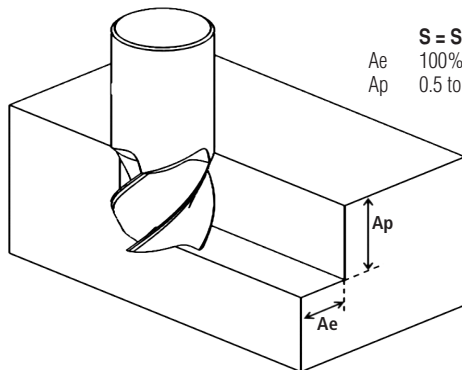


Feeds and Speeds Chart for FeR_x Rougher

Materials		Carbon Steels	Alloy Steel	Stainless Steel 300 Series	Stainless Steel 400 Series	Precipitation Stainless Steels	Gray Cast Iron	Ductile Cast Iron	High Temp Alloys	Titanium Pure	Titanium Cast/Wrought
Diameter	Description	10XX, 11XX, 12XX, 13XX	40XX, 41XX, 42XX, 43XX, 44XX, 46XX, 86XX, Series	304, 304L, 316, 316L, 312	420, 420F, 416, 440C	15-5PH, 16-6PH, 17-4PH, AM-XX Series	Gray	Ductile	Inconel 625/718, A286, Haynes	Pure	Cast/Wrought 6AL4V, ASTM 1,2,3, Alpha-Beta
	SFM<32Rc	200-450	150-300	150-300	200-450	80-250	250-450	120-350	70-120	140-220	140-200
	SFM>32Rc	100-250	80-200	80-200	100-250	90-125	130-300	80-140	40-90	90-160	90-160
1/4"	S	0.0015	0.0014	0.0014	0.0014	0.0013	0.0013	0.0013	0.0010	0.0014	0.0013
	HP	0.0015	0.0014	0.0014	0.0014	0.0013	0.0013	0.0013	0.0010	0.0014	0.0013
	P	0.0017	0.0015	0.0015	0.0015	0.0014	0.0014	0.0014	0.0011	0.0015	0.0014
	LP	0.0021	0.0019	0.0019	0.0019	0.0018	0.0018	0.0018	0.0014	0.0019	0.0018
3/8"	S	0.0024	0.0022	0.0022	0.0022	0.0020	0.0020	0.0020	0.0016	0.0022	0.0020
	HP	0.0024	0.0022	0.0022	0.0022	0.0020	0.0020	0.0020	0.0016	0.0022	0.0020
	P	0.0026	0.0024	0.0024	0.0024	0.0022	0.0022	0.0022	0.0018	0.0024	0.0022
	LP	0.0033	0.0030	0.0030	0.0030	0.0028	0.0028	0.0028	0.0023	0.0030	0.0028
1/2"	S	0.0031	0.0029	0.0029	0.0029	0.0026	0.0026	0.0026	0.0021	0.0029	0.0026
	HP	0.0031	0.0029	0.0029	0.0029	0.0026	0.0026	0.0026	0.0021	0.0029	0.0026
	P	0.0034	0.0031	0.0031	0.0031	0.0029	0.0029	0.0029	0.0023	0.0031	0.0029
	LP	0.0044	0.0040	0.0040	0.0040	0.0037	0.0037	0.0037	0.0030	0.0040	0.0037
5/8"	S	0.0035	0.0032	0.0032	0.0032	0.0029	0.0029	0.0029	0.0022	0.0032	0.0029
	HP	0.0035	0.0032	0.0032	0.0032	0.0029	0.0029	0.0029	0.0022	0.0032	0.0029
	P	0.0038	0.0035	0.0035	0.0035	0.0031	0.0031	0.0031	0.0024	0.0035	0.0031
	LP	0.0049	0.0044	0.0044	0.0044	0.0040	0.0040	0.0040	0.0031	0.0044	0.0040
3/4"	S	0.0042	0.0039	0.0039	0.0039	0.0035	0.0035	0.0035	0.0027	0.0039	0.0035
	HP	0.0042	0.0039	0.0039	0.0039	0.0035	0.0035	0.0035	0.0027	0.0039	0.0035
	P	0.0046	0.0042	0.0042	0.0042	0.0038	0.0038	0.0038	0.0030	0.0042	0.0038
	LP	0.0059	0.0054	0.0054	0.0054	0.0049	0.0049	0.0049	0.0038	0.0054	0.0049
1"	S	0.0059	0.0054	0.0054	0.0054	0.0049	0.0049	0.0049	0.0039	0.0054	0.0049
	HP	0.0059	0.0054	0.0054	0.0054	0.0049	0.0049	0.0049	0.0039	0.0054	0.0049
	P	0.0065	0.0059	0.0059	0.0059	0.0054	0.0054	0.0054	0.0043	0.0059	0.0054
	LP	0.0083	0.0076	0.0076	0.0076	0.0069	0.0069	0.0069	0.0055	0.0076	0.0069



S = SLOTTING

A_e 100% x D
 A_p 0.5 to 1.0 x D

HP = HEAVY PERIPHERAL

> 40% x D
 0.5 to 1.0 x D

P = PERIPHERAL

25% to 40% x D
 1.0 to 1.5 x D

LP = LIGHT PERIPHERAL

5% to 25% x D
 2 x D