

## Standard cutting conditions

Work materials	Recommended grade	Cutting speed $v_c$ (SFM)	Operation	Feed: $f$ (in/rev)			
				Groove width: $W$ (in)			
				.078	.118	.157	.196
Low carbon steels	T9125	260 ~ 650	Grooving (GE□□)	.002 ~ .008	.002 ~ .009	.002 ~ .010	.002 ~ .012
Alloy steels (~ 150HB)	NS9530	330 ~ 650					
Medium carbon steels	T9125	260 ~ 590	Parting off (GE□□R/L)	.001 ~ .003	.001 ~ .006	.001 ~ .006	.001 ~ .006
	Alloy steels (150 ~ 250HB)	NS9530					
High carbon steels	T9125	260 ~ 500	Traversing (GT□□)	-	ap = .008 ~ .060 f = .002 ~ .006	ap = .020 ~ .078 f = .002 ~ .009	ap = .020 ~ .098 f = .002 ~ .010
	Alloy steels (250HB ~ )	NS9530					
Stainless steels	AH120	260 ~ 500	Profiling (GR□□)	-	ap = .020 ~ .055 f = .002 ~ .009	ap = .020 ~ .060 f = .002 ~ 0.10	ap = .020 ~ .062 f = .002 ~ .012
	Alloy steels	NS9530					
Grey and ductile cast irons	AH120	260 ~ 650	Grooving for Aluminum alloys (GE□□-AL)	.001 ~ .003	.001 ~ .003	.001 ~ .003	-
	Alloy steels	NS9530					
Aluminum alloys, Non-ferrous metals	KS05F	650 ~ 1000					