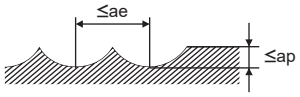
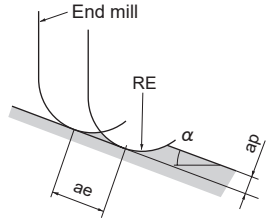
Recommended Cutting Conditions

(inch)

Workpiece Material		Nickel-based Heat Resistant Super Alloy Inconel718, Inconel713C, WASPALOY etc.					
RE		$\alpha \leq 15°$		$\alpha > 15°$		Depth of Cut ap	Depth of Cut ae
(mm)	(inch)	Revolution (SFM)	Feed Rate (IPM)	Revolution (SFM)	Feed Rate (IPM)		
0.5	**.020**	65	25.2	65	29.9	.004	.010
1.0	**.039**	65	12.6	65	15.0	.008	.020
1.5	**.059**	65	9.8	65	9.8	.012	.030
2.0	**.079**	65	7.5	65	8.7	.016	.039
2.5	**.098**	65	7.1	65	7.9	.020	.049
3.0	**.118**	65	6.7	65	8.3	.024	.059
4.0	**.157**	60	5.1	60	6.3	.031	.079
5.0	**.197**	60	5.1	60	5.5	.039	.098
6.0	**.236**	60	4.3	60	4.7	.047	.118
Depth of cut							

Note 1) For heat resistant super alloy, the use of water-soluble coolant is effective.
Note 2) If the depth of cut is shallow, the revolution and feed rate can be increased.
Note 3) Vibration may occur if the rigidity of machine or workpiece is low. In this case, please reduce the revolution and feed rate proportionately.
Note 4) α is the inclination angle of the machined surface.



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