для заказа - kyocera@kyocera-tools.ru

Recommended Cutting Conditions (VNB-S)

Workpiece Material	Recommended Insert Grades (Cutting Speed Vc: sfm)						VNB01-S VNB015-S		VNB02-S ~ VNB04-S		Notes
	MEGA COAT	PVD	Carbide	CBN	PCD						
	PR1225	PR930	KW10	KBN510	KPD001	KPD010	D.O.C. (inch), f (ipr)				
							D.O.C.	f	D.O.C.	f	
Carbon Steel / Alloy Steel	★ 100~390	☆ 100~330					~0.0039	~0.0004	~0.0079	~0.0012	Wet
Stainless Steel	★ 100~300	☆ 100~260					~0.0039	~0.0004	~0.0079	~0.0008	

★ : 1st Recommendation
☆ : 2nd Recommendation

Recommended Cutting Conditions (VNB / VNB-NB / VNBT)

Workpiece Material	Recommended Insert Grades (Cutting Speed Vc: sfm)						VNB02		VNB03		VNB004 VNBT04		VNB05 VNB06 VNB07 VNBT05		Notes
	MEGA COAT	PVD	Carbide	CBN	PCD										
	PR1225	PR930	KW10	KBN510	KPD001	KPD010	D.O.C. (inch), f (ipr)								
							D.O.C.	f	D.O.C.	f	D.O.C.	f	D.O.C.	f	
Carbon Steel / Alloy Steel	★ 100~390	☆ 100~330					~0.0118	~0.0012	~0.0157	~0.0016	~0.0177	~0.0028	~0.0197	~0.0039	
Stainless Steel	★ 100~330	☆ 100~260					~0.0118	~0.0008	~0.0157	~0.0012	~0.0177	~0.0020	~0.0197	~0.0028	Wet
Non-ferrous Metals			☆ ~330		★ ~980	☆ ~980	~0.0118	~0.0020	~0.0157	~0.0024	~0.0177	~0.0039	~0.0197	~0.0059	

★ : 1st Recommendation
☆ : 2nd Recommendation

Recommended Cutting Conditions (VNBX-S)

Workpiece Material	Recommended Insert Grades (Cutting Speed Vc: sfm)							VNBX01-S VNBX015-S		VNBX02-S ~ VNBX04-S		Notes
	PVD Coated Carbide			Carbide	CBN	PCD						
	PR630	PR915	PR930	KW10	KBN510	KPD001	KPD010	D.O.C. (inch), f (ipr)				
								D.O.C.	f	D.O.C.	f	
Carbon Steel / Alloy Steel			★ 100~330					~0.0039	~0.0004	~0.0079	~0.0012	Wet
Stainless Steel			★ 100~260					~0.0039	~0.0004	~0.0079	~0.0008	

★ : 1st Recommendation

kyocera@kyocera-tools.ru
www.kyocera-tools.ru