

Criterion™ Finish Boring | Imperial (inch)

ISO	Material	Hardness (BHN)	SFM		Feed (IPR)
			Uncoated Inserts	Coated Inserts	
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 250	350 - 700	450 - 800	0.003 - 0.005
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 275	350 - 700	450 - 800	0.002 - 0.004
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 325	400 - 700	500 - 800	0.002 - 0.004
	Alloy Steel 4140, 5140, 8640, etc.	125 - 375	300 - 600	400 - 700	0.002 - 0.004
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 400	300 - 600	350 - 650	0.002 - 0.004
	Tool Steel H-13, H-21, A-4, O-2, 5-3, etc.	150 - 250	300 - 600	300 - 700	0.002 - 0.004
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	100 - 250	150 - 300	0.002 - 0.004
M	Stainless Steel 400 Series 1010, 1020, 1025, 1522, 1144, etc.	185 - 350	350 - 600	400 - 650	0.002 - 0.004
	Stainless Steel 300 Series 1010, 1020, 1025, 1522, 1144, etc.	135 - 275	350 - 600	400 - 650	0.002 - 0.004
	Super Duplex Stainless Steel 1010, 1020, 1025, 1522, 1144, etc.	135 - 275	350 - 600	400 - 650	0.002 - 0.004
K	Nodular, Grey, Ductile Cast Iron	120 - 320	400 - 600	500 - 700	0.002 - 0.004
N	Cast Aluminum	30 - 180	750 - 1000	800 - 1100	0.002 - 0.004
	Wrought Aluminum	30 - 180	750 - 1000	750 - 1000	0.002 - 0.004
	Brass	100	700 - 950	750 - 1000	0.002 - 0.004

NOTICE: The modular boring system's configuration, including the length of boring bar, boring head off set, and amount of extensions and/or reducers, may all affect performance of boring systems. All of these factors may increase imbalance of the modular boring system. Imbalance at excessive RPM will cause vibration in the machine tool, which can cause damage to the machine tool; in particular the spindle. This vibration may occur at spindle speeds above 1000 RPM. If vibration is present, reduce spindle speed.