

## SPEEDS AND FEEDS FOR FACE GROOVING

MATERIAL	TYPE	SPEED SURFACE FEET PER MINUTE	FEED Inches per revolution
PLASTIC	TEFLON	350-400	.003 - .006
	NYLON	350-600	.001 - .003
	PHENOLIC	500-600	.001 - .003
	GLASS FILLED	250-300	.001 - .003
MAGNESIUM	AZ,AM,EZ,ZE,HK	850-1000	.001 - .002
ALUMINUM	2021 THRU 6061	900-1000	.002 - .003
COPPER	101-707	450-500	.002 - .003
	834-978	500-600	.001 - .002
BRASS		200-250	.001 - .002
BRONZE		200-250	.001 - .002
CAST IRON	GRAY	120-350	.002 - .003
	DUCTILE	70-350	.002 - .003
	MALLEABLE	75-550	.002 - .003
STEEL	1005-1029	250-450	.002 - .003
	1030-1055	110-370	.001 - .003
	1060-1095	90-250	.001 - .003
	10L45-10L50	130-450	.002 - .003
	12L13-12L15	550-600	.002 - .003
	41L30-41L50	65-350	.002 - .003
	4140-4150	65-400	.002 - .003
	4140 (35 HRC)	190-200	.001 - .003
	8617-8622	100-400	.001 - .002
	M1-M6	150-200	.001 - .002
	H10-H19	65-250	.001 - .002
	D2-D7	150-200	.001 - .002
	A2-A9, 01-07	150-250	.001 - .002
	W1, W2	150-250	.001 - .002
M-50, 52100	60-300	.001 - .002	
TITANIUM	TI-9Al-6V	90-100	.001 - .002
STAINLESS	201-385	200-280	.001 - .002
	405-446	250-300	.001 - .002
	15-5PH, 16-6PH, 14-4PH	100-200	.001 - .002
NICKEL	NICKEL 200-230	200-250	.001 - .002
MONEL		100-150	.001 - .002
INCONEL		40-50	.001 - .002
WASPALLOY		70-100	.001 - .002
HASTELLOY		70-90	.001 - .002

NOTE: ALL SPEEDS AND FEEDS LISTED HERE ARE PROVIDED FOR REFERENCE ONLY.

$$\frac{RPM = SFM \times 12}{(\pi) \times \text{DIAMETER}}$$