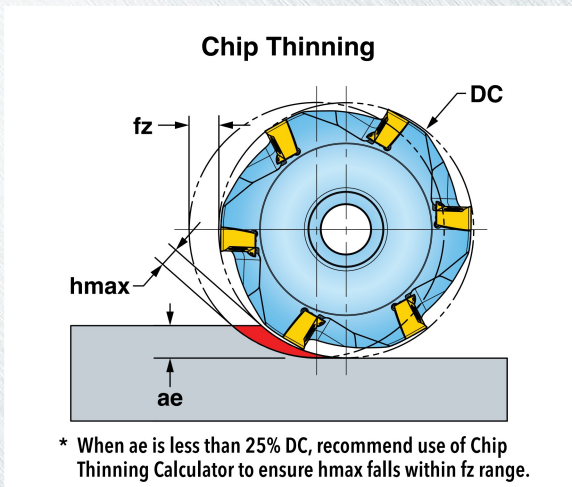


HIPOST⁺ OPERATING GUIDELINES - SERIES 22J3P



Materials				V _c Cutting Speed SFM	f _z Feed/Tooth (inch)	Harder <-----> Tougher						Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN2504	IN10K	IN2010	IN2505	IN4030 IN2530	IN2035	
P	1 thru 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	300-600	.003-.005	3			2	1		NO
	6 thru 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	250-500								
	10, 11	High-alloy Steel	H13, A2, D2, M2, T1	250-450								
M	12 thru 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	300-500	.003-.004				3	2	1	YES
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	250-450								May not be required at high speeds
K	15 thru 16	Gray Cast Iron	CLS. 20, 30, 45	300-600	.003-.005	1		2	3			NO
	17 thru 20	Nodular Cast Iron	60-40-18, 100-70-03	300-500								
N	21 thru 30	Aluminum	7075, 6061	800-1500	.003-.006		1					YES
S	31 thru 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	50-120	.003-.004				2	3	1	YES
	36 thru 37	Titanium Alloys	6AL-4V, 5Al-5Mo-5V-3Cr	60-130								

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.