



INCH

METRIC

Super Diemaster

Recommended Cutting Data for Super Diemaster

Material	SFM	Parameters	INSERT SIZE				
			7mm	10mm	12mm	16mm	20mm
Gray Cast Iron	700	IPT	.012"	.015"	.016"	.020"	.025"
		DOC	.025"	.040"	.060"	.100"	.140"
		WOC	70%	70%	70%	70%	70%
Nodular Cast Iron	650	IPT	.012"	.015"	.016"	.020"	.025"
		DOC	.025"	.040"	.060"	.100"	.140"
		WOC	70%	70%	70%	70%	70%
Carbon Steel	600	IPT	.012"	.015"	.016"	.020"	.025"
		DOC	.025"	.040"	.060"	.080"	.100"
		WOC	70%	70%	70%	70%	70%
Low Alloy Steel	550	IPT	.012"	.015"	.016"	.020"	.025"
		DOC	.025"	.035"	.040"	.060"	.080"
		WOC	70%	70%	70%	70%	70%
Mold Steel	500	IPT	.010"	.012"	.016"	.020"	.025"
		DOC	.012"	.015"	.020"	.030"	.040"
		WOC	60%	60%	60%	60%	60%
Tool & Die Steel (40-50 HRC)	400	IPT	.010"	.012"	.016"	.020"	.025"
		DOC	.012"	.015"	.020"	.025"	.030"
		WOC	60%	60%	60%	60%	60%
Hardened Die Steel (50-60 HRC)	200	IPT	.005"	.006"	.007"	.008"	.010"
		DOC	.005"	.008"	.010"	.012"	.015"
		WOC	40%	40%	40%	40%	40%
Stainless Steel	300	IPT	.010"	.012"	.015"	.020"	.025"
		DOC	.015"	.020"	.030"	.040"	.060"
		WOC	60%	60%	60%	60%	60%
Titanium	200	IPT	.010"	.012"	.015"	.020"	.025"
		DOC	.010"	.012"	.015"	.020"	.025"
		WOC	60%	60%	60%	60%	60%
Inconel	100	IPT	.005"	.006"	.008"	.010"	.012"
		DOC	.005"	.008"	.010"	.015"	.020"
		WOC	60%	60%	60%	60%	60%
Aluminum	2000	IPT	.015"	.020"	.025"	.030"	.040"
		DOC	.020"	.040"	.060"	.100"	.140"
		WOC	60%	60%	60%	60%	60%
Graphite	600	IPT	.008"	.010"	.012"	.015"	.018"
		DOC	.010"	.012"	.015"	.020"	.025"
		WOC	60%	60%	60%	60%	60%

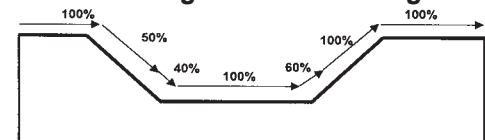
- NOTE:** 1. These parameters are for stable machining with steel bodies at lengths 4XD. See table below for longer applications.
 2. RPM = 3.82 x SFM / Dia.
 3. IPM = RPM x IPT x # of flutes (or teeth)

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