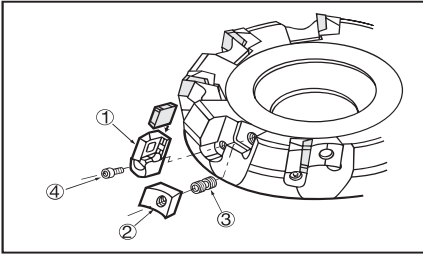


Replacement parts



No.	Part	Part Cat. No.
①	Locator	LP514R
②	Insert locking wedge	WF500R
③	Wedge fixing screw	FDS-8S
④	Locator fixing screw	CM4×0.7×14
—	T-handle wrench	TP-4

Standard cutting conditions

Work materials	Grades	Roughing (Depth of cut: .060 ~ .315 in)		Finishing (Depth of cut: .012 ~ .028 in)	
		Cutting speed v_c (SFM)	Feed per tooth f_z (ipt)	Cutting speed v_c (SFM)	Feed per tooth f_z (ipt)
Cast irons	T1115	325 ~ 660	.004 ~ .012	325 ~ 660	.004 ~ .012
Ductile cast irons	TH10•UX30	260 ~ 425		260 ~ 425	
Mild steels Unhardened steels (< 180 HB)	NS740	490 ~ 820	.004 ~ .010	490 ~ 820	.004 ~ .012
	GH330		.004 ~ .012		.004 ~ .013
	T3130	490 ~ 990	.004 ~ .014	590 ~ 980	.004 ~ .014
Carbon steels Alloy steels (< 300 HB)	UX30	325 ~ 590	.004 ~ .012	425 ~ 650	.004 ~ .014
	T3130	490 ~ 920	.004 ~ .012	590 ~ 920	.004 ~ .014
	NS740	325 ~ 590	.004 ~ .010	490 ~ 820	.004 ~ .012
Die steels (< 30 HRC)	GH330	325 ~ 660	.004 ~ .011		.004 ~ .013
	UX30	260 ~ 425	.004 ~ .012	325 ~ 490	.004 ~ .014
	T3130•GH330	325 ~ 490	.004 ~ .008	325 ~ 490	.004 ~ .008
Stainless steels (< 9.84 HB)	UX30	260 ~ 425	.004 ~ .012	260 ~ 425	.004 ~ .008
	T3130	490 ~ 820	.006 ~ .012	650 ~ 820	.006 ~ .011
	GH330	490 ~ 760	.006 ~ .012	650 ~ 820	.006 ~ .011
	UX30	490 ~ 590	.006 ~ .012	590 ~ 660	.006 ~ .012

Notes: • Dry cutting is recommended for above materials.
• When wet machining mild steels, carbon steels and alloy steels, use T3130 at lower cutting conditions.