для размещения заказа - guhring@guhring-tools.ru

Using These Tables. The Speeds & Feeds listed below are conservative recommendations for initial setup. In actual use, depending on the machining environment and workpiece material, significantly higher speeds and feeds may be achievable. Using the below as a starting point, cutting speed/feed can be gradually adjusted upwards until the optimum settings per application are found.
Questions? Contact us by telephone at (800) 776-6170.

Series # 773

Material group	Hardness	SFM	Feed Rate - IPR									
			1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	≤100 Bhn	•	•	•	•	•	•	•	•	•	•	•
	>100-260 Bhn	•	•	•	•	•	•	•	•	•	•	•
Free-cutting steels	≤24 Rc	•	•	•	•	•	•	•	•	•	•	•
	>24-30 Rc	•	•	•	•	•	•	•	•	•	•	•
Unalloyed heat-treatable steels	≤16 Rc	•	•	•	•	•	•	•	•	•	•	•
	16-24 Rc	•	•	•	•	•	•	•	•	•	•	•
	24-30 Rc	•	•	•	•	•	•	•	•	•	•	•
Alloyed heat-treatable steels	24-30 Rc	•	•	•	•	•	•	•	•	•	•	•
	>30-38 Rc	•	•	•	•	•	•	•	•	•	•	•
Unalloyed case hardened steels	≤230 Bhn	•	•	•	•	•	•	•	•	•	•	•
Alloyed case hardened steels	24-30 Rc	•	•	•	•	•	•	•	•	•	•	•
	>30-38 Rc	•	•	•	•	•	•	•	•	•	•	•
Nitriding steels	≥24-30 Rc	•	•	•	•	•	•	•	•	•	•	•
	>30-38 Rc	•	•	•	•	•	•	•	•	•	•	•
Tool steels	≤24 Rc	•	•	•	•	•	•	•	•	•	•	•
	>24-30 Rc	•	•	•	•	•	•	•	•	•	•	•
High speed steels	≥14-30 Rc	•	•	•	•	•	•	•	•	•	•	•
Spring steels	≤330 Bhn	•	•	•	•	•	•	•	•	•	•	•
Stainless steels, sulphured	≤24 Rc	•	•	•	•	•	•	•	•	•	•	•
austenitic	≤24 Rc	•	•	•	•	•	•	•	•	•	•	•
martensitic	≤24 Rc	•	•	•	•	•	•	•	•	•	•	•
Hardened steels	≤40-48 Rc	•	•	•	•	•	•	•	•	•	•	•
	>48-60 Rc	•	•	•	•	•	•	•	•	•	•	•
Special alloys	≤38 Rc	•	•	•	•	•	•	•	•	•	•	•
Cast iron	≤240 Bhn	395	•	0.0030	0.0050	0.0070	0.0080	0.0100	0.0125	•	•	•
	<300 Bhn	330	•	0.0030	0.0050	0.0070	0.0080	0.0100	0.0125	•	•	•
Spheroidal graphite iron and	≤240 Bhn	295	•	0.0030	0.0050	0.0070	0.0080	0.0100	0.0125	•	•	•
malleable cast iron	<300 Bhn	260	•	0.0030	0.0050	0.0070	0.0080	0.0100	0.0125	•	•	•
Chilled cast iron	≤350 Bhn	130	•	0.0013	0.0020	0.0025	0.0030	0.0040	0.0050	•	•	•
Ti and Ti-alloys	≤24 Rc	•	•	•	•	•	•	•	•	•	•	•
	>24-38 Rc	•	•	•	•	•	•	•	•	•	•	•
Aluminium and Al-alloys	≤120 Bhn	1345	•	0.0050	0.0080	0.0120	0.0125	0.0160	0.0200	•	•	•
Al wrought alloys	≤150 Bhn	1345	•	0.0050	0.0080	0.0120	0.0125	0.0160	0.0200	•	•	•
Al cast alloys ≤ 10 % Si	≤200 Bhn	1245	•	0.0050	0.0080	0.0120	0.0125	0.0160	0.0200	•	•	•
> 10 % Si	≤200 Bhn	1080	•	0.0050	0.0080	0.0120	0.0125	0.0160	0.0200	•	•	•
Magnesium alloys	≤150 Bhn	•	•	•	•	•	•	•	•	•	•	•
Copper, low-alloyed	≤120 Bhn	•	•	•	•	•	•	•	•	•	•	•
Brass, short-chipping	≤200 Bhn	920	•	0.0040	0.0060	0.0090	0.0100	0.0125	0.0160	•	•	•
long-chipping	≤200 Bhn	•	•	•	•	•	•	•	•	•	•	•
Bronze, short-chipping	≤200 Bhn	360	•	0.0030	0.0050	0.0070	0.0080	0.0100	0.0125	•	•	•
	>200-260 Bhn	260	•	0.0025	0.0040	0.0050	0.0060	0.0080	0.0100	•	•	•
Bronze, long-chipping	≤24 Rc	•	•	•	•	•	•	•	•	•	•	•
	>24-30 Rc	•	•	•	•	•	•	•	•	•	•	•
Duroplastics	–	•	•	•	•	•	•	•	•	•	•	•
Thermoplastics	–	•	•	•	•	•	•	•	•	•	•	•
Reinforced plastics - Kevlar	–	•	•	•	•	•	•	•	•	•	•	•
Reinforced plastics - GFK / CFK	–	•	•	•	•	•	•	•	•	•	•	•

