

Recommended Cutting Conditions

■ Cutting Speed

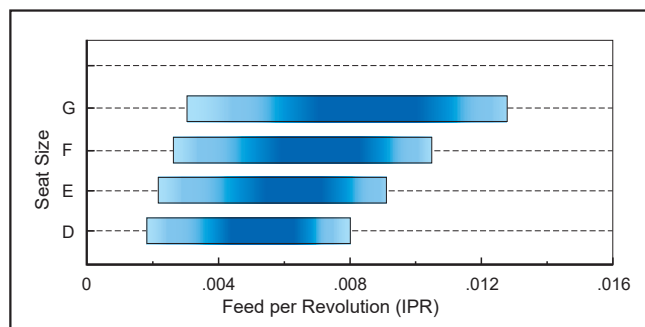
	Work Material	Properties	Grade	Cutting Speed vc (SFM)					
				165	330	490	655	820	985
P	Mild Steels	Hardness ≤160HB	VP20RT		330		785		
			VP10RT		360		820		
	Carbon Steels Alloy Steels	Hardness 160—280HB	VP20RT		260		655		
			VP10RT		295		690		
			VP30RT	195		590			
			MY5015		360		820		
		Hardness ≥280HB	VP20RT	195		525			
			VP10RT		230		560		
			VP30RT	130		460			
			MY5015		295		690		
M	Stainless Steels	Hardness ≤270HB	VP20RT		195		590		
			VP10RT		230		620		
			VP30RT	130		525			
K	Gray Cast Irons	Tensile Strength ≤300MPa	VP20RT		260		655		
			VP10RT		295		690		
			MY5015			460		985	
	Ductile Cast Irons	Tensile Strength ≤800MPa	VP20RT		195		525		
			VP10RT		230		560		
			MY5015			295		690	
S	Heat Resistant Alloys Titanium Alloys	—	VP20RT	100 195					
			VP10RT	130 230					

Note 1) VP20RT is the first recommended grade for materials.

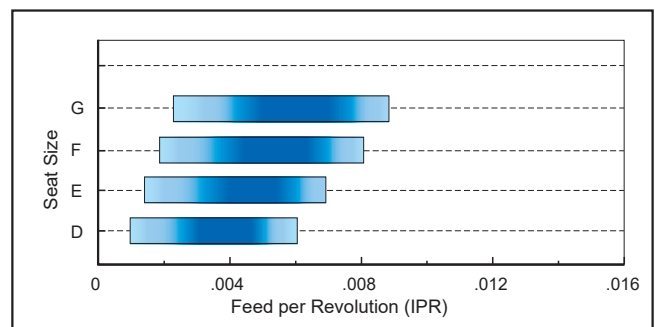
Note 2) For VP10RT, VP20RT, VP30RT and MY5015, wet cutting is recommended.

