

ISO	Material Group	Workpiece Material	Tensile Strength MPa	Recommended Starting Speeds v_c (ft/min)														
				GM1115			GM1125			GM3215			GM3225					
				f_n (inch/rev)			f_n (inch/rev)			f_n (inch/rev)			f_n (inch/rev)					
				.004	.008	.012	.004	.008	.012	.004	.008	.012	.004	.008	.012			
M Stainless Steel	M1	Austenitic Stainless Steels Ex. 200 Series, 301, 302, 304, 304L, 309 Brinell Hardness HB 130-200	<600	980	870	780	850	750	650	690	600	470	620	470	290			
	M2	High-Strength Austenitic Stainless and Cast Stainless Steels Ex. 310, 316, 316L, 321, 347, 384 Brinell Hardness HB 150-230	600-800	880	780	700	760	670	580	630	540	420	560	420	260			
	M3	Duplex Stainless Steels Ex. 323, 329, F55, 2205 Brinell Hardness HB 135-275	<800	790	700	620	670	600	520	570	480	380	495	375	230			