KNUX CUTTING DATA



COPY TURNING TYPE

				Material	P			M		K		N	S	H
					Non-alloy steel <25 HRc	Low alloy steel 25-35 HRc	High alloy steel, Tool steel 35-45 HRc	Ferritic / Martensitic Stainless steel	Austenitic Stainless steel	Grey Cast iron	Nodular Cast iron	Aluminium & Non-ferrous material	Heat Resistant and Super Alloys	Hard materials <55 HRc
Order Code	Insert	f_n (mm/rev)	a_p (mm)	VDI	1-5	6-9	10-11	12-13	14	15-16	17-20	21-30	31-37	38-41
KEN1206542N	KNUX160405-RH C25PK TURNING INSERT	0.10 - 0.40	0.5 - 6.0	v_c (m/min)	120 - 200	70 - 230	70 - 180	70 - 180	-	60 - 160	60 - 120	-	-	40 - 80
KEN1206542P	KNUX160405-RH C25PM TURNING INSERT	0.10 - 0.40	0.5 - 6.0		150 - 350	90 - 300	70 - 250	120 - 220	50 - 180	-	-	-	-	-

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up.
The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

Cromwell Group Ltd, Leicester, LE18 2FS, England, **Tel:** 0800 338 877, **Email:** contactus@cromwell.co.uk, **Website:** www.cromwell.co.uk