

Speed & Feed Guide

Series 270

815 | Multi Flute | Square & Radius | Ni-Alloys

Material	Axial ↓	Radial →	SFM	1/8		1/4		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
P	Carbon Steel 10XX, 11XX, 12XX, 13XX	1 x D	.3 x D	220	6723	13	3362	13	2241	16	1681	17	1345	16	1121	15
		1.25 x D	.2 x D	264	8068	19	4034	194	2689	23	2017	24	1614	23	1345	21
		1.5 X D	.08 x D	317	9681	39	4841	39	3227	45	2420	47	1936	46	1614	42
		1.5 x D	.05 x D	380	11618	60	5809	51	3873	59	2904	62	2324	59	1936	54
	Alloy Steel 4140, 8620	1 x D	.3 x D	180	5501	11	2750	15	1834	13	1375	14	1100	13	917	12
		1.25 x D	.2 x D	225	6876	17	3438	23	2292	20	1719	21	1375	20	1146	18
		1.5 X D	.08 x D	270	8251	33	4126	462	2750	39	2063	40	1650	39	1375	36
		1.5 x D	.05 x D	297	9076	47	4538	54	3025	46	2269	48	1815	46	1513	42
	Tool Steel A2 ,A3, D2, H11, H13	.5 x D	.3 x D	160	4890	10	2445	14	1630	12	1222	12	978	12	815	11
		1.0 x D	.2 x D	200	6112	15	3056	21	2037	18	1528	18	1222	18	1019	16
		1.5 x D	.08 x D	240	7334	29	3667	411	2445	34	1834	36	1467	35	1222	32
		1.5 x D	.05 x D	264	8068	42	4034	48	2689	41	2017	43	1614	41	1345	38
M	SS 300 & 400 Series 303, 304, 316, 420, 417	.75 x D	.3 x D	140	4278	9	2139	7	1426	10	1070	11	856	10	713	9
		1.25 x D	.2 x D	185	5654	14	2827	11	1885	16	1413	17	1131	16	942	15
		1.5 x D	.08 x D	230	7039	28	3519	23	2346	33	1760	34	1408	33	1173	30
		1.5 x D	.05 x D	276	8446	44	4223	34	2815	43	2112	45	1689	43	1408	40
	Precipitation SS 15-5, 16-6, 17-4, 17-6	.5 x D	.3 x D	115	3514	7	1757	6	1171	7	879	7	703	7	586	6
		1.25 x D	.2 x D	180	5501	13	2750	11	1834	12	1375	12	1100	12	917	11
		1.5 x D	.08 x D	250	7640	31	3820	24	2547	26	1910	28	1528	27	1273	24
		1.5 x D	.05 x D	300	9168	48	4584	37	3056	44	2292	46	1834	44	1528	41
S	High Temp Alloys Inconel 718, Hastalloy, A286, Waspalloy, CoCr	.25 x D	.3 x D	70	2139	4	1070	3	713	4	535	4	428	4	357	4
		1 x D	.2 x D	80	2445	6	1222	5	815	5	611	5	489	5	407	5
		1.25 x D	.08 x D	125	3820	15	1910	12	1273	13	955	14	764	13	637	12
		1.5 x D	.05 x D	160	4890	25	2445	20	1630	23	1222	25	978	24	815	22