

600 Nano Technical Data

	Common Work Piece	Common Condition		Lower Temp. Slower Cool Machining, Lower Feed & Speed.	Higher Temp, High RPM, Rotor Dry Machining, Higher Feed and Speed.
		Continuous Cutting, Drilling, Turning, etc	Interrupted Cutting Drilling, Turning, Sawing, etc		
1	Carbon Steels 1000 Series	a,b,c,e	a,b,e	a,b,e	c
2	Alloy Steels 4,5,8,9000 Series	a,b,c,e	a,b,e	a,b,e	c
3	Free Machine Steels 1100,1200	a,b,e	a,b,e	a,b,e	a,b,e
4	Tool Steels Hss Etc	a,b,c,e	a,b,e	a,b,e	a,b,e
5	Stainless Steels 200,300	b,c	b,c	b,c	c
6	Stainless 400,500PH	b,c	b,c	b,c	c
7	Maleable/Gray Cast Iron	b,c	b,c	b,c	c
8	Alloy/Nodular Cast Iron	b,c	b,c	b,c	c
9	Aluminum<10% Silica	c,e,f	c,e,f	b,c,e,f	c,f
10	Aluminum>10% Silica	b,c,e,f	b,c,e,f	b,c,e,f	b,c,f
11	Brass, Bronze, Nickel, Copper	a,b,d,e,f	a,b,d,e	a,b,d,e	n/a
12	Non Ferrous Alloys (Monels Etc)	c	c	c	c
13	Titanium	c,e	c,e	c,e	c
14	Tough Ni-Co-Fe Super Alloys	c	c	c	c
15	Plastics/Composites	a,b,d,e	b,d,e,f	a,b,d,e	b,c
16	Wood/Paper	a,b,d,e	b,f	a,b,e	b

a:TiIn b:TiCh c:TiAlIn d:CrIn e:ZrIn f:Diamond