для заказа - kyocera@kyocera-tools.ru

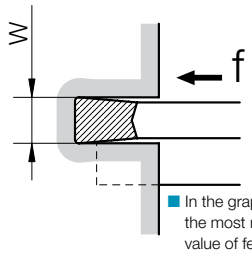
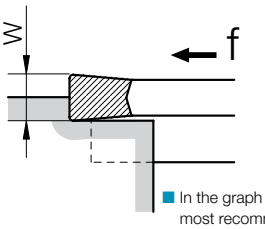
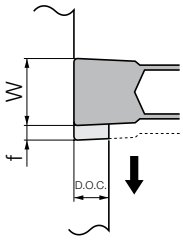
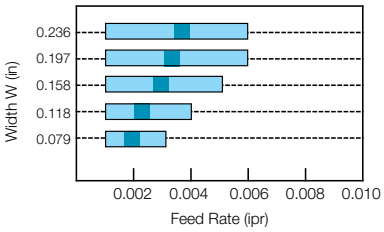
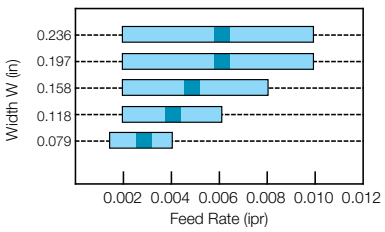
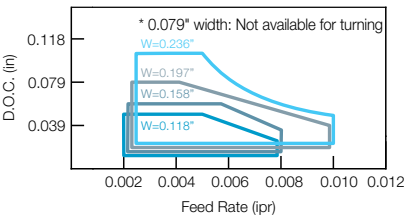
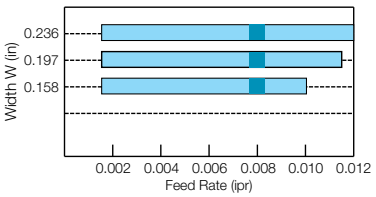
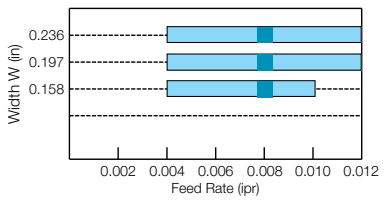
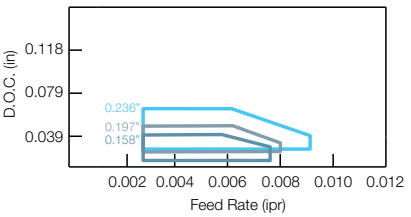
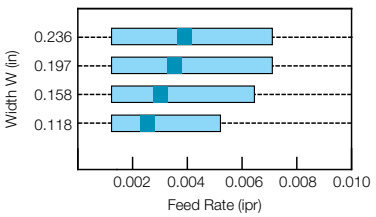
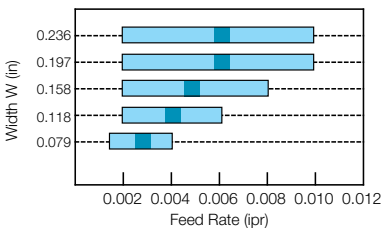
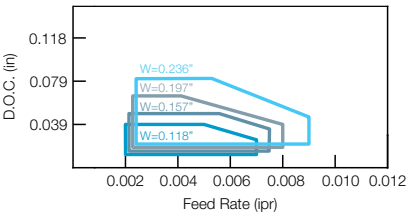
Recommended Cutting Conditions (Vc)

Workpiece Material	Recommended Insert Grade (Vc : sfm)				Notes
	Cermet		MEGACOAT		
	TN620	TN90	PR1225	PR1215	
Carbon Steel	☆ 200~660	☆ 260~660	★ 200~520	☆ 260~520	Wet
Alloy Steel	☆ 200~520	☆ 230~520	★ 200~490	☆ 200~490	
Stainless Steel	-	-	★ 160~390	☆ 160~390	
Cast Iron	-	-	-	★ 260~520	

★ : 1st Recommendation ☆ : 2nd Recommendation

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

(Workpiece Material : 1049)

Chipbreaker	Grooving	Shoulder Grooving (Side Grooving)	Traversing
	 ■ In the graph indicates the most recommended value of feed (f)	 ■ In the graph indicates the most recommended value of feed (f)	
GM (Grooving and Traversing)			
GH (Grooving, Traversing and High Feed Grooving)			
DM (Deep grooving and Turning)			

● When shouldering,

- If D.O.C. is set smaller, set feed higher.
- If D.O.C. is set larger, set feed lower.

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