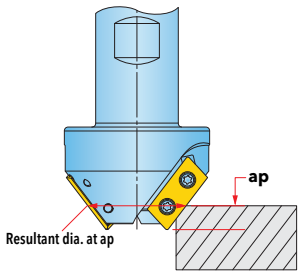
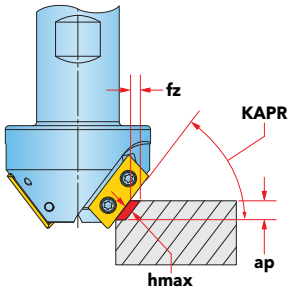
OPERATING GUIDELINES - 25MM INSERT (BEHW)

RPM Calculation



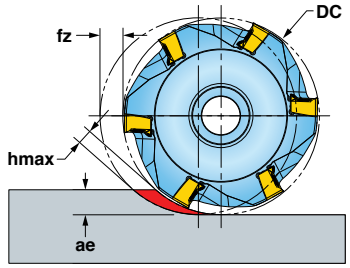
Calculation is to be made using the resultant diameter at ap

Lead Angle Chip Thinning



***Chip thinning calculator is recommended to ensure hmax falls within fz range**

Chip Thinning



* When ae is less than 25% DC, recommend use of Chip Thinning Calculator to ensure hmax falls within fz range.

Materials				Vc Cutting Speed SFM	fz * Feed/Tooth (inch)	Harder ⟷ Tougher		Coolant
ISO	Mat'l Group	Type	Examples			IN2540	IN15K	
P	1-5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.006	1		No
	6-9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	300-500				
	10-11	High-alloy Steel	H13, A2, D2, M2, T1	300-700				
M	12	Stainless Steel (ferritic & martensitic)	203, 303, 409	300-700	.003-.006	1		May not be required at high speeds
	13	Stainless Steel (martensitic)	410, 416, 440	400-900				
	14	Stainless Steel (austenitic)	304, 310, 13-8	200-400				Yes
K	15-16	Gray Cast Iron	CLS. 20, 30, 45	300-1000	.003-.006	1		No
	17-18	Nodular Cast Iron	60-40-18, 100-70-03	300-600				
N	21-30	Aluminum	7075, 6061	1000-8000	.003-.006		1	Yes

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.