

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

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CNC Programming Handbook Peter Smid,2003 Comes with a CD ROM packed with a variety of problem solving projects

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

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

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