CASTELAR TOOL

281

SPEEDS AND FEEDS

WORK MATERIAL	TYPE OFCUT	AXIAL DOC	RADIAL DOC	SFM	IPT			
					1/16"Ø	1/8"Ø	1/4"Ø	3/8"Ø
PRE-HARDENED STEELS 25- 48 Rc	Roughing	.06xD	.3 x D	140-185	0.0005-0.0010	0.0010-0.0022	0.0039-0.0043	0.0059-0.0065
	Finishing	.05xD	.15 x D	170-220	0.0005-0.0017	0.0010-0.0034	0.0059-0.0064	0.0089-0.0096
HARDENED STEELS <48 Rc	Roughing	.06xD	.3 x D	140-185	0.0005-0.0012	0.0010-0.0022	0.0039-0.0043	0.0059-0.0065
	Finishing	.07xD	.15 x D	170-220	0.0005-0.0017	0.0010-0.0034	0.0059-0.0064	0.0089-0.0096
HARDENED STEELS 48- 57 Rc	Roughing	.05xD	.3 x D	110-140	0.0005-0.0010	0.0010-0.0022	0.0039-0.0043	0.0059-0.0065
	Finishing	.06xD	.15 x D	115-150	0.0005-0.0017	0.0020-0.0034	0.0059-0.0064	0.0089-0.0096
HARDENED STEELS <65 Rc	Roughing	.04xD	.20 x D	90-120	0.0005-0.0010	0.0010-0.0022	0.0039-0.0043	0.0059-0.0065
	Finishing	.03xD	.10 x D	115-150	0.0005-0.0012	0.0010-0.0024	0.0039-0.0044	0.0059-0.0066
HARDENED STEELS >65 Rc	Roughing	.025xD	.20 x D	55-75	0.0005-0.0010	0.0010-0.0012	0.0019-0.0023	0.0029-0.0035
	Finishing	.02xD	.10 x D	100-130	0.0005-0.0012	0.0010-0.0024	0.0039-0.0044	0.0059-0.0066

WORK MATERIAL	TYPE OFCUT	AXIAL DOC	RADIAL DOC	SFM	IPT			
					1/2"Ø	5/8"Ø	3/4"Ø	1"Ø
PRE-HARDENED STEELS 25- 48 Rc	Roughing	.06xD	.3 x D	140-185	0.0078-0.0086	0.0097-0.0107	0.0117-0.0129	0.0156-0.0172
	Finishing	.05xD	.15 x D	170-220	0.0118-0.0127	0.0148-0.0159	0.0177-0.0191	0.0236-0.0255
HARDENED STEELS <48 Rc	Roughing	.06xD	.3 x D	140-185	0.0078-0.0086	0.0097-0.0107	0.0117-0.0129	0.0156-0.0172
	Finishing	.07xD	.15 x D	170-220	0.0118-0.0127	0.0148-0.0159	0.0177-0.0191	0.0236-0.0255
HARDENED STEELS 48- 57 Rc	Roughing	.05xD	.3 x D	110-140	0.0078-0.0086	0.0097-0.0107	0.0117-0.0129	0.0156-0.0172
	Finishing	.06xD	.15 x D	115-150	0.0118-0.0127	0.0148-0.0159	0.0177-0.0191	0.0236-0.0255
HARDENED STEELS <65 Rc	Roughing	.04xD	.20 x D	90-120	0.0078-0.0086	0.0097-0.0107	0.0117-0.0129	0.0156-0.0172
	Finishing	.03xD	.10 x D	115-150	0.0078-0.0087	0.0098-0.0109	0.0117-0.0131	0.0156-0.0175