для заказа - kyocera@kyocera-tools.ru

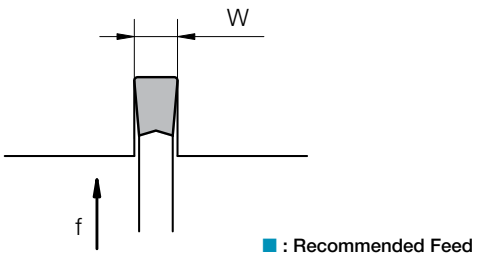
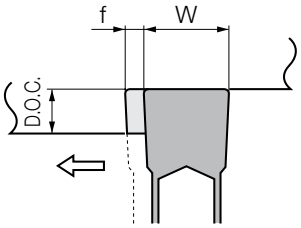
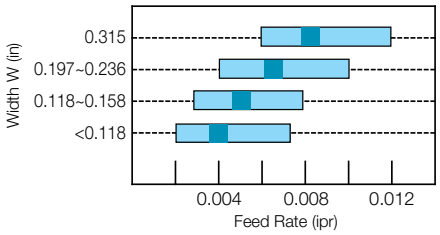
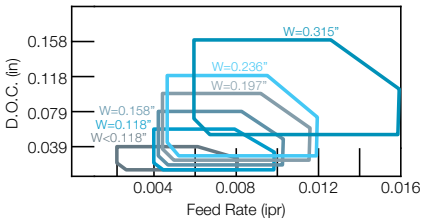
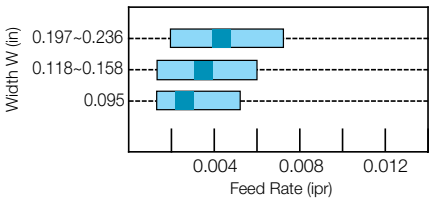
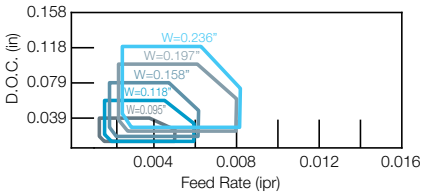
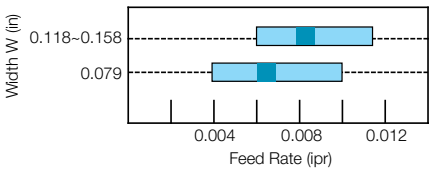
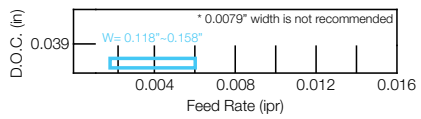
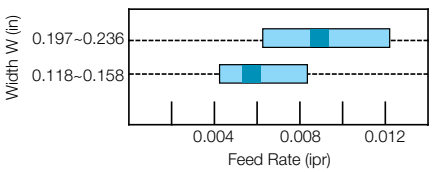
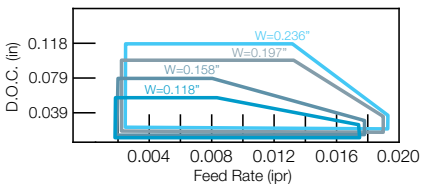
Recommended Cutting Conditions (Vc)

Workpiece Material	Chipbreaker	Recommended Insert Grade (Vc : sfm)								Notes
		Cermet	MEGACOAT NANO	MEGACOAT		Carbide	MEGACOAT CBN	CBN	PCD	
		TN90	PR1535	PR1225	PR1215	GW15	KBN05M	KBN570	KPD001	
Carbon Steel	GM GL CM PH GS	☆ 330~720	☆ 260~660	★ 260~660	☆ 330~660	-	-	-	-	Wet
Alloy Steel		☆ 260~660	☆ 230~590	★ 230~590	☆ 260~590	-	-	-	-	
Stainless Steel		☆ 230~590	★ (PH) 200~490	★ 200~490	☆ 200~490	-	-	-	-	
Cast Iron		-	-	-	★ 330~660	-	-	-	-	
Aluminum	GS NB	-	-	-	-	☆ 660~1640	-	-	★ 490~6560	
Brass		-	-	-	-	☆ 330~660	-	-	★ 660~2620	
Hardened Material	NB	-	-	-	-	-	★ 260~490	-	-	
Powdered Steel		-	-	-	-	-	-	★ 330~820	-	

★ : 1st Recommendation ☆ : 2nd Recommendation

Recommended Cutting Conditions (Feed Rate / D.O.C.)

(Workpiece Material : 1049)

Chipbreaker	Grooving	Traversing
		
GM (General Purpose)		
GL (Low Feed)		
PH (High Feed)		
CM (Copying)		

1) The above values reflect a T dimension that is 0.669" (17mm) or less.

2) If the toolholder is not for the 0.315" (8mm) width insert and its T dimension is over 0.669" (17mm), set the values for longitudinal turning to less than 90% of those above.

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