

Operating Guidelines

GoldMax 8 - Series VJ6K									
Material	Brinell Hardness	SFM	Feed per Insert	INC505	INC530	INM005	INM030	Coolant	
Aluminum	6061-T6, 7075-T6, 2024	-	1500 - 8000	.004 - .016	2	3	1	Yes	
Cast Iron	Gray	150 - 250	400 - 750	.004 - .012	3		1	2	No
	Nodular		300 - 650						
Steel	Low Carbon 1018, 8620	100 - 250	350 - 650	.004 - .012		3	2	1	No
	High Carbon F-6180	250 - 400	300 - 600	.004 - .008					
	Alloyed Steel 4140, 4340	150 - 300	250 - 500	.004 - .008					
	Tool Steel A2, 01, D2, P20	Up to 300							
Stainless Steel	300 Series, 304, 316	-	250 - 450	.004 - .010		2	3	1	May not be required at high speeds
	400 Series, 15-5 PH	Up to 320	300 - 600						Yes
	13-8 PH	-	200 - 400						Yes
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.003 - .006		2	3	1	Yes
Titanium	6-4, 10-2-3, 5-5-5-3	-	75 - 200	.003 - .006		2	3	1	Yes

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.