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Recommended Cutting Conditions (Ground Chipbreaker : GE□...A(R), GE□...B(R))

Workpiece Material	Recommended Insert Grade (Vc sfm)				① f (feed) during Grooving (ipr) / ② f (feed) during Traversing (ipr) / ③ D.O.C. during Traversing (in)			Notes
	Cermet	MEGA COAT	PVD	Carbide				
	TN6020	**PR1225**	**PR1025**	**KW10**	GE□ 100~200-010A 100~200-100AR	GE□ 100~200-010B 100~200-100BR	GE□ 250~300-020B	
Carbon Steel	☆ 160~260	★ 160~260	☆ 160~260	-	① 0.0004~0.0012 ② 0.0004~0.0012 ③ Max. 0.0020	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0020	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0039	Wet
Alloy Steel	☆ 160~260	★ 160~260	☆ 160~260	-	① 0.0004~0.0012 ② 0.0004~0.0012 ③ Max. 0.0020	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0020	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0039	
Stainless Steel	-	★ 160~260	☆ 160~260	-	① 0.0004~0.0012 ② 0.0004~0.0012 ③ Max. 0.0020	① 0.0004~0.0012 ② 0.0004~0.0012 ③ Max. 0.0020	① 0.0004~0.0012 ② 0.0004~0.0012 ③ Max. 0.0039	
Cast Iron	-	-	-	★ 160~260	① 0.0004~0.0012 ② 0.0004~0.0012 ③ Max. 0.0020	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0020	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0039	
Aluminum	-	-	-	★ 160~330	① 0.0004~0.0012 ② 0.0004~0.0012 ③ Max. 0.0039	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0039	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0079	
Brass	-	-	-	★ 160~330	① 0.0004~0.0012 ② 0.0004~0.0012 ③ Max. 0.0039	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0039	① 0.0008~0.0016 ② 0.0008~0.0016 ③ Max. 0.0079	

• Use PVD coated grade or uncoated carbide for traversing with edge width 0.0394"(1mm). (GE□100-005A/100-005B)

★ : 1st Recommendation ☆ : 2nd Recommendation

Recommended Cutting Conditions (Ground Chipbreaker : GE□...C(R),GE□...D(R),GE□...E)

Workpiece Material	Recommended Insert Grade (Vc sfm)				① f (feed) during Grooving (ipr) / ② f (feed) during Traversing (ipr) / ③ D.O.C. during Traversing (in)							Notes
	Cermet	MEGA COAT	PVD	Carbide								
	TN6020	**PR1225**	**PR1025**	**GW15**	GE□ 100~200-010C 200-100CR	GE□ 250~350-020C 250~300-150CR						
					GE□ 100~145-010D	GE□ 150~195-010D	GE□ 200~280-020D 200-100DR		GE□ 300~400-020D 300-150DR			
					GE□ 100-010E	GE□ 150~195-010E	GE□ 200~225-010E 230-020E	GE□ 250~330-020E		GE□ 350~430-020E	GE□ 450~500-020E	
Carbon Steel	☆ 390~590	★ 200~460	☆ 200~460	-	① 0.0012~0.0031 ② 0.0012~0.0031 ③ Max. 0.0118	① 0.0012~0.0031 ② 0.0012~0.0031 ③ Max. 0.0118	① 0.0016~0.0035 ② 0.0016~0.0035 ③ Max. 0.0118	① 0.0016~0.0035 ② 0.0016~0.0035 ③ Max. 0.0118	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0197	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0197	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0197	Wet
Alloy Steel	☆ 330~520	★ 200~390	☆ 200~390	-	① 0.0012~0.0028 ② 0.0012~0.0039 ③ Max. 0.0118	① 0.0012~0.0028 ② 0.0012~0.0039 ③ Max. 0.0118	① 0.0016~0.0031 ② 0.0016~0.0031 ③ Max. 0.0118	① 0.0016~0.0031 ② 0.0016~0.0031 ③ Max. 0.0118	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0197	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0197	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0197	
Stainless Steel	☆ 230~430	★ 200~360	☆ 200~360	-	① 0.0012~0.0028 ② 0.0012~0.0039 ③ Max. 0.0118	① 0.0012~0.0028 ② 0.0012~0.0039 ③ Max. 0.0118	① 0.0016~0.0031 ② 0.0016~0.0031 ③ Max. 0.0118	① 0.0016~0.0031 ② 0.0016~0.0031 ③ Max. 0.0118	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0197	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0197	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0197	
Cast Iron	-	-	-	★ 200~330	① 0.0012~0.0031 ② 0.0012~0.0031 ③ Max. 0.0118	① 0.0012~0.0031 ② 0.0012~0.0031 ③ Max. 0.0118	① 0.0016~0.0035 ② 0.0016~0.0035 ③ Max. 0.0118	① 0.0016~0.0035 ② 0.0016~0.0035 ③ Max. 0.0118	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0197	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0197	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0197	
Aluminum	-	-	-	★ 490~980	① 0.0020~0.0047 ② 0.0020~0.0047 ③ Max. 0.0197	① 0.0020~0.0047 ② 0.0020~0.0047 ③ Max. 0.0197	① 0.0020~0.0059 ② 0.0020~0.0059 ③ Max. 0.0197	① 0.0020~0.0059 ② 0.0020~0.0059 ③ Max. 0.0197	① 0.0031~0.0059 ② 0.0031~0.0059 ③ Max. 0.0315	① 0.0031~0.0059 ② 0.0031~0.0059 ③ Max. 0.0315	① 0.0031~0.0059 ② 0.0031~0.0059 ③ Max. 0.0315	
Brass	-	-	-	★ 330~820	① 0.0020~0.0047 ② 0.0020~0.0047 ③ Max. 0.0197	① 0.0020~0.0047 ② 0.0020~0.0047 ③ Max. 0.0197	① 0.0020~0.0059 ② 0.0020~0.0059 ③ Max. 0.0197	① 0.0020~0.0059 ② 0.0020~0.0059 ③ Max. 0.0197	① 0.0031~0.0059 ② 0.0031~0.0059 ③ Max. 0.0315	① 0.0031~0.0059 ② 0.0031~0.0059 ③ Max. 0.0315	① 0.0031~0.0059 ② 0.0031~0.0059 ③ Max. 0.0315	

