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RECOMMENDED CUTTING CONDITIONS

GV (Ground Chipbreaker)

Workpiece Material	Recommended Insert Grade (Vc sfm)						① f (feed) during Grooving (ipr)						Notes
	Cermet			MEGA	PVD	Carbide	② f (feed) during Traversing (ipr)						
							③ D.O.C. during Traversing (in)						
	TN90	TC40	TC60M	PR1225	PR930	KW10	GV™ 100~300-...SS 100~300-...S	GV™ 145~185-...B	GV™ 200~280-...B	GV™ 300~400-...B			
							GV™ 100~340-...A 200~300-...AR		GV™ 200-100BR	GV™ 300-150BR	GV™ 280~300-...C	GV™ 340~400-...C	GV™ 430~500-...C
Carbon Steel	☆ 390~590	☆ 390~590	☆ 260~390	★ 260~520	☆ 260~460	-	① 0.0012~0.0031 ② 0.0012~0.0031 ③ MAX 0.012	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 0.0020~0.0047 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0016~0.0035 ② 0.0016~0.0035 ③ MAX 0.012	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 0.020	Wet
Alloy Steel	☆ 330~520	☆ 330~520	☆ 260~330	★ 260~460	☆ 260~390	-	① 0.0012~0.0028 ② 0.0012~0.0039 ③ MAX 0.012	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 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0016~0.0031 ② 0.0016~0.0031 ③ MAX 0.012	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 0.020	
Stainless Steel	☆ 230~430	-	☆ 200~330	★ 200~430	☆ 200~360	-	① 0.0012~0.0028 ② 0.0012~0.0039 ③ MAX 0.012	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 0.0020~0.0039 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0016~0.0031 ② 0.0016~0.0031 ③ MAX 0.012	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 0.020	
Cast Iron	-	-	-	-	-	★ 200~330	① 0.0012~0.0031 ② 0.0012~0.0031 ③ MAX 0.012	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 0.0020~0.0047 ② 0.0020~0.0039 ③ MAX 0.020	① 0.0016~0.0035 ② 0.0016~0.0035 ③ MAX 0.012	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 0.020	
Aluminum	-	-	-	-	-	★ 490~980	① 0.0020~0.0047 ② 0.0020~0.0047 ③ MAX 0.020	① 0.0020~0.0047 ② 0.0020~0.0047 ③ MAX 0.020	① 0.0020~0.0059 ② 0.0020~0.0059 ③ MAX 0.020	① 0.0031~0.0059 ② 0.0031~0.0059 ③ MAX 0.031	① 0.0020~0.0059 ② 0.0020~0.0059 ③ MAX 0.020	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	-	-	-	-	-	★ 330~820	① 0.0020~0.0047 ② 0.0020~0.0047 ③ MAX 0.020	① 0.0020~0.0047 ② 0.0020~0.0047 ③ MAX 0.020	① 0.0020~0.0059 ② 0.0020~0.0059 ③ MAX 0.020	① 0.0031~0.0059 ② 0.0031~0.0059 ③ MAX 0.031	① 0.0020~0.0059 ② 0.0020~0.0059 ③ MAX 0.020	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	

* Use MEGACOAT, PVD coated grade or carbide for turning with edge width 0.0394" (1mm) (GV™100SS/100S/100A)

★ : 1st Recommendation ☆ : 2nd Recommendation

GVF (Ground Chipbreaker)

Workpiece Material	Recommended Insert Grade (Vc sfm)							① f (feed) during Grooving (ipr)				Notes
	Cermet				MEGA	PVD	Carbide	② f (feed) during Traversing (ipr)				
								③ D.O.C. during Traversing (in)				
	TN60	TN90	TC40	TC60M	PR1225	PR930	KW10	GVF™ 200~340...A GVF™ 200-100AR ~300-150AR	GVF™ 250~350...B GVF™ 300-150BR	GVF™ 400~490...B GVF™ 400-200BR	GVF™ 350~450...C	GVF™ 500~600...C	
Carbon Steel	-	☆ 490~720	☆ 490~720	☆ 330~490	★ 260~660	☆ 260~590	-	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	Wet
Alloy Steel	-	☆ 430~660	☆ 430~660	☆ 260~430	★ 260~590	☆ 260~520	-	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	
Stainless Steel	-	☆ 230~490	-	☆ 200~330	★ 260~490	☆ 200~430	-	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	
Cast Iron	-	-	-	-	-	-	★ 200~330	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	
Aluminum	-	-	-	-	-	-	★ 490~1310	① 0.0020~0.0047 ② 0.0020~0.0047 ③ MAX 0.020	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	① 0.0020~0.0047 ② 0.0020~0.0047 ③ MAX 0.020	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	

- Apply a sufficient amount of coolant.
- The D.O.C. should be under 0.020" (0.5mm) if a good surface finish is required.

★ : 1st Recommendation ☆ : 2nd Recommendation

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