GOLDSLOT™ OPERATING GUIDELINES

Materials				Vc Cutting Speed SFM	fz Feed/ Tooth (inch) WOC .187 & Below	fz Feed/ Tooth (inch) WOC .250 & Above	Harder <-------> Tougher							Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples				IN4015	IN4005	IN2505	IN05S	IN4030	IN4035	IN2535	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	350 - 600	.002 - .006	.004 - .010		1	2		3			NO
	6 - 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	250 - 500	.002 - .006	.004 - .010		1	2		3			
	10 - 11	High-alloy Steel	H13, A2, D2, M2, T1	250 - 400	.002 - .006	.004 - .010		2	1		3			
M	12 - 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	300 - 600	.002 - .006	.004 - .010					3	2	1	May not be required at high speeds
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	250 - 400	.002 - .006	.004 - .010					3	2	1	YES
K	15 - 16	Gray Cast Iron	CLS. 20, 30, 45	400 - 750	.002 - .006	.004 - .010	1	2	3					NO
	17 - 20	Nodular Cast Iron	60-40-18, 100-70-03	300 - 650	.002 - .006	.004 - .010		1	2		3			
N	21 - 30	Aluminum	7075, 6061	1000+	.004 - .008	.006 - .015			2	1				YES
S	31 - 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	75 - 120	.002 - .006	.004 - .010					3	2	1	YES
	36 - 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	100 - 150	.002 - .006	.004 - .010					3	2	1	
H	38 - 39	Hardened Steel >48	A2, O1, D2	150 - 300	.002 - .004	.004 - .006		2	1					NO

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.