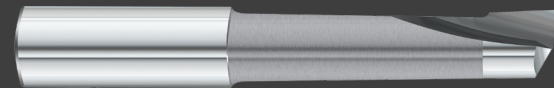


2400 BORING TOOL



FULLERTON®
SPEEDS / FEEDS

Material	Speed SFM (ft/min)	Feed (IPR)		Tool Diameter				
				.050-.100	.110-.160	.180-.230	.290-.320	.360+
		Min	Max	Max DOC	Max DOC	Max DOC	Max DOC	Max DOC
Low Si Aluminum	75-250	0.0005	.0015	.015	.019	.023	.038	.056
Hi Si Aluminum	75-200	0.0005	.0015	.015	.019	.023	.038	.056
Composites	NR							
Plastics	NR							
Brass and Copper	75-300	0.001	.0100	.012	.015	.021	.030	.045
Graphite	NR							
Cast Iron	75-200	0.0005	.0100	.008	.010	.014	.020	.031
Hardened Steels	50-100	0.0005	.0050	.002	.003	.004	.006	.008
Steels								
Low Carbon	75-200	0.0005	.0070	.005	.006	.008	.012	.017
High Carbon	75-200	0.0005	.0070	.004	.005	.007	.010	.015
Stainless Steels								
Free Machining	75-175	0.0005	.0050	.003	.004	.006	.008	.013
Work Hardening	75-210	0.0005	.0050	.003	.004	.006	.008	.012
Super Alloys	50-130	0.0005	.0040	.003	.003	.005	.007	.010
Titanium								
Titanium Soft	50-120	0.0005	.0050	.004	.005	.006	.009	.014
Hard	50-90	0.0005	.0050	.004	.005	.006	.009	.014