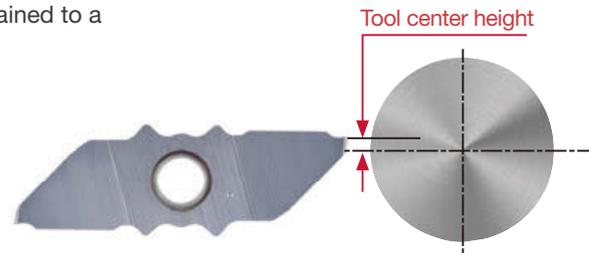


Adjustment of tool center height

When parting off bars, it is essential that the center height is maintained to a tolerance of ± 0.1 mm for maximum tool life.



STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grades	Cutting speed V_c (m/min)	Feed f (mm/rev)
P	Low carbon steels S15C, SS400, etc. C15E4, E275A, etc.	SH725	50 - 200	0.01 - 0.05
	Carbon steels, Alloy steels S55C, SCM440, etc. C55, 42CrMo4, etc.	SH725	50 - 200	0.01 - 0.05
	Free cutting steels SUH22, SUH23, etc.	SH725	50 - 200	0.01 - 0.05
M	Stainless steels SUS304, X5CrNi18-9, etc.	SH725	50 - 200	0.01 - 0.05
N	Aluminium alloys A5056, A6061, etc.	SH725	150 - 200	0.01 - 0.05
	Copper alloy C2600, C280C, etc.	SH725	100 - 200	0.01 - 0.05
S	Titanium alloys Ti-6Al-4V, etc.	SH725	30 - 80	0.01 - 0.05
	Superalloys Inconel718, etc.	SH725	30 - 80	0.01 - 0.05