
Cast Iron, Medium	80 – 120	300 – 400	0.025 – 0.125	0.001 – 0.005
Cast Iron, Malleable	110 – 140	350 – 400	0.025 – 0.125	0.001 – 0.005
Brass	230 – 280	750 – 900	0.025 – 0.125	0.001 – 0.005
Bronze	230 – 280	750 – 900	0.025 – 0.125	0.001 – 0.005
Copper	230 – 280	750 – 900	0.025 – 0.125	0.001 – 0.005
Magnesium	610	2000	0.025 – 0.125	0.001 – 0.005
Nickel Alloys, Nickel 200	90	300	0.025 – 0.125	0.001 – 0.005
Monel	60 – 65	200	0.025 – 0.125	0.001 – 0.005
Stainless Steels 316/316L	62	200	0.025 – 0.125	0.001 – 0.005
Stainless Steel 304	80	250	0.025 – 0.125	0.001 – 0.005
Stainless Steel 17-4 PH	85	275	0.025 – 0.125	0.001 – 0.005
Stainless Steel 15-5 PH	80	250	0.025 – 0.125	0.001 – 0.005
Steels, Low Carbon	115 – 150	350 – 475	0.025 – 0.125	0.001 – 0.005
Steels, Medium Carbon	100 – 130	300 – 400	0.025 – 0.125	0.001 – 0.005
Steels, High Tensile (35-40 Rc)	80 – 96	250 – 300	0.025 – 0.125	0.001 – 0.005
Steels, High Tensile (45+ Rc)	40	125	0.025 – 0.125	0.001 – 0.005
Tool Steels D-2	50 – 65	150 – 200	0.025 – 0.125	0.001 – 0.005
Mold Steel P-20	115 – 145	350 – 450	0.025 – 0.125	0.001 – 0.005
High Temperature Alloys	50 – 65	150 – 200	0.025 – 0.125	0.001 – 0.005
Titanium	65 – 80	150 – 200	0.025 – 0.125	0.001 – 0.005
Molybdenum	65 – 80	200 – 250	0.025 – 0.125	0.001 – 0.005
Inconel	25	70	0.025 – 0.125	0.001 – 0.005
Rene 41	20	60	0.025 – 0.125	0.001 – 0.005
Waspalloy	25	70	0.025 – 0.125	0.001 – 0.005