









Recommended depth of cut and cutting feed

General turning

CoroTurn® 107 positive basic-shape inserts

| Insert | Rec. depth of cut | | | Rec. cutting feed | | | |
|--|-------------------|------|------|---------------------|------|------|------|
| | $a_p = \text{mm}$ | | | $f_n = \text{mm/r}$ | | | |
| | Min | Max | | Min | Max | | |
|  WF P ¹⁾ M S | CCMT060204-WF | 0.80 | 0.30 | 2.00 | 0.12 | 0.05 | 0.30 |
| | CCMT060208-WF | 0.80 | 0.30 | 2.00 | 0.15 | 0.09 | 0.35 |
| | CCMT09T304-WF | 1.00 | 0.30 | 3.00 | 0.20 | 0.07 | 0.30 |
| | CCMT09T308-WF | 1.00 | 0.30 | 3.00 | 0.25 | 0.12 | 0.35 |
| | DCMX070204-WF | 0.70 | 0.30 | 2.00 | 0.12 | 0.05 | 0.25 |
| | DCMX070208-WF | 0.70 | 0.30 | 2.00 | 0.15 | 0.09 | 0.35 |
| | DCMX11T304-WF | 1.00 | 0.30 | 3.00 | 0.20 | 0.07 | 0.30 |
| | DCMX11T308-WF | 1.00 | 0.30 | 3.00 | 0.25 | 0.12 | 0.35 |
| | TCMX090204-WF | 0.70 | 0.30 | 2.00 | 0.12 | 0.05 | 0.30 |
| | TCMX090208-WF | 0.70 | 0.30 | 2.00 | 0.25 | 0.10 | 0.35 |
| | TCMX110304-WF | 1.00 | 0.30 | 2.50 | 0.20 | 0.07 | 0.30 |
| | TCMX110308-WF | 1.00 | 0.30 | 2.50 | 0.25 | 0.12 | 0.35 |
|  WM P ¹⁾ M S | CCMT060208-WM | 1.20 | 0.50 | 2.50 | 0.20 | 0.10 | 0.40 |
| | CCMT09T304-WM | 1.50 | 0.50 | 4.00 | 0.25 | 0.12 | 0.40 |
| | CCMT09T308-WM | 1.50 | 0.70 | 4.00 | 0.30 | 0.15 | 0.50 |
| | DCMX11T304-WM | 1.50 | 0.50 | 4.00 | 0.25 | 0.12 | 0.40 |
| | DCMX11T308-WM | 1.50 | 0.50 | 4.00 | 0.30 | 0.15 | 0.50 |
| | TCMX110304-WM | 1.20 | 0.50 | 3.00 | 0.25 | 0.12 | 0.35 |
| TCMX110308-WM | 1.20 | 0.50 | 3.00 | 0.30 | 0.15 | 0.50 | |
|  PF P ¹⁾ | CCMT060202-PF | 0.30 | 0.06 | 1.70 | 0.06 | 0.03 | 0.11 |
| | CCMT060204-PF | 0.30 | 0.10 | 1.70 | 0.08 | 0.05 | 0.17 |
| | CCMT09T302-PF | 0.40 | 0.08 | 2.00 | 0.08 | 0.04 | 0.15 |
| | CCMT09T304-PF | 0.40 | 0.10 | 2.00 | 0.11 | 0.06 | 0.23 |
| | CCMT09T308-PF | 0.40 | 0.20 | 2.00 | 0.15 | 0.08 | 0.30 |
| | DCMT070202-PF | 0.30 | 0.06 | 1.50 | 0.06 | 0.03 | 0.11 |
| | DCMT070204-PF | 0.30 | 0.08 | 1.50 | 0.08 | 0.05 | 0.17 |
| | DCMT11T302-PF | 0.40 | 0.08 | 2.00 | 0.08 | 0.04 | 0.15 |
| | DCMT11T304-PF | 0.40 | 0.10 | 2.00 | 0.11 | 0.06 | 0.23 |
| | DCMT11T308-PF | 0.40 | 0.20 | 2.00 | 0.15 | 0.08 | 0.30 |
| | TCMT06T102-PF | 0.30 | 0.06 | 1.50 | 0.06 | 0.03 | 0.11 |
| | TCMT06T104-PF | 0.30 | 0.08 | 1.50 | 0.08 | 0.05 | 0.17 |
| | TCMT06T108-PF | 0.30 | 0.10 | 1.50 | 0.11 | 0.06 | 0.23 |
| | TCMT090202-PF | 0.30 | 0.06 | 1.70 | 0.06 | 0.03 | 0.13 |
| | TCMT090204-PF | 0.30 | 0.10 | 1.70 | 0.10 | 0.05 | 0.19 |
| | TCMT110302-PF | 0.30 | 0.06 | 1.70 | 0.06 | 0.03 | 0.13 |
| | TCMT110304-PF | 0.30 | 0.10 | 1.70 | 0.10 | 0.05 | 0.19 |
| | TCMT110308-PF | 0.30 | 0.10 | 1.70 | 0.13 | 0.07 | 0.26 |
| | VBMT110302-PF | 0.30 | 0.06 | 1.70 | 0.06 | 0.03 | 0.13 |
| | VBMT110304-PF | 0.30 | 0.10 | 1.70 | 0.10 | 0.05 | 0.19 |
| VBMT110308-PF | 0.30 | 0.10 | 1.70 | 0.13 | 0.07 | 0.26 | |
| VBMT160402-PF | 0.30 | 0.07 | 1.80 | 0.07 | 0.04 | 0.14 | |
| VBMT160404-PF | 0.30 | 0.10 | 1.80 | 0.10 | 0.05 | 0.20 | |
| VBMT160408-PF | 0.30 | 0.10 | 1.80 | 0.14 | 0.07 | 0.27 | |
| VBMT160412-PF | 0.30 | 0.10 | 1.80 | 0.16 | 0.09 | 0.32 | |
|  PM P ¹⁾ | CCMT060204-PM | 0.60 | 0.20 | 2.40 | 0.11 | 0.06 | 0.17 |
| | CCMT060208-PM | 0.60 | 0.40 | 2.40 | 0.15 | 0.08 | 0.23 |
| | CCMT09T304-PM | 0.60 | 0.30 | 3.00 | 0.15 | 0.08 | 0.23 |
| | CCMT09T308-PM | 0.80 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 |
| | DCMT070204-PM | 0.60 | 0.20 | 2.30 | 0.11 | 0.06 | 0.17 |
| | DCMT070208-PM | 0.60 | 0.40 | 2.30 | 0.15 | 0.08 | 0.23 |
| | DCMT11T304-PM | 0.80 | 0.30 | 3.00 | 0.15 | 0.08 | 0.23 |
| | DCMT11T308-PM | 0.80 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 |
| | DCMT11T312-PM | 0.80 | 0.60 | 3.00 | 0.24 | 0.12 | 0.36 |
| | TCMT090204-PM | 0.60 | 0.20 | 2.30 | 0.11 | 0.06 | 0.17 |
| | TCMT090208-PM | 0.60 | 0.40 | 2.30 | 0.15 | 0.08 | 0.23 |
| | TCMT110304-PM | 0.70 | 0.20 | 2.50 | 0.13 | 0.06 | 0.19 |
| | TCMT110308-PM | 0.70 | 0.40 | 2.50 | 0.17 | 0.09 | 0.26 |
| | TCMT110312-PM | 0.70 | 0.50 | 2.50 | 0.20 | 0.10 | 0.31 |
| | VBMT160404-PM | 0.70 | 0.20 | 2.70 | 0.14 | 0.07 | 0.20 |

