

◆ Cutting Performance at Shouldering (Extending front piece of $\varnothing 40 / \varnothing 50$)

Cutting Conditions		
Cutting Dia.: $\varnothing 40$ Workpiece Material: C50 (S50C) Insert: With notch NDMM12T308ER-N2 / N3 (PR660)		
Combination	Cutting Speed	Vc=70~120m/min
	ap	
Combination	Cutting Speed	Vc=70~120m/min
	ap	

Cutting Conditions		
Cutting Dia.: $\varnothing 50$ Workpiece Material: C50 (S50C) Insert: With notch NDMM12T308ER-N2 / N3 (PR660)		
Combination	Cutting Speed	Vc=70~120m/min
	ap	
Combination	Cutting Speed	Vc=70~120m/min (Limit ae=15mm) Vc=60~90m/min (In case of ae=15~20mm)
	ap	
Combination	Cutting Speed	Vc=70~120m/min
	ap	
Combination	Cutting Speed	Vc=70~120m/min
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