

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	Ann 160	R	45	150	170
		F	52	170	190
		R	33	120	145
Lower C / lower Cr grades	Ann 175	F	40	145	175
		R	20	80	100
Lower C / lower Cr grades	Q&T 300	F	25	98	120
		R	20	95	105
Higher C / higher Cr grades	Ann 240	F	24	105	120
		R	15	67	80
Higher C / higher Cr grades	Q&T 320	F	21	80	92
WROUGHT FERRITIC Free machining grades	Ann 160	R	45	150	165
		F	50	165	185
		R	33	137	155
12 - 17% Cr grades	Ann 160	F	40	155	180
WROUGHT AUSTENITIC Free machining grades	Ann 160	R	31	125	140
		F	36	140	155
		R	23	85	95
Other grades (304, 316, 321 etc)	Ann 160	F	28	97	112
WROUGHT DUPLEX	Ann 230	R	24	53	55
		F	30	60	70
CAST PLAIN Cr	N&T 210	R	21	83	100
		F	27	105	130
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

Christian G. Meyer

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

Turning Feeds And Speeds Guide:

Turning Feeds And Speeds Guide Book Review: Unveiling the Magic of Language

In an electronic era where connections and knowledge reign supreme, the enchanting power of language has become more apparent than ever. Its capability to stir emotions, provoke thought, and instigate transformation is really remarkable. This extraordinary book, aptly titled "**Turning Feeds And Speeds Guide**," written by a highly acclaimed author, immerses readers in a captivating exploration of the significance of language and its profound affect our existence. Throughout this critique, we will delve in to the book is central themes, evaluate its unique writing style, and assess its overall influence on its readership.

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