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Recommended Cutting Conditions

H Chipbreaker (EZB-HP...H Type / EZB-ST...H Type)

Workpiece Material	Insert Grade (Vc : sfm)		EZB020/025		EZB030/035		EZB040/045		EZB050/055/060/065/075		Notes
	MEGACOAT	Carbide	Depth of Cut: D.O.C. (inch), Feed: f (ipr)								
	PR1225	**GW05**	D.O.C.	f	D.O.C.	f	D.O.C.	f	D.O.C.	f	
Carbon Steel / Alloy Steel	100~330	-	~0.0118	~0.0012	~0.0157	~0.0016	~0.0177	~0.0028	~0.0197	~0.0039	Wet
Stainless Steel	100~260	-	~0.0079	~0.0008	~0.0118	~0.0012	~0.0138	~0.0020	~0.0157	~0.0028	
Non-ferrous Material	-	~330	~0.0118	~0.0020	~0.0157	~0.0024	~0.0177	~0.0039	~0.0197	~0.0059	

F Chipbreaker (EZB-HP...F Type / EZB-ST...F Type)

Workpiece Material	Insert Grade (Vc : sfm)	EZB020/025		EZB030/035		EZB040/045		EZB050/055/060/065/075		Notes
	MEGACOAT	Depth of Cut: D.O.C. (inch), Feed: f (ipr)								
	PR1225	D.O.C.	f	D.O.C.	f	D.O.C.	f	D.O.C.	f	
Carbon Steel / Alloy Steel	100~330	~0.0079	~0.0012	~0.0079	~0.0020	~0.0118	~0.0028	~0.0118	~0.0028	Wet
Stainless Steel	100~260	~0.0079	~0.0008	~0.0079	~0.0012	~0.0098	~0.0020	~0.0098	~0.0020	

NB (Without Chipbreaker)

Workpiece Material	Insert Grade (Vc : sfm)	EZB020/025		EZB030/035		EZB040/045		EZB050/055/060/065/075		Notes
	MEGACOAT	Depth of Cut: D.O.C. (inch), Feed: f (ipr)								
	PR1225	D.O.C.	f	D.O.C.	f	D.O.C.	f	D.O.C.	f	
Carbon Steel / Alloy Steel	100~330	~0.0118	~0.0012	~0.0157	~0.0016	~0.0177	~0.0028	~0.0197	~0.0039	Wet
Stainless Steel	100~260	~0.0079	~0.0008	~0.0118	~0.0012	~0.0138	~0.0020	~0.0157	~0.0028	
Non-ferrous Material	200~330	~0.0118	~0.0020	~0.0157	~0.0024	~0.0177	~0.0028	~0.0197	~0.0039	

Workpiece Material	Insert Grade (Vc : sfm)		EZB030		EZB040/045		EZB050/060/070		Notes
	MEGACOAT CBN	PCD	Depth of Cut: D.O.C. (inch), Feed: f (ipr)						
	KBN05M	**KPD001**	D.O.C.	f	D.O.C.	f	D.O.C.	f	
Non-ferrous Material	-	~980	-	-	~0.0177	~0.0039	~0.0197	~0.0059	Wet
Hardened Materials	~330	-	~0.0028	~0.0012	~0.0039	~0.0020	~0.0059	~0.0028	

EZ Bar Compatibility

EZ Bar is compatible with conventional Micro-Bars

Sleeve \ Bar	**EZB...HP**	**EZB...ST/NB**	**HPB...**(Conventional)
EZH...CT/HP	✓	✓	※1 ※2 ✓ (Compatible)
EZH...ST	✓	✓	※1 ✓ (Compatible)
PSH...(Discontinued Sleeve)	※1 ✓ (Compatible)	※1 ✓ (Compatible)	✓

※1 Some diameters of conventional Micro-Bars are incompatible
※2 Use them without Adjustment Pins. Overhang length of bar is not adjustable.