

RECOMMENDED CUTTING CONDITIONS

CCGT MINI INSERTS

ISO P M K N S H

WORK MATERIAL	Vc Cutting speed • m/min	f Feed • mm/rev	ap Depth of cut • mm	l/d
P **Carbon Steel, Alloy Steel** 180–350HB	**80** 40 – 120	**0.03** 0.01 – 0.05	**0.2** 0.1 – 0.3	**3 – 5**
M **Stainless Steel** ≤200HB	**80** 40 – 120	**0.03** 0.01 – 0.05	**0.2** 0.1 – 0.3	**3 – 5**
K **Cast Iron** ≤350MPa	**80** 40 – 120	**0.03** 0.01 – 0.05	**0.2** 0.1 – 0.3	**3 – 5**
N **Non-Ferrous Material**	**120** 80 – 160	**0.05** 0.01 – 0.08	**0.4** 0.1 – 0.6	**3 – 5**
H **Heat Treated Steel** 35–65HRC	**80** 40 – 120	**0.03** 0.01 – 0.05	**0.1** 0.03 – 0.2	**3 – 5**

How to read: the large figure is the recommended starting value; the range underneath is the working range.

Vc	f	ap	l/d
Cutting speed (m/min)	Feed (mm/rev)	Depth of cut (mm)	Length / diameter ratio