

## ■ 3rd Step – Select the Cutting Speed

### Gray Cast Iron

Material Group	grade	Speed - m/min (sfm)									Starting Conditions ◊			
		60 (200)	150 (500)	240 (800)	330 (1100)	420 (1400)	510 (1700)	600 (2000)	690 (2300)	780 (2600)	m/min	sfm		
K1	KCK05												450	1500
	KCK15												360	1200
	KCK20												300	1000

### Ductile, Compacted Graphite & Malleable Cast Irons (<80 KSI tensile strength)

Material Group	grade	Speed - m/min (sfm)									Starting Conditions ◊			
		60 (200)	150 (500)	240 (800)	330 (1100)	420 (1400)	510 (1700)	600 (2000)	690 (2300)	780 (2600)	m/min	sfm		
K2	KCK05												360	1200
	KCK15												270	900
	KCK20												240	800

### Ductile, Compacted Graphite & Malleable Cast Irons (>80 KSI tensile strength)

Material Group	grade	Speed - m/min (sfm)									Starting Conditions ◊			
		60 (200)	150 (500)	240 (800)	330 (1100)	420 (1400)	510 (1700)	600 (2000)	690 (2300)	780 (2600)	m/min	sfm		
K3	KCK05												240	800
	KCK15												215	725
	KCK20												210	700