

Speed & Feed Guide

Series 1031

SRF4 | 4 FL | Square | Chip Breaker | Hurrimill

Material	Axial ↓	Radial →	SFM	1/8		1/4		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
P	Carbon Steel 10XX, 11XX, 12XX, 13XX	1 x D	1 x D	220	6723	13	3362	13	2241	16	1681	17	1345	16	1121	15
		1.25 x D	.3 x D	264	8068	19	4034	19	2689	23	2017	24	1614	23	1345	21
		1.5 X D	.1 x D	343	10488	42	5244	42	3496	50	2622	53	2098	51	1748	47
	Alloy Steel 4140, 8620	1 x D	1 x D	180	5501	21	2750	16	1834	13	1375	13	1100	13	917	12
		1.25 x D	.3 x D	225	6876	31	3438	24	2292	19	1719	20	1375	19	1146	17
		1.5 X D	.1 x D	270	8251	63	4126	47	2750	38	2063	40	1650	38	1375	35
	Tool Steel A2 ,A3, D2, H11, H13	1 x D	.5 x D	180	5501	10	2750	10	1834	13	1375	13	1100	13	917	12
		1.25 x D	.3 x D	225	6876	16	3438	16	2292	19	1719	20	1375	19	1146	17
		1.5 X D	.1 x D	270	8251	31	4126	31	2750	38	2063	40	1650	38	1375	35
M	SS 300 & 400 Series 303, 304, 316, 420, 416	.75 x D	1 x D	140	4278	7	2139	7	1426	8	1070	9	856	8	713	8
		1.25 x D	.3 x D	185	5654	11	2827	11	1885	13	1413	14	1131	13	942	12
		1.5 x D	.1 x D	230	7039	23	3519	23	2346	28	1760	29	1408	28	1173	25
	Precipitation SS 15-5, 16-6, 17-4, 17-5	2 X D	0.07 X D	393 - 800	12000	50	10696	107	7131	107	5348	107	4270	107	4075	107
		1.5 X D	0.15 X D	393 - 800	12000	55	10696	118	7131	118	5348	118	4270	118	4075	118
		1.0 X D	0.25 X D	393 - 800	12000	62	10696	132	7131	132	5348	132	4270	132	4075	132
K	Cast Iron- Grey, GG-10, GG-40	1 x D	1 x D	100	3056	6	1528	6	1019	7	764	7	611	7	509	6
		1.25 x D	.3 x D	125	3820	8	1910	8	1273	10	955	10	764	10	637	9
		1.5 X D	.1 x D	163	4966	18	2483	18	1655	22	1242	23	993	22	828	20
	Cast Iron- Ductile GGG-40, GGG-70	.75 x D	1 x D	155	4737	8	2368	8	1579	10	1184	10	947	10	789	9
		1.25 x D	.3 x D	180	5501	11	2750	11	1834	14	1375	14	1100	14	917	13
		1.5 x D	.1 x D	216	6601	23	3300	23	2200	27	1650	29	1320	27	1100	25
S	High Temp Alloys Inconel 718, Hastalloy, A286, CoCr	2 X D	0.1 X D	93 - 125	3820	8	1910	8	1273	5	955	8	764	8	477	6
		1.5 X D	0.15	84 - 112	3438	6	1719	6	1146	4	860	6	688	6	429	5
		1.0 X D	0.25	70-90	2865	5	1433	5	955	3	716	5	573	5	358	4