

Series 204/205/206/207/209/210/224/226 Inch

| Workpiece Material Group | | Examples | Series | | | | | | | | |
|-----------------------------------------|---|----------------------------------------------|--------|-----|------|-----|-----|-----|-----|-----|-----|
| | | | 204 | 205 | 205T | 206 | 207 | 209 | 210 | 224 | 226 |
| | | | SFM | | | | | | | | |
| Steels | P | Low Carbon Steels 1018 | 175 | 175 | 175 | 175 | | 275 | | 175 | 175 |
| | | Alloy Steels (up to 35 Rc) 4140 | 165 | 150 | 150 | 165 | | 250 | | 165 | 165 |
| | | Alloy Steels (36-45 Rc) 4140 | 150 | 120 | 120 | 150 | | 225 | | 150 | 150 |
| Austenitic | M | 304/316 | 125 | 140 | 140 | 125 | | | 80 | 125 | 125 |
| Precipitation Hardened Stainless Steels | M | 17-4 PH | | 60 | 60 | | | 80 | | | |
| Cast Irons | K | Gray Cast Iron A48 Class 20/G4000 | 275 | 175 | 175 | 275 | | | 275 | 275 | 275 |
| | | Ductile Cast Iron A536/60-40-18 | 175 | 175 | 175 | 175 | | | 175 | 175 | 175 |
| Special Alloys | S | Titanium 6AL-4V | | 80 | 80 | | | 100 | | | |
| | | High Temp Alloys Inconel/Hastelloy/Waspelloy | | 60 | 60 | | | 50 | | | |
| Hardened Steels | H | >45 Rc A2/52100 | | 50 | 50 | | | | | | |
| Non-Ferrous | N | Plastic | 400 | 300 | 300 | 400 | 300 | | | 400 | 400 |
| | | Kevlar/Graphite | 400 | | | 400 | 375 | | | 400 | 400 |

| Workpiece Material Group | | Examples | Tool Diameter | | | | | | | | |
|-----------------------------------------|---|----------------------------------------------|---------------|-------|-------|-------|-------|-------|-------|-------|-------|
| | | | 1/32 | 1/16 | 1/8 | 1/4 | 3/8 | 1/2 | 5/8 | 3/4 | 1 |
| | | | IPR | | | | | | | | |
| Steels | P | Low Carbon Steels 1018 | .0010 | .0020 | .0030 | .0060 | .0080 | .0100 | .0110 | .0120 | .0140 |
| | | Alloy Steels (up to 35 Rc) 4140 | .0010 | .0020 | .0030 | .0060 | .0080 | .0100 | .0110 | .0120 | .0140 |
| | | Alloy Steels (36-45 Rc) 4140 | .0010 | .0020 | .0030 | .0060 | .0080 | .0100 | .0110 | .0120 | .0140 |
| Austenitic | M | 304/316 | .0010 | .0020 | .0030 | .0060 | .0080 | .0100 | .0110 | .0120 | .0140 |
| Precipitation Hardened Stainless Steels | M | 17-4 PH | .00025 | .0005 | .0020 | .0040 | .0050 | .0060 | .0080 | .0100 | .0120 |
| Cast Irons | K | Gray Cast Iron A48 Class 20/G4000 | .0010 | .0020 | .0030 | .0060 | .0080 | .0100 | .0110 | .0120 | .0140 |
| | | Ductile Cast Iron A536/60-40-18 | .0010 | .0020 | .0030 | .0060 | .0080 | .0100 | .0110 | .0120 | .0140 |
| Special Alloys | S | Titanium 6AL-4V | .00025 | .0005 | .0020 | .0040 | .0050 | .0060 | .0080 | .0100 | .0120 |
| | | High Temp Alloys Inconel/Hastelloy/Waspelloy | .00025 | .0005 | .0020 | .0040 | .0050 | .0060 | .0080 | .0100 | .0120 |
| Hardened Steels | H | >45 Rc A2/52100 | .0005 | .0010 | .0010 | .0010 | .0020 | .0020 | .0020 | .0030 | .0030 |
| Non-Ferrous | N | Plastic | .00025 | .0005 | .0020 | .0040 | .0050 | .0060 | .0080 | .0100 | .0120 |
| | | Kevlar/Graphite | | | | | | | | | |

