

NOTE: These are all suggestions, so use your good judgment or ask for help to determine if it is right for your operation.

LATHE

COMMON TURNING SPEEDS (RPM)

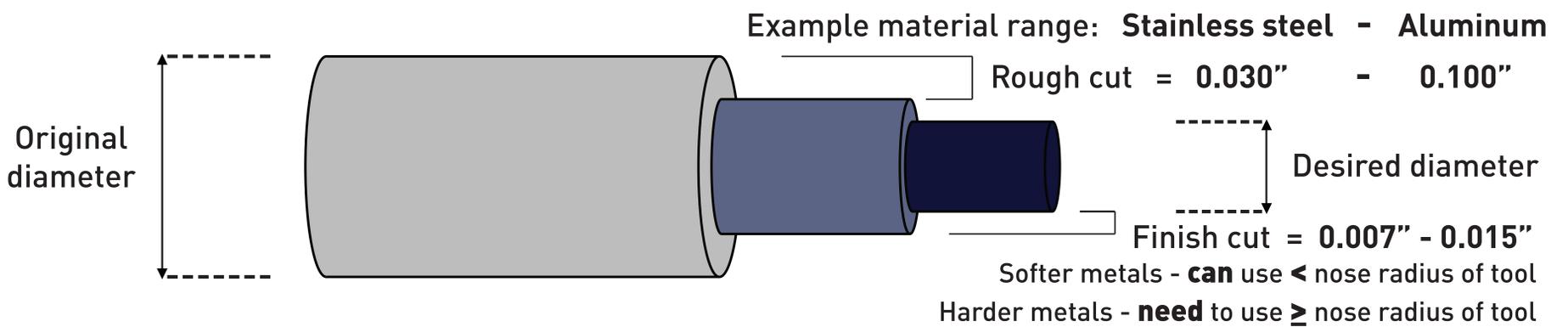
Stock Material Stock Diameter (in)	Aluminum		Plain Carbon Steel		Stainless Steel	
	HSS Tool	Carbide Tool	HSS Tool	Carbide Tool	HSS Tool	Carbide Tool
0.25	1120	1120	1120	1120	700	1120
0.50	900	1120	600	1000	400	800
0.75	800	1120	350	700	250	500
1.00	650	1120	250	500	200	400

Helpful Speed Factors

Operation	Parting Tool	Center Drill	Drill	Reamer	Counter Bore/Sink
Speed Factor	0.50	0.65	0.75	0.25	0.50

* Multiply the speed factor by the calculated/common turning speed

Max Depth of Cut for Feed (in)



Chip Thickness for Rough and Finish Feed (in)

Aluminum				Plain Carbon Steel				Stainless Steel			
H.S.S Tool		Carbide Tool		H.S.S Tool		Carbide Tool		H.S.S Tool		Carbide Tool	
Rough	Finish	Rough	Finish	Rough	Finish	Rough	Finish	Rough	Finish	Rough	Finish
0.0040	0.0020	0.0050	0.0025	0.0016	0.0008	0.0020	0.0010	0.0018	0.0009	0.0020	0.0010