MATERIAL	Hardness: 29-37 Rc (279-344 HBn)														
	SFM	Chip Load (PT)			Depth of Cut		Chip Load (FT)						Depth of Cut		
			0.015	0.031	0.047	Radial	Asiai	0.062	0.678	0.093	.0125	0.187	0.250	Radial	Axial
CARBON STEELS Free-Machining-Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	Skilling	20000	.00012	.00018	1 x Dia	26 x Dia	.00021	.00026	.00031	.00042	.00062	.00083	1xDa	50 x Dia
		Augray	.00007	.00014	.00021	.50 x Dia	1xDa	.00034	.00031	.00036	50549	.00073	.00098	.60 x Dia	1 x Dia
		Freeing	00007	.00015	.00023	.13 x Dia	1x0a	00027	.00034	00040	00054	.00081	.00109	.25 x Dia	1 x Cla
1030 - 1005, 1140 - 1151, 13xx, 15xx, 2xx, 3xxx, 4xxx & 4x1,xx, 5xxx & 541,xx, 51xxx & 501,xxx, 51xxx & 511,xxx, 52xxx & 521,xxx, 6xxx, 8xxx, 9xxx	200	Story	00005	.00011	.00016	1xDa	20 x Dia	.00019	.0004	.0028	0008	.00017	.00076	1x0a	.50 x Dia
		Pourtey	00006	.00013	.00019	30 x Du	1xDa	00022	.00028	.00033	.00045	.00007	.00089	60 x Dia	1xDa
		Freeing	00007	.00014	.00021	.13 x Dia	1x0a	00025	.00031	.00037	50050	.00074	.00099	25 x Dia	1 x Dia
STANLESS STEELS	450	Story	,0000	.00012	.00018	1xDa	20 x Dia	.00021	.00036	.0031	0002	,0000	.00083	txDa	.50 x Dia
203 EZ, 303 (all types), 416, 4165e, 416 Plus X, 429F, 420F5e, 430F, 430F5e, 440F, 440F5e		Roughing	00007	00014	.00021	30 x Da	1xDa	00004	.00031	.00036	50049	00073	00008	80 x Da	1xDa
		Frenky	00007	.00015	.00023	.13 x Dia	1xDa	00027	.00034	.00040	.0054	,00001	.00109	.25 x Dia	1 x Dia
201, 202, 203, 205, 301, 302, <mark>304,</mark> 3041, 308, 309, 310, 314, 316, 3161, 317, 321, 329, 330, 347, 348, 365, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	280	Story	00005	.00011	.00016	1 x Dia	20 x Dia	.00019	.00024	00028	80008	10067	.00076	1x0a	50 x Dia
		Augrey	00006	.00013	.00019	.30 x Dia	1xDa	00022	.00028	.00033	.00045	.00067	00089	Contract of	1xDa
		Freeing	00007	.00014	,00021	.13 x Da	1xDia	0003	.00031	.00037	00000	.00074	.0009	25 x Da	1x0a

Manual Lathe Speeds And Feeds Chart

Puja Mehta

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