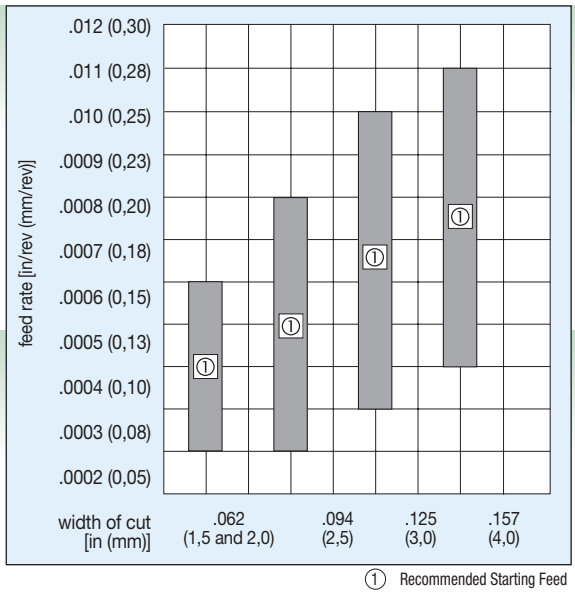
Feed Values for Grooving Inserts

CM Cut-Off Medium

- Double-ended, V-bottom and top, mechanically clamped.
- Neutral, right-, and left-hand lead angles up to 12°.
- Designed to increase speed and feed.
- Chip geometry designed for excellent chip control and minimised cutting pressure on various materials.
- Ideal for 300 Series stainless steel, tool steel, titanium, INCONEL®, and other nickel-based alloys at moderate speeds and feeds.

CM-W Cut-Off Medium with Wiper

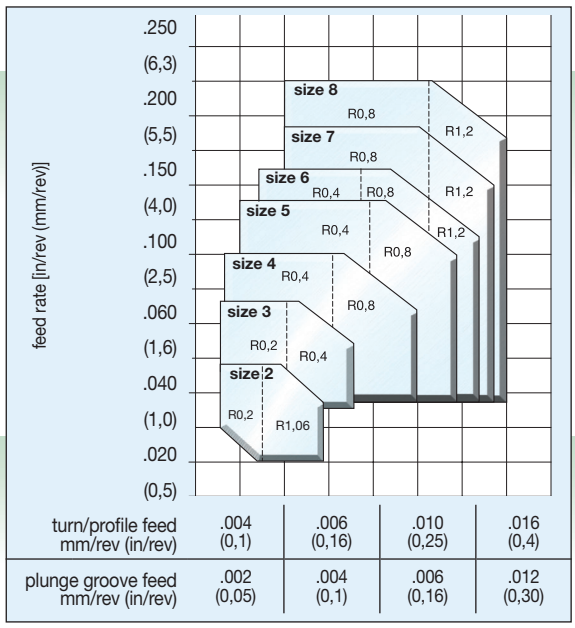
- Wiper flats where surface finish is critical.
- Double-ended, V-bottom, and top, mechanically clamped.
- Neutral, right-, and left-hand lead angles up to 12°.
- Designed to increase speed and feed.
- Chip geometry designed for excellent chip control and minimised cutting pressure on various materials.



① Recommended Starting Feed

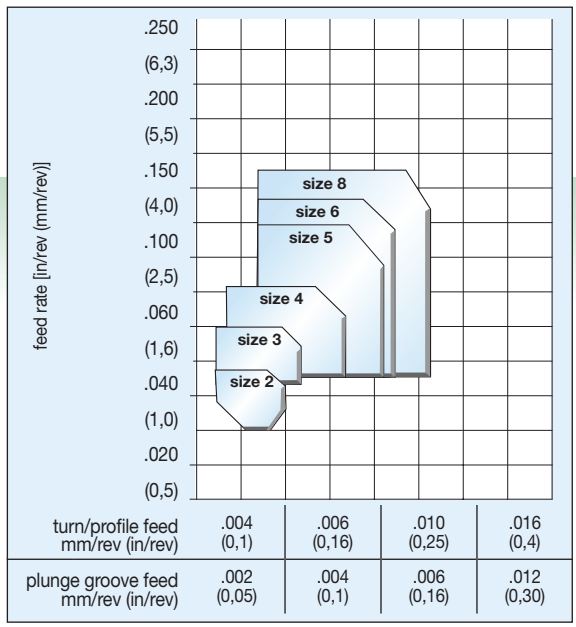
PT Plunge, Groove, and Turn Inserts

- High positive rake geometry for low cutting force, especially in soft materials.
- Deep grooving tool for plunge and turn O.D. and face grooving operations.
- Delivers chip control over full range of DOC when turning.
- Cuts in both axial and radial directions.



