HARDWARE

Cutter Series	Insert Screw		Wrench
	Part No.	Torque	Part No.
SP6H	SM40-120-20	30-35 in lbs	DS-T15T
SP6N	SM50-160-10	35-40 in lbs	DS-T20B

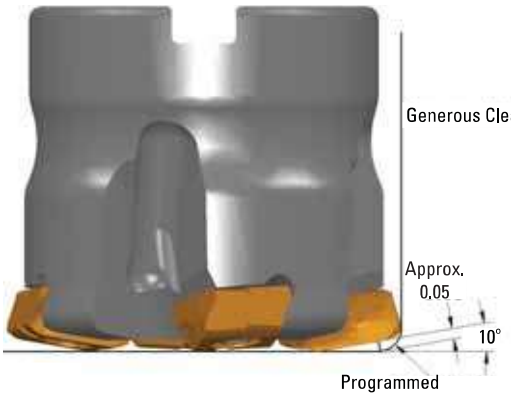
S-MAX TECHNICAL INFORMATION

Series SP6H/SP6N Material		Brinell Hardness	SFM	Feed per Insert	DOC DPM324L	DOC DPM434L	Grades IN2005	Grades IN1530	Coolant
Steel	Low Carbon 1018, 8620	100-250	500-800	.035-.100	.040-.080	.060-.120	1	2	No
	High Carbon F-6180	250-400	400-700						
	Alloyed Steel 4140, 4340	150-300	300-600						
	Tool Steel A-6, D-1, D-2	Up to 300							
Stainless Steel	300 Series, 304, 316	-	300-600	.030-.080	.030-.080	.050-.100	1	2	May not be required at high speeds.
	400 Series 15-5 PH	Up to 320	300-500						
	13-8 PH	-	200-400						
Titanium	6AL-4V	-	100-200	.030-.060	.030-.070	.040-.100	2	1	Yes

ADDITIONAL PROGRAMMING INFORMATION

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

Programming Note:
Program all SP6H series S-Max High Feed cutters as though they are bullnose cutters with a .118"/3.0mm corner radius. Program all SP6Nseries S-Max High Feed cutters as though they are bullnose cutters with a .158"/4.0mm corner radius. This method will both ensure and minimize remaining stock for secondary passes.



MARKETING & TECHNOLOGY CENTER
845 SOUTH LYFORD ROAD
ROCKFORD, IL 61108-2749
TEL: 815.387.6600
FAX: 815.387.6968
WWW.INGERSOLL-IMC.COM