STANDARD CUTTING CONDITIONS

For negative inserts

Chipbreaker	Grades	Corner radius r_ε	Depth of cut *a*p (mm)	Feed *f* (mm/rev)	Cutting speed: *V*c (m/min)	
					Grey cast iron	Ductile cast iron
CM	T515	0.8	1.0 - 5.0	0.15 - 0.40	150 - 700	150 - 300
	T515	1.2	1.0 - 5.0	0.15 - 0.50	150 - 700	150 - 300
CH	T515	0.4	2.0 - 6.0	0.10 - 0.30	150 - 700	150 - 300
	T515	0.8	2.0 - 6.0	0.20 - 0.45	150 - 700	150 - 300
	T515	1.2	2.0 - 6.0	0.20 - 0.65	150 - 700	150 - 300
All-round	T515	0.4	1.0 - 6.0	0.20 - 0.30	150 - 700	150 - 300
	T515	0.8	1.0 - 6.0	0.20 - 0.50	150 - 700	150 - 300
	T515	1.2	1.0 - 6.0	0.20 - 0.50	150 - 700	150 - 300
	T515	1.6	1.0 - 6.0	0.30 - 0.50	150 - 700	150 - 300
Fiat-top	T515	0.8	0.05 - 2.0	0.20 - 0.45	150 - 700	150 - 300
	T515	1.2	0.05 - 2.0	0.30 - 0.80	150 - 700	150 - 300
SW (Wiper)	T515	0.8	0.5 - 2.0	0.30 - 0.60	150 - 700	150 - 300
	T515	1.2	0.5 - 2.0	0.50 - 0.80	150 - 700	150 - 300

For positive insert

Chipbreaker	Grades	Corner radius r_ε	Depth of cut *a*p (mm)	Feed *f* (mm/rev)	Cutting speed: *V*c (m/min)	
					Grey cast iron	Ductile cast iron
CM	T515	0.4	0.05 - 2.0	0.05 - 0.2	150 - 700	150 - 300
	T515	0.8	0.05 - 2.0	0.05 - 0.3	150 - 700	150 - 300
	T515	1.2	0.05 - 2.0	0.05 - 0.3	150 - 700	150 - 300