

Speed & Feed Guide

Series 2215

738 | 7 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	24	3362	24	2241	28	1681	30	1345	28	1121	26
		1.25 x D	.3 x D	264	8068	34	4034	34	2689	41	2017	43	1614	41	1345	38
		1.5 X D	.1 x D	343	10488	73	5244	73	3496	88	2622	93	2098	89	1748	81
	Alloy Steel 4140, 8620	1 x D	1 x D	180	5501	37	2750	27	1834	22	1375	23	1100	22	917	20
		1.25 x D	.3 x D	225	6876	55	3438	41	2292	33	1719	35	1375	33	1146	30
		1.5 X D	.1 x D	270	8251	110	4126	82	2750	66	2063	69	1650	66	1375	61
	Tool Steel A2 ,A3, D2, H11, H13	1 x D	.5 x D	180	5501	18	2750	18	1834	22	1375	23	1100	22	917	20
		1.25 x D	.3 x D	225	6876	27	3438	27	2292	33	1719	35	1375	33	1146	30
		1.5 X D	.1 x D	270	8251	55	4126	55	2750	66	2063	69	1650	66	1375	61
M	SS 300 & 400 Series 303, 304, 316, 420, 416	.75 x D	1 x D	140	4278	12	2139	12	1426	15	1070	15	856	15	713	14
		1.25 x D	.3 x D	185	5654	19	2827	19	1885	23	1413	24	1131	23	942	21
		1.5 x D	.1 x D	230	7039	40	3519	40	2346	48	1760	51	1408	49	1173	44
	Precipitation SS 15-5, 16-6, 17-4, 17-5	0.5	1 x D	115	3514	10	1757	10	1171	11	879	12	703	12	586	11
		1.25 x D	.3 x D	180	5501	18	2750	18	1834	21	1375	23	1100	22	917	20
		1.5 x D	.1 x D	250	7640	41	3820	41	2547	50	1910	52	1528	50	1273	46
K	Cast Iron - Grey, GG-10 to GG-40	1 x D	1 x D	100	3056	10	1528	10	1019	12	764	12	611	12	509	11
		1.25 x D	.3 x D	125	3820	14	1910	14	1273	17	955	18	764	18	637	16
		1.5 X D	.1 x D	163	4966	31	2483	31	1655	38	1242	40	993	38	828	35
	Cast Iron - Ductile GGG-40, to GGG-70	.75 x D	1 x D	155	4737	14	2368	14	1579	17	1184	18	947	17	789	16
		1.25 x D	.3 x D	180	5501	20	2750	20	1834	24	1375	25	1100	24	917	22
		1.5 x D	.1 x D	216	6601	40	3300	40	2200	48	1650	50	1320	48	1100	44
S	High Temp Alloys Inconel 718, Hastalloy, Waspalloy, A286, CoCr	.25 x D	.4 x D	70	2139	6	1070	6	713	7	535	7	428	7	357	6
		1.25 x D	.2 x D	80	2445	8	1222	8	815	9	611	10	489	9	407	8
		1.5 x D	.07 x D	125	3820	20	1910	20	1273	24	955	25	764	24	637	22
	Titanium Alloy Ti-6Al4V Grades (5-38)	0.5	1 x D	180	5501	13	2750	13	1834	16	1375	17	1100	16	917	15
		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	360	11002	54	5501	54	3667	65	2750	68	2200	65	1834	60