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Recommended Cutting Conditions - Boring (Positive Insert)

[D.O.C. Indicates Radius]

ISO Classification	Workpiece Material	Hardness	Cutting Range	Application	Recommended Chipbreaker	Recommended Insert Grade	Corner-R (rε)	Lower Limit - **Recommendation** - Upper Limit		
								Vc (sfm)	D.O.C. (inch)	Feed Rate f (ipr)
P※	Low-carbon Steel Low-carbon Alloy	HB ≦ 300	Finishing (Solid Type)	Continuous	EZB-F EZB-H	PR1225	0.002	100 - **230** - 360	0.0020 - **0.0039** - 0.0079	0.0004 - **0.0016** - 0.0028
				Interrupted			0.006	100 - **200** - 300	0.0020 - **0.0039** - 0.0079	0.0012 - **0.0028** - 0.0039
			Finishing	Continuous	F	PR1425	0.004	130 - **260** - 390	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	130 - **230** - 330	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing-Medium	Continuous	CF	PR1425	0.004	130 - **260** - 390	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	130 - **230** - 330	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0028** - 0.0039
	Medium-carbon Steel Medium-carbon Alloy	HB ≦ 300	Finishing (Solid Type)	Continuous	EZB-F EZB-H	PR1225	0.002	100 - **230** - 360	0.0020 - **0.0039** - 0.0079	0.0004 - **0.0016** - 0.0028
				Interrupted			0.006	100 - **200** - 300	0.0020 - **0.0039** - 0.0079	0.0012 - **0.0028** - 0.0039
			Finishing	Continuous	F	PR1425	0.004	130 - **260** - 390	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	130 - **230** - 390	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing-Medium	Continuous	CF	PR1425	0.004	130 - **260** - 390	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	130 - **230** - 330	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0028** - 0.0039
	High-carbon Alloy	HB ≦ 280	Finishing (Solid Type)	Continuous	EZB-F EZB-H	PR1225	0.002	100 - **230** - 360	0.0020 - **0.0039** - 0.0079	0.0004 - **0.0016** - 0.0028
				Interrupted			0.006	100 - **200** - 300	0.0020 - **0.0039** - 0.0079	0.0012 - **0.0028** - 0.0039
			Finishing	Continuous	F	PR1425	0.004	130 - **260** - 390	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	130 - **230** - 330	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing-Medium	Continuous	CF	PR1425	0.004	130 - **260** - 390	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	130 - **230** - 330	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0028** - 0.0039
M	Stainless Steel	HB ≦ 220	Finishing (Solid Type)	Continuous	EZB-F EZB-H	PR1225	0.002	100 - **200** - 260	0.0020 - **0.0039** - 0.0079	0.0004 - **0.0012** - 0.0020
				Interrupted			0.006	100 - **200** - 260	0.0020 - **0.0039** - 0.0079	0.0008 - **0.0020** - 0.0028
			Finishing	Continuous	F	PR1225 PR1535	0.004	100 - **200** - 260	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	100 - **200** - 260	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing-Medium	Continuous	CF	PR1225 PR1535	0.004	100 - **200** - 260	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	100 - **200** - 260	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0028** - 0.0039
	Stainless Steel	HB ≦ 300	Finishing (Solid Type)	Continuous	EZB-F EZB-H	PR1225	0.002	100 - **200** - 260	0.0020 - **0.0039** - 0.0079	0.0004 - **0.0012** - 0.0020
				Interrupted			0.006	100 - **200** - 260	0.0020 - **0.0039** - 0.0079	0.0008 - **0.0020** - 0.0028
			Finishing	Continuous	F	PR1225 PR1535	0.004	100 - **200** - 260	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	100 - **200** - 260	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing-Medium	Continuous	CF	PR1225 PR1535	0.004	100 - **200** - 260	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	100 - **200** - 260	0.0020 - **0.0059** - 0.0098	0.0012 - **0.0028** - 0.0039
