

Operating Guidelines

HiQuad Plungers - Series QHU					IN2530	IN2535	IN4005	IN4030	IN4035	IN4015	Coolant
Material	Brinell Hardness	SFM	Feed per Insert								
Cast Iron	Gray	150 - 250	250 - 800	.005 - .012			2			1	No
	Nodular		200 - 800								
Steel	Low Carbon 1018, 8620	100 - 250	250 - 800	.004 - .012	3		2	1			No
	High Carbon F-6180	250 - 400	200 - 700								
	Alloyed Steel 4140, 4340	150 - 300	250 - 700								
	Tool Steel A-6, D-1, D-2	Up to 300									
Stainless Steel	300 Series, 304, 316	-	250 - 600	.004 - .008	5	2	4	3	1		May not be required at high speeds
	400 Series 15-5 PH	Up to 320	300 - 700								
	13-8 PH	-	200 - 250								.004 - .008
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.004 - .008		2	4	3	1		Yes
Titanium	6AL-4V	-	100 - 150	.004 - .008		2	4	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.