

Recommended Cutting Conditions

Dry-Wet Cutting

(inch)

Work Material	Tensile Strength	Grade	vc (SFM)	fz (IPT)
K Gray Cast Iron	≤350MPa	MC5020	720 (490-985)	.012 (.008-.016)
		VP15TF VP20RT	590 (425-755)	.012 (.008-.016)
Ductile Cast Iron	≤450MPa	MC5020	655 (490-820)	.008 (.004-.012)
		VP15TF VP20RT	560 (395-720)	.008 (.004-.012)
	≤800MPa	MC5020	560 (490-655)	.008 (.004-.012)
		VP15TF VP20RT	460 (330-590)	.008 (.004-.012)

*Use 2-3 pcs of Wiper inserts in case of 'over .236 IPR'.

(Note) With reference to the above examples, adjust the cutting conditions according to the use environment.

(Note) Tool life when wet cutting is short compared to dry cutting.

Finishing (Use of Wiper Inserts)

(inch)

Work Material	Grade	ap	vc (SFM)	fz (IPT)
K Gray Cast Iron	MC5020	<.0197	1050 (820-1310)	.008 (.004-.012)
		.0197-.118	855 (655-1150)	
Ductile Cast Iron	MC5020	<.0197	855 (655-1150)	
		.0197-.118	720 (655-820)	