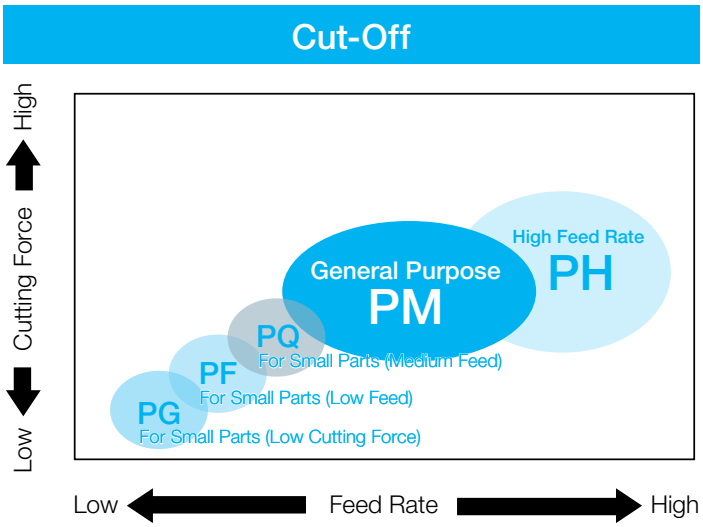
для заказа - kyocera@kyocera-tools.ru

Application Map



Recommended Cutting Conditions (PF / PQ / PG Chipbreakers)

Workpiece Material	Recommended Insert Grade (Vc sfm)			Feed Rate (ipr)						Notes
				PF(rε=0.0012)			PF (rε=0.0059)			
	MEGACOAT NANO	MEGACOAT		Edge Width			Edge Width			
	PR1535	PR1225	PR1225	0.051"~0.059" (1.3mm~1.5mm)	0.079" (2.0mm)	0.098"~0.118" (2.5mm~3.0mm)	0.059" (1.5mm)	0.079" (2.0mm)	0.098"~0.118" (2.5mm~3.0mm)	
Carbon Steel	☆ 230~490	★ 230~490	☆ 230~590	0.0004~0.0016	0.0008~0.0024	0.0008~0.0031	0.0004~0.0020	0.0012~0.0031	0.0016~0.0039	Wet
Alloy Steel	☆ 230~490	★ 230~490	☆ 230~590							
Stainless Steel	★ 200~390	☆ 200~390	☆ 200~490	0.0004~0.0012	0.0004~0.0016	0.0004~0.0020	0.0004~0.0016	0.0012~0.0028	0.0016~0.0031	
Cast Iron	-	-	★ 260~660	0.0004~0.0020	0.0008~0.0028	0.0012~0.0031	0.0004~0.0024	0.0012~0.0035	0.0016~0.0039	

★ : 1st Recommendation ☆ : 2nd Recommendation

Workpiece Material	Recommended Insert Grade (Vc sfm)					Feed Rate (ipr)				Notes
						PQ		PG		
	MEGACOAT NANO	MEGACOAT		DLC	Carbide	Edge Width		Edge Width		
	PR1535	PR1225	PR1225	PDL025	GW15	0.079" (2.0mm)	0.098"~0.118" (2.5mm~3.0mm)	0.079" (2.0mm)	0.098"~0.118" (2.5mm~3.0mm)	
Carbon Steel	☆ 225~500	★ 225~500	☆ 225~600	-	-	0.0012~0.0039	0.0016~0.0047	0.0004~0.0016	0.0004~0.0020	Wet
Alloy Steel	☆ 225~500	★ 225~500	☆ 225~600	-	-					
Stainless Steel	★ 200~400	☆ 200~400	☆ 200~500	-	-	0.0008~0.0028	0.0008~0.0031	0.0004~0.0012	0.0004~0.0016	
Cast Iron	-	-	★ 250~650	-	☆ 150~325	0.0016~0.0039	0.0016~0.0047	0.0004~0.0016	0.0004~0.0020	
Aluminum		-	-	★ 660~1640	☆ 650~1475	-	-	0.0004~0.0020	0.0004~0.0024	
Brass		-	-	-	★ 325~650	-	-	0.0004~0.0028	0.0004~0.0031	

★ : 1st Recommendation ☆ : 2nd Recommendation

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