

Technical Information

Recommended cutting conditions

Turning

Cutting Speed			Vc (m/min.)															
ISO	VDI	Sub Group	YG1010		YG1001		YG3010		YG3015		YG3115		YG3020		YG3030		YG801	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	-	-	220	480	230	450	200	430	180	500	160	380	130	350	120	200
	6~9	Low-Alloyed Steel	-	-	220	420	180	380	150	350	170	450	140	320	130	280	70	200
	10~11	High-Alloyed Steel	-	-	-	-	60	200	90	180	60	300	60	130	70	110	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	-	-			-	-			-	-
	14	Austenitic Stainless Steel	-	-	-	-	-	-	-	-			-	-			-	-
K	15~16	Grey Cast Iron	300	450	250	420	120	300	-	-			-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	350	120	300	120	280	-	-			-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-			-	-	-	-	-	-
S	31~37	Superalloys & Titanium	-	-	-	-	-	-	-	-			-	-	-	-	-	-
H	38~41	Hard Materials	-	-	-	-	-	-	-	-			-	-	-	-	-	-

Turning

Cutting Speed			Vc (m/min.)															
ISO	VDI	Sub Group	YG2025		YG211		YG213		YG214		YG401		YT100		YG100		YG10	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel			-	-	-	-	-	-	-	-	150	480	-	-	-	-
	6~9	Low-Alloyed Steel			-	-	-	-	-	-	-	-	160	480	-	-	-	-
	10~11	High-Alloyed Steel			-	-	-	-	-	-	-	-	70	180	-	-	-	-
M	12~13	Ferritic & Martensitic	170	220	170	270	120	180	100	150	-	-	150	280	-	-	-	-
	14	Austenitic Stainless Steel	150	200	150	230	40	160	100	150	-	-	130	260	-	-	-	-
K	15~16	Grey Cast Iron			-	-	-	-	-	-	-	-	130	450	-	-	-	-
	17~18	Nodular Cast Iron			-	-	-	-	-	-	-	-	100	400	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)			-	-	-	-	-	-	-	-	-	-	250	1200	250	800
S	31~37	Superalloys & Titanium			30	100	30	70	30	50	30	90	-	-	-	-	-	-
H	38~41	Hard Materials			-	-	-	-	-	-	-	-	-	-	-	-	-	-

Parting & Grooving

Cutting Speed			Vc (m/min.)			
ISO	VDI	Sub Group	YG602G (YG602)		YG603	
			Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	120	180		
	6~9	Low-Alloyed Steel	100	140		
	10~11	High-Alloyed Steel	80	110		
M	12~13	Ferritic & Martensitic	70	160	50	90
	14	Austenitic Stainless Steel	55	140	40	80
K	15~16	Grey Cast Iron	110	185		
	17~18	Nodular Cast Iron	110	140		
N	21~30	Non-Ferrous Metals (Al)	250	440		
S	31~37	Superalloys & Titanium	25	45		
H	38~41	Hard Materials	25	50		