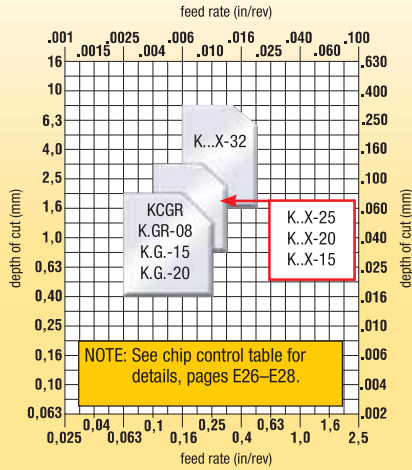


■ **Step 1 • Select the insert geometry**

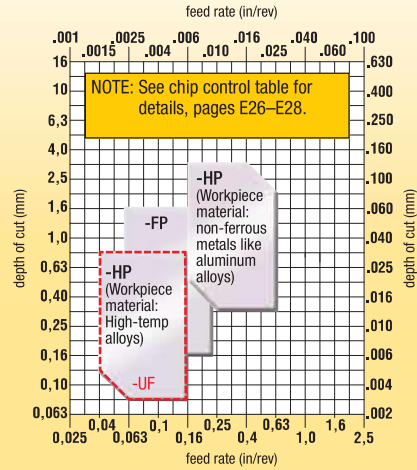
Negative Inserts

-  -K...X-32
Roughing
-  -K...X-25-K...X-15,
Medium Machining
-  -K GR-08, K.G.-15,
K.G.-20
Finishing



Positive Inserts

-  -VCMR
Medium Machining
-  -CGR, VBMR
Finishing
-  -VCGN
Finishing
-  -KCGR
Finishing



Chip Control Range

- UF: feed 0,08–0,3 mm/rev; DOC 0,1–1,3mm
- FP: feed 0,1–0,3 mm/rev; DOC 0,1–1,3mm
- HP: feed 0,2–0,4 mm/rev; DOC 0,6–2,3mm

■ **Step 2 • Select the grade**

cutting condition	Image	Steel			Stainless Steel		
		Finishing	Medium Machining	Roughing	Finishing	Medium Machining	Roughing
heavily interrupted cut		KCP25	KCM25	KCM25	KCM25	KCM25	KCM25
lightly interrupted cut		KCP10	KCP25	KCP25	KC5010/KCU10	KC5025/KCU25	KC5025/KCU25
varying depth of cut, casting, or forging skin		KT315	KCP25	KCP25	KT315	KCM25	KCM25
smooth cut, pre-turned surface		KT315	KCP05/KCP10	KCP10	KT315	KC5010/KCU10	KCM25

cutting condition	Image	Cast Iron			Non-Ferrous		
		Finishing	Medium Machining	Roughing	Finishing	Medium Machining	Roughing
heavily interrupted cut		KCP10	KCP10	KCP10	KC5010/KCU10	KC5010/KCU10	KC5010/313/KCU10
lightly interrupted cut		KCP05	KCP05	KCP05	KC5410/KD1425	KC5010/KCU10	KC5010
varying depth of cut, casting, or forging skin		KCK05	KCK05	KCK05	KD1425	KC5410	KC5410
smooth cut, pre-turned surface		KC5010/KCU10	KC5010/KCU10	KC5010/KCU10	KD1425	KC5410	KC5410

cutting condition	Image	High-Temperature Alloys		
		Finishing	Medium Machining	Roughing
heavily interrupted cut		KC5025/KUC25	K68	K68
lightly interrupted cut		KC5010	KC5010	KCM25
varying depth of cut, casting, or forging skin		KC5010	KC5010	KC5010
smooth cut, pre-turned surface		KC5010/KCU10/K313	KC5010/KCU10	KC5010

Step 3 • Select the cutting speed

Steel speed — m/min (SFM) starting conditions

material group	grade	50 (170)	100 (330)	150 (490)	200 (655)	250 (820)	300 (980)	350 (1150)	400 (1300)	m/min	SFM
P	KT315	◇								260	850
	KCP05/KCP10	◇								340	800
	KCP25	◇								180	600
	KCM25	◇								165	550

Stainless Steel speed — m/min (SFM) starting conditions

material group	grade	50 (170)	100 (330)	150 (490)	200 (655)	250 (820)	300 (980)	350 (1150)	400 (1300)	m/min	SFM
M	KT315	◇								230	750
	KC5010/KCU10	◇								180	600
	KC5025/KCU25	◇								120	400
	KCM25	◇								150	500

Cast Iron speed — m/min (SFM) starting conditions

material group	grade	150 (490)	200 (655)	250 (820)	300 (980)	350 (1150)	400 (1300)	500 (1600)	750 (2400)	m/min	SFM
K	KB1345	◇								760	2520
	KT315	◇								275	900
	KC5010/KCU10	◇								245	800
	KCK20	◇								245	800
	KCP25	◇								230	750

Non-Ferrous speed — m/min (SFM) starting conditions

material group	grade	250 (800)	500 (1600)	750 (2400)	1000 (3200)	1250 (4000)	1500 (4800)	1750 (5600)	2000 (6400)	m/min	SFM
N	K01425	◇								765	2500
	KC5410	◇								550	1800
	KC5010/KCU10	◇								460	1500
	K68/K313	◇								150	500

High-Temperature Alloys speed — m/min (SFM) starting conditions

material group	grade	15 (50)	40 (120)	55 (180)	80 (250)	100 (330)	170 (550)	200 (655)	120 (400)	m/min	SFM
S	KC5010/KCU10	◇								60	200
	KC5025/KCU25	◇								50	170
	KCM25	◇								70	230
	K68/K313	◇								30	100

◇ Represents the recommended starting conditions. Optimize for your specific application.