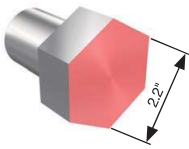

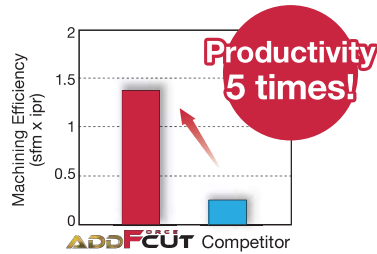
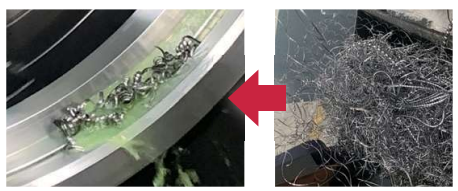


STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Hardness	Grade	Cutting speed Vc (sfm)
P	Steels 1045, 4140, etc.	< 300 HB	AH7025	160 - 590
M	Stainless steel 304, etc.	< 200 HB	AH7025	160 - 390
K	Gray cast iron No.250B, etc.	-	AH7025	160 - 590
	Ductile cast irons 65-45-12, etc.	-	AH7025	160 - 390
S	Superalloys Inconel718, etc.	< HRC 40	AH7025	60 - 200
	Titanium alloys Ti-6Al-4V, etc.	< HRC 40	AH7025	60 - 260

PRACTICAL EXAMPLES

Workpiece type		Bolt parts	Ring
Toolholder		QSG82-3T / CHTBL16-82	QSER16-5T33
Insert		QGS3-020	QGS5-030
Grade		AH7025	AH7025
Workpiece material		304 M	E P
			
Cutting conditions	Grooving width (in)	0.118	0.197
	Grooving depth (in)	1.063	0.650
	Cutting speed : Vc (sfm)	230	302
	Feed : f (ipr)	0.006	0.005
	Machining	Parting off	Grooving
	Coolant	Wet	Wet
Results		 <p>TungFeed-Blade doubled tool life, while also increasing feed rate 5 times when used with the high rigidity CHTBL holder.</p>	 <p>AddForceCut improved chip control and chip evacuation when compared to existing tools, and also doubled the feed rate.</p>