



SUPEROMAX™ HARDWARE

	Insert Screw	Driver Handle	Driver Bit	L-Nest	L-Nest Screw	**OPTIONAL**	**OPTIONAL**	**OPTIONAL**
9M2L-04R01	SM50-160-R0	DS-A007	DS-T206B	NE143R13	SE-03-65	DS-A00-.25-T	DT-44-.25	DS-T20B
9M2L-06R01	SM50-160-R0	DS-A007	DS-T206B	NE143R13	SE-03-65	DS-A00-.25-T	DT-44-.25	DS-T20B
9M2L-08R01	SM50-160-R0	DS-A007	DS-T206B	NE143R13	SE-03-65	DS-A00-.25-T	DT-44-.25	DS-T20B
9M2L-10R01	SM50-160-R0	DS-A007	DS-T206B	NE143R13	SE-03-65	DS-A00-.25-T	DT-44-.25	DS-T20B
9M2L-12R01	SM50-160-R0	DS-A007	DS-T206B	NE143R13	SE-03-65	DS-A00-.25-T	DT-44-.25	DS-T20B

SUPEROMAX™ OPERATING GUIDELINES

MATERIALS				Vc Cutting Speed SFM	fz* Feed/Tooth (inch) LPE Inserts	GRADES (LPE INSERTS) Harder <-----> Tougher				Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN4040	IN2540	IN4030	IN2530	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	400 - 800	.006 - .018			2	1	NO
M	12 - 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	250 - 450	.006 - .014			2	1	NO
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	250 - 450	.006 - .014			2	1	NO
K	15 - 16	Gray Cast Iron	CLS. 20, 30, 45	500 - 900	.006 - .018			1	2	NO
	17 - 18	Nodular Cast Iron	60-40-18, 100-70-03	400 - 800	.006 - .018			1	2	NO

MATERIALS				Vc Cutting Speed SFM	fz* Feed/Tooth (inch) LSE/ZSE Inserts	GRADES (LSE/ZSE INSERTS) Harder <-----> Tougher				Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN4040	IN2540	IN4030	IN2530	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	350 - 750	.008 - .024	1	2			NO
	6 - 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	175 - 450	.008 - .018	1	2			NO
	10 - 11	High-alloy Steel	H13, A2, D2, M2, T1	175 - 450	.008 - .018	1	2			NO
H	38 - 39	Hardened Steel >48	A2, O1, D2	125 - 500	.010 - .014	1	2			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.