




WOHLHAUPTER® | Boring | Imperial (inch)

ISO	Material	Hardness (BHN)	Speed (SFM)			Feed Rate (IPR)
			 AM300®	 AM200®	 TiN	
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 250	750 - 1000	700 - 950	550 - 750	.0035 - .007
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 275	700 - 1000	650 - 900	500 - 700	.003 - .0065
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 325	650 - 850	600 - 750	500 - 700	.0035 - .0065
	Alloy Steel 4140, 5140, 8640, etc.	125 - 375	600 - 800	550 - 700	500 - 700	.0035 - .0065
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 400	500 - 700	450 - 600	350 - 500	.003 - .005
	Structural Steel A36, A285, A516, etc.	100 - 350	700 - 850	650 - 750	500 - 700	.003 - .0065
	Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	150 - 250	350 - 650	300 - 550	200 - 500	.0025 - .005
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	-	-	-	-
M	Stainless Steel 400 Series 416, 420, etc.	185 - 350	-	-	-	-
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	-	-	-	-
	Super Duplex Stainless Steel	135 - 275	-	-	-	-
K	Nodular, Grey, Ductile Cast Iron	120 - 320	650 - 800	600 - 750	450 - 650	.004 - .008
N	Cast Aluminum	30 - 180	1150 - 1500	1100 - 1400	850 - 1000	.006 - .012
	Wrought Aluminum	30 - 180	1150 - 1500	1100 - 1400	850 - 1000	.006 - .012
	Brass	30 - 100	850 - 1200	800 - 1150	650 - 1000	.005 - .009

NOTE: For speeds/feeds not listed, contact our Application Engineering department for assistance. ext: 7611 | email: appeng@alliedmachine.com

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)
 - Refer to example on page B10-N: 8 in the Wohlhaupter Master Product Catalog (B10-WHL) for calculating length to diameter ratio
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