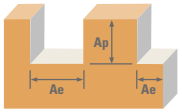
Picatinny Rail Non-Ferrous Dovetail Form Tool



	Picatinny Rail Non-Ferrous Dovetail Form Tool 3 Flute Made to MIL-STD-1913	Hardness		Ae x DC	Ap x DC	Vc (sfm)		DC • in 0.6050
P	CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536			Tool not recommended for this material group				
P	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100			Tool not recommended for this material group				
M	STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F, 440F			Tool not recommended for this material group				
M	STAINLESS STEELS (DIFFICULT) 304, 304L, 316, 316L			Tool not recommended for this material group				
M	STAINLESS STEELS (PH) 13-8 PH, 15-5 PH, 17-4 PH, Custom 450			Tool not recommended for this material group				
K	CAST IRONS (LOW & MEDIUM ALLOY) Gray, Malleable, Ductile			Tool not recommended for this material group				
N	ALUMINUM ALLOYS 2017, 2024, 356, 6061, 7075	≤ 150 Bhn or ≤ 7 HRc	Profile	≤ .50	APMX	2000 (1600-2400)	RPM	12628
							Fz	0.0056
							Feed (ipm)	211.39
N	ALUMINUM DIE CAST ALLOYS (HIGH SILICONE) A-390, A-392, B-390	≤ 125 Bhn or ≤ 77 HRb	Profile	≤ .50	APMX	750 (600-900)	RPM	4736
							Fz	0.0056
							Feed (ipm)	79.27
N	COPPER ALLOYS Alum Bronze, C110, Muntz Brass	≤ 140 Bhn or ≤ 3 HRc	Profile	≤ .50	APMX	430 (344-516)	RPM	2715
							Fz	0.0046
							Feed (ipm)	37.72
N	PLASTICS Polycarbonate, PVC, Polypropylene		Profile	≤ .50	APMX	2000 (1600-2400)	RPM	12628
							Fz	0.0093
							Feed (ipm)	353.03
S	SUPER ALLOYS (NICKEL, COBALT, IRON BASE) Inconel 601, 617, 625, Incoloy, Monel 400			Tool not recommended for this material group				
S	SUPER ALLOYS (NICKEL, COBALT, IRON BASE) Inconel 718, X-750, Incoloy, Waspaloy, Hastelloy, Rene			Tool not recommended for this material group				
S	TITANIUM ALLOYS Pure Titanium, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si			Tool not recommended for this material group				
S	TITANIUM ALLOYS (DIFFICULT) Ti10Al2Fe3Al, Ti5Al5V5Mo3Cr, Ti7Al4Mo, Ti3Al8V6Cr4Zr4Mo, Ti6Al6V6Sn, Ti15V3 Cr3Sn3Al			Tool not recommended for this material group				
H	TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2			Tool not recommended for this material group				

Bhn (Brinell) HRc (Rockwell C)
when recommended speed exceeds your capability, use maximum available and recalculate ipm
rpm = Vc x 3.82 / DC
ipm = Fz x 3 x rpm
reduce speed and feed for materials harder than listed
reduce feed and Ae when finish milling (.02 x DC maximum)
refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)