

GW Series

RECOMMENDED CUTTING CONDITIONS

■ Cutting Speed

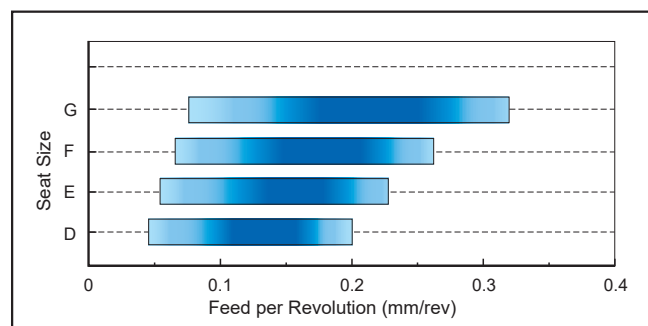
	Workpiece Material	Hardness	Grade	Cutting Speed (m/min)					
				50	100	150	200	250	300
P	Mild Steel	≤160HB	VP20RT		100		240		
			VP10RT		110		250		
	Carbon Steel Alloy Steel	160—280HB	VP20RT		80		200		
			VP10RT		90		210		
			VP30RT	60		180			
			MY5015		110		250		
		≥280HB	VP20RT	60		160			
			VP10RT		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 all materials.

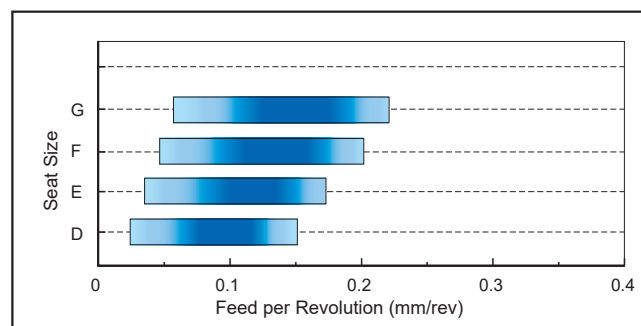
Note 2) For VP10RT, VP20RT, VP30RT and MY5015, wet cutting is recommended.

■ Feed per Revolution

GM Breaker



GS Breaker

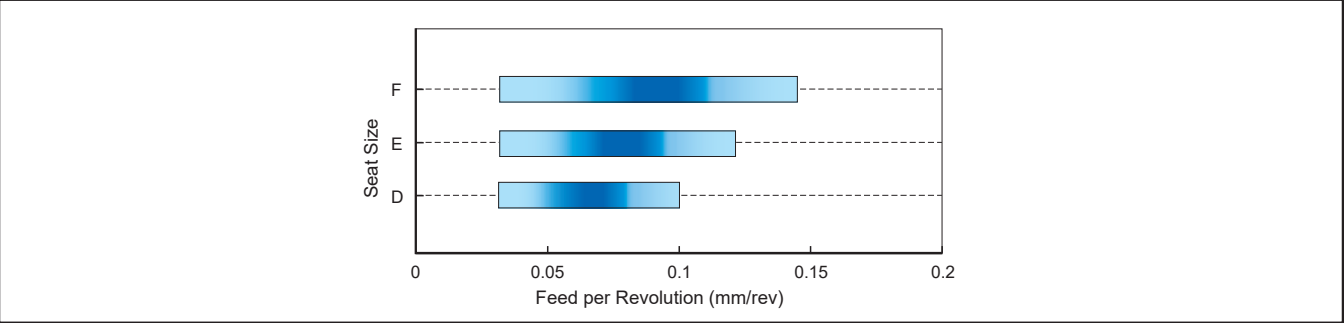


Chip Breaker	Feed per Revolution (mm/rev)			
	Seat Size D	Seat Size E	Seat Size F	Seat Size G
GM Breaker	0.05—0.20	0.06—0.23	0.07—0.26	0.08—0.32
GS Breaker	0.03—0.15	0.04—0.17	0.05—0.20	0.06—0.22

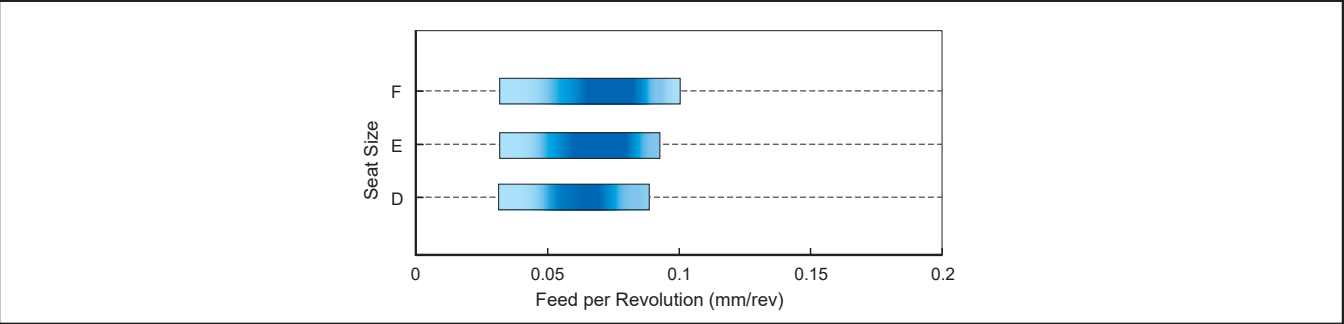
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Cutting Off Feed per Revolution

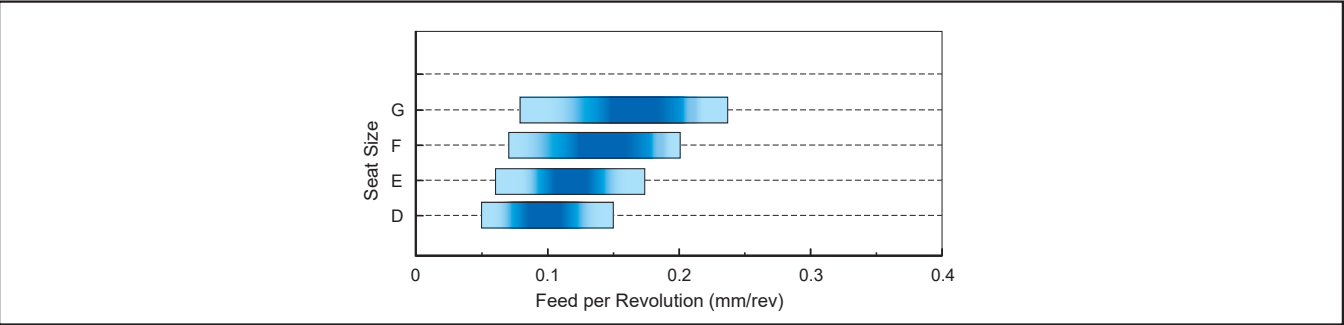
R05-GS Breaker



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
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	0.03–0.10	—
R05-GM	5°	R/L	0.05–0.15	0.06–0.17	0.07–0.20	0.08–0.23