

**SPEEDS AND FEEDS FOR GROOVING TOOLS**

MATERIAL	TYPE	SPEED SURFACE FEET PER MINUTE	FEED	FEED	FEED
			Inches per revolution CARBIDE INSERT OUR SERIES 26 PAGE 53	Inches per revolution SOLID CARBIDE OUR SERIES 20 PAGE 10	Inches per revolution TIN COATED SOLID CARBIDE OUR SERIES 22 PAGE 11
PLASTIC	TEFLON	350-400	.003 - .006	.007	.012
	NYLON	350-600	.001 - .003	.007	.012
	PHENOLIC	500-600	.001 - .003	.007	.012
	GLASS FILLED	250-300	.001 - .003	.005	.012
MAGNESIUM	AZ,AM,EZ,ZE,HK	850-1000	.005 - .012	.008	.012
ALUMINUM	2021 THRU 6061	900-1000	.005 - .012	.008	.014
COPPER	101-707	150-170	.003 - .005	.008	.014
	834-978	500-600	.003 - .005	.008	.014
BRASS		200-250	.001 - .003	.006	.011
BRONZE		200-250	.001 - .002	.006	.011
CAST IRON	GRAY	120-350	.004 - .010	.007	.007
	DUCTILE	70-350	.004 - .010	.007	.007
	MALLEABLE	75-550	.004 - .010	.007	.007
STEEL	1005-1029	250-450	.003 - .007	.007	.014
	1030-1055	110-370	.003 - .007	.007	.014
	1060-1095	90-250	.003 - .005	.007	.014
	10L45-10L50	130-450	.004 - .006	.007	.014
	12L13-12L15	550-600	.003 - .005	.007	.014
	41L30-41L50	65-350	.003 - .005	.007	.014
	4140-4150	65-400	.003 - .005	.007	.014
	4140 (35 HRC)	190-200	.001 - .004	.004	.007
	8617-8622	100-400	.002 - .004	.007	.006
	M1-M6	150-200	.003 - .008	.006	.005
	H10-H19	65-250	.003 - .007	.006	.005
	D2-D7	150-200	.004 - .010	.006	.005
	A2-A9, 01-07	150-250	.003 - .008	.006	.005
	W1, W2	150-250	.003 - .008	.006	.006
M-50, 52100	60-300	.004 - .010	.007	.006	
TITANIUM	TI-9AI-6V	90-100	.001 - .003	.005	.008
STAINLESS	201-385	200-280	.001 - .004	.005	.008
	405-446	250-300	.001 - .004	.005	.008
	15-5PH,16-6PH,14-4PH	100-200	.002 - .004	.005	.008
NICKEL	NICKEL 200-230	200-250	.002 - .005	.004	.007
MONEL		100-150	.001 - .003	.004	.007
INCONEL		40-50	.001 - .003	.004	.007
WASPALOY		70-100	.001 - .003	.004	.007
HASTELLOY		70-90	.001 - .003	.004	.007

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

**RPM=SFM X 12  
(D) X DIAMETER**