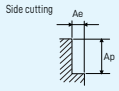
6FLUTE RECOMMENDED CUTTING CONDITIONS(INCH)

ISO Hardness (BHN)	Work Materials	Speed and Feed Recommendations			
		Type of Cut	Ap x D1	Ae x D1	Parameters
P<300	CARBON STEEL 10**, 11**, 12**, 12L**, 15**	Side Cutting	2 (*)	0.05	RPM Fz FEED SFM
300<P<380	ALLOY STEEL 41**, 43**, 51**, 86**	Side Cutting	2 (*)	0.05	RPM Fz FEED SFM
P<380	TOOL STEEL A2, D2, H13, P20, T15	Side Cutting	2 (*)	0.05	RPM Fz FEED SFM
M	STAINLESS STEELS 300 304, 316, 304L, 316LSUS316	Side Cutting	2 (*)	0.05	RPM Fz FEED SFM
M	STAINLESS STEELS 400 416, 420F, 430F, 440F	Side Cutting	2 (*)	0.05	RPM Fz FEED SFM
M	STAINLESS STEELS (PH) 17-4PH, 15-5PH, 13-8PH	Side Cutting	2 (*)	0.05	RPM Fz FEED SFM
S	TITANIUM Ti6Al4V, Ti5Al5V5Mo, Ti17Al4Mo	Side Cutting	2 (*)	0.05	RPM Fz FEED SFM
S	HIGH-TEMPERATURE ALLOY INCONEL, HASTALLOY, RENE	Side Cutting	2 (*)	0.05	RPM Fz FEED SFM

Diameter						
1/4	5/16	3/8	1/2	5/8	3/4	1
984 (787-1181)						
15036	12028	10024	7518	6014	5012	3759
0.0027	0.0046	0.0057	0.0068	0.0080	0.0089	0.0091
241.52	329.60	340.96	307.22	286.98	266.38	206.00
666 (533-799)						
10176	8141	6784	5088	4071	3392	2544
0.0020	0.0033	0.0042	0.0050	0.0059	0.0066	0.0069
120.19	163.46	169.88	153.85	143.27	133.82	104.57
328 (262-394)						
5012	4009	3341	2506	2005	1671	1253
0.0016	0.0028	0.0035	0.0041	0.0048	0.0054	0.0057
48.54	67.25	69.46	62.15	58.25	54.06	42.62
482 (386-578)						
7365	5892	4910	3682	2946	2455	1841
0.0016	0.0028	0.0035	0.0041	0.0048	0.0054	0.0056
71.33	98.82	102.07	91.34	85.60	79.45	62.20
699 (559-839)						
10681	8545	7120	5340	4272	3560	2670
0.0019	0.0033	0.0041	0.0049	0.0057	0.0064	0.0066
123.63	169.55	174.93	157.69	147.34	136.24	105.97
440 (352-528)						
6723	5379	4482	3362	2689	2241	1681
0.0016	0.0028	0.0035	0.0041	0.0048	0.0054	0.0056
65.11	90.21	93.17	83.38	78.14	72.53	56.38
381 (305-457)						
5822	4657	3881	2911	2329	1941	1455
0.0013	0.0022	0.0028	0.0033	0.0038	0.0044	0.0046
45.38	60.51	64.18	57.07	53.36	51.80	40.22
108 (86-130)						
1650	1320	1100	825	660	550	413
0.0013	0.0022	0.0028	0.0032	0.0038	0.0044	0.0045
12.86	17.15	18.19	15.98	15.13	14.55	11.21



NOTES:
- Feed to be reduced by approximately 50% if L.O.C. (Length Of Cut) is over 3xD
- The above recommendations are based on ideal conditions; for smaller taper machining centers or less rigid conditions please adjust parameters accordingly on diameters greater than 1/2"
- In profile operations, engaging more that 2xD, reduce the radial depth of cut by 50%-60%
- Finish cuts typically require reduced cutting feeds and speeds; also, it is recommended the radial width of cut (AE) should not exceed 2% x D1