GOLDOMAX4™ OPERATING GUIDELINES

Materials				Vc Cutting Speed SFM	fz* Feed/Tooth (inch)	Harder <-------> Tougher					Coolant
ISO	Mat'l Group #VDI 3323	Type	Examples			IN4015	IN4005	IN05S	IN4030	IN2530	
P	1 - 5	Non-alloy Steel	1018, A36, 1045, A572, 1070	450-700	.005-.014		1			2	No
	6 - 9	Low-alloy Steel	4140, 4340, P20, 8620, 300M	300-600	.004-.012		1			2	
	10 - 11	High-alloy Steel	H13, A2, D2, M2, T1	250-400	.004-.012				2	1	
M	12 - 13	Stainless Steel (Ferritic & Martensitic)	410, 416, 440	350-600	.004-.012				2	1	Yes
	14	Stainless Steel (Austenitic)	303, 304, 316, 15-5, 17-4	300-500	.004-.012				2	1	May not be required at high speeds
K	15 - 16	Gray Cast Iron	CLS. 20, 30, 45	600-850	.005-.015	1	2				No
	17 - 20	Nodular Cast Iron	60-40-18, 100-70-03	400-450	.005-.015	1	2				
N	21 - 30	Aluminum	7075, 6061	750+	.006-.016			1			Yes
S	31 - 35	High-Temp Alloys	Inconel, Hastelloy, Nimonic, Monel	60-125	.004-.008				2	1	Yes
	36 - 37	Titanium Alloys	6Al-4V, 5Al-5Mo-5V-3Cr	75-150	.004-.008				2	1	
H	38 - 39	Hardened Steel >48	A2, O1, D2	150-400	.002-.004		2			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.

GOLDOMAX4™ PRE-ENGINEERED TAILOR MADE SPECIALS

Max WOC Change	DGM315	DGM325	DGM426
Δ WOC	.125"	.200"	.200"