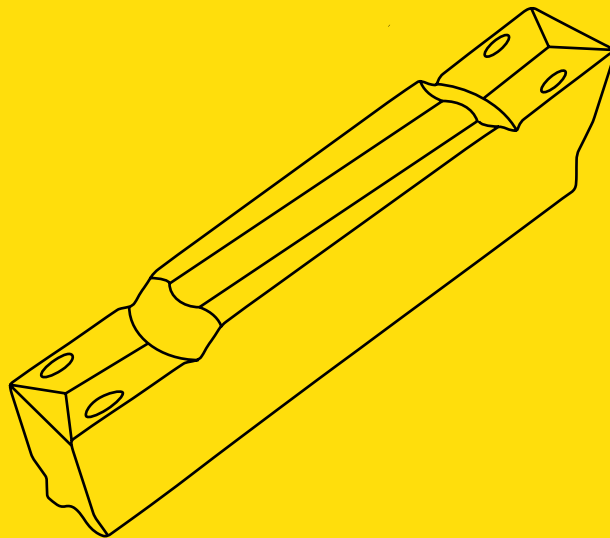


GROOVING / diamond



- TURNING
- GROOVING
- THREADING
- MILLING
- DRILLING
- ENDMILLS
- DRILLS
- SPARE PARTS
- INDEX

Grades

ISO DIN 513	N				
	N01	N10	N20	N30	N40
PCD			PC100		
		PC150			
		PC200			
	PC300				

Cutting Parameters

NA	ALUMINIUM ALLOYS
NS	ALUMINIUM ALLOYS (Si≤15%)
NH	AL ALLOYS AGED AND HARDENED
NB	BRASS

NC	BRONZE AND ELECTROLYTIC COPPER
NG	GRAPHITE
HM	HARD METAL (Co≤16%)
ST	TITANIUM ALLOYS

MATERIAL		fn (mm/rev)	CUTTING CONDITION			PCD					
						PC100	PC150	PC200	PC300		
N	NA	0,05~0,15	○	⊕	☉		600~2500	600~2500			
		0,05~0,15	○	⊕	☉		600~2500	600~2500			
	NS	0,05~0,15	○	⊕	☉		500~1500	500~1500			
		0,05~0,15	○	⊕	☉		500~1500	500~1500			
	NB	0,05~0,15	○	⊕	☉		400~1200	400~1200			
		0,05~0,15	○	⊕	☉		400~1200	400~1200			
	NG	0,05~0,15	○	⊕	☉		300~800	300~800			
		0,05~0,15	○	⊕	☉		300~800	300~800			