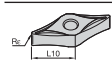
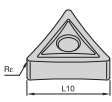
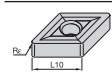
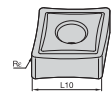
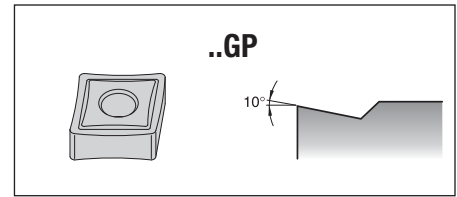


cutting conditions				
cutting speed (SFM) range	N1-N2	410	1800	3280
	N4	410	900	2460
	N5	410	560	3940
	N6	328	655	1640
	N8	328	705	1640
carbide grade		KC5410		



ISO catalog number	ANSI catalog number	KC5410	L10		R ϵ		ap min	starting value depth of cut (in)		ap max	starting value feed rate (in/rev)		f/rev max
			mm	in	mm	in		ap min	ap max		f/rev min	f/rev max	
CNGP120401	CNGP430	1785715	12,90	.508	0,1	.004	.003	.011	.039	.001	.003	.004	
CNGP120402	CNGP4305	1785716	12,90	.508	0,2	.008	.007	.019	.070	.003	.005	.007	
CNGP120404	CNGP431	1785717	12,90	.508	0,4	1/64	.011	.031	.110	.011	.013	.017	
CNGP120408	CNGP432	1785718	12,90	.508	0,8	1/32	.019	.047	.126	.011	.015	.019	
CNGP120412	CNGP433	1785719	12,90	.508	1,2	3/64	.031	.078	.137	.011	.017	.021	
DNGP150402	DNGP4305	1560717	15,50	.610	0,2	.008	.007	.019	.070	.003	.005	.007	
DNGP150404	DNGP431	1785733	15,50	.610	0,4	1/64	.011	.031	.110	.011	.013	.017	
DNGP150408	DNGP432	1785734	15,50	.610	0,8	1/32	.019	.047	.126	.011	.015	.019	
DNGP150604	DNGP441	1785735	15,50	.610	0,4	1/64	.011	.031	.110	.011	.013	.017	
TNGP160404	TNGP331	1785740	16,50	.650	0,4	1/64	.011	.031	.110	.011	.013	.017	
TNGP160408	TNGP332	1785741	16,50	.650	0,8	1/32	.019	.047	.126	.011	.015	.019	
VNGP160401	VNGP330	1785746	16,61	.654	0,1	.004	.003	.011	.039	.001	.003	.003	
VNGP160402	VNGP3305	1785747	16,61	.654	0,2	.008	.007	.019	.070	.003	.005	.007	

