

## Grades, Speeds & Feeds

MATERIAL	RECOMMENDED CARBIDE GRADE	FEED MM/REV			
		0,05	0,1	0,2	0,4
CUTTING SPEED M/MIN					
Low carbon steel	P30C		180	130	110
Carbon steel	P30C	200	190	160	85
Alloyed steel	P30C	165	150	110	
Stainless steel	P30C	155	140	100	
Cast steel	P30C	115	95	80	60
Heat resistant Iron-based alloys	K10C	125	80	80	50
Hard steel (Manganese steel)	K10		30	25	
Malleable Iron	K10C	160	150	130	85
Cast Iron	K10C	155	135	120	85
Aluminium alloys	K10	350	300	300	200
Heat resistant Nickel-based alloys	K10	35	25	15	
Heat resistant Cobalt-based alloys	K10	35	25	15	
Non-Ferous materials	K10	300	200	150	100

### RECOMMENDATIONS FOR SIDE TURNING

- Cutting speed same as cutting speed for grooving.
- Feed from 0,1 mm. to 0,25 mm.
- Cutting depth: min. 0,25 mm.  
max. 0,8 x cutting width of insert.

### NOTE

The above data are for guidance only. Actual performance depends on various factors, such as mounting stability, workpiece shape and specific material characteristics.