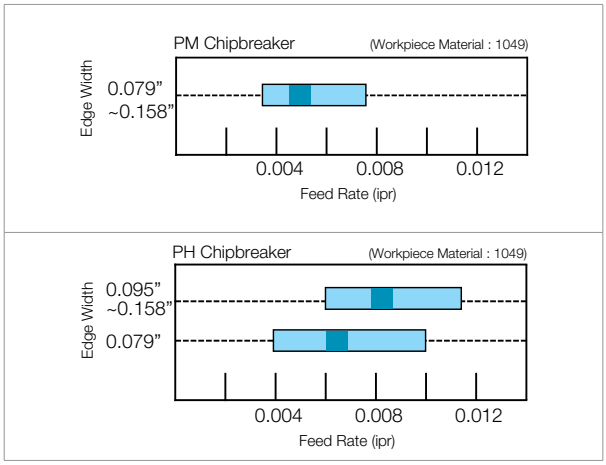
для заказа - kyocera@kyocera-tools.ru

Recommended Cutting Conditions (PM / PH Chipbreakers)

Workpiece Material	Recommended Insert Grade (Vc sfm)			Feed Rate (ipr)			Remarks
				PM	PH		
	MEGACOAT NANO	MEGACOAT		Edge Width	Edge Width		
	PR1535	PR1225	PR1215	0.079"~0.158" (2mm~4mm)	0.079" (2mm)	0.095"~0.158" (3mm~4mm)	
Carbon Steel	☆ 260~660	★ 260~660	☆ 330~660	0.0031~0.0071	0.0039~0.0098	0.0059~0.0110	Wet
Alloy Steel	☆ 230~590	★ 230~590	☆ 260~590				
Stainless Steel	★ 200~490	☆ 200~490	☆ 200~490	0.0024~0.0047	0.0020~0.0047	0.0031~0.0059	
Cast Iron	-	-	★ 330~660	0.0031~0.0071	0.0039~0.0098	0.0059~0.0110	

★ : 1st Recommendation ☆ : 2nd Recommendation

Feed Examples



■ : Indicates the center value of feed (f)

CAUTION During Cut-Off

1) Flood coolant is recommended. Apply enough coolant to the cutting edge

2) Keep spindle revolution constant during processing to achieve longer tool life

3) Cut off as close to the chuck as possible

4) Reduce feed rate by 30-50% when diameter is same as cut-off insert width to prevent impact

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