

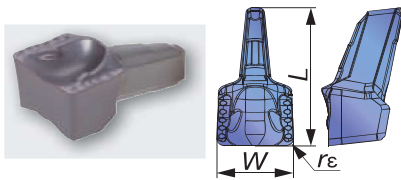
STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness	Grades	Chip-breaker	Cutting speed Vc (sfm)
P	Low carbon steels (1015, etc.)	- 300 HB	AH725	ETX	160 - 600
		- 300 HB	AH725	EGM	160 - 600
	Carbon steels, Alloy steels (1055, etc.)	- 300 HB	AH725	ETX	160 - 600
		- 300 HB	AH725	EGM	160 - 600
	Prehardened steels (NAK80, PX5 etc.)	- 300 HB	AH725	ETX	160 - 600
		- 300 HB	AH725	EGM	160 - 600
M	Stainless steels (S30400, etc)	-	AH725	ETX	160 - 400
		-	AH725	ETX	160 - 400

Note: See page 9 for more information about grades.

INSERTS

ETX

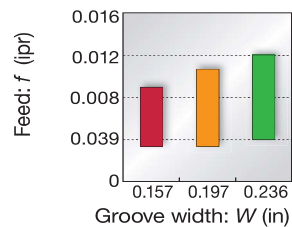


Designation	Grade	$W \pm 0.002$	L	r_ϵ
ETX4-040	AH725	0.157	0.315	0.016
ETX5-040	AH725	0.197	0.394	0.016
ETX6-040	AH725	0.236	0.472	0.016

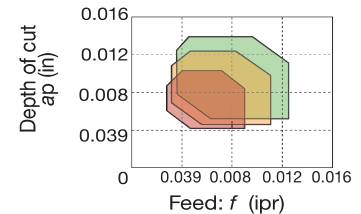
√ : Stocked items

Note: See page 9 for more information about grades.

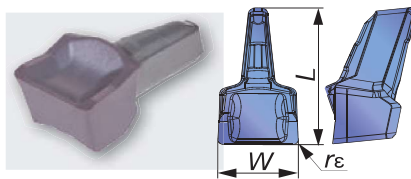
Standard feed for grooving



Standard feed and DoC for turning



EGM



Designation	Grade	$W \pm 0.002$	L	r_ϵ
EGM4-030	AH725	0.157	0.315	0.012

√ : Stocked items

Note: See page 9 for more information about grades.

Standard feed for grooving

