для заказа - kyocera@kyocera-tools.ru

RECOMMENDED CUTTING CONDITIONS

GB (Ground Chipbreaker) will be phased out and switched to GBA

Workpiece Material	Recommended Insert Grade (Vc sfm)								① f (feed) during Grooving (ipr)					Notes
	Cermet			PVD		Carbide	CBN	PCD	② f (feed) during Traversing (ipr)					
									③ D.O.C. during Traversing (in)					
	TN90	TC40	TC60M	PR630	PR930	KW10	KBN510	KPD001 (KPD010)	GB○○R 050 ~ 100	GB○○R 125 ~ 200	GB○○R 230 ~ 300	GB○○R 330 ~ 400	GB○○R 400 ~ 480	
Carbon Steel	-	☆ 490~720	☆ 330~490	☆ 260~660	★ 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	Wet
Alloy Steel	-	☆ 430~660	☆ 260~430	☆ 260~590	★ 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	-	-	☆ 200~330	☆ 200~490	★ 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	-	-	-	-		★ 200~330	-	-	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	
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	

★ : 1st Recommendation ☆ : 2nd Recommendation

TGF (Ground Chipbreaker)

Workpiece Material	Recommended Insert Grade (Vc sfm)							① f (feed) during Grooving (ipr)				Notes
	Cermet	MEGA	PVD		Carbide	CBN	PCD	② f (feed) during Traversing (ipr)				
								③ D.O.C. during Traversing (in)				
	TC40	PR1215	PR930	PR1115	KW10	KBN510	KPD001 (KPD010)	TGF32R 033~050~005	TGF32R 075~095~010	TGF32R 100~145~010	TGF32R 150~250~010	
Carbon Steel	☆ 490~720	★ 260~590	☆ 260~590	☆ 260~590	-	-	-	① 0.0004~0.0020 ② Traversing N/A ③ Traversing N/A	① 0.0008~0.0028 ② Traversing N/A ③ Traversing N/A	① 0.0012~0.0031 ② 0.0012~0.0024 ③ MAX 0.008	① 0.0012~0.0031 ② 0.0012~0.0024 ③ MAX 0.008	Wet
Alloy Steel	☆ 430~660	★ 260~520	☆ 260~520	☆ 260~520	-	-	-	① 0.0004~0.0016 ② Traversing N/A ③ Traversing N/A	① 0.0008~0.0024 ② Traversing N/A ③ Traversing N/A	① 0.0012~0.0028 ② 0.0008~0.0020 ③ MAX 0.008	① 0.0012~0.0028 ② 0.0008~0.0020 ③ MAX 0.008	
Stainless Steel	-	☆ 200~430	☆ 200~430	★ 200~430	-	-	-	① 0.0004~0.0016 ② Traversing N/A ③ Traversing N/A	① 0.0008~0.0024 ② Traversing N/A ③ Traversing N/A	① 0.0012~0.0028 ② 0.0008~0.0020 ③ MAX 0.008	① 0.0012~0.0028 ② 0.0008~0.0020 ③ MAX 0.008	
Cast Iron	-	-	-	-	★ 200~330	-	-	① 0.0004~0.0020 ② Traversing N/A ③ Traversing N/A	① 0.0008~0.0028 ② Traversing N/A ③ Traversing N/A	① 0.0012~0.0031 ② 0.0012~0.0024 ③ MAX 0.008	① 0.0012~0.0031 ② 0.0012~0.0024 ③ MAX 0.008	
Aluminum	-	-	-	-	★ 490~1310	-	★ 490~6560	① 0.0004~0.0020 ② Traversing N/A ③ Traversing N/A	① 0.0008~0.0028 ② Traversing N/A ③ Traversing N/A	① 0.0012~0.0031 ② 0.0012~0.0024 ③ MAX 0.008	① 0.0012~0.0031 ② 0.0012~0.0024 ③ MAX 0.008	
Brass	-	-	-	-	★ 490~980	-	★ 660~2620	① 0.0004~0.0016 ② Traversing N/A ③ Traversing N/A	① 0.0008~0.0024 ② Traversing N/A ③ Traversing N/A	① 0.0012~0.0028 ② 0.0008~0.0020 ③ MAX 0.008	① 0.0012~0.0028 ② 0.0008~0.0020 ③ MAX 0.008	

* MEGA indicates MEGACOAT.

★ : 1st Recommendation ☆ : 2nd Recommendation

TG (Ground Chipbreaker) will be phased out and switched to GBA

Workpiece Material	Recommended Insert Grade (Vc sfm)								Feed Rate (ipr)					Notes
	Cermet			PVD		Carbide	CBN	PCD						
	TN60	TC40	TC60M	PR630	PR930	KW10	KBN510	KPD001 (KPD010)	TG○○R 075~095	TG○○R 125~200	TG○○R 230~300	TG○○R 330~400	TG○○R 430~450	
Carbon Steel	★ 490~720	-	-	-	-	-	-	-	0.0012~0.0028	0.0012~0.0031	0.0020~0.0039	0.0020~0.0047	0.0020~0.0047	Wet
Alloy Steel	★ 430~660	-	-	-	-	-	-	-	0.0008~0.0024	0.0012~0.0028	0.0020~0.0035	0.0020~0.0039	0.0020~0.0039	

* Above cutting condition is for external grooving. Set both cutting speed and feed 10% lower for internal grooving.

★ : 1st Recommendation ☆ : 2nd Recommendation

kyocera@kyocera-tools.ru
www.kyocera-tools.ru