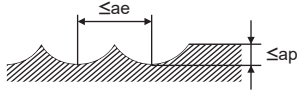


Recommended Cutting Conditions

(inch)

| Workpiece Material | | Nickel-based Heat Resistant Super Alloy | | | | | |
|--------------------|--------|---|--------------------|---------------------|--------------------|-----------------------|-----------------------|
| | | Inconel718, Inconel713C, Waspaloy etc. | | | | | |
| RE | | $\alpha \leq 15^\circ$ | | $\alpha > 15^\circ$ | | Depth of Cut a_p | Depth of Cut a_e |
| (mm) | (inch) | Revolution (SFM) | Feed Rate (IPM) | Revolution (SFM) | Feed Rate (IPM) | | |
| 1.0 | .039 | 65 | 15.0 | 65 | 20.1 | .008 | .020 |
| 1.5 | .059 | 65 | 13.4 | 65 | 16.5 | .012 | .030 |
| 2.0 | .079 | 65 | 12.6 | 65 | 15.0 | .016 | .039 |
| 2.5 | .098 | 65 | 9.8 | 65 | 12.2 | .020 | .049 |
| 3.0 | .118 | 65 | 8.3 | 65 | 9.8 | .024 | .059 |
| 4.0 | .157 | 60 | 6.3 | 60 | 7.5 | .031 | .079 |
| 5.0 | .197 | 60 | 5.9 | 60 | 7.9 | .039 | .098 |
| 6.0 | .236 | 60 | 5.9 | 60 | 6.7 | .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.

