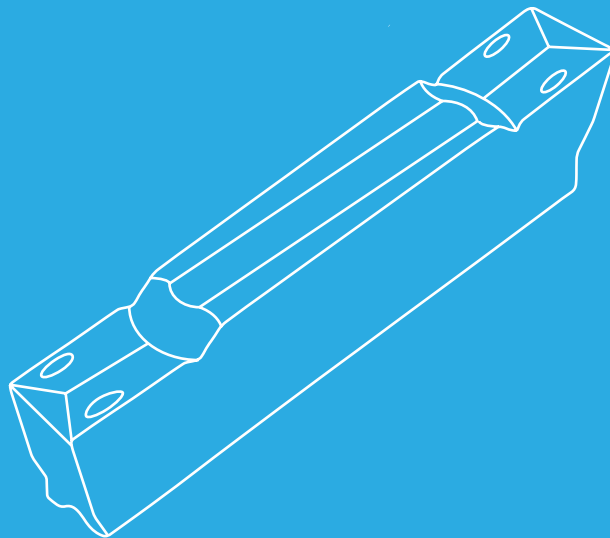
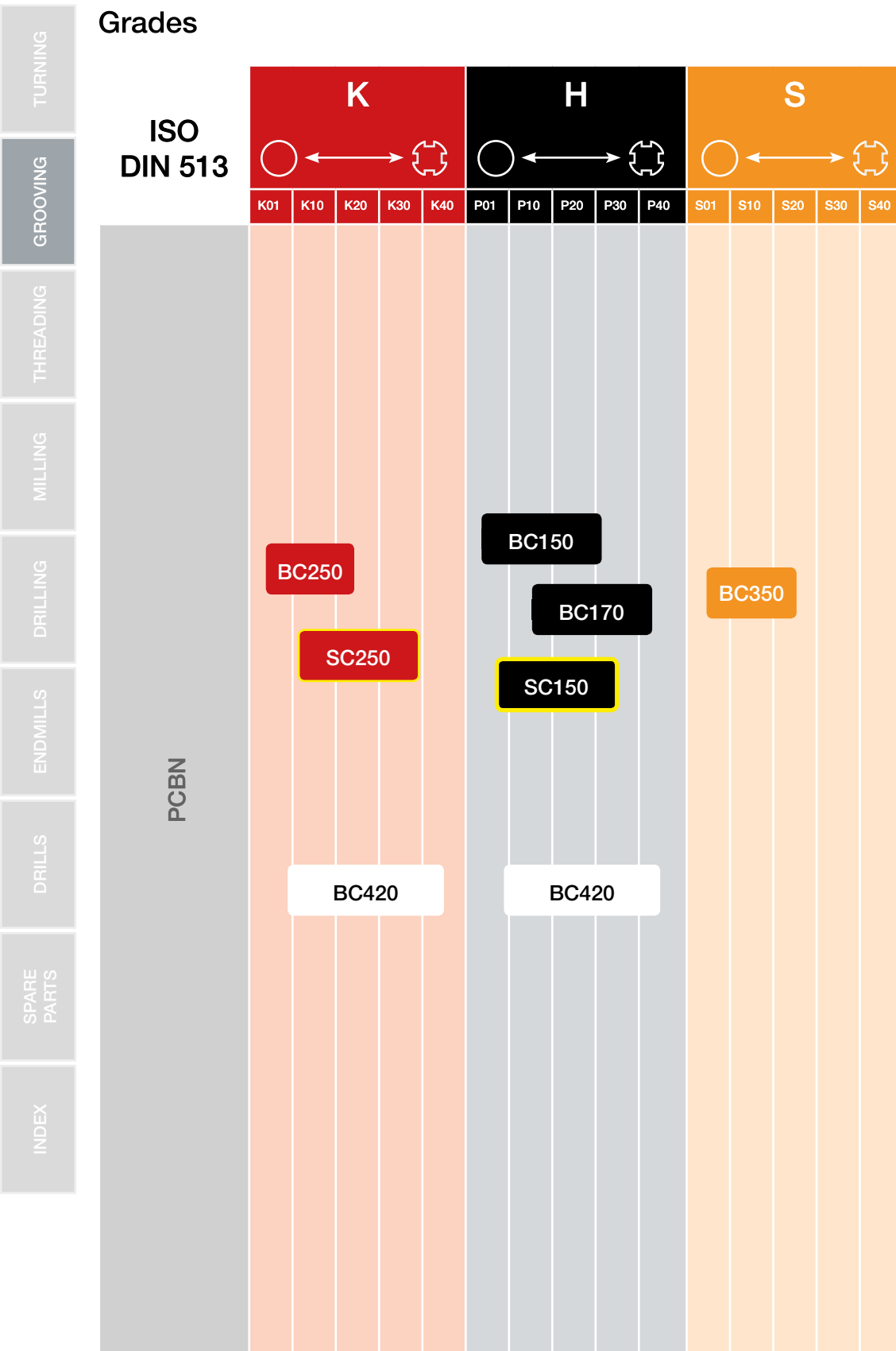


GROOVING / PCBN





Cutting Parameters

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS



















DRILLS

SPARE PARTS

INDEX

KG	GREY CAST IRON
KN	NODULAR CAST IRON
KW	WHITE CAST IRON
KS	SINTERED MATERIAL

HH	HARDENED STEEL
HC	CASE HARDENED STEEL
HB	BEARING STEEL
SA	SUPER ALLOYS (Ni Based)

MATERIAL		fn (mm/rev)	CUTTING CONDITION	PCBN						
				BC150	BC170	SC150	BC250	SC250	BC350	BC420
H	HH	0,05~0,15	  	80~180	80~180					80~150
			  	60~120	60~120					80~150
	HC	0,05~0,15	  	80~140	80~140					80~140
			  	60~100	60~100					80~140
	HB	0,05~0,15	  	80~120	80~120					80~120
			  	60~100	60~100					80~120