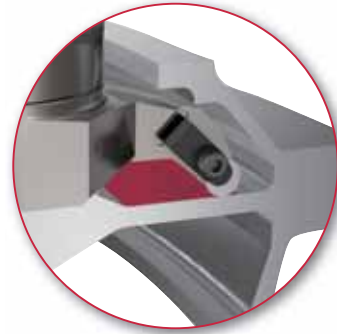
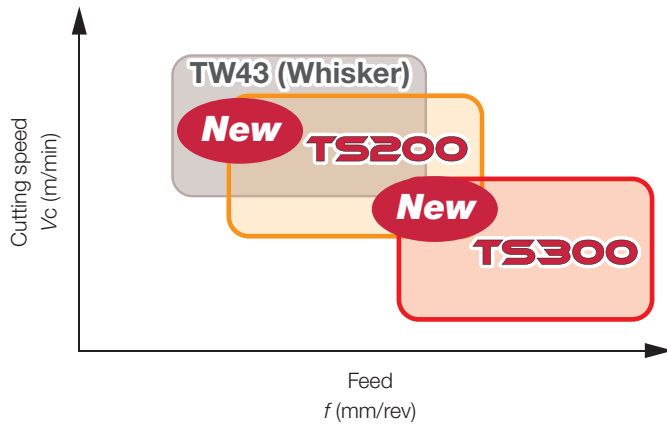


APPLICATION RANGE (high temperature alloys)



TS200: High speed finishing
TS300: Scaling and roughing

STANDARD CUTTING CONDITIONS

| ISO | Workpiece materials | Grades | Cutting speed V_c (m/min) | Feed f (mm/rev) | Depth of cut a_p (mm) |
|----------|-----------------------|--------|-----------------------------|-------------------|-------------------------|
| S | Ni-based super alloys | TS200 | 200 - 350 | 0.1 - 0.4 | 0.1 - 2 |
| | | TS300 | 150 - 250 | 0.1 - 0.2 | 0.1 - 2 |
| | Co-based super alloys | TS200 | 200 - 350 | 0.1 - 0.4 | 0.1 - 2 |
| | | TS300 | 150 - 250 | 0.1 - 0.2 | 0.1 - 2 |