

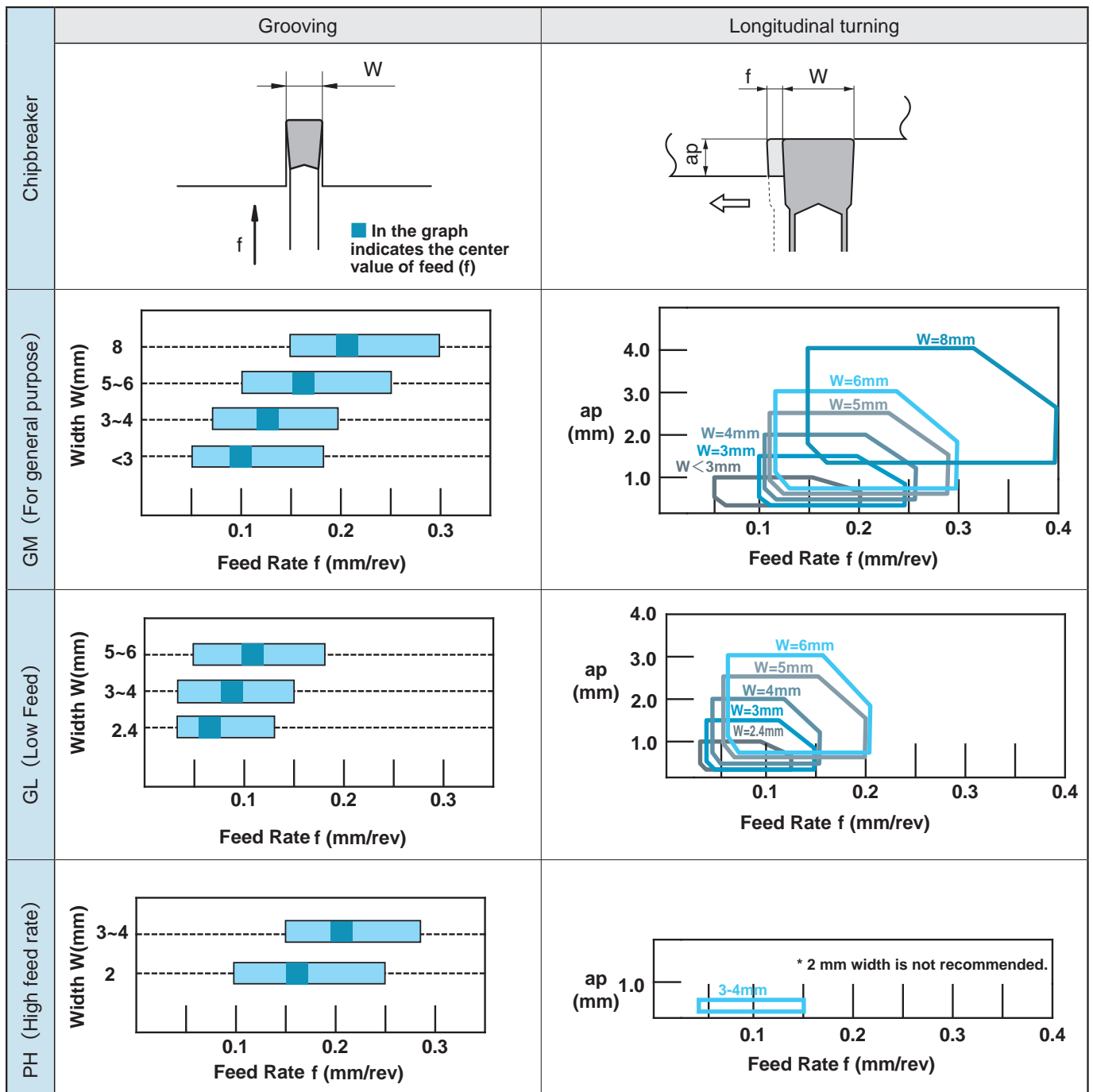
Recommended Cutting Conditions

Recommended Cutting Conditions (Vc)

Workpiece Material	Chipbreaker	Recommended Insert Grade (Vc :m/min)				Remarks
		Cermet	MEGACOAT		Carbide	
		TN90	PR1225	PR1215	GW15	
Carbon Steel (SxxC etc.)	GM	☆ 100~220	★ 80 ~ 200	☆ 100 ~ 200	-	Coolant
Alloy Steel (SCM etc.)	GL	☆ 80 ~ 200	★ 70 ~ 180	☆ 80 ~ 180	-	
Stainless Steel (SUS304 etc.)	CM	☆ 70 ~ 180	★ 60 ~ 150	☆ 60 ~ 150	-	
Cast Iron (FC/FCD etc.)	PH	-	-	★ 100 ~ 200	-	
Aluminum	GS	-	-	-	★ 200 ~ 500	
Brass	PM	-	-	-	★ 100 ~ 200	

Recommended Cutting Conditions (Feed Rate / ap) ★ : 1st Recommendation ☆ : 2nd Recommendation

(Workpiece Material : S50C)



- 1) The above values are based on the condition that the dimension T of toolholder is 17 mm or less.
- 2) If the toolholder is not for the 8 mm width insert and its dimension T is over 17 mm, set the values for Longitudinal turning to less than 90% of those above.

