

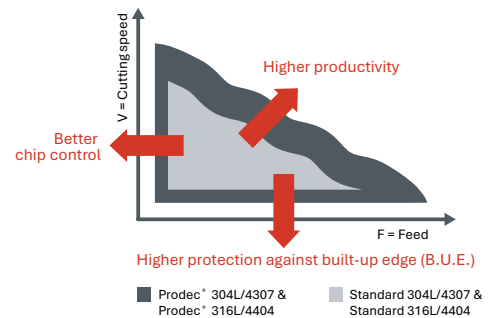


Prodec[®] 304L/4307 and Prodec[®] 316L/4404 are enhanced variants of standard Types 304 (UNS S30400) / 304L (UNS S30403) and 316 (UNS S31600) / 316L (UNS S31603) respectively with enhanced metallurgy for better machinability. The general rules for machining stainless steel also apply to the Prodec[®] grades.

The difference is that Prodec[®] grades enable a longer tool life and/or tougher machining conditions.

The machining window illustrated demonstrates this >>

Other fabrication operations such as welding, hot working and cold working can be performed in the same way as for standard 304L/4307 and 316L/4404.



Product forms

Prodec[®] 304L/4307 and Prodec[®] 316L/4404 are available as round bar (10 - 180mm), and cold drawn (7.95 - 100mm) round, hexagon and square bars.

Machining guidelines

The cutting parameters in this guideline will work under normal cutting conditions.

It is suggested to begin with cutting parameters in the ranges indicated in the tables and then to improve parameters by moving to higher or lower speed, feed or depth of cut until best performance is reached.

It is possible to end up in a range somewhat outside the values indicated in the tables depending on the actual machine set-up.

A guide for further optimization of cutting parameters can be found under the "Troubleshooting" section overleaf.

Turning

- The machine and setup must be rigid
- Use shortest possible tool length
- Use coolant
- Use smallest possible nose radius to avoid vibrations

Milling

- Avoid cutting through holes/cavities
- Ensure good chip evacuation, recutting of chips may cause tool damage

Turning	Carbide Tooling				HSS Tooling		
	Depth of cut or width (mm)	Speed (m/min)	Feed (mm/rev)	Tool Grade	Speed (m/min)	Feed (mm/rev)	Tool Grade
Finishing	-2	260 - 280	0.10	M10 - 15	50 ¹⁾	0.10	T15
Medium	2 - 5	200 - 260	0.25	M10 - 25	35	0.25	T15
Roughing	5 - 10	50 - 220	0.40	M25 - 35	20	0.40	T15

¹⁾ Coated tools

Milling	Carbide Tooling			HSS Tooling		
	Speed (m/min)	Feed (mm/rev)	Tool Grade	Speed (m/min)	Feed (mm/rev)	Tool Grade
Face milling	150 - 250	0.08 - 0.30	M10 - 30	24 - 40	0.08 - 0.20	T15
Side milling	180 - 240	0.08 - 0.30	M10 - 30	24 - 40	0.08 - 0.20	T15
End milling	150 - 220	0.05 - 0.20	M10 - 30	24 - 40	0.025 - 0.15	T15
End milling ²⁾	50 - 100	0.05 - 0.20	M35	—	—	—

²⁾ Solid cemented carbide

Drilling - high speed steel twist drills

- Use coolant
- If possible use internal coolant through drill
- Use of cobalt high alloyed drills is preferred
- With PVD-coated HSS drills the cutting speed can be increased by 10%
- Use as short a drill as possible

Other machining operations

Cut-off

- Reduce feed by 50% approximately 6mm from the center

Reaming

- Type of coolant: emulsion or cutting oil

Tapping

- For blind holes use spiral flute grinding for good chip evacuation
- For through holes use spiral point grinding with gun nose to push the chips forward

Threading single insert

- Full profile insert for high quality thread forms
- V-profile insert - threading with minimum tool inventory
- Multipoint insert for economic threading in mass production

Drilling indexable insert

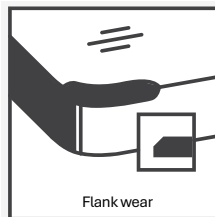
- Cutting data is very dependent on the drill design. Hence, the manufacturers recommendations must be considered.

Drilling ³⁾	HSS Tooling			
	Diameter (mm)	Speed (m/min)	Feed (mm/rev)	Rpm (rev/min)
	1	10 - 12	0.05	3200 - 3800
	3	15 - 17	0.10	1600 - 1800
	5	17 - 20	0.12	1080 - 1270
	10	17 - 20	0.15	540 - 640
	15	17 - 20	0.20	360 - 430
	20	17 - 20	0.30	270 - 320
	30	17 - 20	0.30	180 - 220

³⁾ HSS-5%Co

Other machining operations	Carbide Tooling			HSS Tooling		
	Speed (m/min)	Feed (mm/rev)	Tool Grade	Speed (m/min)	Feed (mm/rev)	Tool Grade
Cut-off	100 - 150	0.05 - 0.15	M30	24	0.05	T15
Reaming	50	0.10 - 0.40	M10 - M30	10 - 15	0.10 - 0.40	T15
Tapping	–	–	–	5 - 13	–	–
Threading single insert	90 - 130	–	M10 - M30	15 - 20	–	T15
Drilling indexable insert	200 - 250	0.06 - 0.12	Center M30 Periferi M10	–	–	–

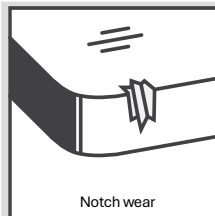
Troubleshooting



Flank wear

Flank wear

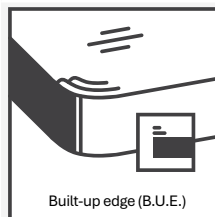
For longer tool life - reduce cutting speed or use a harder insert.



Notch wear

Notch wear

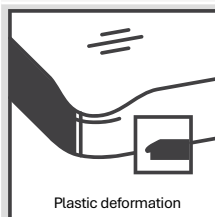
Notch wear is a common wear mechanism when machining stainless steel. Increased cutting speed will reduce notch but increase flank wear. If possible, use an insert with smaller entering angle 60-80 degrees or variable cutting depth or softer insert grade.



Built-up edge (B.U.E.)

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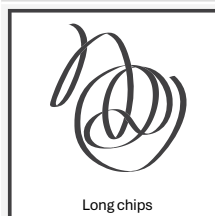
Built-up edge occurs when the cutting speed is too low and the stainless steel tends to stick to the tool (in milling the chips stick to the tool). To avoid - increase cutting speed or use another coating.



Plastic deformation

Plastic deformation

To avoid - reduce either cutting speed, feed or use a harder insert.



Long chips

Long chips

To avoid - increase feed or use an insert with smaller chip breaker.



www.offshorestainless.com

+44 (0)1922 414 003

sales@offshorestainless.co.uk