

RECOMMENDED CUTTING CONDITIONS

■ General Machining

Work Material	Tensile Strength	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)
K Cast Iron	≤200MPa	MC5020	300 (250—350)	0.3 (0.2—0.4)
	250—350 MPa		220 (150—300)	0.3 (0.2—0.4)
Ductile Cast Iron	≤450MPa		200 (150—250)	0.2 (0.1—0.3)
	500—800 MPa		170 (150—200)	0.2 (0.1—0.3)

■ Finishing (When using wiper insert)

Work Material	Axial Depth of Cut (mm)	Cutting Speed (m/min)	Feed per Revolution (mm/rev.)
K Cast Iron	<0.5	320 (250—400)	0.2 (0.1—0.3)
	0.5—3	270 (200—350)	
Ductile Cast Iron	<0.5	270 (200—350)	
	0.5—3	220 (200—250)	