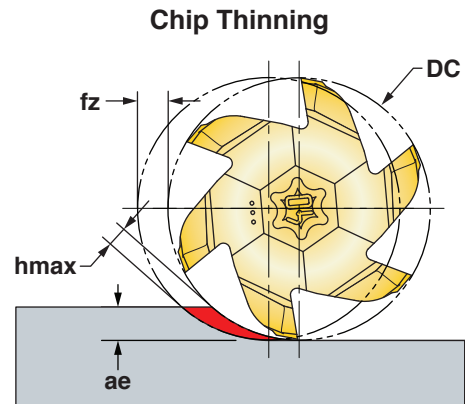


CHIP SURFER™ OPERATING GUIDELINES: 17N & 18N



* Chip Thinning Calculator is recommended to ensure hmax is within fz range.

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	450-800	.002-.006	No
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	400-750	.002-.005	
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	400-700	.002-.005	
M	12 thru 14	Stainless Steel	410, 416, 440, 303, 304, 316, 15-5, 17-4	200-500	.002-.005	May not be required at high speeds
K	15 thru 18	Iron	CLS. 20, 30, 45, 60-40-18, 100-70-03	500-800	.002-.006	No
S	31 thru 37	High-Temp, Ti	Inconel, Hastelloy, 6Al-4V, 5Al-5Mo-5V-3Cr	65-250	.002-.005	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.