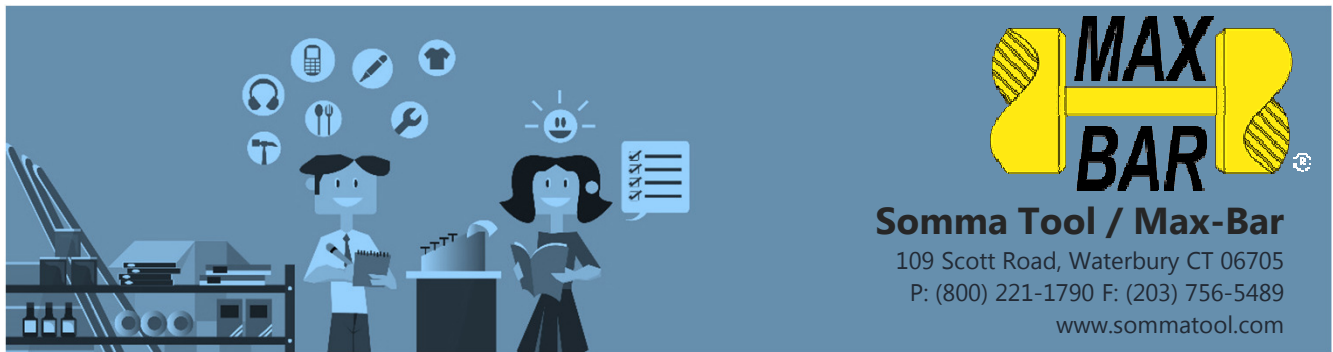


# Recommended Speeds & Feeds



Category	Grade (if applicable)	Coating (C2 substrate)	Speed (SFM)	Feed (IPR)
<b>Steel</b>	1011-1029	TiN or TiCN	500	0.0010
	12L13-12L14	TiN or TiCN	600	0.0020
	1005-1010	TiN or TiCN	450	0.0015
	1030-1055	TiN or TiCN	370	0.0014
	1060-1095	TiN or TiCN	255	0.0010
	4140-4150	TiN or TiCN	325	0.0012
	41L30-41L50	TiN or TiCN	350	0.0014
	8617-8622	TiN or TiCN	325	0.0015
	H11-H13	TiN or TiCN	190	0.0010
	O1-O2	TiN or TiCN	205	0.0010
	W1-W2	TiN or TiCN	375	0.0014
	<b>Stainless</b>	201-385	TiN, TiCN or AlTiN	275
405-446		TiCN or AlTiN	300	0.0010
17-4PH		TiCN or AlTiN	190	0.0008
<b>Aluminum</b>	2024-6061	TiN	1,000	0.0010
<b>Titanium</b>		AlTiN	100	0.0010
<b>Inconel</b>	804-825	TiN or AlTiN	95	0.0010
	713C-718	TiN or AlTiN	45	0.0010
<b>Brass</b>		TiN	250	0.0010
<b>Copper</b>		TiN	410	0.0040
<b>Teflon</b>		TiN	400	0.0010
<b>Phenolic (Cast or Molded)</b>		TiN	600	0.0015
<b>Fiberglass</b>		TiN	250	0.0020
<b>Nylon</b>	6, 616, 612	TiN	600	0.0015
	Glass Filled	TiN	450	0.0010
<b>Carbon</b>		TiN	350	0.0020