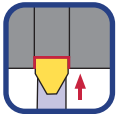
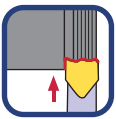


Standard cutting conditions



Wide grooving

ISO	Workpiece materials	Hardness (HB)	Grade	Cutting speed Vc (m/min)
P	Alloy steels (SCM440 / 42CrMo4 etc.)	< 300	AH725	50 - 180
	Alloy steels (SCM440 / 42CrMo4 etc.)	< 300	UX30	50 - 120
PSGM type insert	Groove width: W (mm)			
	10	15	20	25
Feed: f (mm/rev)	0.2 - 0.4	0.2 - 0.4	0.3 - 0.5	0.3 - 0.5



Forming

ISO	Workpiece materials	Hardness (HB)	Grade	Cutting speed Vc (m/min)
P	Steels (S45C / C45 etc.)	< 200	UX30	50 - 150
	Alloy steels (SCM440 / 42CrMo4 etc.)	< 300	UX30	50 - 120
M	Stainless steels (SUS303 / X10CrNiS18-9 etc.)	< 200	UX30	50 - 120
K	Grey cast irons (FC250 / 250 etc.)	-	TH10	50 - 150
	Ductile cast irons (FCD450 / 450-10S etc.)	-	TH10	50 - 120
N	Aluminium alloy (Si < 12% etc.)	-	TH10	100 - 500