| Insert | Rec. depth of cut | | | Rec. cutting feed | | | |
|--|-------------------|------|------|---------------------|------|------|------|
| | $a_p = \text{mm}$ | | | $f_n = \text{mm/r}$ | | | |
| | Min | Max | | Min | Max | | |
|  PR P ¹⁾ | VBMT160408-PM | 0.70 | 0.50 | 2.70 | 0.18 | 0.09 | 0.27 |
| | VBMT160412-PM | 0.70 | 0.50 | 2.70 | 0.22 | 0.11 | 0.32 |
| | VCMT110304-PM | 0.80 | 0.30 | 2.60 | 0.15 | 0.10 | 0.25 |
| | VCMT110308-PM | 0.80 | 0.60 | 2.60 | 0.20 | 0.13 | 0.33 |
| | CCMT060208-PR | 1.60 | 0.80 | 3.20 | 0.19 | 0.09 | 0.26 |
|  MF M S ¹⁾ | CCMT09T308-PR | 2.00 | 1.00 | 4.00 | 0.25 | 0.12 | 0.35 |
| | CCMT09T312-PR | 2.00 | 1.20 | 4.00 | 0.30 | 0.14 | 0.42 |
| | DCMT11T308-PR | 2.00 | 1.00 | 4.00 | 0.25 | 0.12 | 0.35 |
| | DCMT11T312-PR | 2.00 | 1.20 | 4.00 | 0.30 | 0.14 | 0.42 |
| | TCMT110308-PR | 1.50 | 0.80 | 3.00 | 0.21 | 0.10 | 0.30 |
| | TCMT110312-PR | 1.50 | 0.90 | 3.00 | 0.26 | 0.12 | 0.36 |
| | VBMT160408-PR | 1.80 | 0.90 | 3.60 | 0.23 | 0.11 | 0.32 |
| | VBMT160412-PR | 1.80 | 1.10 | 3.60 | 0.27 | 0.13 | 0.38 |
| | CCMT060202-MF | 0.30 | 0.06 | 1.70 | 0.06 | 0.03 | 0.11 |
| | CCMT060204-MF | 0.30 | 0.10 | 1.70 | 0.08 | 0.05 | 0.17 |
| CCMT09T302-MF | 0.40 | 0.08 | 2.00 | 0.08 | 0.04 | 0.15 | |
| CCMT09T304-MF | 0.40 | 0.10 | 2.00 | 0.11 | 0.06 | 0.23 | |
| CCMT09T308-MF | 0.40 | 0.20 | 2.00 | 0.15 | 0.08 | 0.30 | |
| DCMT070202-MF | 0.30 | 0.06 | 1.50 | 0.06 | 0.03 | 0.11 | |
| DCMT070204-MF | 0.30 | 0.08 | 1.50 | 0.08 | 0.05 | 0.17 | |
| DCMT11T302-MF | 0.40 | 0.08 | 2.00 | 0.08 | 0.04 | 0.15 | |
| DCMT11T304-MF | 0.40 | 0.10 | 2.00 | 0.11 | 0.06 | 0.23 | |
| DCMT11T308-MF | 0.40 | 0.20 | 2.00 | 0.15 | 0.08 | 0.30 | |
| TCMT06T102-MF | 0.30 | 0.06 | 1.50 | 0.06 | 0.03 | 0.11 | |
| TCMT06T104-MF | 0.30 | 0.08 | 1.50 | 0.08 | 0.05 | 0.17 | |
| TCMT06T108-MF | 0.30 | 0.10 | 1.50 | 0.11 | 0.06 | 0.23 | |
| TCMT090202-MF | 0.30 | 0.06 | 1.70 | 0.06 | 0.03 | 0.13 | |
| TCMT090204-MF | 0.30 | 0.10 | 1.70 | 0.10 | 0.05 | 0.19 | |
| TCMT110302-MF | 0.30 | 0.06 | 1.70 | 0.06 | 0.03 | 0.13 | |
