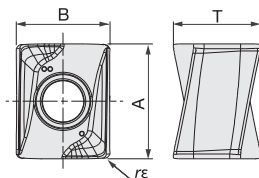


Inserts



Cat. No.	Accuracy	Honing	Grades Coated			Dimensions (mm)				Cutter
			AH725	AH120	AH140	A	B	T	r ϵ	
LQMU110704PNER-MJ	M	with	●	●	●	11.0	9.0	8.3	0.4	EPQ11R TPQ11R
LQMU110708PNER-MJ	M	with	●	●	●	11.0	9.0	8.3	0.8	
LQMU110716PNER-MJ	M	with	●	●	●	11.0	9.0	8.3	1.6	
New LQMU180804PNER-MJ	M	with	●	●	●	17.5	11.5	10.9	0.4	TPQ18R EPQ18R
New LQMU180808PNER-MJ	M	with	●	●	●	17.5	11.5	10.9	0.8	
New LQMU180816PNER-MJ	M	with	●	●	●	17.5	11.5	10.9	1.6	
New LQMU180824PNER-MJ	M	with	●	●	●	17.5	11.5	10.9	2.4	

● : Stocked items

Standard cutting conditions

Workpiece materials	Hardness HB	Grades	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
Low carbon steel (S15C / C15E etc.)	~ 200	AH725	100 - 250	0.10 - 0.25
High carbon steel (S45C / C45, S55C / C55 etc.)	200 ~ 300		100 - 230	0.10 - 0.20
Alloy steel (SCM440 / 42CrMo4 etc.)	150 ~ 300		100 - 180	
Tool steel (SKD11 / X153CrMoV12 etc.)	~ 300			
Stainless steel (SUS304 / X5CrNi18-9 etc.)	-	AH140	90 - 180	0.10 - 0.25
Grey cast iron (FC250 / GG25 / 250 etc.)	150 ~ 250	AH120	140 - 250	0.10 - 0.25
Ductile cast iron (FCD450 / GGG45 / 450-10S etc.)			110 - 200	0.10 - 0.25
Superalloys (Inconel 718, Ti-6Al-4V etc.)	-	AH725	20 - 50	0.08 - 0.20

- To remove excessive chip accumulation use an air blast.
- When cutting an interrupted surface or a casted skin, the feed per tooth (fz) should be reduced to the lower recommended value shown in the above table.

- Cutting conditions are limited by machine power, work piece rigidity and spindle output. When the cutting width, depth or overhang length is large, set Vc and fz to the lower recommended values and check the machine power and vibration.