

FACE MILL OPERATING GUIDELINES

					Grades										Coolant
Series 4W2A SERIES APLH, AOMT, APXX, APXH, APLV, APLS, APEB, APXB, NNE, SPLH, SHET, SHEW, YPLH INSERTS					IN30M	IN40P	IN2005	IN2015	IN1030	IN1530	IN2030	IN2040	IN5015	IN6530	
Material		Brinell Hardness	SFM	Feed per Insert											
Aluminum	6061-T6, 7075-T6, 2024	-	1500-3000	.004-.010	1	3	2								Yes
Cast Iron	Gray	150-250	300-1000	.004-.010		3	1					2	4		No
	Nodular		300-600												
Steel	Low Carbon 1018, 8620	100-250	400-1000	.004-.010		5	2		1	1	1*	3	4	4	No
	High Carbon F-6180, Nitralloy 52100	250-400	350-500	.004-.008											
	Alloyed Steel 4140, 4340, 6150	150-300	300-700	.004-.010		5	3		1	1	1*	2	4	4	
	Tool Steel A-6, D-1, D-2, P-20	Up to 300													
Stainless Steel	300 Series, 304, 316	-	300-700	.004-.010											May not be required at high speeds Yes
	400 Series, 15-5 PH, 17-4 PH	-	400-900		5	6	2	3	1	1	1*	5		4	
	13-8 PH	-	200-400												
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.003-.006		2	3	1	1	1					Yes
Titanium	6AL-4V	-	100-150	.005-.008	4	1	2	2	2						Yes

*Preferred for higher SFM.

Series 4W2A SERIES RPLP, RPLB, RPCB, RPLS, SHLP BUTTON INSERTS AND PNCU INSERTS											Grades					Coolant
											IN40P	IN1530	IN2030	IN2040/1540	IN6530	
Material		Brinell Hardness	SFM	Feed per Insert RPLT, RPLH, RPLP, PNCU	RPLW, RPCW, RPLB, RPLS, RPCB											
Aluminum	6061-T6, 7075-T6, 2024	-	1500-3000	.005-.015	-	1					Yes					
Cast Iron	Gray	150-250	250-800	.005-.015	.008-.020		3	2		1	No					
	Nodular		200-800													
Steel	Low Carbon 1018, 8620	150-250	250-1000	.005-.015	.008-.020	1	2	2*	1	4	No					
	High Carbon F-6180, Nitr alloy 52100	250-400	200-750	.005-.015	.008-.020	1	2	2*	1	4						
	Alloyed Steel 4140, 4340, 6150	150-300	250-750													
	Tool Steel A-6, D-1, D-2, P-20	Up to 300														
Stainless Steel	300 Series, 304, 316	-	250-750	.005-.015	.005-.015		2	1		3	May not be required at high speeds Yes					
	400 Series, 15-5 PH, 17-4 PH	Up to 320	300-800													
	13-8 PH	-	200-600													
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75-120	.005-.008	-		1	2		3	Yes					
Titanium	6AL-4V	-	100-150	.005-.010	-		2	1		3	Yes					

*Preferred for higher SFM.

The success of any cutter application is a function of many variables. Our initial preference of grade is based on applying a more tough grade.