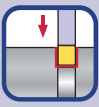
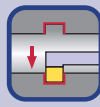

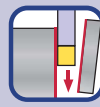
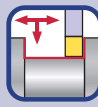
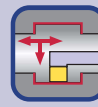



● Insert application

Insert	Application						
	Grooving			Parting	Turning		
	External	Internal	Face		External	Internal	Face
							
DGM / SGM	●		●	●			
DGS / SGS	●		●	●			
DTE	●		●		●		●
DGG	●		●				
DGE	●						
DTX	●	●	●	●	●	●	●
DTI		●				●	
DGIM / DGIS		●					
DTF			●				●
DTR	●		●		●		●
DTIU	● Undercutting	● Undercutting					
DTA					● Al wheel machining	● Al wheel machining	
SGN	●						

● Standard cutting conditions

ISO	Workpiece materials	Hardness	Priority	Grade	Cutting speed Vc (sfm)
P	Steels 1045 SAE, 4135 SAE etc.	< 300 HB	First choice	AH7025, AH725	160 - 600
		< 300 HB	Priority for wear resistance	T9125	260 - 660
		< 300 HB	Priority for impact resistance	GH130	160 - 400
		< 300 HB	Priority for surface finish	NS9530	260 - 720
M	Stainless steels 303, 304 etc.	< 200 HB	First choice	AH7025, AH725	160 - 400
		< 200 HB	Priority for impact resistance	GH130	160 - 400
K	Gray cast irons CLASS 25 etc.	-	First choice	GH130	160 - 600
	Ductile cast irons 65-45-12 etc.	-	First choice	GH130	160 - 400
N	Aluminum alloys (Si < 12%)	-	First choice	TH10	330 - 1650
S	Titanium alloys (Ti-6Al-4V etc.)	< 40 HRC	First choice	AH905	60 - 260
		< 40 HRC	Priority for impact resistance	AH7025, AH725	60 - 260
H	Hardened steels 4137 etc.	> 50 HRC	First choice	BX360	260 - 500