для заказа - kyocera@kyocera-tools.ru

GMG / GMM / GMN / GMGA

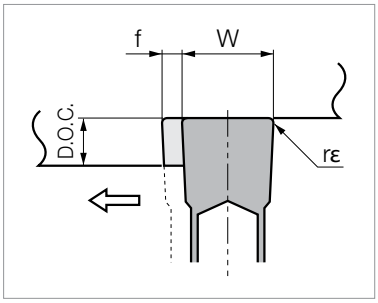
Workpiece Material	Recommended Insert Grade (Vc sfm)						Grooving				Traversing				Notes
	Cermet	CVD	PVD			Carbide	Edge Width (in)				Edge Width (in)				
	TN90	CR9025	PR915	PR930	PR905	KW10	0.0787~0.1181	0.1575	0.1969	0.2362/0.3150	0.0787~0.1181	0.1575	0.1969	0.2362/0.3150	
							Feed Rate (ipr)				Feed Rate (ipr)				
Carbon Steel	☆ 330~720	☆ 260~660	☆ 260~660	★ 260~660	-	-	0.0020~0.0059	0.0039~0.0098	0.0059~0.0138	0.0079~0.0138	0.0039~0.0079	0.0059~0.0118	0.0079~0.0157	0.0098~0.0157	Wet
Alloy Steel	☆ 260~660	☆ 230~590	☆ 230~590	★ 230~590	-	-	0.0020~0.0059	0.0039~0.0098	0.0059~0.0138	0.0079~0.0138	0.0039~0.0079	0.0059~0.0118	0.0079~0.0157	0.0098~0.0157	
Stainless Steel	☆ 230~520	☆ 200~490	★ 200~490	☆ 200~490	-	-	0.0020~0.0059	0.0039~0.0079	0.0059~0.0138	0.0079~0.0138	0.0039~0.0079	0.0059~0.0098	0.0079~0.0157	0.0098~0.0157	
Cast Iron	-	-	-	-	★ 330~660	☆ 230~490	0.0020~0.0079	0.0039~0.0118	0.0059~0.0157	0.0079~0.0157	0.0039~0.0098	0.0059~0.0138	0.0079~0.0177	0.0098~0.0177	
Aluminum	-	-	-	-	-	★ 660~1640	0.0020~0.0079	0.0031~0.0098	0.0039~0.0098	0.0047~0.0118	0.0039~0.0079	0.0039~0.0098	0.0039~0.0098	0.0059~0.0118	
Brass	-	-	-	-	-	★ 330~660	0.0020~0.0059	0.0031~0.0079	0.0039~0.0098	0.0047~0.0118	0.0039~0.0079	0.0039~0.0098	0.0039~0.0098	0.0059~0.0118	

★ : 1st Recommendation ☆ : 2nd Recommendation

Turning Conditions

① **KGM Toolholder**

	Recommended Cutting Conditions	
D.O.C.(MAX) (in)	Under 80% of Edge Width	D.O.C.≤0.0315w
f (MAX) (ipr)	Under 10% of Edge Width	f≤0.0039w



• (D.O.C.) x (f) should not exceed ½ of D.O.C.(MAX) x f(MAX)

Edge Width (in) / Load (in²)	0.0787~0.0984	0.1181	0.1575	0.1969	0.2362	0.3150
D.O.C. x Feed Rate (f)	~0.0079	~0.0142	~0.0252	~0.0394	~0.0567	~0.1008

• D.O.C. x f ≤ ½ x 0.0315w x 0.0039w = 0.0016w²

② **KGM-T Toolholder** (Deep Grooving)

Use KGM-T toolholder under 90% lower cutting conditions than the KGM Toolholder

③ **KGMM / KGMS / KFMS-8 Toolholder**

	Recommended Cutting Conditions	
D.O.C.(MAX) (in)	Under 50% of Edge Width	D.O.C.≤0.0197w
f (MAX) (ipr)	Under 4% of Edge Width	f≤0.0016w

• (D.O.C.) x (f) should not exceed ½ of D.O.C.(MAX) x f(MAX)

Edge Width (in) / Load (in²)	0.0787~0.0984	0.1181	0.1575	0.1969	0.2362	0.3150
D.O.C. x Feed Rate (f)	~0.0039	~0.0071	~0.0126	~0.0197	~0.0283	~0.0504

• D.O.C. x f ≤ 0.0008w²

④ **KIGM Toolholder**

	Recommended Cutting Conditions	
D.O.C.(MAX) (in)	Under 70% of Edge Width	D.O.C.≤0.0276w
f (MAX) (ipr)	Under 8% of Edge Width	f≤0.0031w

• (D.O.C.) x (f) should be as follows. (under 70% of KGM)

Edge Width (in) / Load (in²)	0.1181	0.1575	0.1969
D.O.C. x Feed Rate (f)	~0.0098	~0.0173	~0.0276

• D.O.C. x f ≤ 0.0016w²

GMG / GMM / GMGA 8030 (Face Grooving)

Workpiece Material	Recommended Insert Grade (Vc sfm)						Face Grooving	Traversing	Notes
	Cermet	CVD	PVD			Carbide	Edge Width (in)	Edge Width (in)	
	TN90	CR9025	PR915	PR930	PR905	KW10	0.3150	0.3150	
							Feed Rate (ipr)	Feed Rate (ipr)	
Carbon Steel	☆ 330~720	☆ 260~520	☆ 260~520	★ 260~520	-	-	0.0039~0.0079	0.0039~0.0098	Wet
Alloy Steel	☆ 260~520	☆ 230~520	☆ 230~520	★ 230~520	-	-	0.0039~0.0079	0.0039~0.0098	
Stainless Steel	☆ 230~460	☆ 200~430	★ 200~430	☆ 200~430	-	-	0.0039~0.0079	0.0039~0.0098	
Cast Iron	-	-	-	-	★ 260~590	☆ 230~430	0.0039~0.0118	0.0039~0.0138	
Aluminum	-	-	-	-	-	★ 660~980	0.0031~0.0098	0.0031~0.0118	
Brass	-	-	-	-	-	★ 330~490	0.0031~0.0098	0.0031~0.0118	

★ : 1st Recommendation ☆ : 2nd Recommendation