

ISO	Material Group	Workpiece Material	Tensile Strength MPa	Recommended Starting Speeds v_c (ft/min)														
				GP1105			GP1115			GP1225			GP1135					
				f_n (inch/rev)			f_n (inch/rev)			f_n (inch/rev)			f_n (inch/rev)					
				.004	.008	.012	.004	.008	.012	.004	.008	.016	.004	.016	.024			
P Steel	P0	Low-Carbon Steels, Long Chipping (C < .25%) Ex. A36, 1008, 1010, 1018, 1108, 1117 Brinell Hardness HB <125	<530	1760	1550	1370	1640	1445	1280	1400	1245	855	1215	790	655			
	P1	Low-Carbon Steels, Short Chipping, Free Machining (C < .25%) Ex. 10L18, 1200 Series, 1213, 12L14 Brinell Hardness HB <125	<530	1500	1330	1120	1400	1245	1050	1180	1015	655	1015	590	525			
	P2	Medium- and High-Carbon Steels (C > .25%) Ex. 1035, 1045, 10L45, 1080, 1137, 1144, 1525, 1572 Rockwell Hardness HRC <25	>530	1120	1050	950	1050	985	885	920	820	590	855	540	460			
	P3	Alloy Steels and Tool Steels (C > .25%) Ex. P20, 1300, 2000, 3000, 4000, 5000, 8000, SAE A, D, H, O, S, M, T Rockwell Hardness HRC <35	600-850	1020	850	700	950	790	655	790	720	490	625	445	330			
	P4	High-Strength Alloy Steels and Tool Steels (C > .25%) Ex. P20, 1300, 2000, 3000, 4000, 5000, 8000, SAE A, D, H, O, S, M, T Rockwell Hardness HRC 35 - 48	850-1400	850	700	560	790	655	525	590	525	330	460	300	230			
	P5	Ferritic, Martensitic and PH Stainless Steels Ex. 13-8 PH, 15-5 PH, 17-4 PH, 400 and 500 Series Rockwell Hardness HRC <35	600-900	1050	880	700	985	820	655	855	720	560	625	460	330			
	P6	High-Strength Ferritic, Martensitic and PH Stainless Steels Ex. 13-8 PH, 15-5 PH, 17-4 PH, 400 and 500 Series Rockwell Hardness HRC 35 - 48	900-1350	630	530	350	590	490	330	425	360	300	360	260	230			