

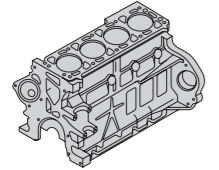






Recommended Types of Materials and Applications : BIDE MICS, Ceramics and CBN ●1st Choice ○2nd Choice

Work material	Tool Grade	Application			Coolant			Cutting speed (SFM)										Feed rate (IPR / IPT)						Depth of cut (inch)					
		Roughing	Semi-finishing	Finishing	Dry	Wet	150	300	600	900	1200	1500	1800	2100	2400	2700	3000	.004	.008	.012	.016	.020	.024	.02	.04	.08	.12	.16	
Heat-resistant alloy 	BIDE MICS	JX1	○	○	○	●	○																						
		JP2		○	○	●	○																						
	Ceramic	SX5	○			○	○			○	○																		
		SX7/SX9	○			○	○	○		○	○				○	○													
		WA1	○			○	○	○		○	○																		
* Based on Using 1/2" IC Insert except JP2																													
Gray cast iron  	Ceramic	SX6	○			○	○																						
		SP9	○			○	○																						
		HC1/HW2			○	○	○																						
		HC2/HC6			○	○	○																						
		WA1			○	○	○																						
	ZBC	B99	○			○	○																						
		B23/B30			○	○																							
Chilled Liners 	Ceramic	HW2	○	○	○	○	○																						
		HC2		○	○	○	○																						
Ductile cast iron 	Ceramic	SP9	○			○	○																						
		HC6			○	○	○																						
	ZBC	B52			○	○	○																						
Hardened material 	Ceramic	ZC4/ZC7			○	○	○																						
		B5K/B52	○			○	○																						
	ZBC	B6K/B36	○			○	○																						
		B40	○			○	○																						
Rolls 	Ceramic	WA1	○			○	○																						
		HC7			○	○	○																						
	ZBC	B23/B6K/B36			○	○	○																						
		HC5/HC2/HC7			○	○	○																						
	Ceramic	B30			○	○	○																						
		HC5/HC6			○	○	○																						
* Based on Using 1/2" IC Insert																													

• Starting speed based on using CNGA432 insert