

Recommended Cutting Data | Imperial (inch)

ISO	Material	(BHN) Hardness	Grade	*Speed SFM	Recommended Feed (inch / tooth) Nose Radi			
					0.004"	0.008"	0.016"	0.031"
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 250	Carbide	525 - 975	0.001 - 0.003	0.002 - 0.005	0.004 - 0.006	0.006 - 0.009
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 275	Carbide	475 - 925	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 325	Carbide	475 - 825	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Alloy Steel 4140, 5140, 8640, etc.	125 - 375	Carbide	400 - 700	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 400	Carbide	325 - 600	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Structural Steel A36, A285, A516, etc.	100 - 350	Carbide	475 - 925	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	150 - 250	Carbide	325 - 600	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	Carbide	100 - 225	0.001 - 0.002	0.002 - 0.003	0.003 - 0.005	0.004 - 0.006
	Titanium Alloy	140 - 310	Carbide	125 - 300	0.001 - 0.002	0.002 - 0.003	0.003 - 0.005	0.004 - 0.006
	Aerospace Alloy S82	185 - 350	Carbide	125 - 300	0.001 - 0.002	0.002 - 0.003	0.003 - 0.005	0.004 - 0.006
M	Stainless Steel 400 Series 416, 420, etc.	185 - 350	Carbide	300 - 525	0.001 - 0.002	0.002 - 0.004	0.003 - 0.004	0.004 - 0.006
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	Carbide	300 - 525	0.001 - 0.002	0.002 - 0.004	0.003 - 0.004	0.004 - 0.006
	Super Duplex Stainless Steel	135 - 275	Carbide	300 - 525	0.001 - 0.002	0.002 - 0.004	0.003 - 0.004	0.004 - 0.006

*Not to exceed max recommended RPM for boring head found in corresponding Wohlhaupter Operation Manual

Deep Hole Boring Speed Adjustment

⚠ For Dynamic Boring Tool Length

Boring Type	7xD	8xD	9xD	10xD
Roughing	❖	❖	❖	❖
Finishing	0.70	0.50	0.30	❖

❖ Contact our Application Engineering department for assistance when boring these depths without NOVI^{TECH}.

Deep Hole Boring Speed Adjustment

⚠ For Dynamic Boring Tool NOVI^{TECH} Length

Boring Type	8xD	9xD	10xD
Roughing	0.80	0.60	0.40
Finishing	0.90	0.70	0.50

*Not to exceed recommended RPM printed on NOVI^{TECH} module

Recommended Speed Example

If the recommended speed for a finish boring assembly under 5xD is 400 SFM, then the speed for a 10xD finish boring assembly in the same application would be 200 SFM. (400 SFM x 0.50 = 200 SFM)

5xD = 400 SFM

10xD = 200 SFM

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com

⚠ WARNING Tool failure can cause serious injury. To prevent:

- Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)
- Refer to example on page B10-N: 8 for calculating length to diameter ratio

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					0.004"	0.008"	0.016"	0.031"
H	Wear Plate Hardox, AR400, T-1, etc.	400 - 600	Carbide	100 - 200	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006
			CBN	225 - 600	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006
	Hardened Steel	300 - 500	Carbide	125 - 275	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006
			CBN	225 - 600	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006
K	SG / Nodular Cast Iron	120 - 320	Carbide	475 - 850	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Grey / White Iron	180 - 320	Carbide	600 - 1050	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
			CBN	1325 - 3275	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
N	Cast Aluminum	30 - 180	Carbide	850 - 2800	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
			PCD	1625 - 6550	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
	Wrought Aluminum	30 - 180	Carbide	675 - 1975	0.001 - 0.003	0.002 - 0.005	0.004 - 0.006	0.006 - 0.009
	Aluminum Bronze	100 - 250	Carbide	475 - 925	0.001 - 0.002	0.002 - 0.004	0.004 - 0.005	0.005 - 0.008
	Brass	100	Carbide	675 - 1975	0.001 - 0.002	0.002 - 0.004	0.003 - 0.005	0.005 - 0.008
Copper	60	Carbide	325 - 600	0.001 - 0.002	0.002 - 0.003	0.003 - 0.004	0.004 - 0.005	

