для заказа - kyocera@kyocera-tools.ru

Recommended Cutting Conditions - Back Turning

KTKF ➡ E12

Workpiece Material		MEGACOAT NANO				MEGACOAT		Remarks
		PR1535		PR1425		PR1225		
		Grooving	Turning	Grooving	Turning	Grooving	Turning	
Carbon steel / Alloy Steel (1045, etc.)	Vc (sfm)	☆ 200 ~ 500		★ 250 ~ 650		☆ 200 ~ 500		Wet
	Feed (ipr)	0.0004 ~ 0.0012	0.0008 ~ 0.0059	0.0004 ~ 0.0012	0.0008 ~ 0.0059	0.0004 ~ 0.0012	0.0008 ~ 0.0059	
Stainless Steel (304 etc.)	Vc (sfm)	★ 200 ~ 425		☆ 200 ~ 500		☆ 200 ~ 425		
	Feed (ipr)	0.0004 ~ 0.0008	0.0008 ~ 0.0039	0.0004 ~ 0.0008	0.0008 ~ 0.0039	0.0004 ~ 0.0008	0.0008 ~ 0.0039	

Workpiece Material		PVD Coated Carbide		Carbide		PCD		Remarks
		PR1025		KW10		KPD001		
		Grooving	Turning	Grooving	Turning	Grooving	Turning	
Carbon steel / Alloy Steel (1045, etc.)	Vc (sfm)	☆ 200 ~ 500		-		-		Wet
	Feed (ipr)	0.0004 ~ 0.0012	0.0008 ~ 0.0059	-		-		
Stainless Steel (304 etc.)	Vc (sfm)	☆ 175 ~ 400		-		-		
	Feed (ipr)	0.0004 ~ 0.0008	0.0008 ~ 0.0039	-		-		
Cast Iron (Gray, Nodular etc.)	Vc (sfm)	-		175 ~ 325		-		
	Feed (ipr)	-		0.0004 ~ 0.0012	0.0008 ~ 0.00395	-		
Aluminum	Vc (sfm)	-		650 ~ 1475		200 ~ 500		
	Feed (ipr)	-		0.0004 ~ 0.0012	0.0008 ~ 0.00395	0.0004 ~ 0.0012	0.0008 ~ 0.00395	
Brass	Vc (sfm)	-		325 ~ 650		200 ~ 425		
	Feed (ipr)	-		0.0004 ~ 0.0008	0.0008 ~ 0.0039	0.0004 ~ 0.0008	0.0008 ~ 0.0039	

★ : 1st Recommendation
☆ : 2nd Recommendation

KTKF (GQ Chipbreaker) ➡ E12

Workpiece Material		MEGACOAT NANO				MEGACOAT		Remarks
		PR1535		PR1425		PR1225		
		Grooving	Turning	Grooving	Turning	Grooving	Turning	
Carbon steel / Alloy Steel (1045, etc.)	Vc (sfm)	☆ 200 ~ 500		★ 250 ~ 650		☆ 200 ~ 500		Wet
	Feed (ipr)	0.0004 ~ 0.0015	0.0008 ~ 0.0059	0.0004 ~ 0.0015	0.0008 ~ 0.0059	0.0004 ~ 0.0015	0.0008 ~ 0.0059	
Stainless Steel (304 etc.)	Vc (sfm)	★ 200 ~ 425		☆ 200 ~ 500		☆ 200 ~ 425		
	Feed (ipr)	0.0004 ~ 0.0012	0.0008 ~ 0.0039	0.0004 ~ 0.0012	0.0008 ~ 0.0039	0.0004 ~ 0.0012	0.0008 ~ 0.0039	

★ : 1st Recommendation
☆ : 2nd Recommendation

ABS15, ABW15, ABW23 ➡ E17~E19

Workpiece Material		MEGACOAT NANO		MEGACOAT		PVD Coated Carbide		Remarks
		PR1425		PR1225		PR1025 (PR930)		
		Grooving	Turning	Grooving	Turning	Grooving	Turning	
Carbon steel / Alloy Steel (1045, etc.)	Vc (sfm)	★ 250 ~ 600		☆ 200 ~ 500		☆ 250 ~ 325		Wet
	Feed (ipr)	0.0008	0.0008 ~ 0.0028	0.0008	0.0008 ~ 0.0028	0.0008	0.0008 ~ 0.0028	
Stainless Steel (304 etc.)	Vc (sfm)	☆ 125 ~ 425		★ 125 ~ 400		☆ 100 ~ 175		
	Feed (ipr)	0.0008	0.0008 ~ 0.0020	0.0008	0.0008 ~ 0.0020	0.0008	0.0008 ~ 0.0020	

★ : 1st Recommendation
☆ : 2nd Recommendation

Workpiece Material		Carbide		Remarks
		KW10		
		Grooving	Turning	
Aluminum	Vc (sfm)	500 ~ 650		Wet
	Feed (ipr)	0.0008	0.0008 ~ 0.0039	
Brass	Vc (sfm)	325 ~ 525		
	Feed (ipr)	0.0012	0.0008 ~ 0.0059	

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