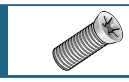
POWERFEED13+™ HARDWARE

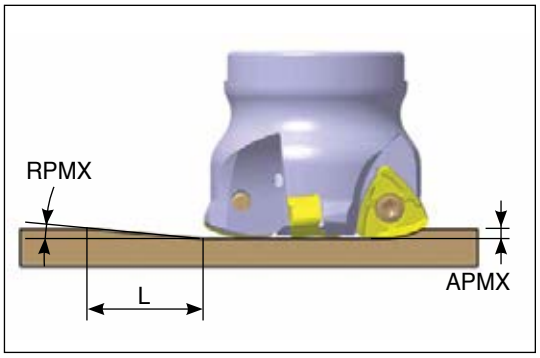
	 Insert Screw	 Driver	 Retention Bolt	 Optional Coolant Bolt	
DG6P-20R01	SM50-106-50	DS-0034	SD06-46	SD-06-89	
DG5P-20R01	SM50-106-50	DS-0034	SD06-46	SD-06-89	
DG6P-25R01	SM50-106-50	DS-0034	SD06-46	SD-06-89	
DG5P-25R01	SM50-106-50	DS-0034	SD06-46	SD-06-89	
DG6P-30R01	SM50-106-50	DS-0034	SD08-46	SD-08-92	
DG6P-30R02	SM50-106-50	DS-0034	SD08-46	SD-08-92	
DG6P-40R01	SM50-106-50	DS-0034	SD-12-82	SD-12-99	
DG5P-40R01	SM50-106-50	DS-0034	SD-12-82	SD-12-99	
DG6P-60R01	SM50-106-50	DS-0034	SD-12-82	SD-12-99	
1DG1P-1202781R01	SM50-106-50	DS-0034	-	-	
1DG1P-12047S9R01	SM50-106-50	DS-0034	-	-	
1DG1P-12017X8R01	SM50-106-50	DS-0034	-	-	
1DG1P-1503386R01	SM50-106-50	DS-0034	-	-	
1DG1P-15073S5R01	SM50-106-50	DS-0034	-	-	
1DG1P-15017X8R01	SM50-106-50	DS-0034	-	-	

POWERFEED13+™ OPERATING GUIDELINES

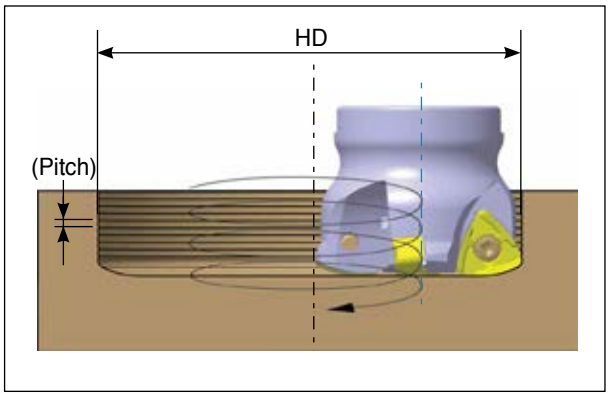
Series DG6P, 1DG1P											
Material		Brinnell Hardness	SFM	Feed per Insert	IN2505	IN2504	IN2510	IN2530	IN2035	IN7035	Coolant
Cast Iron	Gray	190 - 550	450-1300	.020 -.160	2		1				No
	Nodular	140 - 200	330 - 820	.020 - .120	2		1				
Steel	Low Carbon 1018, 8620	85-225	430 - 985	.020 - .180	1			2			No
	High Carbon F-6180	275-375	390 - 820	.015 - .157	1			2			
	Alloyed Steel 4140	375-480	400 - 850	.010 - .140	1	3		2			
	Tool Steel P20 - H13	250-470	165 - 750		1	3		2			
Stainless Steel	300 Series, 304, 316	–	260 - 560	.020 - .100	4	5		3	1	2	Yes
	400 Series 15-5PH, 17-4 PH	-	330 - 685		4	5		3	1	2	
	13-8PH	–	200 - 600		4			3	1	2	
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy	–	60 - 150	.015 - .080	4	5		3	1	2	Yes
Titanium	6AL-4V	–	80 - 120	.010 - .030	4	5		3	1	2	Yes
Hard Steel	All		150 - 400	.020 - .050	2	1					No

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.

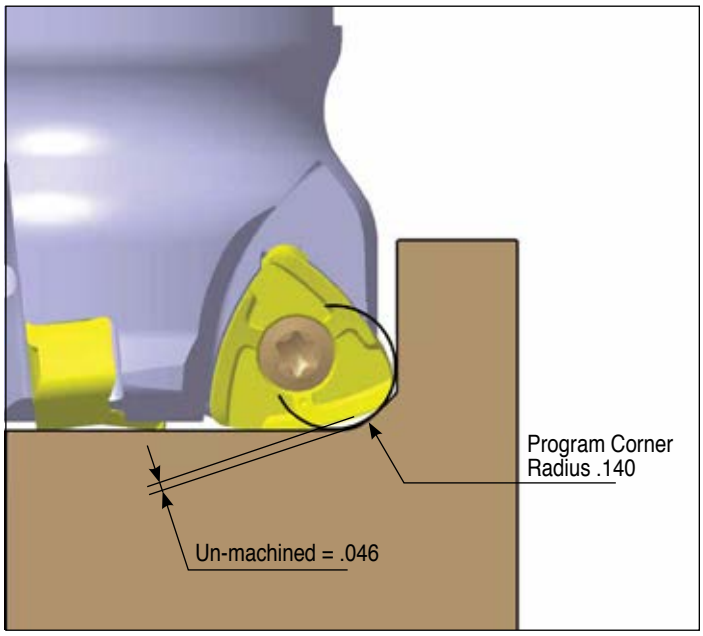
POWERFEED13+™ PROGRAMMING TECHNICAL DATA



DCX Cutting Dia. Max.	RMPX Ramp Angle Max.	L	APMX Depth of Cut Max.
1.25	.9	4.97	.078
1.50	1.5	2.97	.078
2.00	.8	5.58	.078
2.50	.6	7.44	.078
3.00	.4	11.17	.078
4.00	.3	14.89	.078
6.00	.2	22.34	.078



DCX Cutting Dia. Max.	MIN. Diameter Milled Hole	APCPR *MAX. Advance Per Cutter Path Rev.	MAX. Diameter Milled Hole	APCPR *MAX. Advance Per Cutter Path Rev.
1.25	1.56	.015	2.500	.060
1.50	1.98	.039	3.00	.065
2.00	2.94	.041	4.00	.065
2.50	3.92	.046	5.00	.065
3.00	4.91	.041	6.00	.065
4.00	6.91	.047	8.00	.065
6.00	10.91	.053	12.00	.065



Programming Tips:

- During programming verify the tool is defined correctly within the CAM system
- Maintain the shortest allowable tool length (L/D Ratio) for maximum rigidity
- Climb cut when possible
- Utilize favorable stock entry techniques to increase tool life (Example: Ramping, horizontal arcing and vertical arcing)