

Speed & Feed Guide

Series 2205, 2213

538 | 5 FL | Square & Radius | PYSTL

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	1 x D	220	6723	17	3362	17	2241	20	1681	21	1345	20	1121	19
		1.25 x D	.3 x D	264	8068	24	4034	24	2689	29	2017	30	1614	29	1345	27
		1.5 X D	.1 x D	343	10488	52	5244	52	3496	63	2622	66	2098	63	1748	58
	Alloy Steel 4140, 8620	1 x D	1 x D	180	5501	16	2750	20	1834	16	1375	16	1100	16	917	14
		1.25 x D	.3 x D	225	6876	24	3438	29	2292	24	1719	25	1375	24	1146	22
		1.5 X D	.1 x D	270	8251	47	4126	59	2750	47	2063	49	1650	47	1375	43
	Tool Steel A2 ,A3, D2, H11, H13	1 x D	.5 x D	180	5501	13	2750	13	1834	16	1375	16	1100	16	917	14
		1.25 x D	.3 x D	225	6876	20	3438	20	2292	24	1719	25	1375	24	1146	22
		1.5 X D	.1 x D	270	8251	39	4126	39	2750	47	2063	49	1650	47	1375	43
M	SS 300 & 400 Series 303, 304, 316, 420, 416	.75 x D	1 x D	140	4278	9	2139	9	1426	10	1070	11	856	11	713	10
		1.25 x D	.3 x D	185	5654	14	2827	14	1885	17	1413	17	1131	17	942	15
		1.5 x D	.1 x D	230	7039	29	3519	29	2346	34	1760	36	1408	35	1173	32
	Precipitation SS 15-5, 16-6, 17-4, 17-5	0.5	1 x D	115	3514	7	1757	7	1171	8	879	9	703	8	586	8
		1.25 x D	.3 x D	180	5501	13	2750	13	1834	15	1375	16	1100	15	917	14
		1.5 x D	.1 x D	250	7640	30	3820	30	2547	35	1910	37	1528	36	1273	33
K	Cast Iron - Grey GG-10 to GG-40	1 x D	1 x D	100	3056	7	1528	7	1019	8	764	9	611	8	509	8
		1.25 x D	.3 x D	125	3820	10	1910	10	1273	12	955	13	764	13	637	11
		1.5 X D	.1 x D	163	4966	22	2483	22	1655	27	1242	28	993	27	828	25
	Cast Iron- Ductile GGG-40, to GGG-70	.75 x D	1 x D	155	4737	10	2368	10	1579	12	1184	13	947	12	789	11
		1.25 x D	.3 x D	180	5501	14	2750	14	1834	17	1375	18	1100	17	917	16
		1.5 x D	.1 x D	216	6601	28	3300	28	2200	34	1650	36	1320	34	1100	31
S	High Temp Alloys Inconel 718, Hastalloy, Waspalloy, A286, CoCr	.25 x D	.4 x D	70	2139	4	1070	4	713	5	535	5	428	5	357	4
		1.25 x D	.2 x D	80	2445	5	1222	5	815	6	611	7	489	7	407	6
		1.5 x D	.07 x D	125	3820	14	1910	14	1273	17	955	18	764	17	637	16
	Titanium Alloy Ti-6Al4V Grades (5-38)	0.5	1 x D	180	5501	10	2750	10	1834	12	1375	12	1100	12	917	11
		1.25 x D	.3 x D	225	6876	14	3438	14	2292	17	1719	18	1375	17	1146	16
		1.5 x D	.1 x D	360	11002	38	5501	38	3667	46	2750	48	2200	46	1834	43