



S.B. International, Inc.

Valve Seat Insert

Speed & Feed Chart

(Includes Hard Seats, Star Series Seats, & Powder Metal Seats)



SFC01-01
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S.B. International Speeds & Feeds

SBI HARD SEATS (Alloy)

C2 CARBIDE

C4 CARBIDE

<u>SEAT I.D.</u>	<u>Spindle RPM</u>	<u>Feed Inch/Min</u>	<u>Spindle RPM</u>	<u>Feed Inch/Min</u>
0.5000	1500	4.50	2000	6.00
0.6250	1200	3.50	1500	4.50
0.7500	1000	3.00	1300	3.90
0.8750	900	2.70	1000	3.00
1.0000	800	2.40	950	2.80
1.1250	700	2.00	850	2.60
1.2500	600	1.80	750	2.30
1.3750	550	1.65	700	2.10
1.5000	500	1.50	650	1.90
1.6250	470	1.40	600	1.80
1.7500	435	1.30	550	1.60
1.8750	400	1.20	500	1.50
2.0000	380	1.15	480	1.40
2.1250	360	1.10	450	1.35
2.2500	340	1.00	425	1.25
2.3750	320	0.95	400	1.20
2.5000	300	0.90	380	1.15

FOR SEAT WIDTHS OVER 0.070", REDUCE FEED RATES BY UP TO 40%

S.B. International, Inc. • 2108 Utopia Avenue • Nashville, TN 37211

1-888-843-7328 (General Inquiries) • 1-800-843-7328 (Order Desk Only) • 615-248-6281 • FAX 615-248-6377

Website: www.sbintl.com

S.B. International Speeds & Feeds

SBI ★ STAR ★ SERIES

C2 CARBIDE

(NON-MAGNETIC)

C4 CARBIDE

<u>SEAT I.D.</u>	<u>Spindle RPM</u>	<u>Feed Inch/Min</u>	<u>Spindle RPM</u>	<u>Feed Inch/Min</u>
0.5000	900	2.70	1200	3.50
0.6250	750	2.25	950	2.75
0.7500	600	1.80	800	2.25
0.8750	500	1.50	700	2.00
1.0000	450	1.35	600	1.80
1.1250	400	1.20	550	1.65
1.2500	350	1.05	500	1.50
1.3750	325	0.95	450	1.35
1.5000	300	0.90	400	1.20
1.6250	280	0.85	375	1.15
1.7500	260	0.80	350	1.05
1.8750	250	0.75	325	1.00
2.0000	225	0.70	300	0.90
2.1250	210	0.65	285	0.85
2.2500	200	0.60	275	0.80
2.3750	195	0.55	260	0.78
2.5000	180	0.50	250	0.75

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SBI POWDER METAL SEATS

C2 CARBIDE

C4 CARBIDE

<u>SEAT I.D.</u>	<u>Spindle RPM</u>	<u>Feed Inch/Min</u>	<u>Spindle RPM</u>	<u>Feed Inch/Min</u>
0.5000	1200	3.50	1500	4.50
0.6250	950	2.75	1200	3.50
0.7500	800	2.25	1000	3.00
0.8750	700	2.00	900	2.70
1.0000	600	1.80	800	2.40
1.1250	550	1.65	700	2.00
1.2500	500	1.50	600	1.80
1.3750	450	1.35	550	1.65
1.5000	400	1.20	500	1.50
1.6250	375	1.15	470	1.40
1.7500	350	1.05	435	1.30
1.8750	325	1.00	400	1.20
2.0000	300	0.90	380	1.15
2.1250	285	0.85	360	1.10
2.2500	275	0.80	340	1.00
2.3750	260	0.78	320	0.95
2.5000	250	0.75	300	0.90

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