

Operating Guidelines - 50xD

Materials				Condition	Tensile Strength (N/mm2)	HB Hardness	Vc Cutting Speed SFM	IPR Cutting Diameter (in/rev)			
ISO	Mtl Group No.	Type	4.0-4.99 mm (.157-.196")					5.0-5.99 mm (.197-.235")	6.0 mm (.250+")		
P	1	Non alloy steel and cast steel free cutting steel	< 0.25 %C	Annealed	420	125	330	.0060 - .0075	.0075 - .0094	.0094	
	2		>= 0.25 %C	Annealed	650	190					
	3		< 0.55 %C	Quenched and Tempered	850	250					
	4		>= 0.55 %C	Annealed	750	220					
	5		> 0.55 %C	Quenched and Tempered	1000	300					
	6	Low alloy steel and cast steel (less than 5% of alloying elements)			Annealed	600	200	215	.0060 - .0075	.0075 - .0094	.0094
	7				Quenched and Tempered	930	275				
	8					1000	300				
	9					1200	350				
	10	High alloyed steel, cast steel, and tool steel			Annealed	680	200	190	.0040 - .0052	.0052 - .0065	.0065
	11				Quenched and Tempered	1100	325				
M	12	Stainless steel (410, 416, 420, 440)		Ferritic/ Martensitic	680	200	190	.0040 - .0052	.0052 - .0065	.0065	
	13	Stainless steel (15-5, 17-4)		Martensitic	820	240					
	14	Stainless steel (302, 303, 304)		Austenitic	600	180	195	.0025 - .0032	.0032 - .0040	.0040	
		Stainless steel (310, 316, 321)					145	.0018 - .0026	.0026 - .0032	.0032	
	14	Stainless steel (323, 329, F55, 2205)		Austenitic/ Ferritic	820	240	115	.0010 - .0015	.0015 - .0019	.0019	
S	36	Titanium Ti alloys Ti1100, Ti6AL4V				Rm 400	100	.0010 - .0015	.0015 - .0020	.0020	
	37				Alpha + Beta alloys cured	Rm1050					

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.