| TCMT110304-MF | 0.30 | 0.10 | 1.70 | 0.10 | 0.05 | 0.19 | |
| TCMT110308-MF | 0.30 | 0.10 | 1.70 | 0.13 | 0.07 | 0.26 | |
| VBMT110302-MF | 0.30 | 0.06 | 1.70 | 0.06 | 0.03 | 0.13 | |
| VBMT110304-MF | 0.30 | 0.10 | 1.70 | 0.10 | 0.05 | 0.19 | |
| VBMT110308-MF | 0.30 | 0.10 | 1.70 | 0.13 | 0.07 | 0.26 | |
| VBMT110312-MF | 0.30 | 0.10 | 1.70 | 0.15 | 0.08 | 0.31 | |
|  MM M S ¹⁾ | CCMT060204-MM | 0.60 | 0.20 | 2.40 | 0.11 | 0.06 | 0.17 |
| | CCMT060208-MM | 0.60 | 0.40 | 2.40 | 0.15 | 0.08 | 0.23 |
| | CCMT09T304-MM | 0.60 | 0.30 | 3.00 | 0.15 | 0.08 | 0.23 |
| | CCMT09T308-MM | 0.80 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 |
| | DCMT070204-MM | 0.60 | 0.20 | 2.30 | 0.11 | 0.06 | 0.17 |
| | DCMT070208-MM | 0.60 | 0.40 | 2.30 | 0.15 | 0.08 | 0.23 |
| | DCMT11T304-MM | 0.80 | 0.30 | 3.00 | 0.15 | 0.08 | 0.23 |
| | DCMT11T308-MM | 0.80 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 |
| | DCMT11T312-MM | 0.80 | 0.60 | 3.00 | 0.24 | 0.12 | 0.36 |
| | TCMT090204-MM | 0.60 | 0.20 | 2.30 | 0.11 | 0.06 | 0.17 |
| TCMT090208-MM | 0.60 | 0.40 | 2.30 | 0.15 | 0.08 | 0.23 | |
| TCMT110304-MM | 0.70 | 0.20 | 2.50 | 0.13 | 0.06 | 0.19 | |
| TCMT110308-MM | 0.70 | 0.40 | 2.50 | 0.17 | 0.09 | 0.26 | |
| TCMT110312-MM | 0.70 | 0.50 | 2.50 | 0.20 | 0.10 | 0.31 | |
| VBMT160404-MM | 0.70 | 0.20 | 2.70 | 0.14 | 0.07 | 0.20 | |
| VBMT160408-MM | 0.70 | 0.50 | 2.70 | 0.18 | 0.09 | 0.27 | |
| VBMT160412-MM | 0.70 | 0.50 | 2.70 | 0.22 | 0.11 | 0.32 | |
|  MR M S ¹⁾ | CCMT060208-MR | 1.60 | 0.80 | 3.20 | 0.19 | 0.09 | 0.26 |
| | CCMT09T308-MR | 2.00 | 1.00 | 4.00 | 0.25 | 0.12 | 0.35 |
| | CCMT09T312-MR | 2.00 | 1.20 | 4.00 | 0.30 | 0.14 | 0.42 |
| | DCMT11T308-MR | 2.00 | 1.00 | 4.00 | 0.25 | 0.12 | 0.35 |
| | DCMT11T312-MR | 2.00 | 1.20 | 4.00 | 0.30 | 0.14 | 0.42 |
| | TCMT110308-MR | 1.50 | 0.80 | 3.00 | 0.21 | 0.10 | 0.30 |
| | TCMT110312-MR | 1.50 | 0.90 | 3.00 | 0.26 | 0.12 | 0.36 |
| | VBMT160408-MR | 1.80 | 0.90 | 3.60 | 0.23 | 0.11 | 0.32 |
| | VBMT160412-MR | 1.80 | 1.10 | 3.60 | 0.27 | 0.13 | 0.38 |





