






BORING RECOMMENDATIONS

Workpiece Material Group		SFM	Inches Per Tooth (IPT)
Steels	Carbon Steel	78-800	0.0005 - 0.0150
	High-Strength	75-600	0.0005 - 0.0150
	Heat Treated Alloys	75-250	0.0005 - 0.0150
	Powdered Metals	75-250	0.0005 - 0.0150
Tool & Die Steels		75-500	0.0005 - 0.0150
Stainless Steel		75-500	0.0005 - 0.0150
Super Alloys		75-300	0.0003 - 0.0100
Hardened Materials		60-150	0.0001 - 0.0050
Cast-Iron		100-850	0.0005 - 0.0250
Non-Ferrous	Alundum, Brass, Bronze	200-2000	0.0005 - 0.0300
	Copper	130-400	0.0005 - 0.0300
	Zinc	150-350	0.0005 - 0.0300
	Acrylics, Fiberglass, Graphites, Nylons, Phenolics, Plastics	200-1000	0.0005 - 0.0300