

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

WJ Hussar



Turning Feeds And Speeds Guide:

The Top Books of the Year Turning Feeds And Speeds Guide The year 2023 has witnessed a noteworthy surge in literary brilliance, with numerous captivating novels captivating the hearts of readers worldwide. Lets delve into the realm of popular books, exploring the engaging narratives that have charmed audiences this year. Turning Feeds And Speeds Guide : Colleen Hoover "It Ends with Us" This touching tale of love, loss, and resilience has captivated readers with its raw and emotional exploration of domestic abuse. Hoover expertly weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can succeed. Uncover the Best : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This spellbinding historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids absorbing storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Turning Feeds And Speeds Guide : Delia Owens "Where the Crawdads Sing" This evocative coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens crafts a tale of resilience, survival, and the transformative power of nature, entrancing readers with its evocative prose and mesmerizing setting. These bestselling novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of engaging stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a masterful and gripping novel that will keep you speculating until the very end. The novel is a warning tale about the dangers of obsession and the power of evil.

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