■ Feed per Revolution

GM Breaker



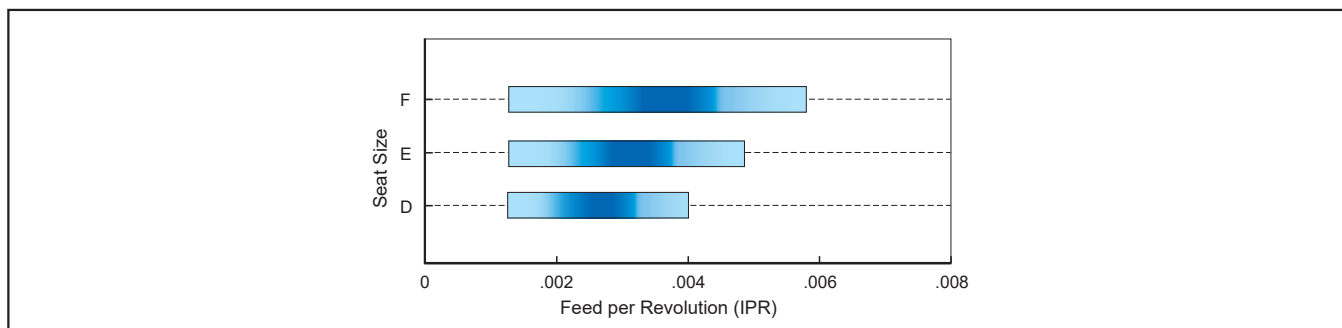
GS Breaker



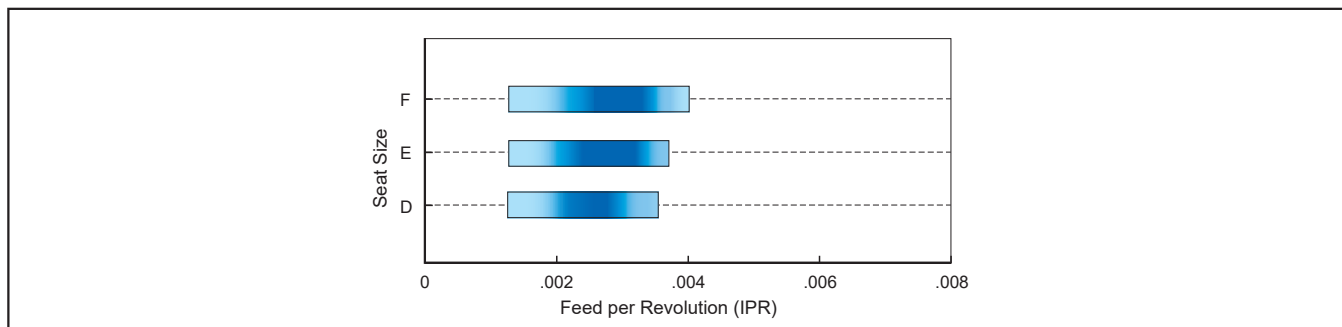
Chip Breaker	Feed per Revolution (IPR)			
	Seat Size D	Seat Size E	Seat Size F	Seat Size G
GM Breaker	.0020 – .0079	.0024 – .0091	.0028 – .0102	.0031 – .0126
GS Breaker	.0012 – .0059	.0016 – .0067	.0020 – .0079	.0024 – .0087

Cutting Off Feed per Revolution

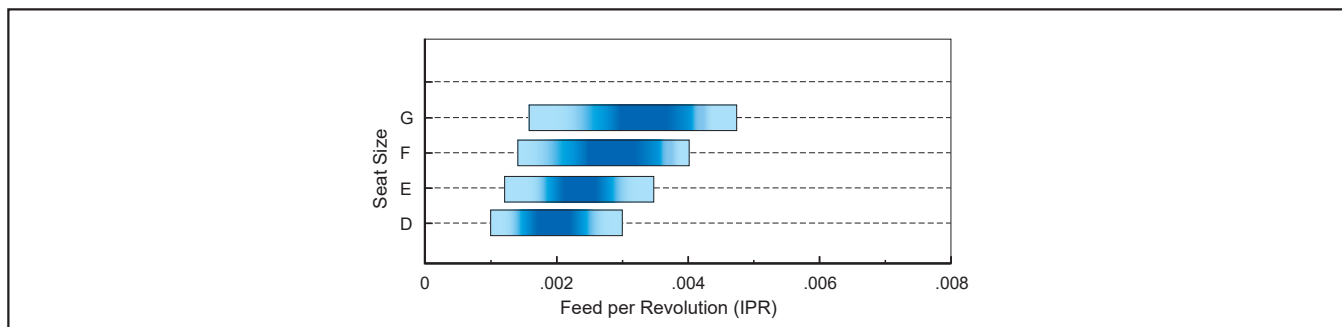
R05-GS Breaker



R08-GS Breaker



R/L05-GM Breaker



Chip Breaker	PSIPR	Hand	Feed per Revolution (IPR)			
			Seat Size D	Seat Size E	Seat Size F	Seat Size G
R05-GS	5°	R	.0012 – .0039	.0012 – .0047	.0012 – .0055	–
R08-GS	8°	R	.0012 – .0031	.0012 – .0035	.0012 – .0055	–
R05-GM	5°	R/L	.0020 – .0059	.0024 – .0067	.0028 – .0079	.0031 – .0091