VCGT CUTTING DATA



35º DIAMOND 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
KEN1208441K	VCGT110302-N ALU TURNING INSERT	0.02 - 0.08	0.5 - 1.0	Vc (m/min)	-	-	-	-	-	-	-	250 - 800	-	-
KEN1208441L	VCGT110304-N ALU TURNING INSERT	0.05 - 0.25	0.2 - 3.0		-	-	-	-	-	-	-	250 - 800	-	-
KEN1208441M	VCGT160402-N ALU TURNING INSERT	0.02 - 0.05	0.5 - 1.0		-	-	-	-	-	-	-	250 - 800	-	-
KEN1208441N	VCGT160404-N ALU TURNING INSERT	0.05 - 0.25	0.5 - 2.0		-	-	-	-	-	-	-	250 - 800	-	-
KEN1208441P	VCGT160408-N ALU TURNING INSERT	0.10 - 0.35	1.0 - 3.0		-	-	-	-	-	-	-	250 - 800	-	-

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.

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