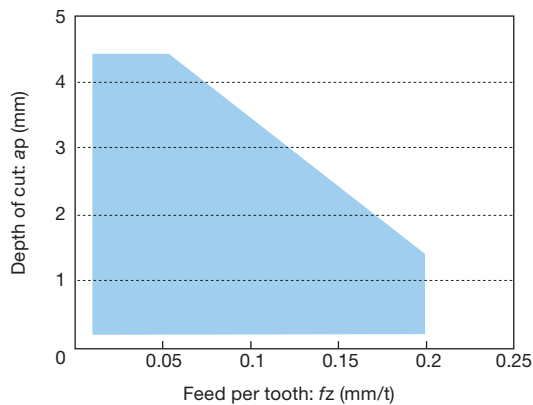


STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grades	Designation	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
N	Cast aluminum alloy / Die-cast (Si < 13%)	DX110	YDEN0603PDFR-D	500 - 4,000	0.05 - 0.20
	Cast aluminum alloy / Die-cast (Si > 13%)	DX110	YDEN0603PDFR-D	200 - 800	0.05 - 0.20
	Aluminum alloy	DX110	YDEN0603PDFR-D	500 - 4,000	0.05 - 0.20
	Copper alloy	DX110	YDEN0603PDFR-D	200 - 500	0.05 - 0.20

- The values in the above list are of standard recommendations and may require adjustments in consideration with cutting depths and/or workpiece/machine rigidity.
- Use wiper inserts (-WD) for better surface requirements and deburring inserts (-BD) to remove burrs.
- Always use wet cutting (emulsion coolant) for machining aluminum or copper alloys.

APPLICATION RANGE



Cutter : TPYD06J080B25.4R16 ($\phi = 80$ mm, z = 16)
 Insert : YDEN0603PDFR-D DX110
 Workpiece material : ADC12
 Cutting speed : Vc = 2,513 m/min
 Coolant : Wet
 Machine : Vertical M/C, BT40, 18.5 kW