

# Speed & Feed Guide

## Series 1040

HGW7 | 7 FL | Square & Radius | Hurrmill

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	
<b>P</b>	<b>Carbon Steel</b> 10XX, 11XX, 12XX, 13XX	1 x D	1 x D	<b>220</b>	6723	24	3362	24	2241	28	1681	30	1345	28	1121	26
		1.25 x D	.3 x D	<b>264</b>	8068	34	4034	34	2689	41	2017	43	1614	41	1345	38
		1.5 X D	.1 x D	<b>343</b>	10488	73	5244	73	3496	88	2622	93	2098	89	1748	81
	<b>Alloy Steel</b> 4140, 8620	1 x D	1 x D	<b>180</b>	5501	37	2750	27	1834	22	1375	23	1100	22	917	20
		1.25 x D	.3 x D	<b>225</b>	6876	55	3438	41	2292	33	1719	35	1375	33	1146	30
		1.5 X D	.1 x D	<b>270</b>	8251	110	4126	82	2750	66	2063	69	1650	66	1375	61
	<b>Tool Steel</b> A2 ,A3, D2, H11, H13	1 x D	.5 x D	<b>180</b>	5501	18	2750	18	1834	22	1375	23	1100	22	917	20
		1.25 x D	.3 x D	<b>225</b>	6876	27	3438	27	2292	33	1719	35	1375	33	1146	30
		1.5 X D	.1 x D	<b>270</b>	8251	55	4126	55	2750	66	2063	69	1650	66	1375	61
<b>M</b>	<b>SS</b> 300 & 400 Series 303, 304, 316, 420, 417	.75 x D	1 x D	<b>140</b>	4278	12	2139	12	1426	15	1070	15	856	15	713	14
		1.25 x D	.3 x D	<b>185</b>	5654	19	2827	19	1885	23	1413	24	1131	23	942	21
		1.5 x D	.1 x D	<b>230</b>	7039	40	3519	40	2346	48	1760	51	1408	49	1173	44
	<b>Precipitation SS</b> 15-5, 16-6, 17-4, 17-6	2 X D	0.07 X D	<b>393 - 800</b>	12000	70	10696	107	7131	107	5348	107	4270	107	4075	107
		1.5 X D	0.15 X D	<b>393 - 800</b>	12000	80	10696	122	7131	122	5348	122	4270	122	4075	122
		1.0 X D	0.25 X D	<b>393 - 800</b>	12000	96	10696	146	7131	146	5348	146	4270	146	4075	146
<b>S</b>	<b>High Temp Alloys</b> Inconel 718, Hastalloy, A286, Waspalloy, CoCr	2 X D	0.07 X D	<b>93 - 125</b>	3820	10	1910	8	1273	5	955	8	764	8	477	6
		1.5 X D	0.15 X D	<b>84 - 112</b>	3438	8	1719	6	1146	4	860	6	688	6	429	5
		1.0 X D	0.25 X D	<b>70-90</b>	2865	6	1433	5	955	3	716	5	573	5	358	4