

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, 8xx & 8Lxx, 51xx & 52Lxx, 51xx & 51Lxx, 52xx & 52Lxx, 8xx, 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, 330, 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

Manual Lathe Speeds And Feeds Chart

Robert Henry Smith



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Table of Contents Manual Lathe Speeds And Feeds Chart

1. Understanding the eBook Manual Lathe Speeds And Feeds Chart
 - The Rise of Digital Reading Manual Lathe Speeds And Feeds Chart
 - Advantages of eBooks Over Traditional Books
2. Identifying Manual Lathe Speeds And Feeds Chart
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Manual Lathe Speeds And Feeds Chart
 - User-Friendly Interface
4. Exploring eBook Recommendations from Manual Lathe Speeds And Feeds Chart
 - Personalized Recommendations
 - Manual Lathe Speeds And Feeds Chart User Reviews and Ratings
 - Manual Lathe Speeds And Feeds Chart and Bestseller Lists
5. Accessing Manual Lathe Speeds And Feeds Chart Free and Paid eBooks
 - Manual Lathe Speeds And Feeds Chart Public Domain eBooks
 - Manual Lathe Speeds And Feeds Chart eBook Subscription Services
 - Manual Lathe Speeds And Feeds Chart Budget-Friendly Options
6. Navigating Manual Lathe Speeds And Feeds Chart eBook Formats

- ePub, PDF, MOBI, and More
- Manual Lathe Speeds And Feeds Chart Compatibility with Devices
- Manual Lathe Speeds And Feeds Chart Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Manual Lathe Speeds And Feeds Chart
 - Highlighting and Note-Taking Manual Lathe Speeds And Feeds Chart
 - Interactive Elements Manual Lathe Speeds And Feeds Chart
- 8. Staying Engaged with Manual Lathe Speeds And Feeds Chart
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Manual Lathe Speeds And Feeds Chart
- 9. Balancing eBooks and Physical Books Manual Lathe Speeds And Feeds Chart
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Manual Lathe Speeds And Feeds Chart
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Manual Lathe Speeds And Feeds Chart
 - Setting Reading Goals Manual Lathe Speeds And Feeds Chart
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Manual Lathe Speeds And Feeds Chart
 - Fact-Checking eBook Content of Manual Lathe Speeds And Feeds Chart
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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