

# **FULLERTON**

## S P E E D S / F E E D S

Approximate suggested speeds for:

MATERIAL	FEET PER TOOTH (FPT)	CARBIDE SPEED (SFM)
Aluminum Aluminum Alloys	.001/.002	300-500
Brass / Bronze	.001/.002	150-250
Iron - Cast Soft	.001/.002	125-225
Iron - Cast Medium Hard	.001/.002	100-175
Iron Malleable	.001/.002	90-150
Magnesium Magnesium Alloys	.001/.002	250-400
High Nickel Steel	.001/.002	50-75
Plastic Bakelite	.001/.002	250-400
Steel - Mild	.001/.002	80-170
Steel - Tool	.001/.002	60-100
Steel - Forgings	.001/.002	50-80
Steel - Alloys 300-400 Brinell	.001/.002	30-50
Steel - High Tensile 35-45 RC	.001/.002	35-60
Steel - High Tensile 45-50 RC	.001/.002	25-40
Steel - High Tensile 50-55 RC	.001/.002	15-20
Stainless Steel (Free Machining)	.001/.002	80-125
Stainless Steel (Work Hardening)	.001/.002	50-75
Inconel Alloy Hastelloy Wrought	.001/.002	25-35
Hastelloy (Cast)	.001/.002	7-15

### Formulas

**$RPM = SFM \times 3.82 \div CUTTER \ O.D. \ (FINISHED \ DIAMETER)$**

**$IPR = FPT \times NUMBER \ OF \ TEETH$**

**$IPM = IPR \times RPM$**

**THESE ARE STARTING FEEDS AND SPEEDS, CUTTING FLUID IS REQUIRED!**