

STANDARD CUTTING CONDITIONS (JXG and JVG inserts)

ISO	Workpiece material	Grade	Cutting speed Vc (sfm)	Feed f (ipr)
P	General steel 1045, etc.	SH725	164 - 656	0.0004 - 0.004
		J740	33 - 328	0.0004 - 0.004
		NS9530	164 - 492	0.0004 - 0.004
	Free-cutting steel	SH725	164 - 656	0.0004 - 0.004
		J740	33 - 328	0.0004 - 0.004
		NS9530	164 - 492	0.0004 - 0.004
M	Stainless steel 303, etc.	SH725	164 - 656	0.0004 - 0.004
		J740	33 - 328	0.0004 - 0.004
		NS9530	164 - 492	0.0004 - 0.004
N	Aluminium alloys, Brass Si < 12%, etc.	TH10	33 - 656	0.0004 - 0.004
S	Difficult-to-cut materials, Titanium alloys Ti-6Al-4V, etc.	TH10	33 - 98	0.0004 - 0.004

