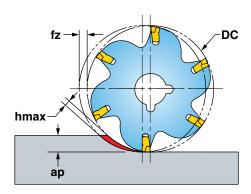


## OPERATING GUIDELINES + TECHNICAL INFORMATION





For radial depths of cut (ap) less than 1/4 of cutter diameter (DC), increase feed rates by the following %, or use the Chip Thinning Calculator to ensure hmax is within the fz range:

https://www.imc-i.com/mpwr/Milling/HChipThickness

Depth of Cut (ap) x Cutter Dia. (DC)	1/4	1/6	1/8	1/10	1/20	
Increase Feed Rate by	0%	15%-	30%	45%	100%	

	Materials			Vc		fz Feed/Tooth (inch)			Harder <> Tougher						
ISO	Group	Туре	Examples	Cutting Speed (SFM)	0.063	0.087-0.094	0.122-0.161	0.188-0.250	K10	П6030	П9030	Т8020	TT5100	Coolant	
	1-5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-700		-0.004 0.003-0.006	0.003-0.007	0.003-0.008	-	-	3	2	1	No	
P	6-9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	200 500											
	10-11	High-alloy Steel	H13, A2, D2, M2, T1	300-300											
	12-13	Stainless Steel (ferritic and martensitic)	410, 416, 440	0.002-0.004 0.003-0.006 0.003-0.006 0.00	0.002-0.004									Yes	
M	14	Stainless Steel (austenitic)	303, 304, 316, 15-5, 17-4				0.003-0.006	-	-	2	1	-	May not be required at high speeds		
K	15-16	Gray Cast Iron	CLS. 20, 30, 45	300-600	0.002-0.004	0.002-0.004	0.003-0.006	0.003-0.007	0.003-0.008	_	1	2	3		No
K	17-18	Nodular Cast Iron	60-40-18, 100-70-03	250-500			0.003-0.000	0.003-0.007	0.003-0.006	-	ı	2	3	-	NO
N	21-30	Aluminum	7075, 6061	700-800	0.002-0.003	0.003-0.007	0.003-0.008	0.003-0.009	1	2	-	3	-	Yes	
S	31-35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-100	0.002-0.003	0.002-0.003	0.003-0.005	0.003-0.005	0.003-0.005	-	-	1	2	-	Yes
3	36-37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	90-130			0.003-0.003	0.003-0.003	0.003-0.003	-	-	2	1	-	165