



HVSS-6																	
Material Guide		HARDNESS	SFM	1/8		3/16		1/4		3/8		1/2		3/4		1	
				HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin	HEM	Fin		
				AUSTENITIC STAINLESS STEEL	Nitronic 50, Nitronic 60, 301, 303, 304, 304L, Incoloy 27-7MO, 316, 316L, 321, 347	75 - 98 HRB	250	.0021	.0013	.0031	.0015	.0040	.0017	.0059	.0019	.0078	.0023
	21 - 36 HRC	225	.0019		.0013	.0026	.0014	.0036	.0016	.0055	.0018	.0071	.0021	.0102	.0026	.0131	.0031
	36 - 50 HRC	180	.0014		.0011	.0021	.0012	.0029	.0014	.0043	.0016	.0057	.0019	.0081	.0023	.0105	.0028
MARTENSITIC & FERRITIC STAINLESS STEEL	403, 410, 416, 420, 440, 430, 446	75 - 98 HRB	325	.0021	.0013	.0031	.0015	.0043	.0017	.0062	.0020	.0081	.0023	.0116	.0027	.0150	.0033
		21 - 36 HRC	310	.0019	.0013	.0026	.0014	.0036	.0016	.0055	.0018	.0071	.0021	.0102	.0025	.0131	.0031
PH STAINLESS STEEL	15-5, 17-4, Carpenter 450, Carpenter 465	21 - 36 HRC	225	.0017	.0011	.0024	.0013	.0031	.0015	.0045	.0017	.0059	.0020	.0086	.0023	.0109	.0028
		36 - 50 HRC	130	.0014	.0011	.0019	.0012	.0026	.0014	.0040	.0016	.0052	.0018	.0074	.0022	.0095	.0027

MILLING PROCESS	ADOC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 10% Diameter
Fin (Finishing)	Up to Max LOC	4%-6% Diameter