Carbide HSS Condition Feed (mm/rev) for width Feed (mm/rev) for width Speed and/or Speed Material 25mm 50mm 12mm hardness (HB) 12mm 25mm 50mm sm/min sm/min WROUGHT MARTENSITIC 0.125 0.10 0.09 115 0.08 0.060.05 Free machining grades Ann 160 33 0.09 105 0.1250.10 0.05Lower C/lower Cr grades 26 0.08 0.06Ann 175 0.05 0.025 55 0.09 0.06 0.04Lower C/lower Cr grades 14 0.05 Q&T 300

0.08

0.04

0.08

0.08

0.08

0.08

0.08

0.04

0.04

14

12

33

26

21

17

17

15

11

C = carbon

0.125

0.08

0.125

0.125

0.150

0.125

0.100

0.08

0.08

0.04

0.02

0.05

0.05

0.05

0.05

0.05

0.02

0.02

N&T = Normalised & tempered

0.06

0.025

0.06

0.06

0.06

0.06

0.06

0.025

0.025

Cr = chromium

65

50

115

100

90

60

50

62

52

0.10

0.05

0.10

0.10

0.10

0.10

0.08

0.06

0.06

0.09

0.04

0.09

0.09

0.09

0.08

0.06

0.04

0.04

Table 8: Suggested speeds & feeds for the form turning of stainless steels with various tool widths

Ann 240

Q&T 320

Ann 160

Ann 160

Ann 160

Ann 160

Ann 230

N&T 210

Ann 170

Q&T = Quenched & tempered

Higher C/higher Cr grades

Higher C/higher Cr grades

WROUGHT FERRITIC

12 - 17% Cr grades

Free machining grades

WROUGHT AUSTENITIC

Other grades (304, 316, 321 etc)

sm/min = surface metres per minute

Free maching grades

WROUGHT DUPLEX

CAST AUSTENITIC

Ann = Annealed

CAST PLAIN Cr

Turning Feeds And Speeds Guide

Robert R. Redfield

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