

Technical Information

Troubleshooting

Countermeasures <	
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*1) The lower feed rate may be suitable.

*2) When the roughing was done with an insert without wave profile peripheral cutting edge.

Case Studies

9SMnPb28 (SUM24L)

- OA Parts
- Vc = 88m/min (n=3,500min⁻¹)
- ap=0.5mm
- fz=0.23mm/t (Vf=3200 mm/min)
- Wet
- 4FESM080-190-08

MEGACOAT	230pcs/edge
Competitor Coating E	100pcs/edge

• In addition to that Kyocera processed 2.3 times more workpieces than Competitor E, there was no edge fracturing and the cutting surface was finished finely.

MEGACOAT
(Tool life: 230 pcs/edge)

Competitor Coating E
(Tool life: 100 pcs/edge)

(Evaluation by the user)

20Cr4 (SCr420)

- Automotive Parts
- Vc = 40m/min (n=3,200min⁻¹)
- ap=0.1mm
- fz=0.01mm/t (Vf=70 mm/min)
- Wet
- 2FESM040-110-06

MEGACOAT	700pcs /edge
Competitor Coating F	350pcs/edge

• Kyocera processed twice as many workpieces compared to Competitor F.
• Competitor F is limited to 350 workpieces due to excessive wear. Kyocera prevented chipping thereby enabling long-life and stabilized machining.

MEGACOAT
(Tool life: 700 pcs/edge)

Competitor Coating F
(Tool life: 350 pcs/edge)

(Evaluation by the user)