

STANDARD CUTTING CONDITIONS



Boring, profiling, chamfering, back boring

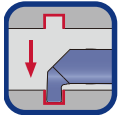
ISO	Workpiece materials	Grade	Cutting speed V _c (m/min)	Feed f (mm/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	0.01 - 0.08 *
	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	0.01 - 0.08 *
	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	0.01 - 0.08 *
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc.)	SH730	40 - 140	0.01 - 0.08 *
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	0.01 - 0.08 *
	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	0.01 - 0.08 *
N	Aluminium alloys, Copper alloys Si < 12%	SH730	90 - 200	0.01 - 0.08 *
S	Titanium alloys (Ti-6Al-4V, etc.)	SH730	30 - 100	0.01 - 0.08 *
	Superalloys (Inconel718, etc.)	SH730	30 - 100	0.01 - 0.08 *

* JBTR/L04020004-D006,
JBTR/L04030004-D006
Max. f = 0.01 mm/rev



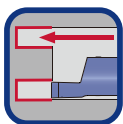
Threading (metric thread)

ISO	Workpiece materials	Grade	Cutting speed V _c (m/min)	Number of passes Pitch (mm)				
				0.5	0.75	1	1.25	1.5
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc.)	SH730	40 - 140	8	10	12	15	18
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	7	9	12	14	17
	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	7	9	12	14	17
N	Aluminium alloys, Copper alloys Si < 12%	SH730	90 - 200	6	8	10	12	15



Internal grooving

ISO	Workpiece materials	Grade	Cutting speed Vc (m/min)	Feed f (mm/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	0.01 - 0.03
	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	0.01 - 0.03
	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	0.01 - 0.03
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc)	SH730	40 - 140	0.01 - 0.03
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	0.01 - 0.03
	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	0.01 - 0.03
N	Aluminium alloys, Copper alloys Si < 12%	SH730	90 - 200	0.01 - 0.03
S	Titanium alloys Ti-6Al-4V etc.	SH730	30 - 100	0.01 - 0.03
	Superalloys (Inconel718, etc.)	SH730	30 - 100	0.01 - 0.03



Face grooving

ISO	Workpiece materials	Grade	Cutting speed Vc (m/min)	Feed f (mm/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	0.01 - 0.05
	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	0.01 - 0.05
	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	0.01 - 0.05
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc)	SH730	40 - 140	0.01 - 0.05
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	0.01 - 0.05
	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	0.01 - 0.05
N	Aluminium alloys, Copper alloys Si < 12%	SH730	90 - 200	0.01 - 0.05
S	Titanium alloys Ti-6Al-4V etc.	SH730	30 - 100	0.01 - 0.05
	Superalloys (Inconel718, etc.)	SH730	30 - 100	0.01 - 0.05