

Criterion™ Finish Boring | Metric (mm)

ISO	Material	Hardness (BHN)	M/min		Feed (mm/rev)
			Uncoated Inserts	Coated Inserts	
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 250	107 - 213	137 - 244	0.08 - 0.13
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 275	107 - 213	137 - 244	0.05 - 0.10
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 325	122 - 213	152 - 244	0.05 - 0.10
	Alloy Steel 4140, 5140, 8640, etc.	125 - 325	91 - 182	122 - 213	0.05 - 0.10
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 400	91 - 182	107 - 198	0.05 - 0.10
	Tool Steel H-13, H-21, A-4, O-2, 5-3, etc.	150 - 250	91 - 182	107 - 213	0.05 - 0.10
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	30 - 76	46 - 91	0.05 - 0.10
M	Stainless Steel 400 Series 1010, 1020, 1025, 1522, 1144, etc.	185 - 350	107 - 182	122 - 198	0.05 - 0.10
	Stainless Steel 300 Series 1010, 1020, 1025, 1522, 1144, etc.	135 - 275	107 - 182	122 - 198	0.05 - 0.10
	Super Duplex Stainless Steel 1010, 1020, 1025, 1522, 1144, etc.	135 - 275	107 - 182	122 - 198	0.05 - 0.10
K	Nodular, Grey, Ductile Cast Iron	120 - 320	122 - 182	152 - 213	0.05 - 0.10
N	Cast Aluminum	30 - 180	229 - 305	244 - 335	0.05 - 0.10
	Wrought Aluminum	30 - 180	229 - 305	229 - 305	0.05 - 0.10
	Brass	100	213 - 290	229 - 305	0.05 - 0.10

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.