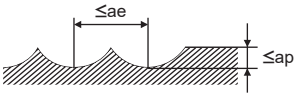
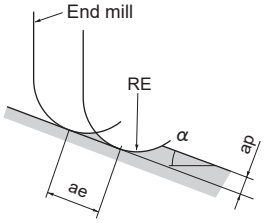
Recommended Cutting Conditions

(inch)

Workpiece Material	Nickel-based Heat Resistant Super Alloy Inconel718, Inconel713C, WASPALOY etc.							
RE		$\alpha \leq 15°$			$\alpha > 15°$			Depth of Cut ap
(mm)	(inch)	Revolution (SFM)	Feed Rate (IPM)	Depth of Cut ae	Revolution (SFM)	Feed Rate (IPM)	Depth of Cut ae	
1.0	**.039**	65	7.1	.016	65	12.2	.020	.008
1.5	**.059**	65	6.7	.024	65	13.4	.030	.012
2.0	**.079**	65	7.5	.031	65	12.6	.039	.016
2.5	**.098**	65	5.9	.039	65	9.8	.049	.020
3.0	**.118**	65	6.7	.047	65	9.8	.059	.024
4.0	**.157**	60	5.1	.063	60	7.5	.079	.031
5.0	**.197**	60	3.9	.079	60	7.9	.098	.039
6.0	**.236**	60	5.1	.094	60	6.7	.118	.047
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.



ae:Pick Feed