

# STEP 5: GRADE, SPEED & FEED

## GENERAL MACHINING RECOMMENDATIONS

Steel (ISO-P)	TP2501	TP2501	TP2501
Stainless Steel (ISO-M)	TM2000	TM2000	TM4000
Cast Iron (ISO-K)	TK1001	TK2001	TK2001
Hardened Steels (ISO-H)	TH1500	TH1500	—

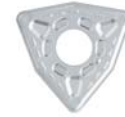
Recommended grades shown above

**FINISHING**  
at low depth of cut. Typical  $a_p = .008-.032"$  and  $f = .008$  in/rev.

**MEDIUM-ROUGH MACHINING**  
Typical one pass machining at  $a_p = .032-.120"$  and  $f = .012$  in/rev.

**ROUGH MACHINING**  
at higher depth of cut and feed rate. In most cases with difficult surface conditions such as scale, irregularities and other conditions leading to interruptions and edge damage. Typically  $a_p = .12-.28"$  and  $f = .02$  in/rev.

### STEEL MACHINING



Available in a broad range of insert shapes and geometries for light, medium and roughing operations,

TP2501, TP1501 and TP0501 insert grades provide the best selection in steel turning, whether your goal is versatile, balanced or high-speed productivity.

