

CG-TYPE

RECOMMENDED CUTTING CONDITIONS

	Material	Properties	Grade	Vc	f		Recommended tool overhang (mm)
					03RS/04RS	05RS/06RS/07RS	
P	Pure iron, Free cutting steel	—	MS7025	80 (40 - 120)	0.02 (0.01 - 0.03)	0.03 (0.01 - 0.05)	LU + 2 mm
	Carbon steel, alloy steel	Hardness 180 - 350HB	MS7025, VP15TF	80 (40 - 120)	0.02 (0.01 - 0.03)	0.03 (0.01 - 0.05)	LU + 2 mm
M	Stainless steel	Hardness ≤200HB	MS7025, MS9025, VP15TF	80 (40 - 120)	0.02 (0.01 - 0.03)	0.03 (0.01 - 0.05)	LU + 2 mm
K	Gray cast iron	Tensile strength ≤350MPa	VP15TF	80 (40 - 120)	0.03 (0.01 - 0.05)	0.03 (0.01 - 0.05)	LU + 2 mm
N	Non-ferrous metal	—	TF15	120 (80 - 160)	0.03 (0.01 - 0.05)	0.05 (0.01 - 0.08)	LU + 2 mm
S	Heat resistant alloy	—	MS9025	60 (40 - 80)	0.02 (0.01 - 0.03)	0.02 (0.01 - 0.03)	LU + 2 mm

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1. Recommend wet machining.