

### HIGH-TEMPERATURE ALLOYS • APPLICATION DATA

Maximum and minimum depth of cut and feed										
Geometry	fn (mm/rev)			ap (mm)		fn (in/rev)			ap (in)	
FS	0,04–0,25			0,10–2,5		.001–.009			.003–.098	
FP	0,08–0,35			0,15–5,0		.003–.013			.005–.197	
MS	0,05–0,55			0,20–11,0		.001–.021			.007–.433	
MP	0,12–0,07			0,60–9,0		.004–.002			.023–.354	
Recommended grade and speeds										
	FS	FP			MS				MP	
—				—			—			
KCS10B™ Vc 15–140 m/min Vc 50–450 SFM		○		KCS10B Vc 15–140 m/min Vc 50–450 SFM	○		KCS10B Vc 15–140 m/min Vc 50–450 SFM	•		
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Maximum and minimum depth of cut and feed										
Geometry	fn (mm/rev)			ap (mm)		fn (in/rev)			ap (in)	
LF	0,01–0,4			0,05–2,3		.000–.015			.001–.090	
FP	0,10–0,45			0,20–4,0		.003–.017			.007–.157	
Recommended grade and speeds										
				LF					MP	
—				—						
KCS10B Vc 15–140 m/min Vc 50–450 SFM				○		KCS10B Vc 15–140 m/min Vc 50–450 SFM			•	
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Iron-Based, Heat-Resistant Alloys (135–320 HB) (<34 HRC)		Speed – m/min (SFM)								Starting Conditions	
material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (850)	m/min	SFM
S1	KCS10B	◁ ▷								80	260

Cobalt-Based, Heat-Resistant Alloys (150–425 HB) (<45 HRC)		Speed – m/min (SFM)								Starting Conditions	
material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (850)	m/min	SFM
S2	KCS10B	◁ ▷								50	165

Nickel-Based, Heat-Resistant Alloys (140–475 HB) (<48 HRC)		Speed – m/min (SFM)								Starting Conditions	
material group	grade	15 (50)	45 (150)	75 (250)	105 (350)	140 (450)	170 (550)	200 (650)	230 (850)	m/min	SFM
S3	KCS10B	◁ ▷								70	230

