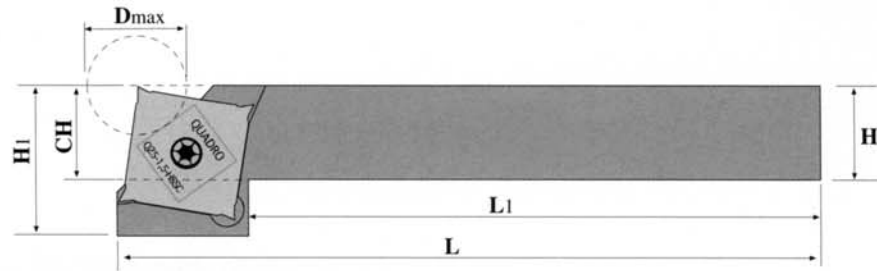


# Technical Information - Speeds & Feeds

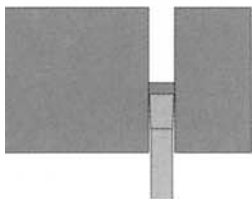
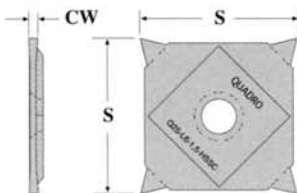


Insert pocket 2 Left

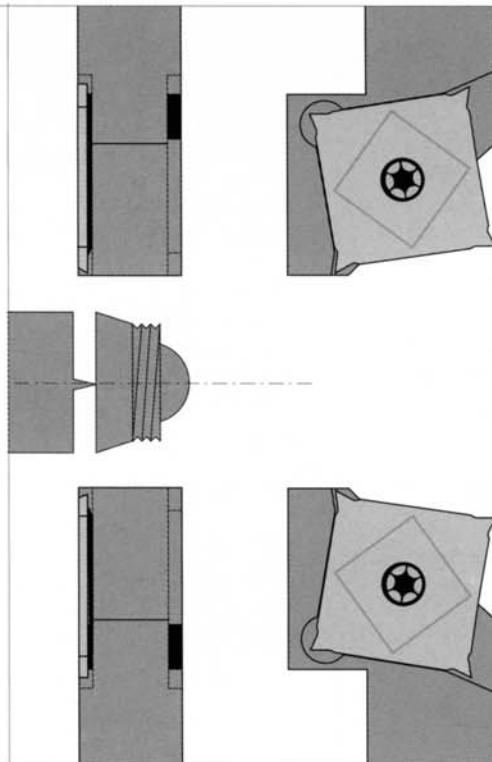
Insert pocket 1 Right



## INSERTS WITH 0° FRONT ANGLE



These inserts can be used as RH inserts as well as LH inserts.



### ATTENTION!

These inserts can only be used as **LH** insert in insert pocket (2) (see drawing of toolholder)

## INSERTS WITH 6° OR 12° FRONT ANGLE

### ATTENTION!

These inserts can only be used as **RH** insert in insert pocket (1) (see drawing of toolholder)

## CUTTING SPEEDS & FEEDS

Material	Cutting speed m/min	Feed mm/rev (Cutting width)						
		0,7~0,9	1,0	1,2	1,5	2,0	2,5	3,0
Unalloyed steel	40 ~ 60	0,05~0,8	0,08~0,1	0,08~0,1	0,1~0,15	0,1~0,2	0,1~0,2	0,1~0,25
Alloyed steel	30 ~ 50	0,04~0,5	0,04~0,06	0,05~0,06	0,05~0,1	0,08~0,15	0,1~0,18	0,1~0,2
Heat resistand steel	30 ~ 40	0,04~0,5	0,04~0,06	0,05~0,06	0,05~0,1	0,08~0,15	0,1~0,18	0,1~0,2
Stainless steel	30 ~ 40	0,04~0,5	0,05~0,06	0,05~0,06	0,05~0,1	0,08~0,15	0,1~0,18	0,1~0,2
Cast iron	20 ~ 30	0,04~0,5	0,05~0,06	0,05~0,06	0,05~0,1	0,08~0,15	0,1~0,18	0,1~0,2
Non-Ferrous materials	~ 150	~0,15	~0,2	~0,2	~0,25	~0,25	~0,25	~0,3

Values are based on a cutting edge lifetime of 15 minutes.