

335 STUB, STANDARD, AND REG LENGTH SPEEDS AND FEEDS

MATERIAL	Carbon Alloys	Alloy Steel	Stainless Steels 300 Series	Stainless Steels 400 Series	Precipitation Stainless Steels	Gray Cast Iron	Ductile Cast Iron	High Temp Alloys	Titanium Pure	Titanium Cast / Wrought
DESCRIPTION	13XX,15XX	40XX, 41XX, 42XX, 43XX, 44XX, 46XX, 86XX, SERIES	304, 304L, 316, 316L, 312	420, 420F, 416, 440C	15-5PH, 16-6PH, 17-4PH, AM-xx Series	Gray	Ductile	Inconel 625/718, A286, Haynes	Pure	Cast/Wrought 6AL4V. ASTM 1,2,3, Alpha - Beta
SFM <32 RC	200-450	150-300	150-350	200-450	80-250	250-450	120-350	70-120	140-220	140-200
SFM >32 RC	100-250	80-200	80-200	100-250	90-125	130-300	80-140	40-90	90-160	90-160
1/8 S	0.0007	0.0006	0.0007	0.0007	0.0006	0.0006	0.0006	0.0005	0.0007	0.0006
HP	0.0008	0.0007	0.0008	0.0008	0.0007	0.0007	0.0007	0.0006	0.0008	0.0007
LP	0.0010	0.0008	0.0009	0.0009	0.0008	0.0008	0.0008	0.0007	0.0009	0.0008
1/4 S	0.0014	0.0012	0.0013	0.0013	0.0012	0.0012	0.0012	0.0010	0.0013	0.0012
HP	0.0017	0.0014	0.0017	0.0017	0.0014	0.0014	0.0014	0.0012	0.0017	0.0014
LP	0.0019	0.0017	0.0018	0.0018	0.0017	0.0017	0.0017	0.0014	0.0018	0.0017
5/16 S	0.0018	0.0015	0.0017	0.0017	0.0015	0.0015	0.0015	0.0012	0.0017	0.0015
HP	0.0021	0.0018	0.0021	0.0021	0.0018	0.0018	0.0018	0.0015	0.0021	0.0018
LP	0.0024	0.0021	0.0023	0.0023	0.0021	0.0021	0.0021	0.0018	0.0023	0.0021
3/8 S	0.0021	0.0018	0.0020	0.0020	0.0018	0.0018	0.0018	0.0014	0.0020	0.0018
HP	0.0025	0.0021	0.0025	0.0025	0.0021	0.0021	0.0021	0.0018	0.0025	0.0021
LP	0.0029	0.0025	0.0027	0.0027	0.0025	0.0025	0.0025	0.0021	0.0027	0.0025
1/2 S	0.0030	0.0025	0.0028	0.0028	0.0025	0.0025	0.0025	0.0020	0.0028	0.0025
HP	0.0035	0.0030	0.0035	0.0035	0.0030	0.0030	0.0030	0.0025	0.0035	0.0030
LP	0.0040	0.0035	0.0038	0.0038	0.0035	0.0035	0.0035	0.0030	0.0038	0.0031
5/8 S	0.0038	0.0031	0.0035	0.0035	0.0031	0.0031	0.0031	0.0025	0.0035	0.0031
HP	0.0044	0.0038	1.0044	0.0044	0.0038	0.0038	0.0038	0.0031	0.0044	0.0044
LP	0.0050	0.0044	0.0049	0.0048	0.0044	0.0044	0.0044	0.0038	0.0048	0.0044
3/4 S	0.0045	0.0038	0.0042	0.0042	0.0038	0.0038	0.0038	0.0030	0.0042	0.0038
HP	0.0053	0.0045	0.0053	0.0053	0.0045	0.0045	0.0045	0.0038	0.0053	0.0045
LP	0.0060	0.0053	0.0057	0.0057	0.0053	0.0053	0.0053	0.0045	0.0057	0.0053
1" S	0.0060	0.0050	0.0056	0.0056	0.0050	0.0050	0.0050	0.0040	0.0056	0.0050
HP	0.0070	0.0070	0.0070	0.0070	0.0060	0.0060	0.0060	0.0050	0.0070	0.0060
LP	0.0080	0.0070	0.0076	0.0076	0.0070	0.0070	0.0070	0.0060	0.0076	0.0070

S=SLOTING
Axial Depth
up to .5 x Diameter

HP: HEAVY PERIPHERAL
Axial Depth up to Effective Length of Cut
Radial width .5 x Diameter

LP=LIGHT PERIPHERAL
Axial Depth up to Effective Length of Cut
Radial width .15 x Diameter