

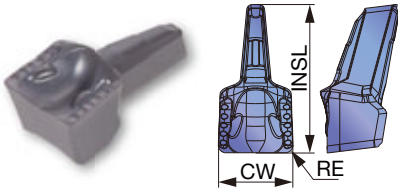
## Single-ended inserts for face grooving & turning

### STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness	Grades	Chip-breaker	Cutting speed Vc (m/min)
<b>P</b>	Low carbon steel (C15, C20, etc.)	- 300 HB	AH725	ETX	80 - 180
		- 300 HB	AH725	EGM	80 - 180
	Carbon steel, Alloy steel (C55, 42CrMoS4, etc.)	- 300 HB	AH725	ETX	80 - 180
		- 300 HB	AH725	EGM	80 - 180
	Prehardened steel (NAK80, PX5, etc.)	- 300 HB	AH725	ETX	80 - 180
		- 300 HB	AH725	EGM	80 - 180
<b>M</b>	Stainless steel (X5CrNi18-9, X5CrNiMo17-12-2, etc)	-	AH725	ETX	50 - 120
		-	AH725	EGM	50 - 120

### INSERTS

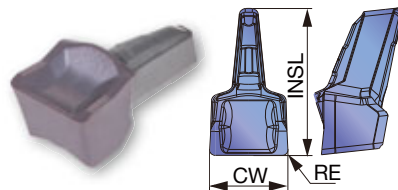
#### ETX



Description	Grade AH725	CW±0.05	INSL	RE
ETX4-040	✓	4	8	0.4
ETX5-040	✓	5	10	0.4
ETX6-040	✓	6	12	0.4

✓ : Stocked items

#### EGM



Description	Grade AH725	CW±0.05	INSL	RE
EGM4-030	✓	4	8	0.3

✓ : Stocked items