

Table 7: Suggested speeds & feeds for single-point turning of stainless steels

Material	Condition and / or hardness (HB)	Roughing (R) or Finishing (F)	Speed sm / min*		
			HSS	Brazed carbide	Disposable carbide
WROUGHT MARTENSITIC Free machining grades Lower C / lower Cr grades Lower C / lower Cr grades Higher C / higher Cr grades Higher C / higher Cr grades	Ann 160	R	45	150	170
		F	52	170	190
		R	33	120	145
	Ann 175	F	40	145	175
		R	20	80	100
		F	25	98	120
	Q&T 300	R	20	95	105
		F	24	105	120
		R	15	67	80
WROUGHT FERRITIC Free machining grades 12 - 17% Cr grades	Ann 160	R	45	150	165
		F	50	165	185
		R	33	137	155
	Ann 160	F	40	155	180
		R	31	125	140
		F	36	140	155
	Ann 160	R	23	85	95
		F	28	97	112
		R	24	53	55
WROUGHT DUPLEX	Ann 230	F	30	60	70
		R	21	83	100
		F	27	105	130
CAST PLAIN Cr	N&T 210	R	15	68	83
		F	20	83	100
CAST AUSTENITIC	Ann 170	R	15	68	83
		F	20	83	100

Roughing: Depth of cut 3.8mm Feed 0.38mm per rev.
Finishing: Depth of cut 0.5 - 1.0 mm Feed 0.20mm per rev.
sm / min = surface metres per minute C = carbon, Cr = chromium
Ann = Annealed Q&T = Quenched & tempered
N&T = Normalised & tempered
* Speeds for coated carbides are approximately 30% higher than those for disposable carbides

Turning Feeds And Speeds Guide

Peter Smid



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