

MATERIAL	Hardness: 29-37 Rc (279-344 HBn)														
	SPM	Chip Load (IPT)			Depth of Cut		Chip Load (IPT)						Depth of Cut		
		0.015	0.031	0.047	Radial	Axial	0.062	0.078	0.093	0.117	0.187	0.250	Radial	Axial	
CARBON STEELS	600	Turning	.00008	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00026	.00031	.00042	.00062	.00083	1 x Dia	.50 x Dia
Free-Machining/Low Carbon steels, 10xx - 1029 & all 12Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx		Roughing	.00007	.00014	.00021	.30 x Dia	1 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.60 x Dia	1 x Dia
		Finishing	.00007	.00015	.00023	.13 x Dia	1 x Dia	.00027	.00034	.00040	.00054	.00081	.00109	.25 x Dia	1 x Dia
1030 - 1035, 1140 - 1151, 12xx, 15xx, 2xx, 3xx, 4xx & 4Lxx, 6xx & 6Lxx, 51xx & 52Lxx, 51xx & 51Lxx, 52xx & 52Lxx, 6xx, 8xx, 9xx	200	Turning	.00005	.00011	.00016	1 x Dia	.20 x Dia	.00019	.00024	.00026	.00038	.00057	.00076	1 x Dia	.50 x Dia
		Roughing	.00006	.00013	.00019	.30 x Dia	1 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.60 x Dia	1 x Dia
		Finishing	.00007	.00014	.00021	.13 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00074	.00099	.25 x Dia	1 x Dia
STAINLESS STEELS	450	Turning	.00006	.00012	.00018	1 x Dia	.20 x Dia	.00021	.00026	.00031	.00042	.00062	.00083	1 x Dia	.50 x Dia
303 EZ, 303 (all types), 416, 416Se, 416 Plus X, 430F, 430FSe, 430F, 430FSe, 440F, 440FSe		Roughing	.00007	.00014	.00021	.30 x Dia	1 x Dia	.00024	.00031	.00036	.00049	.00073	.00098	.60 x Dia	1 x Dia
		Finishing	.00007	.00015	.00023	.13 x Dia	1 x Dia	.00027	.00034	.00040	.00054	.00081	.00109	.25 x Dia	1 x Dia
301, 302, 303, 305, 301, 302, 304, 304L, 308, 309, 316, 314, 316, 316L, 317, 321, 329, 336, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	200	Turning	.00005	.00011	.00016	1 x Dia	.20 x Dia	.00019	.00024	.00026	.00038	.00057	.00076	1 x Dia	.50 x Dia
		Roughing	.00006	.00013	.00019	.30 x Dia	1 x Dia	.00022	.00028	.00033	.00045	.00067	.00089	.60 x Dia	1 x Dia
		Finishing	.00007	.00014	.00021	.13 x Dia	1 x Dia	.00025	.00031	.00037	.00050	.00074	.00099	.25 x Dia	1 x Dia

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