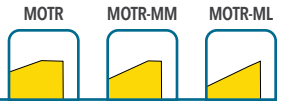
6 mm • Operating Guidelines



Materials				Vc Cutting Speed SFM	fz* Feed/ Tooth (inch)	Harder «----» Tougher						Coolant	Edge Prep		
ISO	Material Group #VDI 3323	Type	Examples			IN2504	IN2505	IN2530	IN6537	IN2036	IN7036		MOTR	MOTR-MM	MOTR-ML
P	1-5	Non-Alloy Steel	1018, A36, 1045, A572, 1070	400-1000	.015-.090		1	2	3			No	1	2	
	6-9	Low-Alloy Steel	4140, 4340, P20, 8620, 300M	300-900											
	10-11	High-Alloy Steel	H13, A2, D2, M2, T1	300-650	.010-.050	2	1	3							
M	12-13	Stainless Steel (ferritic & martensitic)	410, 416, 440	300-650	.010-.030			3		1	2	Yes		2	1
	14	Stainless Steel (austenitic)	303, 304, 316, 15-5, 17-4	300-550											
K	15-16	Gray Cast Iron	CLS. 20, 30, 45	500-750	.020-.040	2	1	3				No	3	2	1
	17-18	Nodular Cast Iron	60-40-18, 100-70-03												
S	31-35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	65-120	.005-.030			3		1	2	Yes		2	1
	36-37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	100-250											
H	38 - 39	Hardened Steel >48	A2, 01, D2	160-350	.010-025	1	2					No	1	2	

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.