

# Recommended Cutting Conditions

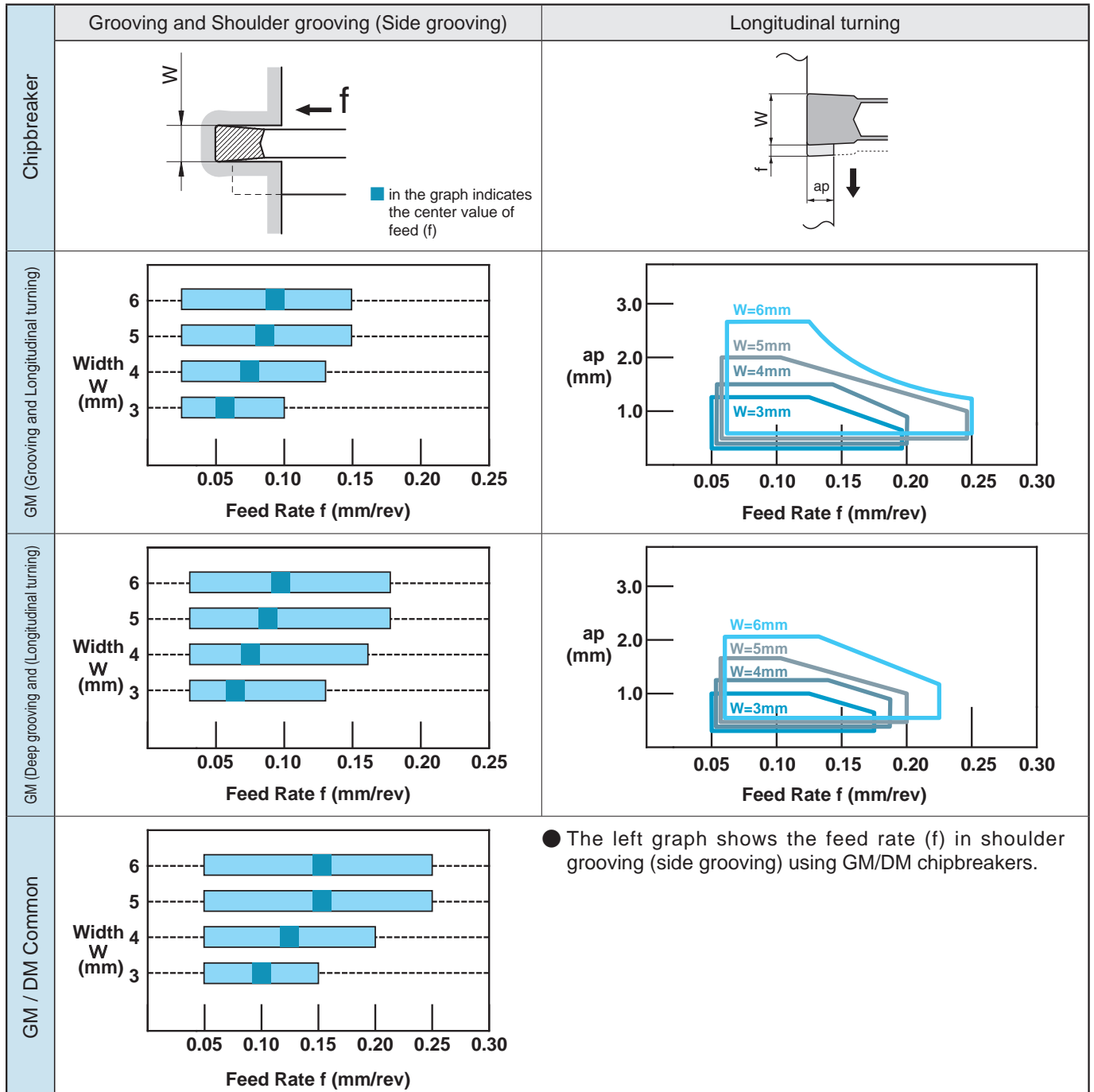
## Recommended Cutting Conditions (Vc)

Workpiece Material	Recommended Grade (Vc : m/min)			Remarks
	Cermet	MEGACOAT		
	TN90	PR1225	PR1215	
Carbon Steel (SxxC etc.)	☆ 80~200	★ 60~160	☆ 80~160	Coolant
Alloy Steel (SCM etc.)	☆ 70~160	★ 60~150	☆ 60~150	
Stainless Steel (SUS304 etc.)	☆ 60~150	★ 50~120	☆ 50~120	
Cast Iron (FC/FCD etc.)	-	-	★ 80~160	

★ : 1st Recommendation ☆ : 2nd Recommendation

## Recommended Cutting Conditions (Feed Rate / ap)

(Workpiece Material: S50C)



- 1) The above values are based on the condition that the dimension T of toolholder is 15 mm or less.
- 2) If the toolholder's dimension T is over 15 mm, set the values for longitudinal turning to less than 90% of those above.