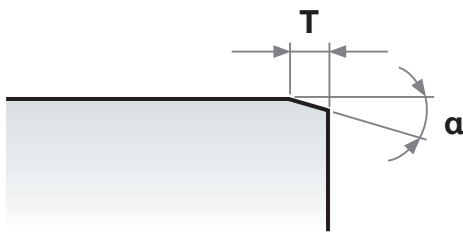


STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Cutting mode	Coolant	Grades	Cutting speed V_c (m/min)	Feed f (mm/rev)	Depth of cut a_p (mm)
K	Gray cast iron	Continuous	Dry	New TZ120	400 - 850	0.1 - 0.3	0.5 - 2
		Continuous, light interrupted	Dry	LX21	400 - 800	0.1 - 0.4	0.5 - 2
		Continuous, interrupted	Dry, Wet	FX105	300 - 600	0.2 - 0.6	0.5 - 4
	Centrifugal cast iron	Continuous	Dry	New TZ120	150 - 400	0.1 - 0.3	0.5 - 2

- TZ120 is suitable for dry continuous turning

STANDARD EDGE PREPARATION



K	Grades	New TZ120	LX21	FX105
	T (mm)	0.1	0.1	0.2
α	20°	30°	25°	