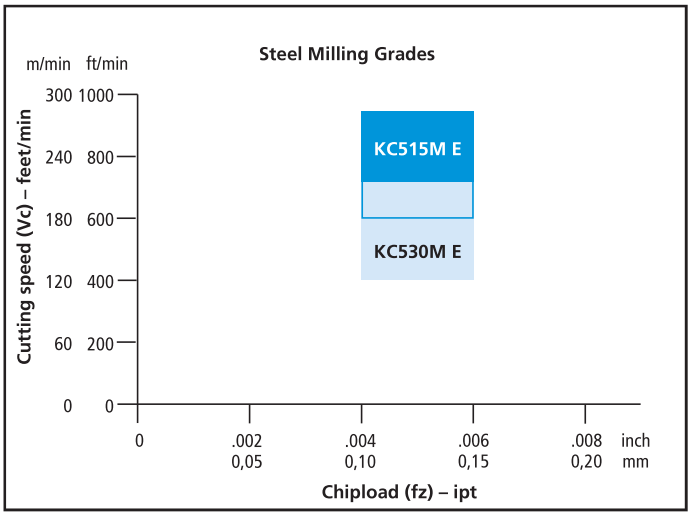
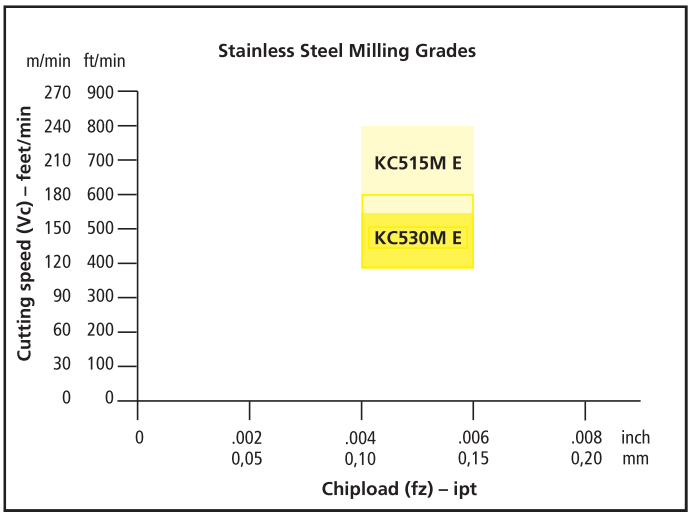
Application Data



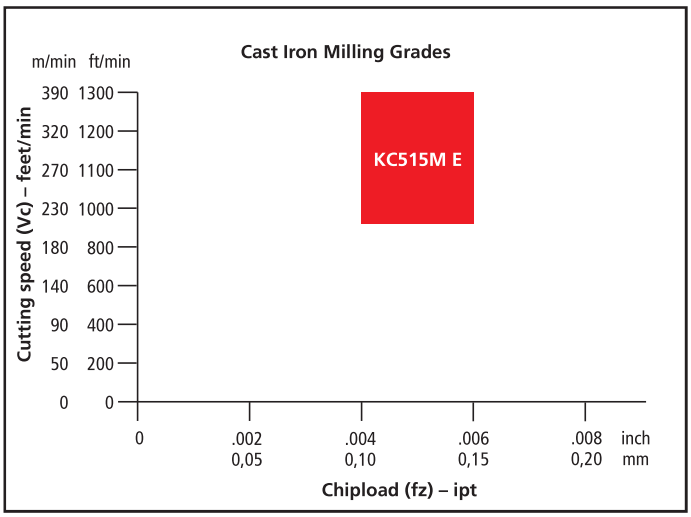
Coolant	Starting operating conditions	speed Vc ft/min / m/min	chipload Fz inch / mm	speed Vc ft/min / m/min	chipload Fz inch / mm	speed Vc ft/min / m/min	chipload Fz inch / mm
	KC530M ▼ E ▼▼	650 / 200	.006 / 0,15	580 / 170	.004 / 0,10	400 / 120	.004 / 0,10
	KC515M ▼▼ E ▼▼▼	850 / 260	.006 / 0,15	750 / 230	.006 / 0,15	450 / 140	.004 / 0,10
		<240HB or Low Alloy content (1018, A36)		240-350HB or Moderate Alloy content (8620, 4140)		>350HB or High Alloy content (15-5, 17-4 stainless, P20)	

