



GROUP #	MATERIAL GROUP	3xD	5xD	8xD	12xD	.118-.234	.236-.345	.354-.469	.472-.571	.591-.630	.708-.787
K1	Gary Cast Iron	525	525	525	525	0.0072	0.0090	0.0114	0.0138	0.0150	0.0170
K2	Ductile Iron (<28)	400	400	400	400	0.0065	0.0065	0.0110	0.0128	0.0138	0.0140
K3	Ductile Iron (<38)	350	350	350	350	0.0040	0.0050	0.0080	0.0100	0.0120	0.0120

GROUP #	MATERIAL GROUP	16xD	20xD	25xD	30xD	.118-.234	.236-.345	.354-.469	.472-.571	.591-.630
K1	Gary Cast Iron	400	400	300	300	0.0060	0.0077	0.0084	0.0091	0.0096
K2	Ductile Iron (<28)	350	325	255	240	0.0060	0.0075	0.0080	0.0085	0.0090
K3	Ductile Iron (<38)	325	300	250	225	0.0050	0.0060	0.0070	0.0085	0.0088

These should be starting points depending upon setup, coolant, machine rigidity. There is a +/- 20% window on speeds & feeds based upon initial testing results.

