

Series SM7F

Cutting Parameters

Suggested Starting Speeds & Feed Rates

Material Group	ISO Code	Material Examples	High Feed	
			.1D Radial x 3D Axial	
			SFM	IPM
High Temp - Titanium Alloys	S	6Al4V, 5553, 99	400	60

Recommended Chip Loads

Material Group	ISO Code	Material Examples	Cutting Diameter						
			3/16	1/4	3/8	1/2	5/8	3/4	1
High Temp - Titanium Alloys	S	6Al4V, 5553, 99	0.0010	0.0014	0.0020	0.0028	0.0035	0.0042	0.0056