ISO Material		HRC	M/Min. (Vc)	CHIPLOAD PER TOOTH (Fz)			
				1.50 - 3.00mm	3.01 - 6.00mm	6.01 - 9.00mm	9.01 - 13.00mm
S	**COBALT BASE ALLOYS**						
	Powdered Metal, Stellite, Hs-21, Haynes 25/188, X-40, L-605	< 40 > 40	25 - 40 15 - 25	.008 - .020	.013 - .025	.020 - .030	.025 - .040
	NICKEL BASE ALLOYS						
	Invar, Kovar, Inconel-625/718, Waspaloy, Rene, Hastelloy, A286	< 40 > 40	30 - 40 25 - 35	.008 - .020	.013 - .025	.020 - .030	.025 - .040
	IRON BASE ALLOYS						
	Incoloy 800-802, Multimet N-155, Timkin 16-25-6, Carpenter 22-b3	< 40 > 40	45 - 50 35 - 45	.010 - .023	.015 - .030	.023 - .035	.025 - .045
	MONEL						
	Monel - 65% Nickel		20 - 35	.008 - .020	.013 - .025	.020 - .030	.025 - .040
	TITANIUM ALLOYS						
	Commercially Pure, 6Al-4V, Astm 1/2/3, 6Al-25N-4Zr-2Mo-Si		40 - 45	.010 - .023	.015 - .030	.023 - .035	.025 - .045
M	**STAINLESS STEELS**						
	(Precipitation) 13/8, 15/5, 17-4, pH Types	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
	(Austentic) 200 Series, 300 Series	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
	(Austentic) 304L, 316L, Nitronic 50	< 40 > 40	25 - 30 15 - 25	.008 - .020	.013 - .025	.020 - .030	.025 - .040
	(Martensitic) 400 Series	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
P	**HIGH STRENGTH TOOL STEELS**						
	4140, 4340, 6150, 5210, A2, D2, P20, H11, H13, S2, O1	< 40 > 40	30 - 40 25 - 35	.008 - .020	.013 - .025	.020 - .030	.025 - .040
	MEDIUM ALLOY TOOL STEELS						
	200, 250, 300, 8620	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
	LOW CARBON STEELS						
	Platinum, A36, 12L14, 1000's, 1100's, 1300's	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
	CAST STEELS						
	Steel		40 - 45	.008 - .020	.013 - .025	.020 - .030	.025 - .040
K	**CAST MATERIAL**						
	Ductile Iron		45 - 70	.013 - .025	.018 - .025	.025 - .040	.025 - .050
	Gray Iron		35 - 70	.013 - .025	.018 - .025	.025 - .040	.025 - .050
N	**NON-FERROUS**						
	Aluminum (6061, 7075)		70	.013 - .025	.018 - .025	.025 - .040	.025 - .050
	Magnesium		70	.013 - .025	.018 - .025	.025 - .040	.025 - .050
	Copper		70	.013 - .025	.018 - .025	.025 - .040	.025 - .050
	Brass, Bronze		40 - 60	.013 - .025	.018 - .025	.025 - .040	.025 - .050
O	**COMPOSITE (non-ISO)**						
	Glass Epoxy, Fiberglass, Plastics, Graphite, G10		40 - 45	.008 - .020	.013 - .025	.020 - .030	.025 - .040

NOTE - ABOVE ARE STARTING PARAMETERS ONLY. HIGHER RESULTS MAY BE ACHIEVED WITH OPTIMUM CONDITIONS.