
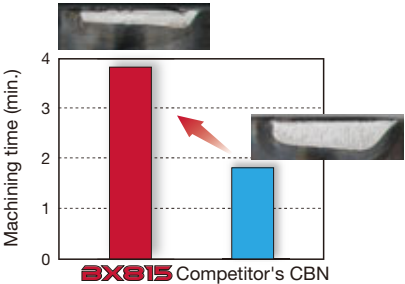


## STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grade	Work condition	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
<b>S</b>	Super alloy (Inconel718, etc.)	BX815	Continuous to light interrupted	80 - <b>300</b> - 500	0.05 - <b>0.25</b> - 0.5	0.05 - <b>0.2</b> - 0.3

for high-efficiency machining **Vc** = 200 - 500 m/min  
for longer tool life **Vc** = 80 - 200 m/min

## PRACTICAL EXAMPLES

Workpiece type		Disk
Toolholder		PDJNL type special
Insert		2QP-DNGA150412
Grade		BX815
Workpiece material		Inconel718
		
Cutting conditions	Cutting speed: Vc (m/min)	<b>350</b>
	Feed : f (mm/rev)	0.2
	Depth of cut : ap (mm)	0.5
	Machining	External turning
	Coolant	Wet
Results		<p>After 2 minutes machining</p>  <p><b>BX815</b> showed twice the tool life compared to the previous grade.</p>