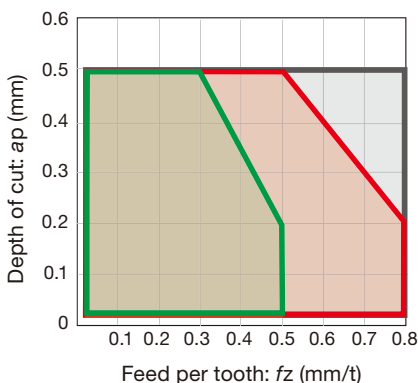


STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness	Priority	Grades	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
P	Carbon steels (S45C / C45, S55C / C55, etc)	- 300HB	First choice	AH3225	100 - 300	0.2 - 0.8
		- 300HB	For wear resistance	AH8015	100 - 300	0.2 - 0.8
	Alloy steels (SCM440 / 42CrMo4, etc)	- 300HB	First choice	AH3225	100 - 300	0.2 - 0.8
		- 300HB	For wear resistance	AH8015	100 - 300	0.2 - 0.8
	Prehardened steels (NAK80, PX5, etc)	30 - 40HRC	First choice	AH8015	100 - 200	0.2 - 0.5
		30 - 40HRC	For impact resistance	AH3225	100 - 200	0.2 - 0.5
M	Stainless steels (SUS304 / X5CrNi18-9, SUS316 / X5CrNiMo17-12-3, etc)	- 200HB	First choice	AH3225	100 - 150	0.2 - 0.5
K	Gray cast irons (FC250 / 250 / GG25, FC300 / 300 / GG30, etc)	150 - 250HB	First choice	AH8015	100 - 300	0.2 - 0.8
		150 - 250HB	For impact resistance	AH3225	100 - 300	0.2 - 0.8
	Ductile cast irons (FCD600 / 600-3 / GGG60, etc)	150 - 250HB	First choice	AH8015	80 - 200	0.2 - 0.8
		150 - 250HB	For impact resistance	AH3225	80 - 200	0.2 - 0.8
S	Titanium alloy (Ti-6Al-4V, etc)	- 40HRC	First choice	AH3225	30 - 60	0.1 - 0.3
		- 40HRC	For wear resistance	AH8015	30 - 60	0.1 - 0.3
	Heat resistance alloy (Inconel, Hastelloy, etc)	- 40HRC	First choice	AH8015	20 - 50	0.1 - 0.3
		- 40HRC	For impact resistance	AH3225	20 - 50	0.1 - 0.3
H	Hardened steel	SKD61 / X40CrMoV5-1, etc	40 - 50HRC	First choice	AH8015	80 - 150
		SKD11 / X153CrMoV12, etc	50-60HRC	First choice	AH8015	50 - 70

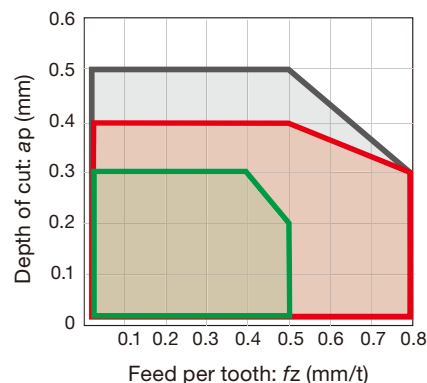
APPLICATION

LSMT02-HM



- For standard shanks in $\leq 3xD$
- For long-neck shanks in $\geq 4xD$
- For modular head shanks in $\geq 7xD$

LSMT02-MM



- For standard shanks in $\leq 3xD$
- For long-neck shanks in $\geq 4xD$
- For modular head shanks in $\geq 7xD$

* When the DOC is 0.5 mm or more, the feed less than 0.15 mm/t is recommended.