

# Speed & Feed Guide

## Series 1035

HGW5 | 5 FL | Square & Radius | Hurrmill

Material	Axial ↓	Radial →	SFM	1/8		1/4		3/8		1/2		5/8		3/4		
				RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	RPM	IPM	
<b>P</b>	<b>Carbon Steel</b> 10XX, 11XX, 12XX, 13XX	1 x D	1 x D	<b>220</b>	6723	17	3362	17	2241	20	1681	21	1345	20	1121	19
		1.25 x D	.3 x D	<b>264</b>	8068	24	4034	24	2689	29	2017	30	1614	29	1345	27
		1.5 X D	.1 x D	<b>343</b>	10488	52	5244	52	3496	63	2622	66	2098	63	1748	58
	<b>Alloy Steel</b> 4140, 8620	1 x D	1 x D	<b>180</b>	5501	16	2750	20	1834	16	1375	16	1100	16	917	14
		1.25 x D	.3 x D	<b>225</b>	6876	24	3438	29	2292	24	1719	25	1375	24	1146	22
		1.5 X D	.1 x D	<b>270</b>	8251	47	4126	59	2750	47	2063	49	1650	47	1375	43
	<b>Tool Steel</b> A2, A3, D2, H11, H13	1 x D	.5 x D	<b>180</b>	5501	13	2750	13	1834	16	1375	16	1100	16	917	14
		1.25 x D	.3 x D	<b>225</b>	6876	20	3438	20	2292	24	1719	25	1375	24	1146	22
		1.5 X D	.1 x D	<b>270</b>	8251	39	4126	39	2750	47	2063	49	1650	47	1375	43
<b>M</b>	<b>SS</b> 300 & 400 Series 303, 304, 316, 420, 417	.75 x D	1 x D	<b>140</b>	4278	9	2139	9	1426	10	1070	11	856	11	713	10
		1.25 x D	.3 x D	<b>185</b>	5654	14	2827	14	1885	17	1413	17	1131	17	942	15
		1.5 x D	.1 x D	<b>230</b>	7039	29	3519	29	2346	34	1760	36	1408	35	1173	32
	<b>Precipitation SS</b> 15-5, 16-6, 17-4, 17-6	2 X D	0.07 X D	<b>393 - 800</b>	12000	60	10696	107	7131	107	5348	107	4270	107	4075	107
		1.5 X D	0.15 X D	<b>393 - 800</b>	12000	66	10696	120	7131	120	5348	120	4270	120	4075	120
		1.0 X D	0.25 X D	<b>393 - 800</b>	12000	74	10696	150	7131	150	5348	150	4270	150	4075	150
<b>S</b>	<b>High Temp Alloys</b> Inconel 718, Hastalloy, A286, Waspalloy, CoCr	2 X D	0.07 X D	<b>93 - 125</b>	3820	10	1910	8	1273	5	955	8	764	8	477	6
		1.5 X D	0.15 X D	<b>84 - 112</b>	3438	8	1719	6	1146	4	860	6	688	6	429	5
		1.0 X D	0.25 X D	<b>70-90</b>	2865	6	1433	5	955	3	716	5	573	5	358	4