

SPEED AND FEEDS FOR BORING TOOLS				DEPTH OF CUT		
MATERIAL	TYPE	SPEED SURFACE FEET PER MINUTE	FEED INCHES PER REVOLUTION	INSERT BARS SERIES 12-17 PAGE 15-21	SOLID CARBIDE BARS OUR SERIES 10 PAGE 8-9	ALTIN COATED SOLID CARBIDE BARS OUR SERIES 18 PAGE 10
PLASTIC	TEFLON	500-600	.003-.006	.007	.012	.016
	NYLON	700-800	.001-.003	.007	.012	.016
	PHENOLIC	700-800	.001-.003	.007	.012	.016
	GLASS FILLED	700-800	.001-.003	.005	.012	.016
MAGNESIUM	AZ,AM,EZ,ZE,HK	750-1500	.005-.012	.008	.012	.016
ALUMINUM	2021 THRU 6061	700-1400	.005-.012	.008	.014	.018
COPPER	101-707	600-800	.003-.005	.008	.014	.016
	834-978	600-800	.003-.005	.008	.014	.016
BRASS		350-400	.001-.003	.006	.011	.012
BRONZE		300-400	.001-.002	.006	.011	.012
CAST IRON	GRAY	250-350	.004-.010	.007	.007	.009
	DUCTILE	250-350	.004-.010	.007	.007	.009
	MALLEABLE	250-350	.004-.010	.007	.007	.009
STEEL	1005-1029	100-300	.003-.007	.007	.014	.016
	1030-1055	100-300	.003-.007	.007	.014	.016
	1060-1095	150-400	.003-.005	.007	.014	.016
	10L45-10L50	300-500	.004-.006	.007	.014	.016
	12L13-12L15	300-500	.003-.005	.007	.014	.016
	41L30-41L50	200-400	.003-.005	.007	.014	.016
	4140-4150	150-400	.003-.005	.007	.014	.016
	4140 (35 HRC)	90-125	.001-.004	.004	.007	.008
	8617-8622	100-300	.002-.004	.007	.006	.007
	M1-M6	150-250	.003-.008	.006	.005	.006
	H10-H19	150-250	.003-.007	.006	.005	.006
	D2-D7	150-250	.004-.010	.006	.005	.006
	A2-A9, 01-07	150-250	.003-.008	.006	.005	.006
	W1, W2	150-250	.003-.008	.006	.006	.007
M-50, 52100	300-400	.004-.010	.007	.006	.007	
TITANIUM	TI-9AI-6V	90-250	.001-.003	.005	.008	.011
STAINLESS	201-385	100-250	.001-.004	.005	.008	.012
	405-446	100-250	.001-.004	.005	.008	.012
	15-5PH, 16-6PH, 14-4 PH	300-400	.002-.004	.005	.008	.012
NICKEL	NICKEL 200-300	100-250	.002-.005	.004	.007	.009
MONEY		80-120	.001-.003	.004	.007	.009
INCONEL		80-120	.001-.003	.004	.007	.009
WASPALLOY		80-120	.001-.003	.004	.007	.009
HASTELLOY		80-120	.001-.003	.004	.007	.009