

Recommended Cutting Conditions

Recommended Cutting Conditions (In case of using GMM-MT, GMM-TK, GMM-NB insert)

Workpiece Material	Recommended Insert Grade (Vc: m/min)					Dimension (mm)					Remarks
	Cermet	CVD Coated Carbide	PVD Coated Carbide		Carbide	1.5	2.0 / 2.5	3.0	4.0		
	-	CR9025	PR915	PR930	KW10	f (mm/rev)					
Carbon Steel	-	☆ 80~180	★ 60~150	☆ 60~130		0.01~0.04	0.02~0.15	0.03~0.20	0.08~0.30		Coolant
Alloy Steel	-	☆ 70~150	★ 60~150	☆ 60~130		0.01~0.04	0.02~0.15	0.03~0.20	0.08~0.30		
Stainless Steel	-	☆ 60~140	★ 50~140	☆ 50~120		0.01~0.03	0.02~0.10	0.03~0.15	0.08~0.25		
Cast Iron	-	-	-	-	★ 50~100	0.01~0.05	0.05~0.12	0.10~0.25	0.10~0.30		
Non-ferrous Metals	-	-	-	-	★ 200~450	0.01~0.05	0.05~0.10	0.05~0.20	0.05~0.25		

• When machining Steel and Stainless Steel by 4mm width Insert of PR930, decrease the Feed Rate by 20%.

★ : 1st Recommendation ☆ : 2nd Recommendation

Recommended Cutting Conditions (TKN, TK^{FL} type Insert)

Workpiece Material	Recommended Insert Grade (Vc: m/min)					Dimension (mm)					Remarks
	Cermet	CVD Coated Carbide	PVD Coated Carbide		Carbide	1.6	2.2 / 2.4	3.1	4.1	4.8~9.6	
	TN90	CR9025	PR660	PR930	KW10	f (mm/rev)					
Carbon Steel	☆ 120~200	★ 80~180	☆ 60~130	☆ 60~130		0.02~0.08	0.04~0.18	0.05~0.25	0.08~0.30	0.15~0.40	Coolant
Alloy Steel	☆ 100~160	★ 70~150	☆ 60~130	☆ 60~130		0.02~0.08	0.04~0.18	0.05~0.25	0.08~0.30	0.15~0.40	
Stainless Steel	☆ 80~150	☆ 60~40	★ 50~120	☆ 60~140		0.02~0.06	0.04~0.12	0.05~0.18	0.08~0.25	0.10~0.30	
Cast Iron	-	-	-	-	★ 50~100	0.02~0.08	0.05~0.12	0.10~0.25	0.10~0.30	0.15~0.35	
Non-ferrous Metals	-	-	-	-	★ 100~450	0.02~0.10	0.05~0.10	0.05~0.20	0.05~0.25	0.10~0.25	

★ : 1st Recommendation ☆ : 2nd Recommendation

Recommended Cutting Conditions (In case of using GMM-TMR type Insert)

Workpiece Material	Vc (m/min)	f (mm/rev)
Carbon Steel	60~200	0.08~0.18
Alloy Steel	60~150	
Stainless Steel	50~140	

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Cut-off