

2007 UPDATED SPEEDS AND FEEDS FOR DURA-BAR MATERIALS*

Gray Iron, Grades G1 and G2					
Operation	Tool Maker	Insert Guide	SFM	Feed, (IPR)	Depth of Cut
Rough Turn (OD & ID)	Sandvik	3210	800 – 1,000	.014" - .028"	.100" - .175"
Finish Turn (OD & ID)	NTK	HC2/HC6	800 – 1,000	.004" - .012"	
	Sandvik	6090	1,400 – 1,800	.004" - .020"	
Drilling (with insert)	Komet	BK69/BK84	400 - 625	.004" - .015"	
	Sandvik	1044/4024	410 - 700		
Drilling	Allied	C3 TiAlN	270 - 350	.003" - .012"	
Grooving (OD & ID)	Iscar	IC9015	400 - 650	.002" - .007"	
	NTK	HC2	900 - 1,200		

Ductile Iron - Grade 65-45-12					
Operation	Tool Maker	Insert Guide	SFM	Feed, (IPR)	Depth of Cut
Rough Turn (OD & ID)	Sandvik	3215	800 - 1,200	.014" - .028"	.100" - .175"
Finish Turn (OD & ID)	NTK	HC2/HC6	800 - 2,000	.004" - .016"	
	Sandvik	6050	1,600 - 2,000	.004" - .020"	
Drilling (with insert)	Komet	BK69/BK84	400 - 700	.004" - .015"	
	Sandvik	1044/4024	475 - 825		
Drilling	Allied	C3 TiAlN	320 - 400	.003" - .012"	
Grooving (OD & ID)	Iscar	IC9015	650 - 850	.002" - .007"	
	Sandvik	525	900 - 1,500		

Ductile Iron - Grade 80-55-06					
Operation	Tool Maker	Insert Guide	SFM	Feed, (IPR)	Depth of Cut
Rough Turn (OD & ID)	Sandvik	3215	700 - 900	.008" - .024"	.100" - .175"
Finish Turn (OD & ID)	NTK	HC2/HC6	800 - 1,200	.004" - .012"	
	Sandvik	6050	1,000 - 1,500	.004" - .020"	
Drilling (with insert)	Komet	BK69/BK84	400 - 550	.004" - .015"	
	Sandvik	1044/4024	410 - 650		
Drilling	Allied	C3 TiAlN	270 - 350	.003" - .012"	
Grooving (OD & ID)	Iscar	IC9015	400 - 600	.002" - .007"	
	NTK	HC2	500 - 900		

Ductile Iron - Grade 100-70-02					
Operation	Tool Maker	Insert Guide	SFM	Feed, (IPR)	Depth of Cut
Rough Turn (OD & ID)	Sandvik	3215	450 - 750	.008" - .022"	.100" - .175"
Finish Turn (OD & ID)	NTK	HC2/HC6	800 - 1,000	.006" - .010"	
	Sandvik	6050	700 - 950	.004" - .010"	
Drilling (with insert)	Komet	BK69/BK84	350 - 500	.004" - .012"	
	Sandvik	1044/4024	400 - 600		
Drilling	Allied	C3 TiAlN	250 - 350	.003" - .012"	
Grooving (OD & ID)	Iscar	IC9015	300 - 600	.002" - .007"	
	NTK	HC2	400 - 800		

*Note: The above information is recommended as a starting point for machining Dura-Bar Continuous Cast Iron only. They may be too aggressive for iron castings or foreign material. Results may vary depending on the manufacturer or grade of the tool insert used, type of equipment, part geometry and desired tool life.

For more information contact: Dura-Bar toll free at 800-227-6455 or visit www.dura-bar.com
 The World Leader of Engineered Continuous Cast Iron