

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

Thomas J. Drozda



Turning Feeds And Speeds Guide:

CNC Programming Handbook Peter Smid, 2003 Comes with a CD ROM packed with a variety of problem solving projects Basic Machining Reference Handbook Arthur R. Meyers, Thomas J. Slattery, 2001 As a comprehensive and easy to use hands on source Basic Machining Reference Handbook is intended to serve as a memory jog for the experienced as well as a reference for programmers and others who will not do the machining but do need to know exactly what's involved in performing a given machining step a series of steps or a complete job The new second edition features expanded chapters on numerical control and computerized operations additional speeds and feeds tables general troubleshooting concepts and a basic review of relevant computer terms and applications Logically organized this time tested reference starts with those machining steps that most often begin the machining process and moves through the basic machining operations It is a must have resource for experienced machinists programmers tooling design and production engineers and students Table of Contents Measurement Standards Cut Off Turning and the Lathe Definition and History The Milling Machine Sensitive Gear Head and Radial Drill Presses Grinding Steels Alloys and Other Materials Numerical Control and CNC Cost Per Cut in the Computer Age Index **Tool and Manufacturing Engineers Handbook: Machining** Thomas J. Drozda, 1983-05-02 Part of the renowned Tool and Manufacturing Engineers Handbook Series the Machining Vol 1 helps you apply cost effective techniques to achieve the best results for over 100 traditional and nontraditional machining processes Chapters include Principles of Metalcutting and Machinability Tolerance Control Cutting Tool Materials Sawing Broaching Planing Shaping and Slotting Turning and Boring Milling Grinding Threading Gear and Spline Production Nontraditional Machining Machine Loading and Unloading Machine Rebuilding and much more **Handbook for Machine Shop and Drafting-room**, 1924 *Factory Division Handbook of Responsibilities, General and Technical Information*, 1985 **The Journeyman's Guide to Cnc Machines** Bryan Hurst, 2006-06-01 The Guide provides instruction in ISO code programming for Turning included are examples that will give an understanding of the principles to apply to any machine and control also featured are GE Fanuc and Siemens Controls The Guide lists functions and codes under the reference JG and provides space to include data for specific machines and controls Extensive examples show how to programme the options and features Component drawings have metric and imperial dimensions simply substitute the dimensions with those of the system of your choice The Guide is your starting point use the instructions and suggestions to build your own unique evolvable folder from here creating an invaluable personal handbook **Tool and Manufacturing Engineers Handbook: Material and Part Handling in Manufacturing** Philip Mitchel, 1983 Get the expert advice you need to shrink handling costs reduce downtime and improve efficiency in plant operations You'll use this comprehensive handbook during post design process selection and planning for establishing quality controls tests and measurements to streamline production and for managerial decision making on capital investments and new automated systems *Machinery and Production Engineering*, 1917 **DUBBEL -**

Handbook of Mechanical Engineering B.J. Davies,Wolfgang Beitz,Karl-Heinz Küttner,2013-06-29 DUBBEL s Handbook of Mechanical Engineering has provided generations of German speaking engineers with a comprehensive source of guidance and reference on which they can rely throughout their professional lives The key sections of this standard work are now available for the first time in English Each subject is discussed in detail and supported by numerous figures and tables DIN standards are retained throughout but ISO equivalents are given where possible The text offers a concise but detailed and authoritative treatment of the topics with full references Contents Mechanics Strength of Materials Thermodynamics Engineering Design Hydraulic and Pneumatic Power Transmission Components of Thermal Apparatus Machine Dynamics and Components Manufacturing Process and Systems **American Machinist** ,1905 The Complete Manual of Woodworking Albert Jackson,David Day,1996-12-03 Designed to instruct and inspire every woodworker from the beginner to the most exacting expert this authoritative guide is a must have classic in the world of woodworking With more than 1 800 drawings diagrams and photos The Complete Manual of Woodworking encompasses the whole art and craft of woodworking Includes a discussion of all the principal hardwoods and softwoods how to choose and use hand tools detailed information on every woodworking technique jointing bonding fastening laminating and much more **AF Manual** United States. Department of the Air Force,1964 **Mechanical & Allied Engineering Solved Papers** YCT Expert Team , 2023 24 RRB JE Mechanical Allied Engineering Solved Papers **Knight's American Mechanical Dictionary** Edward Henry Knight,1881 CNC Control Setup for Milling and Turning Peter Smid,2010 This unique reference features nearly all of the activities a typical CNC operator performs on a daily basis Starting with overall descriptions and in depth explanations of various features it goes much further and is sure to be a valuable resource for anyone involved in CNC **Technical Manual** United States. War Department,1943 *Manufacturing Engineering and Management* ,1960 ASM Specialty Handbook Joseph R. Davis,1996-01-01 Cast iron offers the design engineer a low cost high strength material that can be easily cast into a wide variety of useful and sometimes complex shapes This handbook from ASM covers the entire spectrum of one of the most widely used and versatile of all metals *Manual Training Magazine* Charles Alpheus Bennett,William Thomas Bawden,1928 **Machinery's Handbook Guide** Franklin D. Jones,Nick Jones,John M. Amiss,Robert E. Green,Ryffel,Christopher J. McCauley,1996-04 Illustrates through hundreds of examples solutions and questions how to take full advantage of the Handbook to solve the types of problems typically encountered in drafting rooms machine shops and on the factory floor Allows you to quickly become more thoroughly familiar with the vast range of contents found in the Handbook By practicing the many practical techniques explained in this Guide you will be able to obtain the solution or information needed to resolve on the job problems

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