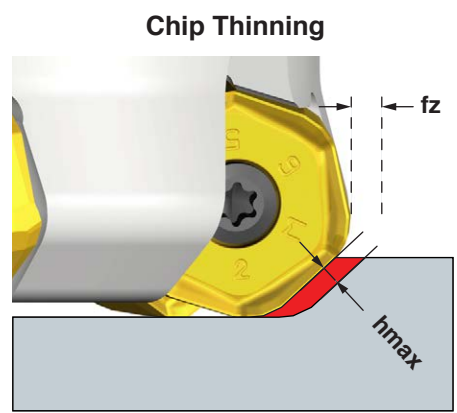


DIPOSHEXA™ 06 OPERATING GUIDELINES



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

ISO	Materials			Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder <-----> Tougher				Coolant
	Mat'l Group #VDI 3323	Type	Examples			IN2510	IN2505	IN2530	IN6537	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.003-.008					No
	6 - 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	350-700			3	2	1	
	10 - 11	High-alloy Steel	H13, A2, D2, M2, T1	300-600						
M	12 - 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.003-.007					Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-550			2	1	3	May not be required at high speeds
K	15 - 16	Gray Cast Iron	CLS. 20, 30, 45	500-1000	.003-.008					No
	17 - 20	Nodular Cast Iron	60-40-18, 100-70-03	400-800		1	2		3	
S	31 - 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150	.003-.006					Yes
	36 - 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200			2	1		

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.