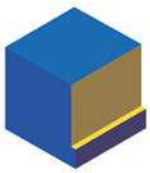
Speed & Feed Recommendations

ZH1MCR, ZH1MCRS Metric	HARDNESS	CUT	SPEED	FEED (mm/flute)				
	BRINELL	Type	m/min	6	10	12	20	25
HIGH TEMPERATURE ALLOY A-286, Hastelloy, Haynes, Incoloy, Inconel, Rene, Udimet, Waspalloy	≤ 300	Slot	21	0.017	0.032	0.041	0.053	0.058
		Profile	27	0.017	0.032	0.041	0.053	0.058
		Light	45	0.036	0.075	0.091	0.120	0.133
	> 300	Slot	16	0.012	0.024	0.029	0.037	0.040
		Profile	21	0.012	0.024	0.029	0.037	0.040
		Light	34	0.026	0.053	0.062	0.085	0.093

CUT TYPE		
SLOT	PROFILE	LIGHT*
$a_p = D_1$ $a_e = D_1$	$a_p = 1.5 \times D_1$ $a_e = 0.5 \times D_1$	$a_p = 1.5 \times D_1$ $a_e = 0.05 \times D_1$
		

rpm = (1000 x m/min) / (3.14 x D_1)
mm/min = (mm/flute) x rpm

- maximum recommended depths shown
- reduce speed and feed for materials harder than listed
- * finish cuts typically require reduced feed and cutting depths of 0.02 x D_1 maximum
- refer to the SGS Tool Wizard for more complete technical information (available at)
- Max. ramp angle = 6° / Max. ramp depth = 1xD (reduce feed accordingly)