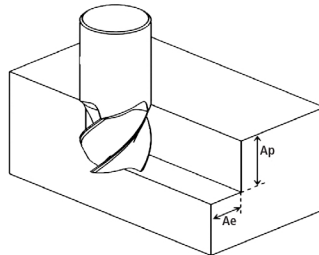
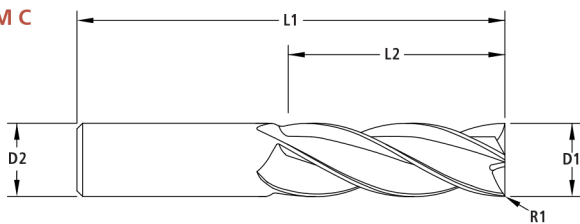


# Feeds and Speed Chart for HiTex Finisher

	Material	Iron Based	Iron-Nickel Based	Nickel-Iron Based	Cobalt Based
	Description	A286, Discaloy, Incoloy 801, ASTM A297	Hastelloy X, N-155, Inconel 718	Inconel 600/625, Rene Alloys, Waspaloy, Monel, Invar	Stellite, Haynes 188, Haynes 230, AiResist 13
Diameter	SFM Rc < 32 SFM Rc > 32	70-120 40-90	70-120 40-90	60-110 40-90	60-110 40-90
1/4"	P LP F	0.0009 0.0011 0.0019	0.0009 0.0011 0.0019	0.0007 0.0009 0.0015	0.0007 0.0009 0.0015
5/16"	P LP F	0.0012 0.0016 0.0025	0.0012 0.0016 0.0025	0.0010 0.0012 0.0020	0.0010 0.0012 0.0020
3/8"	P LP F	0.0016 0.0020 0.0033	0.0016 0.0020 0.0033	0.0013 0.0017 0.0027	0.0013 0.0017 0.0027
7/16"	P LP F	0.0017 0.0022 0.0036	0.0017 0.0022 0.0036	0.0014 0.0018 0.0029	0.0014 0.0018 0.0029
1/2"	P LP F	0.0018 0.0024 0.0039	0.0018 0.0024 0.0039	0.0014 0.0019 0.0030	0.0014 0.0019 0.0030
5/8"	P LP F	0.0021 0.0026 0.0043	0.0021 0.0026 0.0043	0.0016 0.0020 0.0033	0.0016 0.0020 0.0033
3/4"	P LP F	0.0028 0.0037 0.0060	0.0028 0.0037 0.0060	0.0023 0.0029 0.0048	0.0023 0.0029 0.0048
1"	P LP F	0.0034 0.0044 0.0071	0.0034 0.0044 0.0071	0.0026 0.0034 0.0055	0.0026 0.0034 0.0055

## FORM C



- LP = LIGHT PERIPHERAL**
- Ae 5% to 25% x D
- Ap 2 x D
- F = FINISHING**
- Ae < 5% x D
- Ap > 2 x D