

Ferrous and Stainless Steel

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Recommended SFM, Feed Rate, Hook and O.D. Clearance Angles

Material	Hook Angle	O.D. CL. Angle		STOCK DIAMETER RANGE			
				1/4" - 3/4"	3/4" - 1-1/2"	1-1/2" - 2-1/2"	2-1/2" - 3-1/2"
Grey Cast Iron	12°	8°	SFM	82	75	72	66
			Feed Rate	4"/Min.	4"/Min.	3.5"/Min.	3"/Min.
Mild Steel	20°	8°	SFM	160	150	150	130
			Feed Rate	6.3"/Min.	5.9"/Min.	5.5"/Min.	5.1"/Min.
Med. Hard Steel	18°	8°	SFM	100	100	80	80
			Feed Rate	5.1"/Min.	4.7"/Min.	4.3"/Min.	4.3"/Min.
Hard Steel	15°	8°	SFM	66	66	60	57
			Feed Rate	4.3"/Min.	4.3"/Min.	4"/Min.	3.5"/Min.
Stainless Steel	15°	6°	SFM	66	63	60	57
			Feed Rate	2"/Min.	1.75"/Min.	1.75"/Min.	1.5"/Min.