

STANDARD CUTTING CONDITIONS (JXB type insert)

ISO	Workpiece material	Grade	Cutting speed V_c (sfm)	Feed: f (ipr)	
				Grooving	Turning
P	Steel 1045, etc.	J740	33 - 328	0.0004 - 0.0012	0.0008 - 0.004
	Free-cutting steel	J740	33 - 328	0.0004 - 0.0012	0.0008 - 0.004
M	Stainless steel 303, etc.	J740	33 - 328	0.0004 - 0.0008	0.0008 - 0.003
N	Aluminum alloys, Brass Si < 12%, 5056, 6061, etc.	TH10	164 - 656	0.0004 - 0.0020	0.0008 - 0.004
S	Difficult-to-machine material, Titanium alloys Ti-6Al-4V, etc.	TH10	33 - 98	0.0004 - 0.0008	0.0008 - 0.002