PC Grooving and Profiling Inserts

- Superior chip control.
- Full nose radius geometry for plunge and contour operations.
- Effective cutting edge geometry exceeds 180° for increased versatility.



PH Plunge, Groove, and Turn Inserts

- Excellent performance in greater than 35 HRC.
- Deep grooving tool for plunge and turn O.D. and face grooving operations.
- Delivers chip control over full range of DOC when turning.
- Delivers superior chip control in interrupted cuts.

Recommended Cutting Speeds • Metric

Material Group		Cutting Speed – vc m/min														
		WU10HT			WU10PT			WU25PT			WP10CT			WP25CT		
		min	Start	max	min	Start	max	min	Start	max	min	Start	max	min	Start	max
P	0/1	100	**100**	110	190	**200**	210	170	**175**	180	210	**225**	240	170	**175**	180
	2	95	**95**	105	180	**185**	190	150	**160**	170	210	**220**	230	185	**195**	205
	3	95	**95**	105	180	**185**	190	150	**160**	170	210	**220**	230	185	**195**	205
	4	70	**70**	75	165	**170**	175	135	**145**	155	140	**145**	155	125	**125**	135
	5	85	**90**	95	170	**175**	180	140	**150**	160	180	**190**	195	155	**165**	170
	6	50	**50**	50	140	**150**	160	120	**125**	130	70	**75**	80	70	**75**	80
M	1	70	**75**	80	120	**125**	130	120	**125**	130	–	**–**	–	–	**–**	–
	2	50	**50**	50	100	**100**	110	70	**75**	80	–	**–**	–	–	**–**	–
	3	50	**50**	50	95	**100**	105	85	**90**	95	–	**–**	–	–	**–**	–
K	1	85	**90**	95	190	**200**	210	155	**165**	170	215	**225**	235	180	**190**	195
	2	75	**75**	80	185	**190**	200	155	**165**	175	205	**215**	225	175	**185**	195
	3	70	**75**	80	170	**175**	180	140	**150**	160	210	**225**	240	190	**200**	210
N	1	70	**75**	80	140	**150**	160	110	**120**	130	–	**–**	–	–	**–**	–
	2	70	**75**	80	140	**150**	80	110	**120**	80	–	**–**	–	–	**–**	–
	3	70	**75**	80	140	**150**	80	110	**120**	80	–	**–**	–	–	**–**	–
	4	70	**75**	80	140	**150**	80	110	**120**	80	–	–	–	–	–	–
	5	70	**75**	80	140	**150**	80	110	**120**	80	–	**–**	–	–	**–**	–
	6	70	**75**	80	140	**150**	80	110	**120**	80	–	**–**	–	–	**–**	–
	7	70	**75**	80	140	**150**	120	110	**120**	105	–	**–**	–	–	**–**	–
S	1	20	**25**	30	70	**75**	80	60	**65**	65	–	**–**	–	–	**–**	–
	2	20	**25**	30	65	**65**	70	50	**50**	50	–	**–**	–	–	**–**	–
	3	50	**50**	50	100	**100**	110	70	**75**	80	–	**–**	–	–	**–**	–
	4	–	**–**	–	70	**75**	80	50	**50**	50	–	**–**	–	–	**–**	–
H	1	–	**–**	–	15	**30**	60	15	**30**	60	–	**–**	–	–	**–**	–
	2	–	**–**	–	15	**30**	60	15	**30**	60	–	**–**	–	–	**–**	–
	3	–	**–**	–	15	**30**	60	15	**30**	60	–	**–**	–	–	**–**	–
	4	–	**–**	–	15	**30**	60	15	**30**	60	–	**–**	–	–	**–**	–