

STANDARD CUTTING CONDITIONS

Counter boring

ISO	Workpiece materials	Cutting speed V_c (m/min)	Feed : f (mm/rev)	
			$\phi 10 - 12$ ($z = 1$)	$\phi 13 - 59$ ($z = 2$)
P	Carbon steel	80 - 200	0.03 - 0.08	0.1 - 0.3
M	Stainless steel	80 - 150	0.03 - 0.05	0.06 - 0.15
K	Grey cast iron	80 - 200	0.05 - 0.1	0.1 - 0.4
N	Non-ferrous	100 - 300	0.05 - 0.2	0.1 - 0.4
S	Superalloys	50 - 80	0.03 - 0.05	0.06 - 0.15
H	Hard materials	50 - 80	0.03 - 0.05	0.06 - 0.15

Milling

ISO	Workpiece materials	Cutting speed V_c (m/min)	Feed per tooth f_z (mm/t)
P	Carbon steel	80 - 200	0.05 - 0.15
M	Stainless steel	80 - 150	0.05 - 0.1
K	Grey cast iron	80 - 200	0.05 - 0.2
N	Non-ferrous	100 - 300	0.1 - 0.2
S	Superalloys	50 - 80	0.05 - 0.08
H	Hard materials	50 - 80	0.05 - 0.08

Internal boring (With one cutting edge)

ISO	Workpiece materials	Cutting speed V_c (m/min)	Depth of cut a_p (mm)	Feed f (mm/rev)
P	Carbon steel	80 - 200	0.5 -	0.05 - 0.15
M	Stainless steel	80 - 150	0.5 -	0.05 - 0.1
K	Grey cast iron	80 - 200	0.5 -	0.05 - 0.2
N	Non-ferrous	100 - 300	0.5 -	0.1 - 0.2
S	Superalloys	50 - 80	0.5 -	0.05 - 0.08
H	Hard materials	50 - 80	0.5 -	0.05 - 0.08