

HVTIC-C-6

SPEEDS & FEEDS

6 Flute - Corner Radius - Chipbreaker Rougher -
Variable Pitch - For High Efficiency Milling

HVTI-C-6 / HVTIC-C-6

Material Guide		Hardness	SFM	Inches Per Tooth (IPT)				
				1/4	3/8	1/2	3/4	1
				HEM	HEM	HEM	HEM	HEM
PURE NICKEL	Nickel 200, Nickel 201	< 75 HRB	285	.0038	.0058	.0079	.0118	.0159
		75 - 98 HRB	250	.0032	.0049	.0066	.0099	.0134
NICKEL ALLOY	Hastelloy C-22, Inconel 625, Waspaloy, René 41, Inconel 718, Incoloy 20	75 - 98 HRB	80	.0019	.0029	.0041	.0060	.0081
		21 - 36 HRC	75	.0019	.0028	.0039	.0058	.0077
		36 - 50 HRC	70	.0016	.0024	.0034	.0049	.0066
PURE TITANIUM	Ti Grade 1, Ti Grade 2, Ti Grade 3, Ti Grade 4, Ti Grade 7, Ti Grade 12	< 75 HRB	300	.0052	.0079	.0110	.0164	.0220
		75 - 98 HRB	275	.0044	.0066	.0091	.0137	.0183
		21 - 36 HRC	250	.0033	.0050	.0069	.0102	.0137
TITANIUM ALLOY	Ti 3Al-2.5V, Ti 6Al-4V, Ti 10V-2Fe-3Al	21 - 36 HRC	180	.0027	.0041	.0054	.0081	.0108
		36 - 50 HRC	160	.0024	.0036	.0049	.0074	.0099
COBALT ALLOY	ASTM F562, ASTM F90, ASTM F75, ASTM F799	75 - 98 HRB	210	.0022	.0034	.0046	.0069	.0092
		21 - 36 HRC	170	.0021	.0032	.0044	.0067	.0088
		36 - 50 HRC	65	.0014	.0023	.0030	.0046	.0060

Milling Process	ADOC	RDOC
HEM (High Efficiency Milling)	Up to Max LOC	Up to 10% Diameter

NOTES:

IPT values shown are for 2.5xD length of cut tools, and should be adjusted for longer or shorter lengths of cut. For more accurate running parameters, please refer to Machining Advisor Pro.