

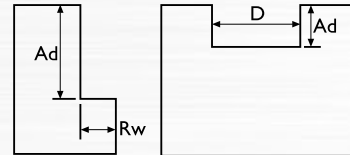
## Z-Carb-HTA™ Speed and Feed Recommendations

High Temp. Alloys	Cutting Diameter																		
	Bhn	1/4		5/16		3/8		7/16		1/2		9/16		5/8		3/4		1	
		rpm	in/min	rpm	in/min	rpm	in/min	rpm	in/min	rpm	in/min	rpm	in/min	rpm	in/min	rpm	in/min	rpm	in/min
Profile - Semi-Rough	<300	1,990	9.6	1,600	9.7	1,325	9.8	1,135	9.9	995	9.9	885	9.9	795	9.9	660	9.7	500	9.7
Profile - Rough	<300	1,680	6.4	1,345	6.5	1,120	6.6	960	6.7	840	6.7	750	6.7	670	6.7	560	6.5	420	6.5
Slotting	<300	1,380	3.9	1,100	4.0	920	4.1	785	4.2	690	4.2	610	4.2	550	4.2	460	4.0	345	4.0
Profile - Semi-Rough	>300	1,840	7.1	1,470	7.2	1,220	7.3	1,050	7.4	920	7.4	815	7.4	735	7.4	610	7.2	460	7.2
Profile - Rough	>300	1,530	4.0	1,225	4.1	1,020	4.2	875	4.3	765	4.3	680	4.3	610	4.3	510	4.1	380	4.1
Slotting	>300	1,220	2.2	980	2.3	815	2.4	700	2.5	610	2.5	545	2.5	490	2.5	410	2.3	305	2.3

Profile - Semi-Rough Radial Width .125 x Diameter (max.)  
Axial Depth 1.5 x Diameter (max.)

Profile - Rough Radial Width .250 x Diameter (max.)  
Axial Depth 1.5 x Diameter (max.)

Slotting Axial Depth 1 x Diameter (max.)



Radial Width of Cut (Rw)  
Axial Depth of Cut (Ad)  
Tool Diameter (D)

### Application Tips

- Tool holders with adequate gripping pressure are required
- Stub length solid holders are recommended for heavy stock removal
- Avoid remilling chips
- Avoid straight plunging - ramp or spiral plunge into pockets
- Regrind and recondition services are available from SGS
- Set-up rigidity critical during heavy roughing

## Z-Carb-HTA™ Speed and Feed Recommendations

High Temp. Alloys	Cutting Diameter														
	Bhn	6		8		10		12		14		16		20	
		rpm	mm/min	rpm	mm/min	rpm	mm/min	rpm	mm/min	rpm	mm/min	rpm	mm/min	rpm	mm/min
Profile - Semi-Rough	<300	2,100	244	1,575	246	1,260	248	1,050	252	900	252	790	252	630	246
Profile - Rough	<300	1,780	163	1,335	165	1,070	168	890	170	760	170	670	170	535	165
Slotting	<300	1,455	100	1,090	102	875	104	730	108	625	108	545	108	440	102
Profile - Semi-Rough	>300	1,940	180	1,455	182	1,165	185	970	188	830	188	730	188	585	182
Profile - Rough	>300	1,620	102	1,215	104	970	106	810	110	695	110	610	110	485	104
Slotting	>300	1,295	55	970	58	775	60	650	64	555	64	485	64	390	58

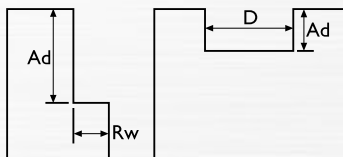
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Axial Depth 1.5 x Diameter (max.)

Profile - Rough Radial Width .250 x Diameter (max.)

Axial Depth 1.5 x Diameter (max.)

Slotting Axial Depth 1 x Diameter (max.)



Radial Width of Cut (Rw)

Axial Depth of Cut (Ad)

Tool Diameter (D)

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