для заказа - kyocera@kyocera-tools.ru

FTK

	Recommended Insert Grade (Vc sfm)					Edge Width (in)		Notes
	Cermet	CVD	PVD		Carbide	0.1575	0.1969	
	TN90	**CR9025**	**PR660**	**PR930**	**KW10**	Feed Rate (ipr)		
Carbon Steel	☆ 390~660	★ 260~590	☆ 200~430	☆ 200~430	-	0.0020~0.0059	0.0020~0.0059	Wet
Alloy Steel	☆ 330~520	★ 230~490	☆ 200~430	☆ 200~430	-	0.0020~0.0059	0.0020~0.0059	
Stainless Steel	☆ 260~490	☆ 200~460	★ 160~390	☆ 160~390	-	0.0020~0.0059	0.0020~0.0059	
Cast Iron	-	-	-	-	★ 160~330	0.0039~0.0118	0.0039~0.0118	
Aluminum	-	-	-	-	★ 660~1480	0.0020~0.0098	0.0020~0.0098	
Brass	-	-	-	-	★ 330~660	0.0020~0.0098	0.0020~0.0098	

★ : 1st Recommendation ☆ : 2nd Recommendation

GMN (CBN / PCD)

Workpiece Material	Recommended Insert Grade (Vc sfm)		① f (feed) during Grooving (ipr)				Notes
	CBN	PCD	② f (feed) during Traversing (ipr)				
	KBN510 KBN525	**KPD001 (KPD010)**	③ D.O.C. during Traversing (in)				
			GMN 2	GMN 3	GMN 4 GMN 5	GMN 6	
Aluminum	-	★ 490~6560	① 0.0020~0.0059	① 0.0020~0.0059	① 0.0031~0.0071	① 0.0039~0.0079	Wet
			② 0.0020~0.0059	② 0.0020~0.0059	② 0.0031~0.0071	② 0.0039~0.0079	
			③ MAX 0.020	③ MAX 0.031	③ MAX 0.031	③ MAX 0.031	
Brass	-	★ 660~2620	① 0.0020~0.0059	① 0.0020~0.0059	① 0.0031~0.0071	① 0.0039~0.0079	
			② 0.0020~0.0059	② 0.0020~0.0059	② 0.0031~0.0071	② 0.0039~0.0079	
			③ MAX 0.020	③ MAX 0.031	③ MAX 0.031	③ MAX 0.031	
Cast Iron	★ 490~1310	-	① 0.0016~0.0035	① 0.0020~0.0039	① 0.0020~0.0047	① 0.0020~0.0059	
			② 0.0016~0.0035	② 0.0020~0.0039	② 0.0020~0.0047	② 0.0020~0.0059	
			③ MAX 0.012	③ MAX 0.020	③ MAX 0.020	③ MAX 0.031	
Hardened Materials	★ 260~390	-	① 0.0008~0.0020	① 0.0012~0.0028	① 0.0012~0.0031	① 0.0020~0.0039	
			② 0.0004~0.0012	② 0.0004~0.0020	② 0.0012~0.0031	② 0.0020~0.0039	
			③ MAX 0.004	③ MAX 0.008	③ MAX 0.012	③ MAX 0.016	

★ : 1st Recommendation ☆ : 2nd Recommendation

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