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Recommended Cutting Data | Metric (mm)

ISO	Material	(BHN) Hardness	Grade	*Speed M / Min	Recommended Feed (mm / tooth) Nose Radi			
					0.1mm	0.2mm	0.4mm	0.8mm
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 250	Carbide	150 - 300	0.02 - 0.08	0.05 - 0.13	0.10 - 0.15	0.15 - 0.23
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 275	Carbide	145 - 280	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 325	Carbide	145 - 280	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
	Alloy Steel 4140, 5140, 8640, etc.	125 - 375	Carbide	120 - 215	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 400	Carbide	100 - 180	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
	Structural Steel A36, A285, A516, etc.	100 - 350	Carbide	145 - 280	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
	Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	150 - 250	Carbide	100 - 180	0.02 - 0.05	0.05 - 0.08	0.08 - 0.10	0.10 - 0.15
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	140 - 310	Carbide	30 - 70	0.02 - 0.05	0.05 - 0.08	0.08 - 0.13	0.10 - 0.15
	Titanium Alloy	140 - 310	Carbide	40 - 90	0.02 - 0.05	0.05 - 0.08	0.08 - 0.13	0.10 - 0.15
	Aerospace Alloy S82	185 - 350	Carbide	40 - 90	0.02 - 0.05	0.05 - 0.08	0.08 - 0.13	0.10 - 0.15
M	Stainless Steel 400 Series 416, 420, etc.	185 - 350	Carbide	90 - 160	0.02 - 0.05	0.05 - 0.10	0.08 - 0.10	0.10 - 0.15
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	Carbide	90 - 160	0.02 - 0.05	0.05 - 0.10	0.08 - 0.10	0.10 - 0.15
	Super Duplex Stainless Steel	135 - 275	Carbide	90 - 160	0.02 - 0.05	0.05 - 0.10	0.08 - 0.10	0.10 - 0.15

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Recommended Speed Example

If the recommended speed for a finish boring assembly under 5xD is 120 M/Min, then the speed for a 10xD finish boring assembly in the same application would be 60 M/Min (120 M/Min x 0.50 = 60 M/Min)

5xD = 120 M/Min

10xD = 60 M/Min

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H	Wear Plate Hardox, AR400, T-1, etc.	400 - 600	Carbide	30 - 60	0.02 - 0.05	0.05 - 0.08	0.08 - 0.10	0.10 - 0.15
			CBN	70 - 180	0.02 - 0.05	0.05 - 0.08	0.08 - 0.10	0.10 - 0.15
	Hardened Steel	300 - 500	Carbide	40 - 80	0.02 - 0.05	0.05 - 0.08	0.08 - 0.10	0.10 - 0.15
			CBN	70 - 180	0.02 - 0.05	0.05 - 0.08	0.08 - 0.10	0.10 - 0.15
K	SG / Nodular Cast Iron	120 - 320	Carbide	145 - 260	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
	Grey / White Iron	180 - 320	Carbide	180 - 320	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
			CBN	400 - 1000	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
N	Cast Aluminum	30 - 180	Carbide	260 - 850	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
			PCD	495 - 1995	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
	Wrought Aluminum	30 - 180	Carbide	205 - 600	0.02 - 0.05	0.05 - 0.13	0.10 - 0.15	0.15 - 0.23
	Aluminum Bronze	100 - 250	Carbide	145 - 280	0.02 - 0.05	0.05 - 0.10	0.10 - 0.13	0.13 - 0.20
	Brass	100	Carbide	205 - 600	0.02 - 0.05	0.05 - 0.10	0.08 - 0.13	0.13 - 0.20
Copper	60	Carbide	100 - 180	0.02 - 0.05	0.05 - 0.08	0.08 - 0.10	0.10 - 0.13	

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