ALLIED MACHINE & ENGINEERING | VolCut Recommended Cutting Data

WOHLHAUPTER® | Boring | Metric (mm)

ISO	Material	Hardness (BHN)	Speed (M/min) AM300®	AM200®	TiN	Feed Rate (mm/rev)
P	**Free Machining Steel** 1118, 1215, 12L14, etc.	100 - 250	230 - 300	210 - 290	170 - 230	0.09 - 0.18
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 275	210 - 300	200 - 270	150 - 210	0.08 - 0.17
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	125 - 325	200 - 260	180 - 230	150 - 210	0.09 - 0.17
	Alloy Steel 4140, 5140, 8640, etc.	125 - 375	180 - 250	170 - 210	150 - 210	0.09 - 0.17
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 400	150 - 210	140 - 180	110 - 150	0.08 - 0.13
	Structural Steel A36, A285, A516, etc.	100 - 350	210 - 260	200 - 230	150 - 210	0.08 - 0.17
	Tool Steel H-13, H-21, A-4, 0-2, S-3, etc.	150 - 250	110 - 200	90 - 170	60 - 150	0.06 - 0.13
S	**High Temp Alloy** Hastelloy B, Inconel 600, etc.	140 - 310	-	-	-	
M	**Stainless Steel 400 Series** 416, 420, etc.	185 - 350	-	-	-	
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	135 - 275	-	-	-	
	Super Duplex Stainless Steel	135 - 275	-	-	-	
K	**Nodular, Grey, Ductile Cast Iron**	120 - 320	200 - 240	180 - 230	140 - 200	0.10 - 0.20
N	**Cast Aluminum**	30 - 180	350 - 460	330 - 430	260 - 300	0.15 - 0.30
	Wrought Aluminum	30 - 180	350 - 460	330 - 430	260 - 300	0.15 - 0.30
	Brass	30 - 100	260 - 370	240 - 350	200 - 300	0.13 - 0.23

NOTE: For speeds/feeds not listed, contact our Application Engineering department for assistance. *ext:* **7611** | *email:* **appeng@alliedmachine.com**

IMPORTANT: Max spindle speed refers to maximum possible speed for individual boring head and is not a recommended parameter. Factory technical assistance is available for your specific applications through our Application Engineering department. *ext:* **7611** | *email:* **appeng@alliedmachine.com**

⚠ WARNING **Tool failure can cause serious injury. To prevent:**
-Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)
-Refer to example on page B10-N: 8 in the Wohlhaupter Master Product Catalog (B10-WHL) for calculating length to diameter ratio
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