ACCUPRO®
High Performance Metalworking

Solid Boring Bars Speeds & Feeds

Material	HB/Rc	Speed (SFM)		Cutting Conditions						
				Feed IPR	Tool Diameter					
		Uncoated	ALTiN+		.015-.045	.050-.100	.110-.160	.180-.230	.290-.320	.360+
					Max Doc	Max Doc	Max Doc	Max Doc	Max Doc	Max Doc
Cast Iron	160 HB	75-200	200-550	.0005-.010	0.006	0.008	0.010	0.014	0.020	0.031
Carbon Steel	18 Rc	75-200	200-450	.0005-.007	0.003	0.005	0.006	0.008	0.012	0.017
Alloy Steel	20 Rc	75-200	200-425	.0005-.007	0.003	0.004	0.005	0.007	0.010	0.015
Tool Steel	25 Rc	75-175	175-300	.0005-.005	0.002	0.003	0.004	0.006	0.008	0.012
300 Stainless Steel	150 HB	75-175	175-350	.0005-.005	0.003	0.003	0.004	0.006	0.008	0.013
400 Stainless Steel	195 HB	75-210	130-420	.0005-.005	0.002	0.003	0.004	0.006	0.008	0.012
High Temp Alloy Ni & Co Base	20 Rc	50-130	130-300	.0005-.004	0.002	0.003	0.003	0.005	0.007	0.010
Titanium	25 Rc	50-120	120-275	.0005-.005	0.003	0.004	0.005	0.006	0.009	0.014
Heat Treated Alloys (38-45 Rc)	40 Rc	50-100	100-200	.0005-.005	0.002	0.002	0.003	0.004	0.006	0.009
Aluminum	100 HB	75-250	250-750	.0005-.015	0.011	0.015	0.019	0.026	0.038	0.056
Brass, Zinc	80 HB	75-300	250-650	.001-.010	0.009	0.012	0.015	0.021	0.030	0.045

SFM = Surface Feet per Minute
DOC = Depth Of Cut
IPR = Inches Per Revolution