

DURA-BAR CONTINUOUS CAST IRON BAR STOCK

Recommended Speeds and Feeds for Machining Dura-Bar Plus Materials

DURA-BAR PLUS - GRADE G2 GRAY IRON

Machining Operation	SFM	Feed, (IPR)	Depth of Cut
Rough Turning (O.D. & I.D.)	800 - 1000	.014" - .028"	.100" - .175"
Finish Turning (O.D. & I.D.)	1400 - 1800	.004" - .020"	.100" - .175"
Drilling (insert)	410 - 700	.004" - .015"	.100" - .175"
Drilling	270 - 350	.003" - .012"	.100" - .175"
Grooving (O.D. & I.D.)	900 - 1200	.002" - .007"	.100" - .175"

DURA-BAR PLUS - GRADE 65-45-12 DUCTILE IRON

Machining Operation	SFM	Feed, (IPR)	Depth of Cut
Rough Turning (O.D. & I.D.)	800 - 1200	.014" - .028"	.100" - .175"
Finish Turning (O.D. & I.D.)	1600 - 2000	.004" - .020"	.100" - .175"
Drilling (insert)	475 - 825	.004" - .012"	.100" - .175"
Drilling	320 - 400	.003" - .012"	.100" - .175"
Grooving (O.D. & I.D.)	900 - 1500	.002" - .007"	.100" - .175"

DURA-BAR PLUS - GRADE 80-55-06 DUCTILE IRON

Machining Operation	SFM	Feed, (IPR)	Depth of Cut
Rough Turning (O.D. & I.D.)	700 - 900	.008" - .024"	.100" - .175"
Finish Turning (O.D. & I.D.)	1000 - 1500	.004" - .020"	.100" - .175"
Drilling (insert)	410 - 650	.004" - .015"	.100" - .175"
Drilling	270 - 350	.003" - .012"	.100" - .175"
Grooving (O.D. & I.D.)	500 - 900	.002" - .007"	.100" - .175"

DURA-BAR PLUS - GRADE 100-70-02 DUCTILE IRON

Machining Operation	SFM	Feed, (IPR)	Depth of Cut
Rough Turning (O.D. & I.D.)	450 - 750	.008" - .022"	.100" - .175"
Finish Turning (O.D. & I.D.)	800 - 1000	.006" - .010"	.100" - .175"
Drilling (insert)	400 - 600	.004" - .012"	.100" - .175"
Drilling	250 - 350	.003" - .012"	.100" - .175"
Grooving (O.D. & I.D.)	400 - 800	.002" - .007"	.100" - .175"

NOTE: Results may vary depending on the Manufacturer or grade of the tool insert used, type of equipment, part geometry and desired tool life.