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

Series 204/205/206/207/209/210/224/226 Metric

| Workpiece Material Group | | Examples | Series | | | | | | | | |
|-----------------------------------------|---|----------------------------------------------|--------|-----|------|-----|-----|-----|-----|-----|-----|
| | | | 204 | 205 | 205T | 206 | 207 | 209 | 210 | 224 | 226 |
| | | | SMM | | | | | | | | |
| Steels | P | Low Carbon Steels 1018 | 55 | 55 | 55 | 55 | | 85 | | 55 | 55 |
| | | Alloy Steels (up to 35 Rc) 4140 | 50 | 45 | 45 | 50 | | 75 | | 50 | 50 |
| | | Alloy Steels (36-45 Rc) 4140 | 45 | 35 | 35 | 45 | | 70 | | 45 | 45 |
| Austenitic | M | 304/316 | 40 | 45 | 45 | 40 | | | 25 | 40 | 40 |
| Precipitation Hardened Stainless Steels | M | 17-4 PH | | 20 | 20 | | | 25 | | | |
| Cast Irons | K | Gray Cast Iron A48 Class 20/G4000 | 85 | 55 | 55 | 85 | | | 85 | 85 | 85 |
| | | Ductile Cast Iron A536/60-40-18 | 55 | 55 | 55 | 55 | | | 55 | 55 | 55 |
| Special Alloys | S | Titanium 6AL-4V | | 25 | 25 | | | 30 | | | |
| | | High Temp Alloys Inconel/Hastelloy/Waspelloy | | 20 | 20 | | | 15 | | | |
| Hardened Steels | H | >45 Rc A2/52100 | | 15 | 15 | | | | | | |
| Non-Ferrous | N | Plastic | 120 | 90 | 90 | 120 | 90 | | | 120 | 120 |
| | | Kevlar/Graphite | 120 | | | 120 | 115 | | | 120 | 120 |

| Workpiece Material Group | | Examples | Tool Diameter(mm) | | | | | | | | |
|-----------------------------------------|---|----------------------------------------------|-------------------|-------|-------|-------|-------|-------|-------|-------|-------|
| | | | 1.0 | 1.5 | 3.0 | 6.0 | 10.0 | 12.0 | 16.0 | 20.0 | 26.0 |
| | | | mm/rev. | | | | | | | | |
| Steels | P | Low Carbon Steels 1018 | .0250 | .0500 | .0760 | .1520 | .2030 | .2540 | .2750 | .3050 | .3560 |
| | | Alloy Steels (up to 35 Rc) 4140 | .0250 | .0500 | .0760 | .1520 | .2030 | .2540 | .2750 | .3050 | .3560 |
| | | Alloy Steels (36-45 Rc) 4140 | .0250 | .0500 | .0760 | .1520 | .2030 | .2540 | .2750 | .3050 | .3560 |
| Austenitic | M | 304/316 | .0250 | .0500 | .0760 | .1520 | .2030 | .2540 | .2750 | .3050 | .3560 |
| Precipitation Hardened Stainless Steels | M | 17-4 PH | .0060 | .0127 | .0500 | .0760 | .1010 | .1520 | .2030 | .2250 | .2540 |
| Cast Irons | K | Gray Cast Iron A48 Class 20/G4000 | .0250 | .0500 | .0760 | .1520 | .2030 | .2540 | .2750 | .3050 | .3560 |
| | | Ductile Cast Iron A536/60-40-18 | .0250 | .0500 | .0760 | .1520 | .2030 | .2540 | .2750 | .3050 | .3560 |
| Special Alloys | S | Titanium 6AL-4V | .0060 | .0127 | .0500 | .0760 | .1010 | .1520 | .2030 | .2250 | .2540 |
| | | High Temp Alloys Inconel/Hastelloy/Waspelloy | .0060 | .0127 | .0500 | .0760 | .1010 | .1520 | .2030 | .2250 | .2540 |
| Hardened Steels | H | >45 Rc A2/52100 | .0060 | .0127 | .0500 | .0760 | .1010 | .1520 | .2030 | .2250 | .2540 |
| Non-Ferrous | N | Plastic | .0060 | .0127 | .0500 | .0760 | .1010 | .1520 | .2030 | .2250 | .2540 |
| | | Kevlar/Graphite | .0060 | .0127 | .0500 | .0760 | .1010 | .1520 | .2030 | .2250 | .2540 |

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