



DIPOS FINISH™ OPERATING GUIDELINES

Materials				fz* Feed/Tooth (inch)	ap Axial Cut Depth (inch)	Vc Cutting Speed SFM	Harder.....Tougher								Coolant	
ISO	Mat'l Group #VDI 3323	Type	Examples				PCD	CBN	DLC	Cermet	Carbide					
							IN93D	IN80B	IN3310	IN62C	IN2504	IN10K	IN2510	IN2505		
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	.004-.010	.010-.020	400-1000								1	No	
						650-1600			1							
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M			350-700										1
						400-900			1							
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1			300-600										1
						350-650			1							
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	.004-.010	.010-.020	350-600								1	Yes	
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4			300-550										1
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	.004-.010	.010-.020	500-1000					1		2	3	No	
						1800-3000		1								
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	.004-.010	.010-.020	400-800					1		2	3		
N	21 - 30	Aluminum	7075, 6061	.004-.010	.010-.020	1000-3000							1		Yes	
						1500-4500	1		2							
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	.004-.010	.010-.020	65-120								1	Yes	
		Co Based > 35 HRC	Stellite, Haynes			250-500		1								
		Ni Based > 35 HRC	Inconel, Hastelloy			200-450		1								
		Fe Based > 35 HRC				150-350		1								
	36 thru 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	.004-.010	.010-.020	85-130								1		
H	38 thru 39	Hardened Steel >48	A2, O1, D2	.004-.010	.010-.020	130-250		1				2			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.