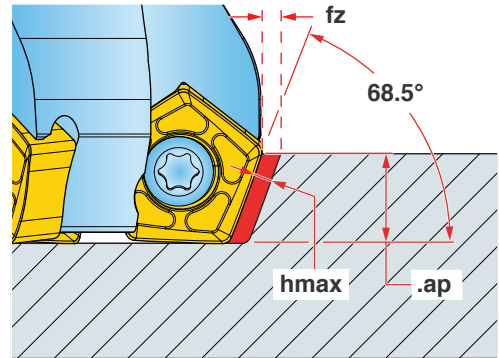


**OPERATING GUIDELINES - 17MM INSERT (DM6Q, DM2Q)**

**Chip Thinning**



\* Chip Thinning Calculator is recommended to ensure hmax is greater than .003"

ISO	Mat'l Group	Materials		Vc Cutting Speed SFM	fz Feed/Tooth (inch)	Harder ← → Tougher				Coolant
		Type	Examples			IN2040	IN6515	IN2505 IN2005	IN4030 IN2530 IN2030	
<b>P</b>	1-5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-800	.004-.025					No
	6-9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700	.004-.020	3		2	1	
	10-11	High-alloy Steel	H13, A2, D2, M2, T1	300-600	.004-.020					
<b>K</b>	15-16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.004-.025		1	2	3	No
	17-20	Nodular Cast Iron	60-40-18, 100-70-03	400-800	.004-.020		1	2	3	

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.