

ISO	Material Group	Workpiece Material	Tensile Strength MPa	Recommended Starting Speeds v_c (ft/min)														
				GS3115														
				f_n (inch/rev)														
				.004	.008	.012												
M Stainless Steel	M1	Austenitic Stainless Steels Ex. 200 Series, 301, 302, 304, 304L, 309 Brinell Hardness HB 130-200	<600	820	670	490												
	M2	High-Strength Austenitic Stainless and Cast Stainless Steels Ex. 310, 316, 316L, 321, 347, 384 Brinell Hardness HB 150-230	600-800	740	600	440												
	M3	Duplex Stainless Steels Ex. 323, 329, F55, 2205 Brinell Hardness HB 135-275	<800	655	535	390												

ISO	Material Group	Workpiece Material	Brinell Hardness HB	Rockwell Hardness HRC	Tensile Strength MPa	Recommended Starting Speeds v_c (ft/min)												
						GS3115												
						f_n (inch/rev)												
						.004	.008	.012										
S High Temp Alloys	S1	Iron-Based Heat-Resistant Alloys Ex. A286, A608, INCOLOY 800 Series, N-155, Haynes 556, Discaloy	200-280	<30	600-1000	330	260	170										
	S2	Cobalt-Based Heat-Resistant Alloys Ex. Haynes 25 (L605), Haynes 188, Stellite, MAR-M302, MAR-M509	250-350	<35	800-1200	250	180	120										
	S3	Nickel-Based Heat-Resistant Alloys Ex. Astroloy, Hastelloy X, INCONEL 600 and 700 Series, Waspalloy	250-350	<35	800-1200	250	180	120										
	S4	Titanium and Titanium Alloys Ex. Commercially Pure Ti, Ti-5Al-2.5Sn, Ti-6Al-4V, Ti-3Al-8V-6Cr-4Zr-4Mo	300-400	33-48	900-1600	-	-	-										