

■ Step 3 • Select the cutting speed *(continued)*

**Low-Carbon (<0.3% C) and Free-Machining Steel**

speed – m/min

Starting Conditions

material group	grade	135	180	225	275	320	360	410	455	495	m/min
P0/P1	WP15CT	◇									395
	WP25CT	◇									275
	WP35CT	◇									210
	WS10PT	◇									280
	WM35CT	◇									280

**Medium- and High-Carbon Steels (<0.3% C)**

speed – m/min

Starting Conditions

material group	grade	135	180	225	275	320	360	410	455	495	m/min
P2	WP15CT	◇									265
	WP25CT	◇									195
	WP35CT	◇									150
	WS10PT	◇									200
	WM35CT	◇									200

**Alloy Steels and Tool Steels (≤330 HB) (≤35 HRC)**

speed – m/min

Starting Conditions

material group	grade	135	180	225	275	320	360	410	455	495	m/min
P3	WP15CT	◇									190
	WP25CT	◇									155
	WP35CT	◇									120
	WS10PT	◇									155
	WM35CT	◇									155

**Alloy steels and Tool Steels (340–450 HB) (36–48 HRC)**

speed – m/min

Starting Conditions

material group	grade	60	90	120	150	180	210	240	270	300	m/min
P4	WP15CT	◇									145
	WP25CT	◇									105
	WP35CT	◇									95
	WS10PT	◇									110
	WM35CT	◇									110

**Ferritic, Martensitic, and PH Stainless Steels (≤330 HB) (≤35 HB)**

speed – m/min

Starting Conditions

material group	grade	120	150	180	210	240	270	300	330	360	m/min
P5	WP15CT	◇									215
	WP25CT	◇									195
	WP35CT	◇									135
	WS10PT	◇									200

**Ferritic, Martensitic, and PH Stainless Steels (340–450 HB) (36–48 HRC)**

speed – m/min

Starting Conditions

material group	grade	105	135	165	195	225	255	285	315	345	m/min
P6	WP15CT	◇									180
	WP25CT	◇									150
	WP35CT	◇									105
	WS10PT	◇									150