

Feeds and Speeds Chart for HiTex-C Rougher

Material		Iron Based	Iron-Nickel Based	Nickel-Iron Based	Cobalt Based	
Description		A286, Discaloy, Incoloy 801, ASTM A297	Hastelloy X, N-155, Inconel 718	Inconel 600/625, Rene Alloys, Waspaloy, Monel, Invar	Stellite, Haynes 188, Haynes 230, AiResist 13	
Diameter	SFM Rc < 32 SFM Rc > 32	70-120 40-90	70-120 40-90	60-110 40-90	60-110 40-90	
1/4"	HP	0.0009	0.0009	0.0007	0.0007	
	P	0.0010	0.0010	0.0008	0.0008	
	LP	0.0012	0.0012	0.0010	0.0010	
5/16"	HP	0.0012	0.0012	0.0009	0.0009	
	P	0.0013	0.0013	0.0010	0.0010	
	LP	0.0016	0.0016	0.0013	0.0013	
3/8"	HP	0.0015	0.0015	0.0012	0.0012	
	P	0.0016	0.0016	0.0013	0.0013	
	LP	0.0021	0.0021	0.0017	0.0017	
7/16"	HP	0.0018	0.0018	0.0015	0.0015	
	P	0.0020	0.0020	0.0016	0.0016	
	LP	0.0025	0.0025	0.0021	0.0021	
1/2"	HP	0.0021	0.0021	0.0017	0.0017	
	P	0.0023	0.0023	0.0019	0.0019	
	LP	0.0029	0.0029	0.0024	0.0024	
5/8"	HP	0.0024	0.0024	0.0020	0.0020	
	P	0.0026	0.0026	0.0022	0.0022	
	LP	0.0034	0.0034	0.0028	0.0028	
3/4"	HP	0.0027	0.0027	0.0022	0.0022	
	P	0.0029	0.0029	0.0024	0.0024	Ae
	LP	0.0038	0.0038	0.0030	0.0030	Ap
1"	HP	0.0040	0.0040	0.0033	0.0033	
	P	0.0044	0.0044	0.0036	0.0036	Ae
	LP	0.0056	0.0056	0.0046	0.0046	Ap

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