

WSF406W

RECOMMENDED CUTTING CONDITIONS

DRY CUTTING

Cutting conditions: ●: Stable cutting ●: General cutting ✖: Unstable cutting

Material	Properties	Conditions	ap	Grade	Vc	fz	ae
Cast irons	≤350MPa	●	<2.0 mm	MC520	250 (210–300)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	220 (190–260)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	200 (180–230)	0.10 (0.08–0.15)	<0.8
		●	<2.0 mm	MC520	220 (190–260)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	200 (180–230)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	180 (160–210)	0.10 (0.08–0.15)	<0.8
		✖	<2.0 mm	MC520	200 (180–230)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	180 (160–210)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	150 (100–180)	0.10 (0.08–0.15)	<0.8
Ductile cast irons	≤450MPa	●	<2.0 mm	MC520	200 (170–230)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	180 (150–210)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	160 (130–190)	0.10 (0.08–0.15)	<0.8
		●	<2.0 mm	MC520	180 (150–210)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	160 (130–190)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	140 (110–170)	0.10 (0.08–0.15)	<0.8
		✖	<2.0 mm	MC520	160 (130–190)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	140 (110–170)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	120 (90–150)	0.10 (0.08–0.15)	<0.8
Ductile cast irons	≤800MPa	●	<2.0 mm	MC520	200 (170–230)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	180 (150–210)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	160 (130–190)	0.10 (0.08–0.15)	<0.8
		●	<2.0 mm	MC520	180 (150–210)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	160 (130–190)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	140 (110–170)	0.10 (0.08–0.15)	<0.8
		✖	<2.0 mm	MC520	160 (130–190)	0.15 (0.10–0.25)	<0.8
			2.0 mm – 4.0 mm	MC520	140 (110–170)	0.13 (0.10–0.20)	<0.8
			4.0 mm – 7.5 mm	MC520	120 (90–150)	0.10 (0.08–0.15)	<0.8