
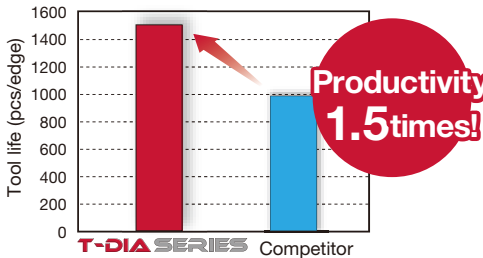


Standard cutting conditions

Work material	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)	Grade selection			
				DX110	DX120	DX140	DX160
Aluminum alloys (Si < 12%)	1500 (1000-2500)	0.5 (0.05-2.0)	0.1 (0.05-0.2)	◎	○	○	
Aluminum alloys (Si ≥ 12%)	600 (400-800)	0.5 (0.05-2.0)	0.1 (0.05-0.2)	◎	○	○	○
Copper and Brass	800 (500-1500)	0.5 (0.05-2.0)	0.1 (0.05-0.2)	◎	○		
Bronze	400 (300-500)	0.5 (0.05-2.0)	0.1 (0.05-0.2)	◎	○	○	
Carbon / Graphite	400 (300-500)	0.5 (0.05-2.0)	0.1 (0.05-0.2)		○	○	◎
FRP	700 (500-1000)	0.2 (0.05-0.5)	0.05 (0.03-0.1)		○	○	◎
Plastic	700 (500-1000)	0.2 (0.05-0.5)	0.03 (0.01-0.05)	◎	○	○	
Cemented carbide (D40 ~ D50)	15 (10-20)	0.1 (0.05-0.2)	0.03 (0.01-0.05)			○	◎
Green ceramics	130 (100-150)	0.5 (0.05-2.0)	0.05 (0.03-0.1)			○	◎

◎ : First choice ○ : Second choice

PRACTICAL EXAMPLES

Workpiece type		Copper-based sintered alloy
Insert		1QP-CCMT09T304, 1QP-CCMT32.51
Grade		DX110
Workpiece		
Cutting conditions	Cutting speed: Vc (m/min)	300
	Feed : f (mm/rev)	0.05
	Depth of cut : ap (mm)	0.1
	Coolant	Water soluble
Results		 <p>Thanks to its optimized rake angle and sharp cutting edge, DX110 eliminated burr formation on the machined surface, while extending tool life by 1.5x over the competitor's.</p>