Dry preferred — Wet, reduce speed by 25%



Coolant	Starting operating conditions	speed Vc ft/min / m/min	chipload Fz inch / mm	speed Vc ft/min / m/min	chipload Fz inch / mm	speed Vc ft/min / m/min	chipload Fz inch / mm
	KC515M ▼▼ E ▼▼▼	800 / 240	.003 / 0,10	700 / 210	.003 / 0,10	660 / 200	.006 / 0,15
	KC530M ▼▼ E ▼▼▼	500 / 150	.003 / 0,10	400 / 120	.003 / 0,10	350 / 110	.002 / 0,05
		Austenitic (304, 316)		Ferritic / Martensitic 135-330 HB		Ferritic / Martensitic 330-450 HB	

Dry preferred — Wet, reduce speed by 25%



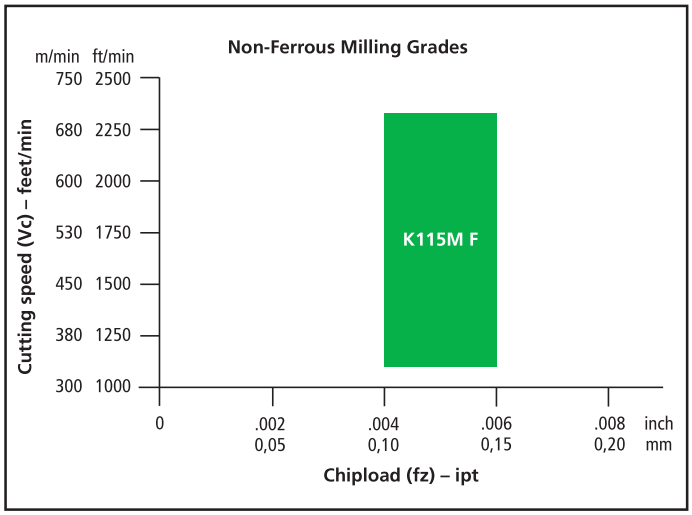
Coolant	Starting operating conditions	speed Vc ft/min / m/min	chipload Fz inch / mm	speed Vc ft/min / m/min	chipload Fz inch / mm
	KC515M ▼▼ E ▼▼▼	1200 / 360	.003 / 0,10	1000 / 300	.002 / 0,05
		<230HB or Gray Iron		<350HB or Ductile Cast Iron	

Dry preferred — Wet, reduce speed by 25%

Edge Preparations
S – hone + T-land (heavy)
E – hone (medium)
F – sharp (extra light)

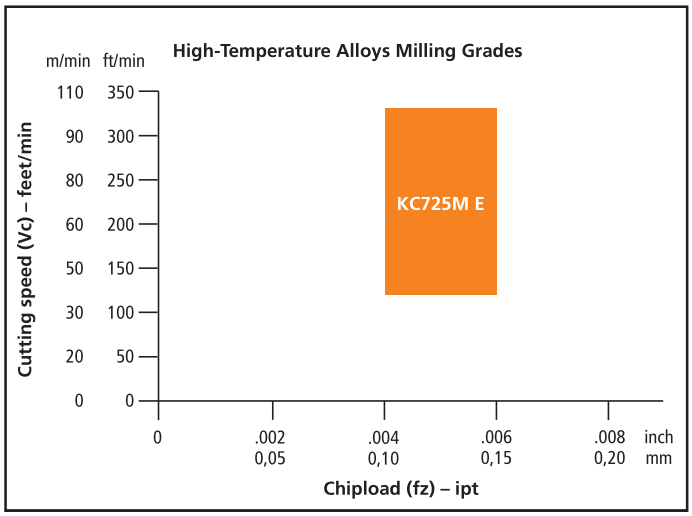
Coolant Requirements
dry
wet

Operating Conditions
▼ extra heavy – heavy interruption, continuous forging/casting skin, long tool extension
▼▼ heavy – moderate interruption, intermittent skin, moderate tool extension
▼▼▼ medium – light interruption, minimal/limited skin, moderate tool extension
▼▼▼▼ light – no interruption, premachined – no skin, shortest extension



