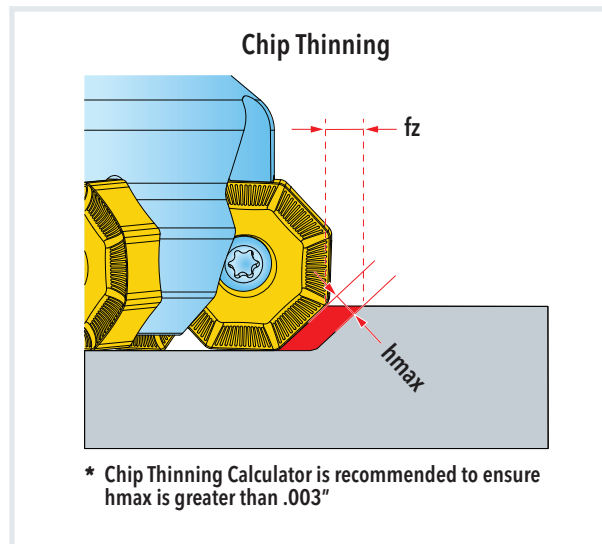


OPERATING GUIDELINES



Material	Brinell Hardness	SFM	Feed per Insert (inch)	Grade										Coolant			
				IN10K	IN2004	IN2005	IN2505	IN4005	IN2030	IN4030	IN2035	IN2010	IN2510		IN4010	IN6510	IN6515
Aluminum	7075-T6, 6061-T6, 2024	-	1500-10000	.006-.012	1												Yes
Cast Iron	Gray	150-250	500-1000	.008-.016		3					1		2	4			No
			1800+	.005-.008											1		
	Nodular		400-800	.007-.014		3						2		1	4		
			1500+	.004-.007												1	
Steel	Low Carbon 1018, 8620	100-250	400-1000	.006-.015													No
	High Carbon F-6180	250-400	400-800	.006-.012											1		
	Alloyed Steel 4140, 4340	150-300	300-700				3	2									
	Tool Steel A-6, D-1, D-2	Up to 300	300-500														
Stainless Steel	300 Series, 304, 316	-	300-700														May not be required at high speeds
	400 Series 15-5 PH	Up to 320	400-700	.005-.009			3	2	1								Yes
	13-8 PH	-	200-400														Yes
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.003-.006			2	3	1								Yes
Titanium	6AL-4V	-	100-150	.004-.007			3	2	1								Yes