

## Cutting Data

ISO	Materials	Cutting Speed m/min	Recommended feed rate mm/rev
<b>P</b>	Low and Medium Carbon Steels <0.55%C	25 - 70	Grooving: 0.01-0.03 Back turning: 0.03-0.10 Face grooving: 0.01-0.08 Chamfering: 0.02-0.08
	High Carbon Steels ≥0.55%C	20 - 50	
	Alloy Steels, Treated Steels	15 - 30	
<b>M</b>	Stainless Steels - Free Cutting	25 - 70	
	Stainless Steels - Austenitic	20 - 40	
	Cast Steels	30 - 70	
<b>K</b>	Cast Iron	15 - 30	
<b>N</b>	Aluminum ≤12%Si, Copper	30 - 90	
	Aluminum >12% Si	20 - 70	
	Synthetics, Duroplastics, Thermoplastics	20 - 70	
<b>S</b>	Nickel Alloys, Titanium Alloys	20 - 50	
<b>H</b>	Hardened Steel 45 - 50HRc	10 - 40	

## Threading Passes

Pitch:	mm	0.5	0.7	0.8	1.0	1.25	1.5	2-5
	TPI	48	36	32	24	20	16	14-5
Number of Passes		6-12	7-14	7-16	8-18	8-20	10-22	20-38