

Standard cutting conditions

For Internal Turning

ISO	Work material	Chip-breaker	Grades	Cutting Speed Vc (m/min)	Depth of cut ap (mm)	Feed <i>f</i> (mm/rev)			
						R0.03	R0.1	R0.2	R0.4
P	Steels S45C, SCM435, etc. (C45, 34CrMo4, etc.)	W08 JS08	SH725	50 - 200	0.05 - 1.0	0.005 - 0.02	0.01 - 0.05	0.02 - 0.10	0.05 - 0.15
M	Stainless steels SUS303, SUS304, etc. (X10CrNiS18-9, etc.)	W08 JS	SH725	30 - 200	0.05 - 1.0	0.005 - 0.02	0.01 - 0.05	0.02 - 0.10	0.05 - 0.15
K	Grey cast irons Ductile cast irons FC250, FCD450, etc. (GG25, GGG45, etc.)	W08 JS	TH10	30 - 100	0.05 - 1.0	0.005 - 0.02	0.01 - 0.05	0.02 - 0.10	0.05 - 0.15
N	Aluminium alloys Copper alloys Si < 13%	W08 JS	TH10	100 - 500	0.05 - 1.0	0.005 - 0.02	0.01 - 0.05	0.02 - 0.10	0.05 - 0.15
S	Titanium Titanium alloys Ti-6Al-4V etc.	W08 JS	SH725	30 - 100	0.05 - 1.0	0.005 - 0.02	0.01 - 0.05	0.02 - 0.10	0.05 - 0.15