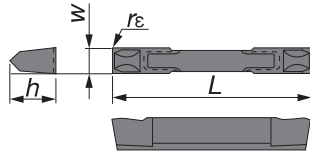


# INSERT

## CGD



Designation	w=0.025	r $\epsilon$	Coating	Cermet	Uncoated	L	h
			GH330	NS9530	UX30		
CGD200	2	0.2	●	●	●	20	3.25
CGD300	3	0.2	●	●	●	28.6	6.3
CGD400	4	0.2	●	●	●	28.6	6.3
CGD500	5	0.2	●	●	●	28.6	6.3
CGD600	6	0.2	●	●	●	28.6	8.5
CGD700	7	0.2	●		●	28.6	8.5
CGD800	8	0.2	●		●	28.6	8.5

● : Line-up

## STANDARD CUTTING CONDITIONS

Operation	Cutting speed v <sub>c</sub> (m/min)	Groove width: W (mm)						
		Feed: f (mm/rev)						
		2	3	4	5	6	7	8
Grooving: Low carbon steels	100 ~ 200	0.08 ~ 0.20	0.08 ~ 0.25	0.08 ~ 0.25	0.08 ~ 0.25	0.08 ~ 0.25	0.08 ~ 0.25	0.08 ~ 0.25
Grooving: Medium carbon steels				0.08 ~ 0.30	0.08 ~ 0.30	0.08 ~ 0.30	0.08 ~ 0.30	0.08 ~ 0.30
Parting off	100 ~ 150	0.08 ~ 0.15	0.08 ~ 0.15	0.08 ~ 0.15	0.08 ~ 0.15	0.08 ~ 0.15	0.08 ~ 0.15	0.08 ~ 0.15

