

Speed & Feed Charts for Ballnose Roughers



Medium Steel: 1018, 1020, 4140, 4150, P-20				
	1" / 25mm	1" / 32mm	1" / 40mm	2" / 50mm
RPMs	1600-2800	1400-2400	1400-2200	800-1800
Feed Rate (inches/minute)	30-90	30-100	10-100	40-100
Depth of Cut	.070-.200	.100-.250	.150-.300	.150-.400
Stepover	.100-.300	.100-.400	.100-.500	.100-.750
Tool Steel: 2, D2, S7, GM190				
	1" / 25mm	1" / 32mm	1" / 40mm	2" / 50mm
RPMs	1400-2400	1300-2200	1200-2200	800-1600
Feed Rate (inches/minute)	30-70	30-70	30-60	30-60
Depth of Cut	.070-.150	.400-.220	.150-.250	.150-.300
Stepover	.100-.200	.100-.300	.100-.400	.100-.500
Iron: Cast, Nodular, Ductile				
	1" / 25mm	1" / 32mm	1" / 40mm	2" / 50mm
RPMs	1800-3000	1800-3000	1600-2800	1200-2000
Feed Rate (inches/minute)	40-100	40-150	40-150	40-150
Depth of Cut	.080-.200	.100-.300	.100-.350	.200-.750
Stepover	.100-.300	.100-.300	.100-.375	.200-1.00