

RECOMMENDED CUTTING CONDITIONS

■ Cutting Speed

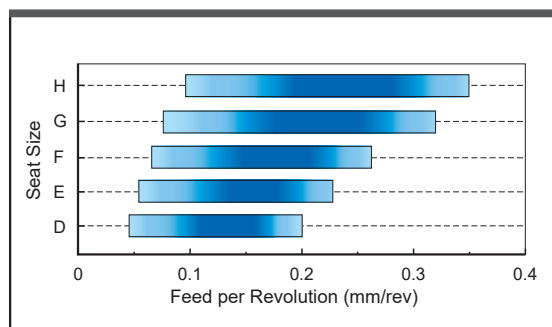
	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)					
				50	100	150	200	250	300
P	Mild Steel	≤160HB	VP20RT		100		240		
			VP10RT		110		250		
	Carbon Steel Alloy Steel	160—280HB	VP20RT	80		200			
			VP10RT	90		210			
			VP30RT	60		180			
			MY5015		110		250		
		≥280HB	VP20RT	60		160			
			VP10RT	70		170			
			VP30RT	40		140			
			MY5015		90		210		
M	Stainless Steel	≤270HB	VP20RT	60		180			
			VP10RT	70		190			
			VP30RT	40		160			
K	Gray Cast Iron	Tensile Strength ≤300MPa	VP20RT		80		200		
			VP10RT		90		210		
			MY5015			140		300	
	Ductile Cast Iron	Tensile Strength ≤800MPa	VP20RT	60		160			
			VP10RT		70		170		
			MY5015		90		210		
S	Heat Resistant Alloy Titanium Alloy	—	VP20RT	30	60				
			VP10RT	40	70				

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

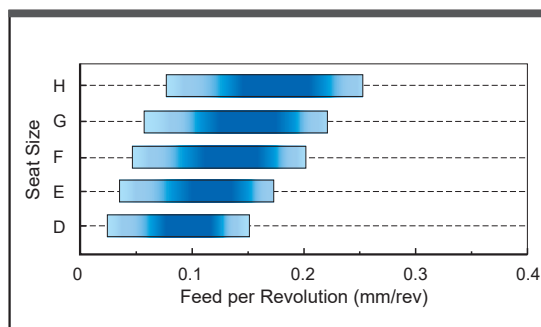
Note 2) For VP10RT, VP20RT, VP30RT and MY5015, wet cutting is recommended.

■ Feed per Revolution

GM Breaker



GS Breaker



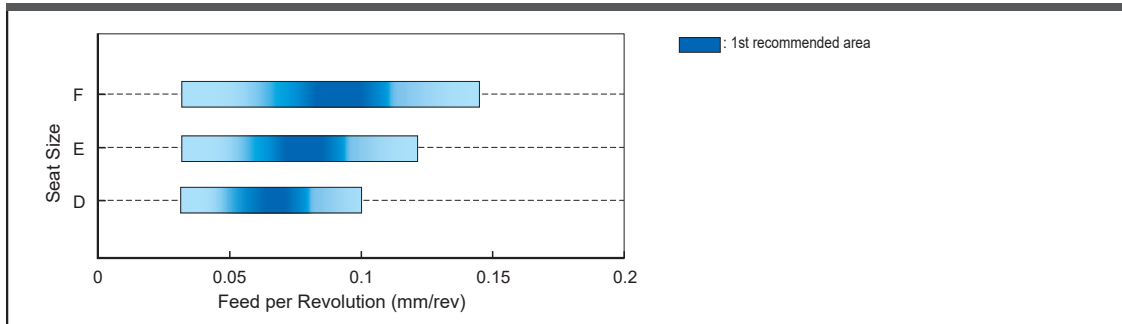
■ : 1st recommended area

Seat Size	
Insert Width (mm)	
D	2.00
E	2.39
F	3.00
G	4.00
H	5.00

Chip Breaker	Feed per Revolution (mm/rev)				
	Seat Size D	Seat Size E	Seat Size F	Seat Size G	Seat Size H
GM Breaker	0.05—0.20	0.06—0.23	0.07—0.26	0.08—0.32	0.10—0.35
GS Breaker	0.03—0.15	0.04—0.17	0.05—0.20	0.06—0.22	0.08—0.25

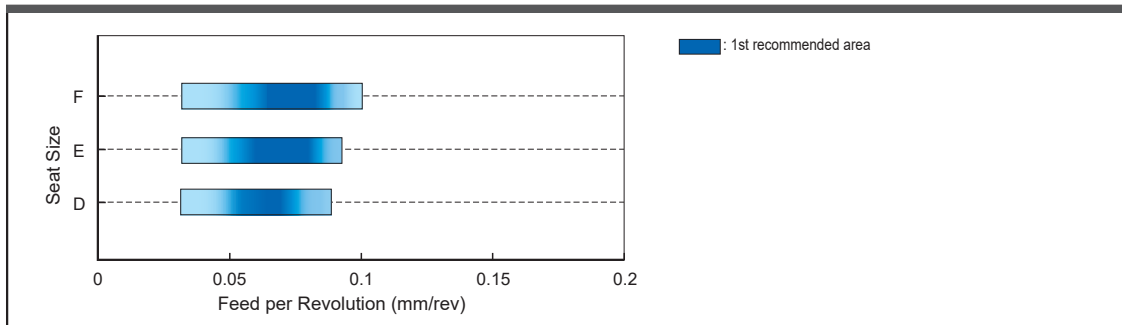
■ Cutting Off Feed per Revolution

R05-GS Breaker

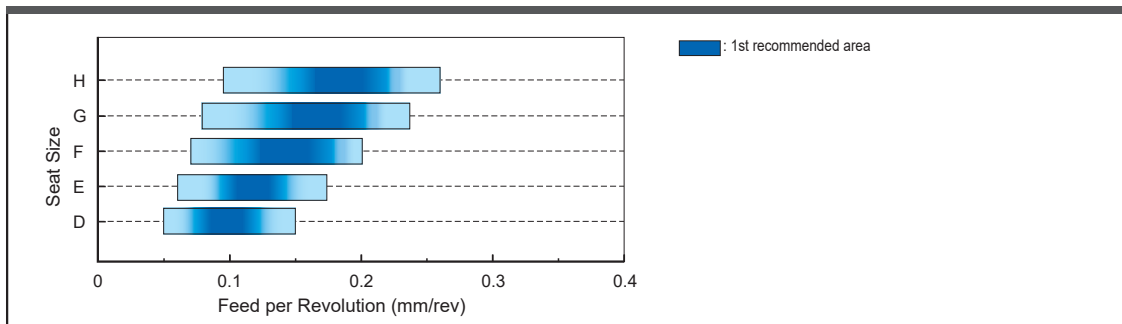


Seat Size	
Insert Width (mm)	
D	2.00
E	2.39
F	3.00
G	4.00
H	5.00

R08-GS Breaker



R/L05-GM Breaker



Chip Breaker	PSIPR	Hand	Feed per Revolution (mm/rev)				
			Seat Size D	Seat Size E	Seat Size F	Seat Size G	Seat Size H
R05-GS	5°	R	0.03–0.10	0.03–0.12	0.03–0.14	—	—
R08-GS	8°	R	0.03–0.08	0.03–0.09	0.03–0.14	—	—
R05-GM	5°	R/L	0.05–0.15	0.06–0.17	0.07–0.20	0.08–0.23	0.10–0.26