• Use PVD coated grade or uncoated carbide for traversing with edge width 0.0394"(1mm). (GE□100-010C / 100-010D / 100-010E)

★ : 1st Recommendation ☆ : 2nd Recommendation

Recommended Cutting Conditions (Molded Chipbreaker : GER...CM, GER...DM, GER...EM)

Workpiece Material	Recommended Insert Grade (Vc sfm)				① f (feed) during Grooving (ipr) / ② f (feed) during Traversing (ipr) / ③ D.O.C. during Traversing (in)						Notes
	Cermet	MEGA COAT	PVD	Carbide							
	TN6020	**PR1225**	**PR1025**	**GW15**	GER 150~200-010CM	GER 250~350-020CM					
					GER 150~200-010DM		GER 230~250-020DM	GER 300~400-020DM			
					GER 150~200-010EM			GER 250~350-020EM	GER 350~400-020EM	GER 450~500-020CM	
Carbon Steel	-	★ 200~520	☆ 200~520	-	① 0.0012~0.0039 ② 0.0012~0.0039 ③ Max. 0.0394	① 0.0012~0.0047 ② 0.0012~0.0039 ③ Max. 0.0591	① 0.0016~0.0047 ② 0.0016~0.0039 ③ Max. 0.0591	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0591	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0591	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0591	Wet
Alloy Steel	-	★ 200~460	☆ 200~460	-	① 0.0012~0.0039 ② 0.0012~0.0039 ③ Max. 0.0394	① 0.0012~0.0039 ② 0.0012~0.0039 ③ Max. 0.0591	① 0.0016~0.0047 ② 0.0016~0.0039 ③ Max. 0.0591	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0591	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0591	① 0.0020~0.0047 ② 0.0020~0.0039 ③ Max. 0.0591	
Stainless Steel	-	★ 200~360	☆ 200~360	-	① 0.0012~0.0031 ② 0.0012~0.0039 ③ Max. 0.0394	① 0.0012~0.0031 ② 0.0012~0.0039 ③ Max. 0.0591	① 0.0016~0.0031 ② 0.0016~0.0039 ③ Max. 0.0591	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0591	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0591	① 0.0020~0.0039 ② 0.0020~0.0039 ③ Max. 0.0591	

★ : 1st Recommendation ☆ : 2nd Recommendation

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