Recommended Cutting Conditions (Coated Carbide)

Workpiece Material	Insert Grades	Cutting Speed Vc (sfm)	Chipbreaker	fz (ipt) 0.0024 0.0039 0.0079 0.0118 0.0157
Cast Iron	CA420M	560 ~ **750** ~ 980	GM★	0.0098
	PR1510	390 ~ **590** ~ 820	GH☆	0.0118
	PR1525		GL	0.0047
Nodular Cast Iron	CA420M	490 ~ **660** ~ 820	GM★	0.0079
	PR1510	330 ~ **490** ~ 660	GH☆	0.0098
	PR1525		GL	0.0039

★: 1st Recommendation ☆: 2nd Recommendation

Recommended Cutting Conditions (Ceramic)

• Without Chipbreaker

Workpiece Material	Insert Grades	Cutting Speed Vc (sfm)	Edge Prep.	fz (ipt) 0.0020 0.0039 0.0079 0.0118 0.0157
Cast Iron	KS6050★	1970 ~ **2950** ~ 3940	0.004 × 20°	0.0039
	CS7050☆			
Nodular Cast Iron	KS6050☆	1310 ~ **1970** ~ 2950		
	CS7050★			

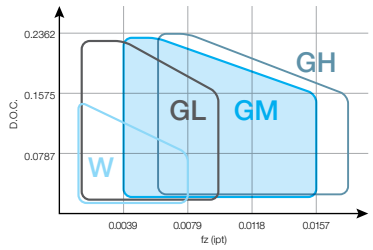
• With Chipbreaker

Workpiece Material	Insert Grades	Cutting Speed Vc (sfm)	Edge Prep.	fz (ipt) 0.0020 0.0039 0.0079 0.0118 0.0157
Cast Iron	KS6050★	1970 ~ **2950** ~ 3940	0.002 × 15°	0.0039
	CS7050☆			
Nodular Cast Iron	KS6050☆	1310 ~ **1970** ~ 2950		
	CS7050★			

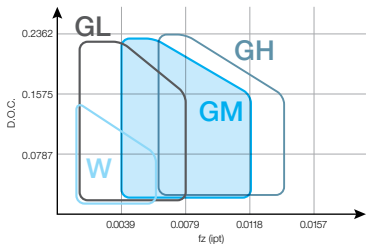
★: 1st Recommendation ☆: 2nd Recommendation

Recommended Application Range

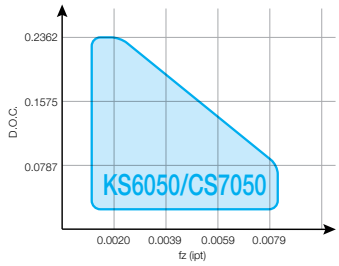
Gray Cast Iron
(Insert Grades : Coated Carbide)



Nodular Cast Iron
(Insert Grades : Coated Carbide)



Gray Cast Iron / Nodular Cast Iron
(Insert Grades : Ceramic)



* Note, when using wiper insert

1. When using W type, please use together with GM or GH.
2. If machining over fz = 0.0079", insert corner will be damaged.
   The main cutting edge of W type insert is receding from that of GM and GH.
   Therefore, the feed rate for the insert next to W type is double of the other inserts.