TECHNICAL INFORMATION

Material		Brinnell Hardness	SFM	Feed per Tooth	Grade	IN2505	IN2504	IN2540	IN2530	IN2035	IN7035	IN10K	Coolant
Aluminum	6061-T6, 7075-T6		1300-1650	.0075 - .047								1	Yes
Cast Iron	Gray	190-220	360 - 690	.005 - .022		1			2				No
	Nodular	140-200	390 - 690			1			2				
Steel	Low Carbon 1018-8620	85-175	721 - 985	.005 - .024		1			2				No
	High Carbon F-6180	175 - 225	490 - 820	.005 - .024		1			2				
	Alloyed Steel 4140	275-325	325 - 590	.005 - .022		1		3	2				
	Tool Steel P20-H13	200-320	275 - 775	.005 - .040		1		3	2				
	Hardened Tool Steels	320-630	250 - 450	.005 - .030		2	1	3					
Stainless Steel	300 Series, 304, 316	-	360 - 600	.005 - .025		4			3	2	1		Optional
	400 Series 15-5 PH, 17-4 PH	-	360 - 720	.003 - .025		4			3	2	1		
	13-8 PH	-	200 - 600	.003 - .020					3	2	1		
Nickel Alloys	Inconel 600, 706, 718	-	80 - 150	.003 - .012					3	2	1		YES
Titanium	903, Hastelloy	-	115 - 195	.003 - .015					3	2	1		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.