



INCH

METRIC

### Recommended Cutting Data for MAX MASTER (QM Max GII)

Material	INSERT	Grade	SFM	IPT	DOC	WOC
Gray Cast Iron	-PH	JC8118 JC7560	700	.025" - .040"	.030" - .040"	70%
Nodular Cast Iron	-PH	JC8118 JC7560	650	.025" - .040"	.030" - .040"	70%
Carbon Steel	-PH	JC7560 JC8118	600	.025" - .040"	.030" - .040"	70%
Low Alloy Steel	-PH	JC7560 JC8118	550	.025" - .040"	.030" - .040"	70%
Mold Steel	-PH	JC8118 JC7560	500	.020" - .035"	.020" - .040"	60%
Tool & Die Steel (40-50 HRC)	-PH	JC8118 JC7560	400	.020" - .030"	.015" - .025"	60%
Hardened Die Steel (50-60 HRC)	-PH	JC8118 JC7560	250	.010" - .015"	.005" - .010"	40%
Stainless Steel	-SL -PH	JC7550 JC8118	300	.015" - .030"	.015" - .030"	60%
Titanium	-SL	JC7550	200	.010" - .025"	.012" - .020"	60%
Inconel	-SL	JC7550	100	.005" - .015"	.010" - .015"	60%

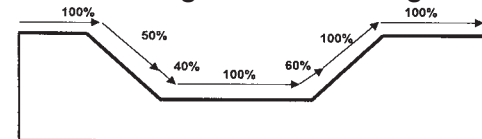
- NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.  
 2. RPM = 3.82 x SFM / Dia.  
 3. IPM = RPM x IPT x # of flutes (or teeth)

### Additional Cutting Data For Longer Tools

Reach/Dia.	~4.0	4.0~4.5	4.5~5.3	5.3~5.7	5.7~6.2	6.3~
rpm %	100	90	80	80	75	70
Feed %	100	90	90	80	75	70

**NOTE:** The above percentages should be applied, according to tool ratio.

### Reduced Cutting Data For Cutting Pattern



**NOTE:** Feed should be reduced when cutting the above pattern