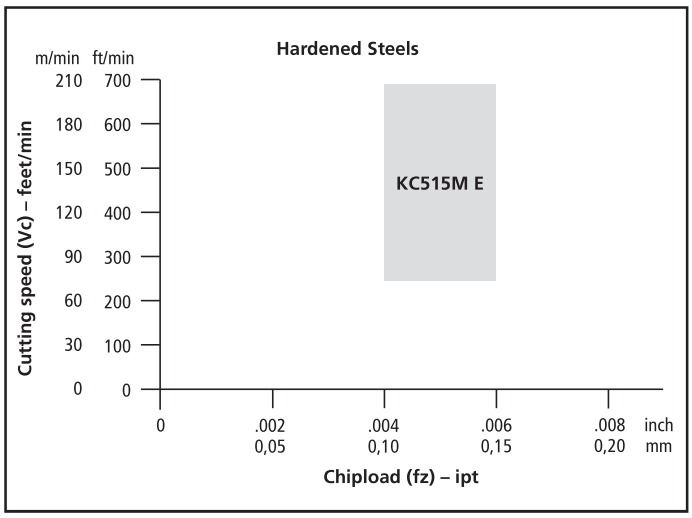
		speed Vc	chipload Fz	speed Vc	chipload Fz	speed Vc	chipload Fz	speed Vc	chipload Fz
Coolant	Starting operating conditions	ft/min	inch	ft/min	inch	ft/min	inch	ft/min	inch
		m/min	mm	m/min	mm	m/min	mm	m/min	mm
	K115M ▼▼ F ▼▼▼	1750	.009	1500	.009	1100	.008	1750	.010
		530	0,25	450	0,25	330	0,20	530	0,25
		Free Machining <9% Si (7075-T6, 6061-T6, 2024)		High Silicon >9%Si (390,380)		Copper, Zinc, Brass		Non-Metallics	

Dry not recommended — Wet preferred



		speed Vc	chipload Fz	speed Vc	chipload Fz	speed Vc	chipload Fz
Coolant	Starting operating conditions	ft/min	inch	ft/min	inch	ft/min	inch
		m/min	mm	m/min	mm	m/min	mm
	KC725M ▼▼ E ▼▼▼	300	.002	150	.002	220	.004
		90	0,05	50	0,05	70	0,10
		Titanium (Ti_6Al_4V)		Nickel, Cobalt Alloys (Inconel, Hastelloy, Monel, Nimonic)		Iron Alloys (X12NiCrSi3616, X2NiCrAlTi3220)	

Dry not recommended — Wet preferred



		speed Vc	chipload Fz	speed Vc	chipload Fz	speed Vc	chipload Fz
Coolant	Starting operating conditions	ft/min	inch	ft/min	inch	ft/min	inch
		m/min	mm	m/min	mm	m/min	mm
	KC515M ▼▼ E ▼▼▼	600	.003	500	.002	300	.002
		180	0,10	150	0,05	90	0,05
		Hardened Steel 45 - 52 HRC		Hardened Steel 53 - 59 HRC		Hardened Steel 60 - 65 HRC	

Dry not recommended — Wet preferred

Edge Preparations
S – hone + T-land (heavy)
E – hone (medium)
F – sharp (extra light)

Coolant Requirements
dry
wet

Operating Conditions
▼ extra heavy – heavy interruption, continuous forging/casting skin, long tool extension
▼▼ heavy – moderate interruption, intermittent skin, moderate tool extension
▼▼▼ medium – light interruption, minimal/limited skin, moderate tool extension
▼▼▼▼ light – no interruption, premachined – no skin, shortest extension