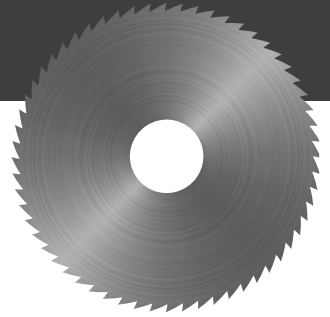


2450 FERROUS SAW



2450 Ferrous Saw

The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.

FULLERTON®
SPEEDS / FEEDS

Material	Speed SFM	SMPM
Low Si Aluminum < 10%	1500	457
High Si Aluminum > 10%	1000	304.8
Composites	400	121.92
Plastics	1000	304.8
Brass & Copper	750	228.6
Graphite	500	152.4
Cast Iron - Soft	450	137.16
Cast Iron - Medium	275	83.32
Cast Iron - Hard	175	53.34
Hardened Steels	100	30.48
Steels - Low Carbon	175	53.34
Steels - Medium Carbon	125	38.1
Stainless Steels - Free Machining	200	60.96
Stainless Steels - Work Hardening	125	38.1
Super Alloys	80	24.384
Titanium - Soft	200	60.96
Titanium - Hard	175	53.34
Feed Rate - Chip Load Per Tooth .001"/ 0.0254mm		