Series # 1047 / # 5242 (3xD body)

Material group	Hardness	SFM	Feed Rate - IPR					
			≤16.000 mm	41/64 - 25/32 in. 16.001 - 20.000 mm	51/64 - 31/32 in. 20.001 - 25.000 mm	63/64 - 1 17/64 in. 25.001 - 31.500 mm	1 1/4 - 1 9/16 in. 31.501 - 40.000 mm	1 37/64 - 1 61/64 in. 40.001 - 50.000 mm
Common structural steels	≤100 Bhn	330	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
	>100-260 Bhn	280	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
Free-cutting steels	≤24 Rc	330	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
	>24-30 Rc	280	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
Unalloyed heat-treatable steels	≤16 Rc	330	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
	16-24 Rc	315	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
	24-30 Rc	280	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
Alloyed heat-treatable steels	24-30 Rc	280	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
	>30-38 Rc	230	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
Unalloyed case hardened steels	≤230 Bhn	330	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
Alloyed case hardened steels	24-30 Rc	280	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
	>30-38 Rc	185	0.0065	0.0080	0.0100	0.0100	0.0125	0.0160
Nitriding steels	≥24-30 Rc	265	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
	>30-38 Rc	185	0.0065	0.0080	0.0100	0.0100	0.0125	0.0160
Tool steels	≤24 Rc	135	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
	>24-30 Rc	115	0.0065	0.0080	0.0100	0.0100	0.0125	0.0160
High speed steels	≥14-30 Rc	135	0.0050	0.0065	0.0080	0.0080	0.0100	0.0125
Spring steels	≤330 Bhn	115	0.0040	0.0050	0.0065	0.0065	0.0080	0.0100
Stainless steels, sulphured	≤24 Rc	135	0.0050	0.0065	0.0080	0.0080	0.0100	0.0125
austenitic	≤24 Rc	100	0.0050	0.0065	0.0080	0.0080	0.0100	0.0125
martensitic	≤24 Rc	85	0.0050	0.0065	0.0080	0.0080	0.0100	0.0125
Hardened steels	≤40-48 Rc	70	0.0040	0.0050	0.0065	0.0065	0.0080	0.0100
	>48-60 Rc	•	•	•	•	•	•	•
Special alloys	≤38 Rc	70	0.0040	0.0050	0.0065	0.0065	0.0080	0.0100
Cast iron	≤240 Bhn	520	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
	<300 Bhn	390	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
Spheroidal graphite iron and	≤240 Bhn	390	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
malleable cast iron	<300 Bhn	325	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
Chilled cast iron	≤350 Bhn	85	0.0040	0.0050	0.0065	0.0065	0.0080	0.0100
Ti and Ti-alloys	≤24 Rc	100	0.0050	0.0065	0.0080	0.0080	0.0100	0.0125
	>24-38 Rc	85	0.0040	0.0050	0.0065	0.0065	0.0080	0.0100
Aluminium and Al-alloys	≤120 Bhn	725	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
Al wrought alloys	≤150 Bhn	660	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
Al cast alloys ≤ 10 % Si	≤200 Bhn	590	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
> 10 % Si	≤200 Bhn	490	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
Magnesium alloys	≤150 Bhn	655	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
Copper, low-alloyed	≤120 Bhn	260	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
Brass, short-chipping	≤200 Bhn	685	0.0125	0.0160	0.0200	0.0200	0.0250	0.0315
long-chipping	≤200 Bhn	455	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
Bronze, short-chipping	≤200 Bhn	260	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
	>200-260 Bhn	210	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
Bronze, long-chipping	≤24 Rc	160	0.0100	0.0125	0.0160	0.0160	0.0200	0.0250
	>24-30 Rc	130	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
Duroplastics	–	260	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
Thermoplastics	–	260	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
Reinforced plastics - Kevlar	–	260	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200
Reinforced plastics - GFK / CFK	–	260	0.0080	0.0100	0.0125	0.0125	0.0160	0.0200