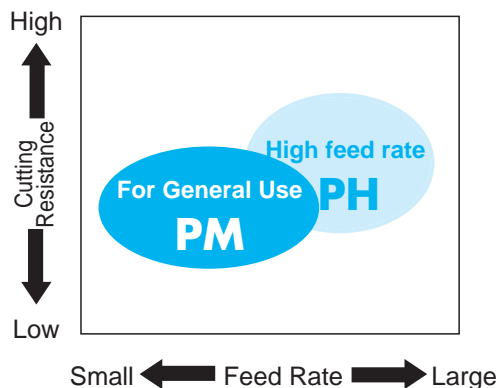
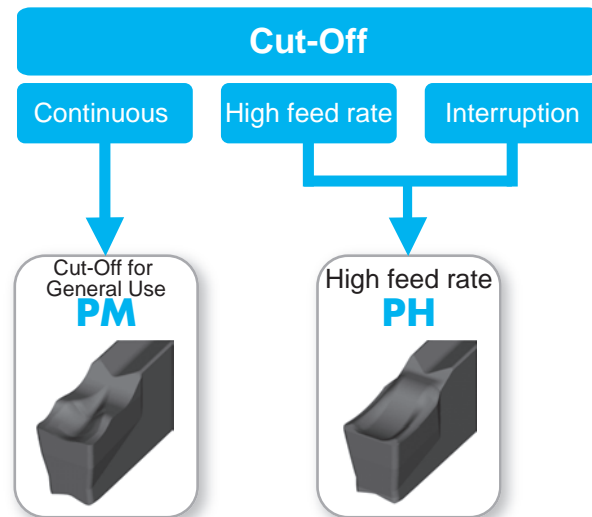


● Application Map

Cut-Off



● Chipbreaker Selection



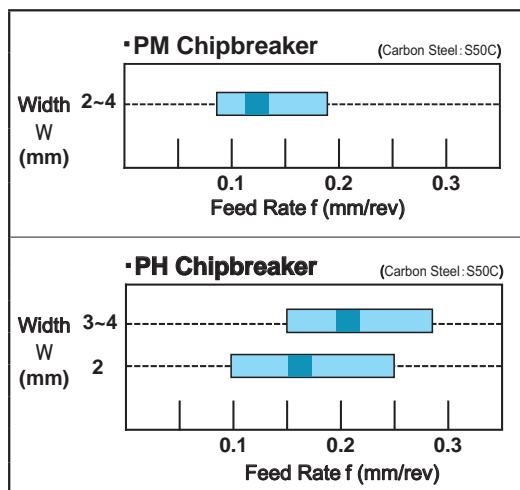
● Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Vc: m/min)		Feed Rate (mm/rev)			Remarks
	MEGACOAT		PM-Chipbreaker	PH-Chipbreaker		
	PR1225	PR1215	Width W (mm)	Width W (mm)		
Carbon Steel (SxxC)	★ 80~200	☆ 100~200	0.08~0.18	0.10~0.25	0.15~0.28	Coolant
Alloy Steel (SCM)	★ 70~180	☆ 80~180				
Stainless Steel (SUS304)	★ 60~150	☆ 60~150	0.06~0.12	0.05~0.12	0.08~0.15	
Cast Iron (FC, FCD)	-	★ 100~200	0.08~0.18	0.10~0.25	0.15~0.28	

★:1st Recommendation ☆:2nd Recommendation

◆ Example of feed

[■] in the graph indicates the center value of feed (f)



◆ Caution (Cut-Off)

1. Be sure to perform wet processing. Apply enough coolant to the cutting edge.
2. Keep a constant rate during processing so that optimal product life will be achieved.
3. Cut off as close to the chuck as possible.
4. Lower the feed rate to 1/2 to 1/3 at the near center to prevent impact caused by cutting.

■ Case Studies (Cut-Off)

C45 (S45CF)		<Result> ·The cutting edge of KGD Cut-off PM Chipbreaker (PR1225) shows good condition even after processing the same number of workpiece as Competitor L. ·Longer product life can be expected. (Competitor L suffered from chipping of cutting blade). (Evaluation by the user)
·Sleeve ·Vc=103 m/min ·f=0.12 mm/rev ·WET ·GDM3020N-025PM (PR1225) ·KGD L2525X-3T20S		
PM Chipbreaker (PR1225) 250 pcs/edge Can be extended		
Competitor L (PVD Coated Carbide) 250 pcs/edge Chipping occurred		

