

Series *XPV & XPVB*

Cutting Parameters

Suggested Starting Speeds & Feed Rates

Material Group	ISO Code	Material Examples	Finishing Cuts		Medium Cuts		Heavy Cuts		Slotting		Facing		Ramping	
			.1D Radial x 2D Axial		.25D Radial x 1.5D Axial		.5D Radial x 1.5D Axial		.5D Axial		.75D Radial x .25D Axial		Max. Ramp Angle -7°	
			SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM	SFM	IPM
High Temp - Titanium Alloys	S	6Al4V, 5553, 99	300	20.00	300	18.00	300	14.00	300	10.00	300	18.00	300	14.00

Recommended Chip Loads

Material Group	ISO Code	Material Examples	Cutting Diameter							
			1/8	3/16	1/4	3/8	1/2	5/8	3/4	1
High Temp - Titanium Alloys	S	6Al4V, 5553, 99	0.0004	0.0005	0.0010	0.0015	0.0020	0.0025	0.0030	0.0040