

MELIN TOOL SPEED & FEED INFORMATION

SERIES: T4TVW BLUE NACO



4 Flute - Variable FL, High Performance Roughing Applications
Series: T4TVW BLUE NACO

MATERIAL	MATERIAL ROCKWELL	CONDITION	SFM	CUTTING DIAMETER										
				1/32"	1/16"	1/8"	3/16"	1/4"	3/8"	1/2"	5/8"	3/4"	1"	
STAINLESS STEELS		ISO-M	CHIP PER TOOTH											
Precipitation 13-8, 15-5, 17-4PH	Less than 32 Rc	Slotting @ $\leq .5$ to 1 x D	80-175	.0002	.0005	.0008	.0013	.0015	.0018	.0024	.0028	.0034	.0050	
	Over 32 Rc	Profiling @ 1-1/2 to 2 x D Axial / $\leq .2$ to .5 D Radial	80-115	.0008	.0015	.0024	.0031	.0033	.0045	.0055	.0068	.0081	.0102	
Austenitic 302, 303, 304L, 316L	Less than 32 Rc	Slotting @ $\leq .5$ to 1 x Dia.	150-250	.0002	.0005	.0008	.0013	.0015	.0018	.0024	.0028	.0034	.0050	
	Over 32 Rc	Profiling @ 1-1/2 to 2 x D Axial / $\leq .2$ to .5 D Radial	80-175	.0008	.0015	.0024	.0031	.0033	.0045	.0055	.0068	.0081	.0102	
Martensitic 403, 410, 416	Less than 32 Rc	Slotting @ $\leq .5$ to 1 x Dia.	200-350	.0002	.0005	.0008	.0013	.0015	.0018	.0024	.0028	.0034	.0050	
	Over 32 Rc	Profiling @ 1-1/2 to 2 x D Axial / $\leq .2$ to .5 D Radial	100-200	.0008	.0015	.0024	.0031	.0033	.0045	.0055	.0068	.0081	.0102	
HIGH TEMP ALLOYS		ISO-S												
Cobalt Base Stellite, Haynes 25, 188, X-40, L-605	Less than 32 Rc	Slotting @ $\leq .5$ to 1 x Dia.	175-165	.0003	.0005	.0007	.0009	.0011	.0015	.0018	.0022	.0028	.0035	
	Over 32 Rc	Profiling @ 1-1/2 to 2 x D Axial / $\leq .2$ to .5 D Radial	50-120	.0006	.0012	.0021	.0023	.0025	.0045	.0047	.0066	.0080	.0085	
Nickel Base - Inconel 600, 625, 718, Nickel 200, 270, Invar, Monel 400, 405, K-Monel, PermaNickel 300, Inconel 600	Less than 32 Rc	Slotting @ $\leq .5$ to 1 x Dia.	75-165	.0003	.0005	.0007	.0009	.0011	.0015	.0018	.0022	.0028	.0035	
	Over 32 Rc	Profiling @ 1-1/2 to 2 x D Axial / $\leq .2$ to .5 D Radial	50-120	.0006	.0012	.0021	.0023	.0025	.0045	.0047	.0066	.0080	.0085	
TITANIUM		ISO-S												
Titanium Alloys 6AL-4V, ASTM 1, 2, 3, 6AL-2S	Less than 32 Rc	Slotting @ $\leq .5$ to 1 x Dia.	175-225	.0003	.0006	.0010	.0013	.0013	.0018	.0022	.0030	.0035	.0050	
	Over 32 Rc	Profiling @ 1-1/2 to 2 x D Axial / $\leq .2$ to .5 D Radial	100-165	.0010	.0016	.0025	.0031	.0038	.0045	.0063	.0072	.0086	.0105	