для заказа - kyocera@kyocera-tools.ru

KTN / KTNS

Workpiece Material	Recommended Insert Grade (Vc sfm)		
	Cermet	PVD Coated Carbide	Carbide
	TC60	**PR1115**	**GW15**
Carbon Steel	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	-
Alloy Steel	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	-
Stainless Steel	☆ 200-260	★ 200-260	-
Initial D.O.C. (Radial)	0.0098" or less	0.0098" or less	-
Cast Iron	-	-	★ 330
Initial D.O.C. (Radial)	-	-	0.0118" or less
Aluminum	-	-	★ 490~1310
Initial D.O.C. (Radial)	-	-	0.0118" or less
Brass	-	-	★ 490~980
Initial D.O.C. (Radial)	-	-	0.0118" or less

SIN / CIN

Workpiece Material	Recommended Insert Grade (Vc sfm)		
	Cermet	PVD Coated Carbide	Carbide
	TC60	**PR1115**	**GW15**
Carbon Steel	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	-
Alloy Steel	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	-
Stainless Steel	☆ 200-260	★ 200-260	-
Initial D.O.C. (Radial)	0.0098" or less	0.0098" or less	-
Cast Iron	-	-	★ 330
Initial D.O.C. (Radial)	-	-	0.0118" or less
Aluminum	-	-	★ 490~1310
Initial D.O.C. (Radial)	-	-	0.0118" or less
Brass	-	-	★ 490~980
Initial D.O.C. (Radial)	-	-	0.0118" or less

- For 06IR/08IR, we recommend 40% lower sfm.

KTT

Workpiece Material	Recommended Insert Grade (Vc sfm)			
	Cermet	PVD Coated Carbide		Carbide
	TC60	**PR930**	**PR1115**	**KW10**
Carbon Steel	☆ 330-490	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	0.0118" or less	-
Alloy Steel	☆ 330-490	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	0.0118" or less	-
Stainless Steel	☆ 200-260	☆ 200-260	★ 200-260	-
Initial D.O.C. (Radial)	0.0098" or less	0.0098" or less	0.0098" or less	-
Cast Iron	-	-	-	★ 330
Initial D.O.C. (Radial)	-	-	-	0.0118" or less
Aluminum	-	-	-	★ 150~400
Initial D.O.C. (Radial)	-	-	-	0.0118" or less
Brass	-	-	-	★ 150~300
Initial D.O.C. (Radial)	-	-	-	0.0118" or less

S...STWP (-E)

Workpiece Material	Recommended Insert Grade (Vc sfm)			
	Cermet	PVD Coated Carbide		Carbide
	TN6020	**TN60**	**PV7020**	**KW10**
Carbon Steel	☆ 330-490	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0098" or less	0.0098" or less	0.0098" or less	-
Alloy Steel	☆ 330-490	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0098" or less	0.0098" or less	0.0098" or less	-
Stainless Steel	-	-	-	-
Initial D.O.C. (Radial)	-	-	-	-
Cast Iron	-	-	-	★ 330
Initial D.O.C. (Radial)	-	-	-	0.0098" or less
Aluminum	-	-	-	★ 150~400
Initial D.O.C. (Radial)	-	-	-	0.0098" or less
Brass	-	-	-	★ 150~300
Initial D.O.C. (Radial)	-	-	-	0.0098" or less

KTTX / S-KTTX

Workpiece Material	Recommended Insert Grade (Vc sfm)			
	Cermet	PVD Coated Carbide		Carbide
	TC60	**PR930**	**PR1115**	**GW15**
Carbon Steel	☆ 330-490	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	0.0118" or less	-
Alloy Steel	☆ 330-490	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	0.0118" or less	-
Stainless Steel	☆ 200-260	☆ 200-260	★ 200-260	-
Initial D.O.C. (Radial)	0.0098" or less	0.0098" or less	0.0098" or less	-
Cast Iron	-	-	-	★ 330
Initial D.O.C. (Radial)	-	-	-	0.0118" or less
Aluminum	-	-	-	★ 150~400
Initial D.O.C. (Radial)	-	-	-	0.0118" or less
Brass	-	-	-	★ 150~300
Initial D.O.C. (Radial)	-	-	-	0.0118" or less

KITG

Workpiece Material	Recommended Insert Grade (Vc sfm)			
	Cermet	PVD Coated Carbide		Carbide
	TC60	**PR930**	**PR1115**	**GW15**
Carbon Steel	☆ 330-490	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	0.0118" or less	-
Alloy Steel	☆ 330-490	☆ 330-490	★ 330-490	-
Initial D.O.C. (Radial)	0.0118" or less	0.0118" or less	0.0118" or less	-
Stainless Steel	☆ 200-260	☆ 200-260	★ 200-260	-
Initial D.O.C. (Radial)	0.0098" or less	0.0098" or less	0.0098" or less	-
Cast Iron	-	-	-	★ 330
Initial D.O.C. (Radial)	-	-	-	0.0118" or less
Aluminum	-	-	-	★ 150~400
Initial D.O.C. (Radial)	-	-	-	0.0118" or less
Brass	-	-	-	★ 150~300
Initial D.O.C. (Radial)	-	-	-	0.0118" or less

★ : 1st Recommendation ☆ : 2nd Recommendation

- Coolant is recommended.
- When using cermet inserts if edge chipping occurs lightly hone cutting edge with diamond file.
- For stainless steel threading, please set smaller intial D.O.C. and two or three more passes than threading for carbon steel.

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