

Recommended Cutting Conditions

Recommended Cutting Conditions - Boring (Positive Insert: Cutting Dia over 10mm) [ap indicates radius]

ISO Classification	Workpiece Material	Hardness	Cutting Range	Application	Recommended Chipbreaker	Recommended Grade	Corner R (rε)	Lower Limit - Recommendation - Upper Limit		
								Vc(m/min)	ap(mm)	f(mm/rev)
* P	Low-carbon Steel Low-carbon Alloy	HB ≤ 300	Precision Cutting	Continuous Interruption	FSF, USF	TN6020 PR1025	0.1 0.2	250 - 300 - 350 100 - 150 - 200	0.05 - 0.3 - 0.5 0.05 - 0.3 - 0.5	0.03 - 0.1 - 0.15 0.03 - 0.1 - 0.15
			Finishing	Continuous Interruption	XP	PV7010 CA5525	0.4 0.4	200 - 250 - 300 150 - 200 - 250	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Finishing-Medium	Continuous Interruption	XQ	PV7010 CA5525	0.4 0.4	150 - 200 - 250 100 - 150 - 200	0.5 - 1.0 - 2.0 0.5 - 1.0 - 1.5	0.1 - 0.15 - 0.25 0.1 - 0.15 - 0.2
			Medium cutting	Continuous Interruption	Standard	PV7020 CA5525	0.8 0.8	100 - 150 - 200 80 - 120 - 150	1.0 - 1.5 - 2.5 1.0 - 1.5 - 2.0	0.1 - 0.15 - 0.3 0.1 - 0.15 - 0.2
	Medium-carbon Steel Medium-carbon Alloy	HB ≤ 300	Precision Cutting	Continuous Interruption	FSF, USF	TN6020 PR1025	0.2 0.4	150 - 200 - 250 100 - 120 - 150	0.05 - 0.3 - 0.5 0.05 - 0.3 - 0.5	0.03 - 0.1 - 0.15 0.03 - 0.1 - 0.15
			Finishing	Continuous Interruption	GP	PV7010 CA5525	0.4 0.4	150 - 200 - 250 120 - 180 - 200	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Finishing-Medium	Continuous Interruption	HQ	PV7010 CA5525	0.4 0.4	120 - 180 - 220 100 - 150 - 200	0.5 - 1.0 - 2.0 0.5 - 1.0 - 1.5	0.1 - 0.15 - 0.25 0.1 - 0.15 - 0.2
			Medium cutting	Continuous Interruption	Standard	PV7020 CA5525	0.8 0.8	100 - 150 - 200 80 - 120 - 150	1.0 - 1.5 - 2.5 1.0 - 1.5 - 2.0	0.1 - 0.15 - 0.3 0.1 - 0.15 - 0.2
	High-carbon Alloy	HB ≤ 280	Precision Cutting	Continuous Interruption	FSF, USF	TN6020 PR1025	0.2 0.4	120 - 150 - 180 100 - 120 - 150	0.05 - 0.3 - 0.5 0.05 - 0.3 - 0.5	0.03 - 0.1 - 0.15 0.03 - 0.1 - 0.15
			Finishing	Continuous Interruption	GP	PV7010 CA5525	0.4 0.4	120 - 150 - 180 100 - 120 - 150	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Finishing-Medium	Continuous Interruption	HQ	PV7010 CA5525	0.4 0.4	120 - 150 - 180 100 - 120 - 150	0.5 - 1.0 - 2.0 0.5 - 1.0 - 1.5	0.1 - 0.15 - 0.25 0.1 - 0.15 - 0.2
			Medium cutting	Continuous Interruption	Standard	CA5515 CA5525	0.8 0.8	100 - 120 - 150 80 - 100 - 120	1.0 - 1.5 - 2.5 1.0 - 1.5 - 2.0	0.1 - 0.15 - 0.3 0.1 - 0.15 - 0.2
	Stainless Steel	HB ≤ 220	Finishing	Continuous Interruption	MQ	CA6525	0.4 0.8	120 - 150 - 180 100 - 120 - 150	0.2 - 0.5 - 0.8 0.2 - 0.5 - 0.8	0.05 - 0.08 - 0.1 0.05 - 0.08 - 0.1
			Medium cutting	Continuous Interruption	Standard	CA6525	0.4 0.8	120 - 150 - 180 100 - 120 - 150	0.5 - 1.0 - 1.5 0.5 - 1.0 - 1.5	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
		HB ≤ 300	Finishing	Continuous Interruption	MQ	CA6525	0.4 0.8	80 - 100 - 120 60 - 80 - 100	0.2 - 0.7 - 1.0 0.2 - 0.7 - 1.0	0.05 - 0.1 - 0.15 0.05 - 0.1 - 0.15
			Medium cutting	Continuous Interruption	Standard	CA6525	0.4 0.8	80 - 100 - 120 60 - 80 - 100	0.5 - 1.0 - 1.5 0.5 - 1.0 - 1.5	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
