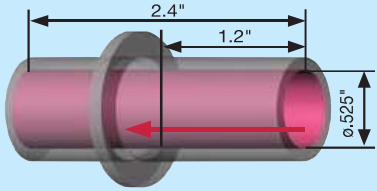
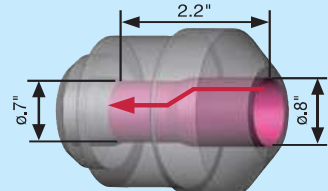


Standard cutting conditions

Work materials	Priority	Grades	Cutting speed Vc (sfm)	Chip- breaker	Depth of cut ap (in)	Feed f (ipr)
Low carbon steels 70, 1025 etc. Carbon steels 1045, 1055 etc. Alloy steels 4140, 5120 etc.	First choice	AH725	150 ~ 600	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
	For improved surface finish	NS9530	250 ~ 850	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
	For wear resistance	GT9530	250 ~ 1000	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
Stainless steels (Austenitic) 304, 316 etc. Stainless steels (Martensitic and ferritic) 430, 416 etc. Stainless steels (Precipitation hardening) S17400 etc.	First choice	AH725	150 ~ 500	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
Gray cast irons No.350B etc.	First choice	AH725	150 ~ 600	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
	For improved surface finish	NS9530	250 ~ 850	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
	For wear resistance	GT9530	250 ~ 1000	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
Ductile cast irons 100-70-03 etc.	First choice	AH725	150 ~ 400	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
	For improved surface finish	NS9530	250 ~ 500	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012
	For wear resistance	GT9530	250 ~ 600	SS	.006 - .060	.002 - .008
				TS	.012 - .080	.003 - .012

Practical examples

Workpiece type	Machine parts	Machine parts
Toolholder	A06-SWLXR2-D08	E08-SWLXR2-D11
Insert	WXGU040304L-TS	WXGU040304L-TS
Grade	AH725	AH725
Work material	1045	5120
		
Cutting conditions	Cutting speed : Vc (sfm)	200
	Feed : f (ipr)	.010
	Depth of cut : ap (in)	.033
	Machining	Internal turning (continuous cutting)
	Coolant	Wet
Results	