

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
<b>COBALT BASE ALLOYS</b>						
Haynes 25/188, Stellite 21, Cobalt Chrome	< 40 > 40	25 - 40 15 - 25	.008 - .020	.013 - .025	.020 - .030	.025 - .040
<b>NICKEL BASE ALLOYS</b>						
Inconel-625/718, Waspaloy, Invar, Rene, Hastelloy, Monel	< 40 > 40	30 - 40 25 - 35	.008 - .020	.013 - .025	.020 - .030	.025 - .040
<b>IRON BASE ALLOYS</b>						
A286, Discaloy, Haynes 556, Carpenter 22, Greek Ascology	< 40 > 40	45 - 50 35 - 45	.010 - .023	.015 - .030	.023 - .035	.025 - .045
<b>TITANIUM ALLOYS</b>						
Commercially Pure, 6Al-4V, Astm 1/2/3, 6Al-25N-4Zr-2Mo-Si		40 - 45	.010 - .023	.015 - .030	.023 - .035	.025 - .045
5553 / Beta Titanium		30 - 35	.010 - .020	.015 - .025	.023 - .030	.025 - .040
<b>STAINLESS STEELS</b>						
13/8, 15/5, 17-4, pH Types	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
300 Series, 304L, Nitronic 50, Duplex, Super-Austenitic	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
400 Series - 403, 405, 420, 455	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
<b>HIGH STRENGTH TOOL STEELS</b>						
A2, D2, P20, H13, S7, O1	< 40 > 40	30 - 40 25 - 35	.008 - .020	.013 - .025	.020 - .030	.025 - .040
<b>MEDIUM ALLOY TOOL STEELS</b>						
4140, 4340, 52100, 6150, 8620	< 40 > 40	30 - 40 25 - 35	.010 - .023	.015 - .030	.023 - .035	.025 - .045
<b>CARBON STEELS</b>						
1000's - 1018, 1020, 12L14	< 40	30 - 40	.010 - .023	.015 - .030	.023 - .035	.025 - .045
<b>CAST MATERIAL</b>						
Ductile Iron		45 - 70	.013 - .025	.018 - .025	.025 - .040	.025 - .050
Gray Iron		35 - 70	.013 - .025	.018 - .025	.025 - .040	.025 - .050
<b>NON-FERROUS</b>						
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
<b>COMPOSITE (non-ISO)</b>						
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.**