

RNLU1205MON-M / RNLU1205MON-S													
Starting Recommendations						Grades					Coolant		
Materials				Hardness (HB)	Cutting Speed VC (SFM)	Feed Per Tooth FZ (in) RNLU-M	Feed Per Tooth FZ (in) RNLU-S	IN2604	IN2605	IN2630		IN2035	IN7035
ISO Class	Group	Type	Examples										
P	1 - 5	CARBON STLS	1018, A36, 1045, A572, 1070	85-175	590 - 985	.005 - .024	.005 - .010		1	2			No
	6 - 9	LOW - MED ALLOY STLS	4140, 4340, P20, 8620, 300M	85-175	590 - 985	.005 - .024	.005 - .010		1	2			No
	10 - 11	HIGH ALLOY & TOOL STLS	H13, A2, D2, M2, T1	175-225	425 - 920	.005 - .022	.005 - .010		1	2			No
M	12 - 13	STAINLESS STLS (ferritic & martensitic)	410, 416, 440,	-	330 - 690	.005 - .020	.005 - .010		4	3	1	2	Yes
	14	STAINLESS STLS (austenitic)	303, 304, 316, 15-5, 17-4	-	305 - 650	.005 - .020	.005 - .010		4	3	1	2	Yes
K	15 - 16	GRAY CAST IRON	CLS 20, 30, 45	140 - 220	490 - 1300	.005 - .020	.005 - .010		1				Yes
	17 - 18	NODULAR CAST IRON	60-40-18 100-70-03						1				Yes
S	31- 35	HIGH TEMP ALLOYS	Inconel, Hastelloy, Nimonic, Monel	-	65 - 195	.004 - .012	.004 .010		4	3	1	2	Yes
	36 - 37	TITANIUM ALLOYS	6Al-4V, 5Al-5Mo-5V-3Cr	-	95 - 260	.004 - .016	.004 .010		4	3	1	2	Yes
H	38- 39	HARDENED STL > 48	A2, O1, D2	495 - 630	165 - 360	.004 - .012	.004 .010	1					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.