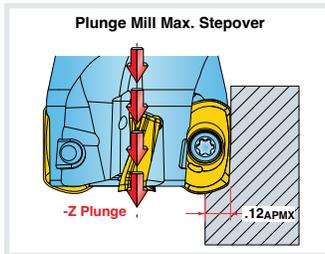


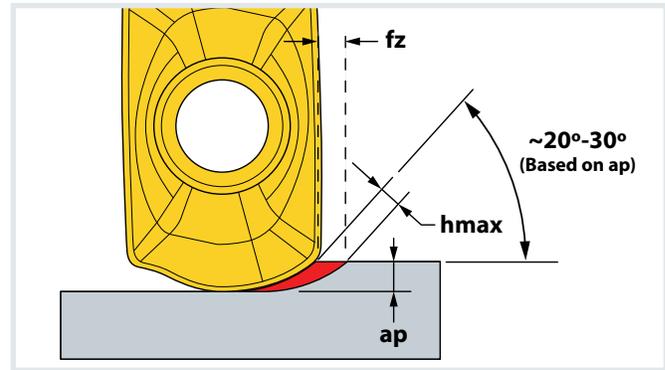
## Hi-Feed • Operating Guidelines



### CHIP THINNING

#### Chip Thinning Calculator

is recommended to ensure  $h_{max}$  is within range. ▶



ISO	Materials			Vc Cutting Speed SFM	fz* Feed/ Tooth (inch) HI-FEED	ap Recommd. (inch)	hmax* Max Chip Thickness (inch)	fz* Feed/ Tooth (inch) PLUNGE	Harder «--» Tougher				Coolant	
	Material Group	Type	Examples						IN2505	IN2530	IN6537	IN2036		
<b>P</b>	1-5	Non-Alloy Steel	1018, A36, 1045, A572, 1070	400-1000										
	6-9	Low-Alloy Steel	4140, 4340, P20, 8620, 300M	350-700	.012-.030	.008-.035	.003-.010	.003-.006	2	1	3		No	
	10-11	Hi-Alloy Steel	H13, A2, D2, M2, T1	300-600										
<b>M</b>	12-13	Stainless Steel (ferritic & martensitic)	410, 416, 440	350-600									Yes	
	14	Stainless Steel (austenitic)	303, 304, 316, 15-5, 17-4	300-550	.012-.030	.008-.035	.003-.010	.003-.005	3	2		1	May not be required at high speeds	
<b>K</b>	15-16	Gray Cast Iron	CLS. 20, 30, 45	500-1000										
	17-18	Nodular Cast Iron	60-40-18, 100-70-03	400-800	.012-.035	.008-.035	.003-.010	.003-.006	1	2	3		No	
<b>S</b>	31-35	Hi-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-150										
	36-37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	85-200	.012-.025	.008-.035	.003-.010	.003-.005	2	3		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.