

STANDARD CUTTING CONDITIONS

For HD holder (High Depth of Cut)

ISO	Insert	Depth of cut a_p (mm)	Feed f (mm/rev)	Cutting speed V_c (m/min)	
				T9215	T9225
P	POMG110612-MNW	0.8 - 5.5	0.4 - 1.2	150 - 400	120 - 300
	POMG130612-MNW	1.0 - 7.0	0.4 - 1.3	150 - 400	120 - 300

ISO	Insert	Depth of cut a_p (mm)	Feed f (mm/rev)	Cutting speed V_c (m/min)	
				AH8015	
M	POMG110612-MNW	0.8 - 5.5	0.4 - 1.2	50 - 150	
	POMG130612-MNW	1.0 - 7.0	0.4 - 1.3	50 - 150	
S	POMG110612-MNW	0.8 - 5.5	0.4 - 1.2	20 - 80	
	POMG130612-MNW	1.0 - 7.0	0.4 - 1.3	20 - 80	

For HF holder (High Feed)

ISO	Insert	Depth of cut a_p (mm)	Feed f (mm/rev)	Cutting speed V_c (m/min)	
				T9215	T9225
P	POMG110612-MNW	1.0 - 2.5	0.5 - 1.5	150 - 400	120 - 300
	POMG130612-MNW	1.0 - 3.0	0.5 - 2.0	150 - 400	120 - 300

ISO	Insert	Depth of cut a_p (mm)	Feed f (mm/rev)	Cutting speed V_c (m/min)	
				AH8015	
M	POMG110612-MNW	1.0 - 2.5	0.5 - 1.5	50 - 150	
	POMG130612-MNW	1.0 - 3.0	0.5 - 2.0	50 - 150	
S	POMG110612-MNW	1.0 - 2.5	0.5 - 1.5	20 - 80	
	POMG130612-MNW	1.0 - 3.0	0.5 - 2.0	20 - 80	