K	Gray Cast Iron	HB ≤ 250	High Speed Cutting	Continuous Interruption	Without Chipbreaker	KBN60M PT600M	0.4 0.8	400 - 500 - 600 200 - 250 - 350	0.05 - 0.2 - 0.5 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.15 0.05 - 0.1 - 0.15
			Finishing (Gloss Oriented)	Continuous Interruption	Standard	PV7005 TN6020	0.8 0.8	200 - 250 - 300 100 - 150 - 200	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Finishing	Continuous Interruption	Standard	CA4010	0.4 0.8	150 - 180 - 200 100 - 150 - 180	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Medium cutting	Continuous Interruption	Conventional Without Chipbreaker	CA4010	0.8 0.8	100 - 150 - 200 80 - 120 - 150	0.5 - 1.0 - 2.0 0.5 - 1.0 - 2.0	0.1 - 0.15 - 0.2 0.05 - 0.1 - 0.15
	Nodular Cast Iron	HB ≤ 270	High Speed Cutting	Continuous Interruption	Without Chipbreaker	KBN60M PT600M	0.4 0.8	200 - 300 - 400 150 - 200 - 250	0.05 - 0.2 - 0.5 0.2 - 0.5 - 1.0	0.03 - 0.05 - 0.1 0.05 - 0.1 - 0.15
			Finishing (Gloss Oriented)	Continuous Interruption	Standard	PV7005 TN6020	0.8 0.8	150 - 200 - 250 100 - 120 - 150	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Finishing	Continuous Interruption	Standard	CA4115 CA4120	0.4 0.8	120 - 150 - 180 100 - 120 - 150	0.2 - 0.5 - 1.0 0.2 - 0.5 - 1.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.2
			Medium cutting	Continuous Interruption	Standard	CA4115 CA4120	0.8 0.8	100 - 120 - 150 80 - 100 - 120	0.5 - 1.0 - 2.0 0.5 - 1.0 - 2.0	0.05 - 0.1 - 0.2 0.05 - 0.1 - 0.15
N	Non-ferrous Metals	HB ≤ 100	High Speed Cutting (Rainbow Surface Gross)	Continuous	Without Chipbreaker	KPD001	0.2	200 - 400-1000	0.05 - 0.1 - 0.3	0.05 - 0.1 - 0.15
			Finishing	Continuous Interruption	FSF, USF	KW10	0.4 0.4	100 - 200 - 400 100 - 200 - 400	0.05 - 0.5 - 1.0 0.05 - 0.5 - 1.0	0.03 - 0.1 - 0.2 0.03 - 0.1 - 0.2
S	Titanium Alloy	HB ≤ 400	Precision Cutting (Rainbow Surface Gross)	Continuous Interruption	Without Chipbreaker	KPD001	0.2 0.4	100 - 120 - 150 70 - 100 - 120	0.05 - 0.1 - 0.3 0.05 - 0.1 - 0.3	0.03 - 0.07 - 0.1 0.03 - 0.07 - 0.1
			Finishing	Continuous Interruption	F, U	KW10	0.2 0.4	30 - 50 - 70 30 - 50 - 70	0.05 - 0.5 - 1.0 0.05 - 0.5 - 1.0	0.03 - 0.1 - 0.2 0.03 - 0.1 - 0.2
	Heat-resistant Alloys	HB ≤ 350	Finishing	Continuous Interruption	F, U	KW10	0.4 0.4	10 - 30 - 50 10 - 30 - 50	0.05 - 0.5 - 1.0 0.05 - 0.5 - 1.0	0.03 - 0.1 - 0.2 0.03 - 0.1 - 0.2
			Finishing	Continuous Interruption	MQ	CA6525	0.4 0.8	40 - 60 - 80 40 - 60 - 80	0.1 - 0.3 - 0.5 0.1 - 0.3 - 0.5	0.03 - 0.05 - 0.1 0.03 - 0.05 - 0.1
H	Hard Materials	40 ~ 50 HRC	Finishing	Continuous Interruption	HQ Without Chipbreaker	CA5515	0.8 0.8	60 - 80 - 100 30 - 50 - 70	0.05 - 0.3 - 0.5 0.05 - 0.3 - 0.5	0.05 - 0.08 - 0.1 0.05 - 0.08 - 0.1
		45 ~ 68 HRC	Finishing	Continuous Interruption	Without Chipbreaker SET, MET	KBN10M KBN25M	0.4 0.8	80 - 120 - 150 60 - 100 - 120	0.1 - 0.2 - 0.3 0.1 - 0.2 - 0.3	0.02 - 0.07 - 0.1 0.02 - 0.07 - 0.1
			Medium cutting	Continuous	Without Chipbreaker (Negative)	KBN900	0.8	60 - 80 - 100	0.3 - 0.7 - 1.0	0.03 - 0.1 - 0.15

* When machining free-cutting steel such as 11SMn (SUM), please use PR1005 for Vc=200m/min or under and use PV7020 / CA5515, etc. for Vc=200m/min or over.