

Lathe Cutting Speeds

Using High-Speed Steel Toolbit

Turning and Boring

Material	Rough Cut		Finish Cut		Threading	
	ft/min	m/min	ft/min	m/min	ft/min	m/min
Mach steel	90	27	100	30	35	11
Tool steel	70	21	90	27	30	9
Cast iron	60	18	80	24	25	8
Bronze	90	27	100	30	25	8
Aluminum	200	61	300	93	60	18

Cutting Data For Turning Of Steel

Minjie Lin



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