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RECOMMENDED CUTTING CONDITIONS

GBA (Ground Chipbreaker)

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
	MC	Cermet			MEGA	PVD			Carbide	CBN	PCD					
	PV7040	TN620	TC40	TN90	PR1215	PR930	PR1115	PR905	KW10	KBN510 KBN525	KPD001 (KPD010)	GBA○○**M** 033 ~ 100 031N ~ 041N	GBA○○**M** 125 ~ 200 047N ~ 078N	GBA○○**M** 230 ~ 300 094N ~ 109N	GBA○○**M** 330 ~ 400 125N ~ 156N	GBA○○**M** 400 ~ 480 172N ~ 188N	
Carbon Steel	☆ 490~790	★ 260~720	☆ 490~720	☆ 490~720	★ 260~660	☆ 260~590	☆ 260~590	-	-	-	-	① 0.0012~0.0031 ② Traversing N/A ③ Traversing N/A	① 0.0016~0.0035 ② 0.0016~0.0035 ③ MAX 0.012	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0047 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0047 ② 0.0020~0.0039 ③ MAX 0.031	
Alloy Steel	☆ 430~720	★ 260~660	☆ 430~660	☆ 430~660	★ 260~590	☆ 260~520	☆ 260~520	-	-	-	-	① 0.0012~0.0028 ② Traversing N/A ③ Traversing N/A	① 0.0016~0.0031 ② 0.0016~0.0031 ③ MAX 0.012	① 0.0020~0.0035 ② 0.0020~0.0035 ③ MAX 0.020	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.031	
Stainless Steel	-		-	☆ 230~490	☆ 200~490	☆ 200~430	★ 200~430	-	-	-	-	① 0.0012~0.0028 ② Traversing N/A ③ Traversing N/A	① 0.0016~0.0031 ② 0.0016~0.0031 ③ MAX 0.012	① 0.0020~0.0035 ② 0.0020~0.0035 ③ MAX 0.020	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.031	
Cast Iron	-		-	-	-	-	-	★ 260~590	☆ 200~390	★ 490~1310	-	① 0.0012~0.0031 ② Traversing N/A ③ Traversing N/A	① 0.0016~0.0035 ② 0.0016~0.0035 ③ MAX 0.012	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0047 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0047 ② 0.0020~0.0039 ③ MAX 0.031	Wet
Aluminum	-		-	-	-	-	-	-	★ 490~1310	-	★ 490~6560	① 0.0020~0.0047 ② Traversing N/A ③ Traversing N/A	① 0.0020~0.0059 ② 0.0020~0.0059 ③ MAX 0.020	① 0.0020~0.0059 ② 0.0020~0.0059 ③ MAX 0.031	① 0.0031~0.0059 ② 0.0031~0.0059 ③ MAX 0.031	① 0.0031~0.0059 ② 0.0031~0.0059 ③ MAX 0.031	
Brass	-		-	-	-	-	-	-	★ 490~980	-	★ 660~2620	① 0.0020~0.0047 ② Traversing N/A ③ Traversing N/A	① 0.0020~0.0059 ② 0.0020~0.0059 ③ MAX 0.020	① 0.0020~0.0059 ② 0.0020~0.0059 ③ MAX 0.031	① 0.0031~0.0059 ② 0.0031~0.0059 ③ MAX 0.031	① 0.0031~0.0059 ② 0.0031~0.0059 ③ MAX 0.031	
Hardened Materials	-		-	-	-	-	-	-	-	★ 260~390	-	① - ② - ③ -	① 0.0008~0.0020 ② Traversing N/A ③ Traversing N/A	① 0.0012~0.0028 ② 0.0004~0.0016 ③ MAX 0.004	① - ② - ③ -	① - ② - ③ -	

• Above cutting condition is for external grooving. Set both cutting speed and feed 10% higher for internal grooving.
* MC indicates MEGACOAT Cermet. MEGA indicates MEGACOAT.

★ : 1st Recommendation ☆ : 2nd Recommendation

GBA (GM Chipbreaker)

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	MEGACOAT					
	TN620	**PR1215**	GBA43**M** 150~020GM	GBA43**M** 175-020GM~230-020GM	GBA43**M** 250-030GM~350-030GM	GBA43**M** 400-040GM	
Carbon Steel	★ 260~720	☆ 260~720	① 0.0012~0.0047 ② 0.0012~0.0031 ③ MAX 0.012	① 0.0012~0.0047 ② 0.0012~0.0035 ③ MAX 0.012	① 0.0016~0.0059 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0059 ② 0.0020~0.0039 ③ MAX 0.031	
Alloy Steel	★ 260~660	☆ 260~660	① 0.0012~0.0047 ② 0.0012~0.0031 ③ MAX 0.012	① 0.0012~0.0047 ② 0.0012~0.0035 ③ MAX 0.012	① 0.0016~0.0059 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0059 ② 0.0020~0.0039 ③ MAX 0.031	Wet
Stainless Steel	-	★ 200~490	① 0.0012~0.0039 ② 0.0012~0.0031 ③ MAX 0.012	① 0.0012~0.0039 ② 0.0012~0.0035 ③ MAX 0.012	① 0.0016~0.0047 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0016~0.0047 ② 0.0020~0.0039 ③ MAX 0.031	

• Above cutting condition is for external grooving. Set both cutting speed and feed 20% higher for internal grooving.

★ : 1st Recommendation ☆ : 2nd Recommendation

GBA (MY Chipbreaker)

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	PVD		Carbide	CBN	PCD						
	TN6020	TC40	PR1215	PR930	PR1115	KW10	KBN510	KPD001 (KPD010)	GBA43**M** 175MY~200MY GBA43**M** 078MYN~200MY	GBA43**M** 230MY~265MY GBA43**M** 094MYN	GBA43**M** 300MY	GBA43**M** 330MY~350MY GBA43**M** 125MYN	GBA43**M** 400MY GBA43**M** 156MYN	
Carbon Steel	☆ 490~720	-	★ 260~660	☆ 260~660	☆ 260~660	-	-	-	① 0.0012~0.0031 ② 0.0012~0.0031 ③ MAX 0.012	① 0.0016~0.0035 ② 0.0016~0.0035 ③ MAX 0.012	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0047 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0047 ② 0.0020~0.0039 ③ MAX 0.031	
Alloy Steel	☆ 430~660	-	★ 260~590	☆ 260~590	☆ 260~590	-	-	-	① 0.0012~0.0028 ② 0.0012~0.0039 ③ MAX 0.012	① 0.0016~0.0031 ② 0.0016~0.0031 ③ MAX 0.012	① 0.0020~0.0035 ② 0.0020~0.0035 ③ MAX 0.020	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.031	Wet
Stainless Steel	☆ 230~490	-	☆ 200~490	☆ 200~490	★ 200~490	-	-	-	① 0.0012~0.0028 ② 0.0012~0.0039 ③ MAX 0.012	① 0.0016~0.0031 ② 0.0016~0.0031 ③ MAX 0.012	① 0.0020~0.0035 ② 0.0020~0.0035 ③ MAX 0.020	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.031	

• Above cutting condition is for external grooving. Set both cutting speed and feed 10% higher for internal grooving.
* MEGA indicates MEGACOAT.

★ : 1st Recommendation ☆ : 2nd Recommendation

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