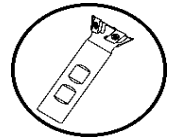


5th AXIS[®]



Dovetail Cutters: DC1750-45, DC1750-60, DC1750-M

Material	Type	Brinnell Hardness	Rockwell Hardness (HRC)	SFM	WOC .12"
Aluminum	6061, 7075	N/A	N/A	1000+	.005"-.010"
Graphite	All Types/ Densities	N/A	N/A	1000+	.002"-.004"
Cast Iron	Gray	100-400	N/A	700-900	.003"-.008"
Cast Iron	Nodular	100-400	N/A	500-700	.003"-.008"
Steel	Low Carbon 11018, A36	100-200	N/A	400-700	.003"-.008"
Steel	Alloyed Steel 4140, 4340, P20	250-400	25-44	350-500	.002"-.005"
Steel	Tool Steel 01, S7, A2, D2	250-400	25-44	350-500	.002"-.005"
Steel	Hardened Steels	400-630	48-58	200-350	.001"-.003"
Stainless Steel	203, 303, 416	200-300	12-32	450-700	.003"-.006"
Stainless Steel	304,316, 410, 113-8 PH	200-300	12-32	300-600	.003"-.006"
Stainless Steel	15-5 PH, 17-4 PH	300-400	32-42	350-500	.003"-.006"
Nickel Alloys	Inconel 718, Hastelloy, Waspalloy	N/A	N/A	75-120	.001"-.003"
Titanium	6Al-4V. 5Al-5Mo-5V-3Cr	275-350	28-38	120-180	.004"-.008"

Note: Speeds and feeds recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may be cause reductions in speeds and feeds or dramatic increases. DOC and WOC may need revisions to optimize tool performance.