для заказа - kyocera@kyocera-tools.ru

RECOMMENDED CUTTING CONDITIONS

GH (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
	Cermet			PVD	Carbide	Ceramic							
	TN90	TC40	TC60M	PR930	KW10	A65	A66N	PT600M	GH 40~50...	GH 55~70...	GH 75~80...	GH 100~120...	
Carbon Steel	☆ 490~720	☆ 490~720	☆ 330~490	★ 260~590	-	-	-	-	① 0.0028~0.0079 ② 0.0028~0.0059 ③ MAX 0.039	① 0.0028~0.0079 ② 0.0028~0.0059 ③ MAX 0.039	① 0.0039~0.0098 ② 0.0039~0.0079 ③ MAX 0.059	① 0.0059~0.0118 ② 0.0059~0.0098 ③ MAX 0.079	
Alloy Steel	☆ 430~660	☆ 430~660	☆ 260~430	★ 260~520	-	-	-	-	① 0.0028~0.0071 ② 0.0028~0.0051 ③ MAX 0.039	① 0.0028~0.0071 ② 0.0028~0.0051 ③ MAX 0.039	① 0.0039~0.0091 ② 0.0039~0.0071 ③ MAX 0.059	① 0.0059~0.0106 ② 0.0059~0.0087 ③ MAX 0.079	
Stainless Steel	☆ 230~490	-	☆ 200~330	★ 200~430	-	-	-	-	① 0.0028~0.0063 ② 0.0028~0.0051 ③ MAX 0.039	① 0.0028~0.0063 ② 0.0028~0.0051 ③ MAX 0.039	① 0.0039~0.0083 ② 0.0039~0.0071 ③ MAX 0.059	① 0.0059~0.0098 ② 0.0059~0.0087 ③ MAX 0.079	
Cast Iron	-	-	-	-	★ 200~330	☆ 490~980	☆ 490~980	☆ 490~980	**KW10** ① 0.0028~0.0079 ② 0.0028~0.0059 ③ MAX 0.039 **A65 / A66N** ① 0.0012~0.0028 ② Traversing N/A ③ Traversing N/A	**KW10** ① 0.0028~0.0079 ② 0.0028~0.0059 ③ MAX 0.039 **A65 / A66N** ① 0.0012~0.0028 ② Traversing N/A ③ Traversing N/A	**KW10** ① 0.0039~0.0098 ② 0.0039~0.0079 ③ MAX 0.059 **A65 / A66N** ① 0.002~0.0035 ② Traversing N/A ③ Traversing N/A	**KW10** ① 0.0059~0.0118 ② 0.0059~0.0098 ③ MAX 0.079 **A65 / A66N** ① 0.002~0.0035 ② Traversing N/A ③ Traversing N/A	Wet
Aluminum	-	-	-	-	★ 490~1310	-	-	-	① 0.0028~0.0079 ② 0.0028~0.0059 ③ MAX 0.039	① 0.0028~0.0079 ② 0.0028~0.0059 ③ MAX 0.039	① 0.0039~0.0098 ② 0.0039~0.0079 ③ MAX 0.059	① 0.0059~0.0118 ② 0.0059~0.0098 ③ MAX 0.079	
Brass	-	-	-	-	★ 490~980	-	-	-	① 0.0028~0.0079 ② 0.0028~0.0059 ③ MAX 0.039	① 0.0028~0.0079 ② 0.0028~0.0059 ③ MAX 0.039	① 0.0039~0.0098 ② 0.0039~0.0079 ③ MAX 0.059	① 0.0059~0.0118 ② 0.0059~0.0098 ③ MAX 0.079	
Hardened Materials	-	-	-	-	-	☆ 130~260	☆ 130~260	☆ 130~260	① 0.0008~0.0020 ② 0.0004~0.0012 ③ MAX 0.004	① 0.0008~0.0020 ② 0.0004~0.0012 ③ MAX 0.008	① 0.0008~0.002 ② 0.0004~0.0016 ③ MAX 0.008	① - ② - ③ -	

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

★ : 1st Recommendation ☆ : 2nd Recommendation

GHU (Molded 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			CVD	PVD		Ceramic					
	TN60	TC40	TC60M	CR9025	PR630	PR930	A65	A66N	GHU 40~20	GHU 50~20	GHU 60~20	
Carbon Steel	☆ 430~660	-	-	☆ 260~590	-	-	-	-	① 0.0024~0.0047 ② 0.0020~0.0039 ③ MAX 0.039	① 0.0024~0.0047 ② 0.0020~0.0039 ③ MAX 0.039	① 0.0024~0.0059 ② 0.0020~0.0047 ③ MAX 0.059	
Alloy Steel	☆ 330~590	-	-	☆ 260~520	-	-	-	-	① 0.0024~0.0047 ② 0.0020~0.0039 ③ MAX 0.039	① 0.0024~0.0047 ② 0.0020~0.0039 ③ MAX 0.039	① 0.0024~0.0059 ② 0.0020~0.0047 ③ MAX 0.059	Wet
Stainless Steel	-	-	-	☆ 200~430	-	-	-	-	① 0.0024~0.0039 ② 0.0020~0.0031 ③ MAX 0.031	① 0.0024~0.0039 ② 0.0020~0.0031 ③ MAX 0.031	① 0.0024~0.0047 ② 0.0020~0.0039 ③ MAX 0.047	

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

★ : 1st Recommendation ☆ : 2nd Recommendation

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