

Technical Information

Recommended cutting conditions

Nanocut

YG812 GRADE			Cutting Speed		Feed per Revolution (Fn)	
ISO	VDI	Sub Group	Vc (m/min.)		Fn (mm/rev.)	
			Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	170	200	0.015	0.025
	6~9	Low-Alloyed Steel	95	160	0.015	0.025
	10~11	High-Alloyed Steel	85	95	0.015	0.025
M	12~13	Ferritic & Martensitic	105	140	0.015	0.025
	14	Austenitic Stainless Steel	95	130	0.015	0.025
K	15~16	Grey Cast Iron	140	190	0.015	0.025
	17~18	Nodular Cast Iron	140	190	0.015	0.025
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-
S	31~37	Superalloys & Titanium	10	75	0.015	0.025
H	38~41	Hard Materials	-	-	-	-

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION