

SPEED & FEED GUIDE



Optimum Performance

Series 210, 215

335 335BN 3 FLUTE

	Material	Axial ↓	Radial →	SFM	1/4		5/16		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	.5 x D	1 x D	220	3362	10	2689	12	2241	12	1681	13	1345	12	1121	12
		1.25 x D	.3 x D	264	4034	15	3227	17	2689	17	2017	18	1614	18	1345	18
		1.5 X D	.1 x D	343	5244	31	4195	38	3496	38	2622	40	2098	38	1748	38
	Alloy Steel 4140, 8620	.5 x D	1 x D	180	2750	8	2200	9	1834	9	1375	10	1100	9	917	9
		1.25 x D	.3 x D	225	3438	12	2750	14	2292	14	1719	15	1375	14	1146	13
		1.5 X D	.1 x D	270	4126	24	3300	28	2750	28	2063	30	1650	28	1375	26
	Tool Steel A2 ,A3, D2, H11, H13	.5 x D	1 x D	160	2445	6	1956	7	1630	8	1222	8	978	8	815	9
		1.0 x D	.3 x D	200	3056	10	2445	13	2037	14	1528	14	1222	14	1019	17
		1.5 x D	.1 x D	240	3667	17	2934	20	2445	21	1834	23	1467	22	1222	26
M	SS 300 & 400 Series303, 304, 316, 420, 416	.5 x D	1 x D	140	2139	5	1711	6	1426	6	1070	7	856	6	713	6
		1.25 x D	.3 x D	185	2827	8	2261	10	1885	10	1413	10	1131	10	942	9
		1.5 x D	.1 x D	230	3519	17	2815	21	2346	21	1760	22	1408	21	1173	19
	Precipitation SS 15-5, 16-6, 17-4, 17-5	.5 x D	1 x D	115	1757	4	1406	5	1171	5	879	5	703	5	586	5
		1.25 x D	.3 x D	180	2750	8	2200	9	1834	9	1375	10	1100	9	917	8
		1.5 x D	.1 x D	250	3820	18	3056	21	2547	21	1910	22	1528	21	1273	20
K	Cast Iron- Grey, GG-10 to GG-40	1 x D	1 x D	100	1528	4	1222	5	1019	5	764	5	611	5	509	5
		1.25 x D	.3 x D	125	1910	6	1528	7	1273	7	955	8	764	8	637	7
		1.5 X D	.1 x D	163	2483	13	1986	16	1655	16	1242	17	993	16	828	15
	Cast Iron- Ductile GGG-40, to GGG-70	.75 x D	1 x D	155	2368	6	1895	7	1579	7	1184	8	947	7	789	7
		1.25 x D	.3 x D	180	2750	8	2200	10	1834	10	1375	11	1100	10	917	9
		1.5 x D	.1 x D	216	3300	17	2640	20	2200	20	1650	21	1320	21	1100	19
S	High Temp Alloys Inconel 718, Hastalloy, Waspalloy, A286, CoCr	.5 x D	1 x D	70	1070	2	856	3	713	3	535	3	428	3	357	3
		1.25 x D	.2 x D	80	1222	3	978	4	815	4	611	4	489	4	407	4
		1.5 x D	.07 x D	125	1910	8	1528	10	1273	10	955	11	764	10	637	9
	Titanium Alloy Ti-6Al4V Grades (5-38)	.5 x D	1 x D	180	2750	6	2200	7	1834	7	1375	7	1100	7	917	6
		1.25 x D	.3 x D	225	3438	9	2750	10	2292	10	1719	11	1375	10	1146	10
		1.5 x D	.1 x D	360	5501	23	4401	28	3667	28	2750	29	2200	28	1834	26