

■ 3rd Step – Select the Cutting Speed

Austenitic Stainless Steel

Material Group	grade	Speed - m/min (sfm)									Starting Conditions		
		90 (300)	135 (450)	180 (600)	225 (800)	270 (900)	315 (1050)	360 (1200)	405 (1350)	450 (1500)	m/min	sfm	
M1	KCM15											180	600
	KCM25											150	500
	KCM35											120	400

Austenitic Stainless Steel

Material Group	grade	Speed - m/min (sfm)									Starting Conditions		
		90 (300)	135 (450)	180 (600)	225 (800)	270 (900)	315 (1050)	360 (1200)	405 (1350)	450 (1500)	m/min	sfm	
M2	KCM15											165	550
	KCM25											150	500
	KCM35											105	350

Austenitic Stainless Steel: Duplex (Ferritic and Austenitic Mixture)

Material Group	grade	Speed - m/min (sfm)									Starting Conditions		
		90 (300)	135 (450)	180 (600)	225 (800)	270 (900)	315 (1050)	360 (1200)	405 (1350)	450 (1500)	m/min	sfm	
M3	KCM15											150	500
	KCM25											120	400
	KCM35											90	300