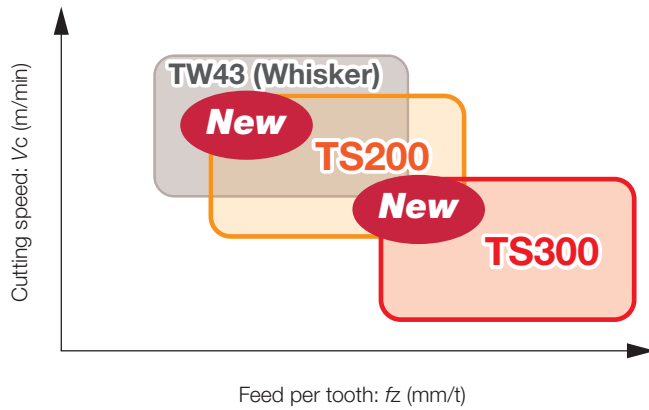


APPLICATION RANGE (high temperature alloys)



TS200: High speed finishing
TS300: Scaling and roughing

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grades	Cutting speed V_c (m/min)	Feed per tooth f_z (mm/t)	Depth of cut a_p (mm)
S	Ni-based super alloys	TS200	550 - 1300	0.05 - 0.2	0.1 - 2
		TS300	270 - 550	0.05 - 0.2	0.1 - 2
	Co-based super alloys	TS200	550 - 1500	0.05 - 0.2	0.1 - 2
		TS300	270 - 550	0.05 - 0.2	0.1 - 2