K	Gray Cast Iron	HB ≦ 250	Finishing (Solid Type)	Continuous	(VNB) (VNB-NB)	KW10	0.001	100 - **200** - 330	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	100 - **200** - 330	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing	Continuous	F	KW10	0.004	100 - **200** - 330	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	100 - **200** - 260	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing-Medium	Continuous	Without Chipbreaker	KW10	0.008	100 - **200** - 330	0.0039 - **0.0079** - 0.0118	0.0012 - **0.0020** - 0.0028
				Interrupted			1/64	100 - **200** - 260	0.0039 - **0.0079** - 0.0118	0.0012 - **0.0028** - 0.0039
	Nodular Cast Iron	HB ≦ 270	Finishing (Solid Type)	Continuous	(VNB) (VNB-NB)	KW10	0.001	100 - **200** - 260	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	100 - **200** - 260	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing	Continuous	F, U	KW10	0.004	100 - **200** - 260	0.0020 - **0.0031** - 0.0039	0.0012 - **0.0020** - 0.0028
				Interrupted			0.008	100 - **200** - 260	0.0020 - **0.0039** - 0.0059	0.0012 - **0.0028** - 0.0039
			Finishing-Medium	Continuous	Without Chipbreaker	KW10	0.008	100 - **200** - 330	0.0039 - **0.0079** - 0.0118	0.0012 - **0.0020** - 0.0028
				Interrupted			1/64	100 - **200** - 260	0.0039 - **0.0079** - 0.0118	0.0012 - **0.0028** - 0.0039
N	Non-ferrous Metals Copper Alloy Aluminum Aluminum Alloy	HB ≦ 100	High Speed Finishing (Rainbow Surface Gloss)	Continuous	Without Chipbreaker	KPD001	0.002	490 - **660** - 980	0.0020 - **0.0039** - 0.0118	0.0020 - **0.0039** - 0.0059
			Finishing (Long Tool Life)	Continuous	F, U	PDL025	0.004	330 - **490** - 660	0.0020 - **0.0118** - 0.0197	0.0012 - **0.0039** - 0.0079
				Interrupted			0.008	330 - **490** - 660	0.0020 - **0.0118** - 0.0197	0.0012 - **0.0039** - 0.0079
			Finishing	Continuous	F, U	KW10	0.004	330 - **490** - 660	0.0020 - **0.0118** - 0.0197	0.0012 - **0.0039** - 0.0079
				Interrupted			0.008	330 - **490** - 660	0.0020 - **0.0118** - 0.0197	0.0012 - **0.0039** - 0.0079
S	Titanium Alloy	HB ≦ 400	Precision Finishing (Rainbow Surface Gloss)	Continuous	Without Chipbreaker	KPD001	0.004	330 - **390** - 490	0.0020 - **0.0039** - 0.0118	0.0012 - **0.0028** - 0.0039
				Interrupted			0.008	230 - **330** - 390	0.0020 - **0.0039** - 0.0118	0.0012 - **0.0028** - 0.0039
			Finishing	Continuous	F, U	KW10	0.004	70 - **130** - 200	0.0020 - **0.0079** - 0.0197	0.0012 - **0.0039** - 0.0079
				Interrupted			0.008	70 - **130** - 200	0.0020 - **0.0079** - 0.0197	0.0012 - **0.0039** - 0.0079
	Heat-restistant Alloys	HB ≦ 350	Finishing (Solid Type)	Continuous	(VNB)	KW10	0.008	30 - **100** - 160	0.0020 - **0.0039** - 0.0118	0.0012 - **0.0020** - 0.0039
				Interrupted			0.008	30 - **100** - 160	0.0020 - **0.0039** - 0.0118	0.0012 - **0.0020** - 0.0031
			Finishing	Continuous	F, U	KW10	0.008	30 - **100** - 160	0.0020 - **0.0079** - 0.0157	0.0012 - **0.0020** - 0.0039
				Interrupted			0.008	30 - **100** - 160	0.0020 - **0.0079** - 0.0157	0.0012 - **0.0020** - 0.0039
H	Hardened Steel Hardened Materials	40 ~ 50 HRC	Finishing	Continuous	(VNB)	PR930	0.008	100 - **160** - 230	0.0020 - **0.0039** - 0.0157	0.0004 - **0.0008** - 0.0020
				Interrupted			0.008	100 - **160** - 230	0.0020 - **0.0039** - 0.0079	0.0004 - **0.0008** - 0.0012
		45 ~ 68 HRC	Finishing	Continuous	ME MES	KBN05M	0.008	200 - **330** - 460	0.0020 - **0.0039** - 0.0079	0.0008 - **0.0020** - 0.0039
				Interrupted			1/64	200 - **260** - 390	0.0020 - **0.0039** - 0.0079	0.0008 - **0.0020** - 0.0039

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