

RECOMMENDED CUTTING CONDITIONS

	Workpiece Material	Hardness	Cutting Mode	l/d≤3		
				Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P	Carbon Steel Alloy Steel	180—350HB	Medium Cutting	110 (80—140)	0.25 (0.1—0.4)	—5.0
M	Stainless Steel	≤200HB	Medium Cutting	80 (60—100)	0.2 (0.1—0.3)	—4.0
K	Gray Cast Iron	Tensile Strength ≤350MPa	Medium Cutting	80 (60—100)	0.25 (0.1—0.4)	—5.0

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 0.8.

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.