

RECOMMENDED CUTTING CONDITIONS

Steel Shank			l/d≤3			l/d=3—4 (Shank Diameter ≥ 25mm)			
Carbide Shank			l/d≤5			l/d=6—7			
Workpiece Material	Hardness	Cutting Mode	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	
P	Carbon Steel Alloy Steel	180—350HB	Light Cutting	130 (90—160)	0.1 (0.05—0.15)	0.2	120 (80—150)	0.1 (0.05—0.15)	0.2
			Medium Cutting	90 (60—120)	0.25 (0.15—0.35)	—3.0	80 (50—110)	0.15 (0.1—0.2)	—1.5
M	Stainless Steel	≤200HB	Light Cutting	140 (100—180)	0.1 (0.05—0.15)	0.2	140 (100—180)	0.1 (0.05—0.15)	0.2
			Medium Cutting	70 (50—90)	0.2 (0.15—0.25)	—2.0	60 (40—80)	0.15 (0.1—0.2)	—1.0
N	Aluminium Alloy	—	Light Cutting	300 (200—400)	0.1 (0.05—0.15)	0.2	300 (200—400)	0.1 (0.05—0.15)	0.2
			Medium Cutting	200 (150—250)	0.1 (0.05—0.15)	—2.0	200 (150—250)	0.1 (0.05—0.15)	—1.5

Note 1) The insert photos are only examples. The letters refer to the chip breaker and the dimension refers to the inscribed circle.

Note 2) Dimensions shown for insert corner RE 0.4.

Note 3) When using insert with right and left hand chip breaker, please use left hand insert for right hand holder and right hand insert for left hand holder.