

## 2004 UPDATED SPEEDS AND FEEDS FOR DURA-PLUS MATERIALS\*

Gray Iron, Grades G1 and G2					
Operation	Tool Maker	Insert Guide	SFM	Feed, (IPR)	Depth of Cut
Rough Turn (OD & ID)	Sandvik	3015	800 – 1,000	.014" - .028"	.100" - .175"
Finish Turn (OD & ID)	NTK	HC2/HC6	800 – 1,000	.004" - .012"	
	Sandvik	650	1,400 – 1,800	.004" - .020"	
Drilling (with insert)	Komet	BK69/BK84	400 - 625	.004" - .015"	
	Sandvik	1020/3040	410 - 700	.004" - .015"	
Drilling	Allied	C3 TiAIN	270 - 350	.003" - .012"	
Grooving (OD & ID)	Iscar	IC9015	400 - 650	.002" - .007"	
	NTK	HC2	900 - 1,200	.002" - .007"	

Ductile Iron - Grade 65-45-12					
Operation	Tool Maker	Insert Guide	SFM	Feed, (IPR)	Depth of Cut
Rough Turn (OD & ID)	Sandvik	3015	800 - 1,200	.014" - .028"	.100" - .175"
Finish Turn (OD & ID)	NTK	HC2/HC6	800 - 2,000	.004" - .016"	
	Sandvik	650	1,600 - 2,000	.004" - .020"	
Drilling (with insert)	Komet	BK69/BK84	400 - 700	.004" - .015"	
	Sandvik	1020/3040	475 - 825	.004" - .015"	
Drilling	Allied	C3 TiAIN	320 - 400	.003" - .012"	
Grooving (OD & ID)	Iscar	IC9015	650 - 850	.002" - .007"	
	Sandvik	525	900 - 1,500	.002" - .007"	

Ductile Iron - Grade 80-55-06					
Operation	Tool Maker	Insert Guide	SFM	Feed, (IPR)	Depth of Cut
Rough Turn (OD & ID)	Sandvik	3015	700 - 900	.008" - .024"	.100" - .175"
Finish Turn (OD & ID)	NTK	HC2/HC6	800 - 1,200	.004" - .012"	
	Sandvik	650	1,000 - 1,500	.004" - .020"	
Drilling (with insert)	Komet	BK69/BK84	400 - 550	.004" - .015"	
	Sandvik	1020/3040	410 - 650	.004" - .015"	
Drilling	Allied	C3 TiAIN	270 - 350	.003" - .012"	
Grooving (OD & ID)	Iscar	IC9015	400 - 600	.002" - .007"	
	NTK	HC2	500 - 900	.002" - .007"	

Ductile Iron - Grade 100-70-02					
Operation	Tool Maker	Insert Guide	SFM	Feed, (IPR)	Depth of Cut
Rough Turn (OD & ID)	Sandvik	3015	450 - 750	.008" - .022"	.100" - .175"
Finish Turn (OD & ID)	NTK	HC2/HC6	800 - 1,000	.006" - .010"	
	Sandvik	650	700 - 950	.006" - .010"	
Drilling (with insert)	Komet	BK69/BK84	350 - 500	.004" - .010"	
	Sandvik	1020/3040	400 - 600	.004" - .012"	
Drilling	Allied	C3 TiAIN	250 - 350	.003" - .012"	
Grooving (OD & ID)	Iscar	IC9015	300 - 600	.002" - .007"	
	NTK	HC2	400 - 800	.002" - .007"	

\*Note: The above information is recommended as a starting point for machining Dura-Bar Plus Continuous Cast Iron only. They may be too aggressive for iron castings or foreign material.