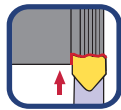


Standard cutting conditions



Wide grooving

ISO	Workpiece materials	Hardness (HB)	Grade	Cutting speed Vc (sfm)
P	Alloy steels (4140, 4340 etc.)	< 300	AH725	165 - 590
		< 300	UX30	165 - 390
PSGM type insert	Groove width: W (in)			
	0.394	0.590	0.787	0.984
Feed: f (ipr)	0.008 - 0.016	0.008 - 0.016	0.012 - 0.020	0.012 - 0.020



Forming

ISO	Workpiece materials	Hardness (HB)	Grade	Cutting speed Vc (sfm)
P	Steels (1045, 1055 etc.)	< 200	UX30	165 - 490
	Alloy steels (4140, 4340 etc.)	< 300	UX30	165 - 390
M	Stainless steels (303, 304 etc.)	< 200	UX30	165 - 390
K	Gray cast irons (25 etc.)	-	TH10	165 - 490
	Ductile cast irons (64-45-12, 80-55-06 etc.)	-	TH10	165 - 390
N	Aluminum alloy (Si < 12% etc.)	-	TH10	330 - 1640