1) Above recommendations are valid for first choice grade in main ISO area


Continued

Recommended depth of cut and cutting feed

General turning

CoroTurn® 107 positive basic-shape inserts

| Insert | Rec. depth of cut | | | Rec. cutting feed | | | |
|--|---|---------------|------|---------------------|------|------|------|
| | $a_p = \text{mm}$ | | | $f_n = \text{mm/r}$ | | | |
| | Min | Max | | Min | Max | | |
|  KF S ¹⁾ | CCMT060202-KF | 0.30 | 0.06 | 1.70 | 0.08 | 0.08 | 0.11 |
| | CCMT060204-KF | 0.30 | 0.10 | 1.70 | 0.08 | 0.08 | 0.17 |
| | CCMT09T302-KF | 0.40 | 0.08 | 2.00 | 0.08 | 0.08 | 0.15 |
| | CCMT09T304-KF | 0.40 | 0.10 | 2.00 | 0.11 | 0.08 | 0.23 |
| | CCMT09T308-KF | 0.40 | 0.20 | 2.00 | 0.15 | 0.08 | 0.30 |
| | DCMT070202-KF | 0.30 | 0.06 | 1.50 | 0.08 | 0.08 | 0.11 |
| | DCMT070204-KF | 0.30 | 0.08 | 1.50 | 0.08 | 0.08 | 0.17 |
| | DCMT11T302-KF | 0.40 | 0.08 | 2.00 | 0.08 | 0.08 | 0.15 |
| | DCMT11T304-KF | 0.40 | 0.10 | 2.00 | 0.11 | 0.08 | 0.23 |
| | DCMT11T308-KF | 0.40 | 0.20 | 2.00 | 0.15 | 0.08 | 0.30 |
| | TCMT06T102-KF | 0.30 | 0.06 | 1.50 | 0.08 | 0.08 | 0.11 |
| | TCMT06T104-KF | 0.30 | 0.08 | 1.50 | 0.08 | 0.05 | 0.17 |
| | TCMT06T108-KF | 0.30 | 0.10 | 1.50 | 0.11 | 0.08 | 0.23 |
| | TCMT090202-KF | 0.30 | 0.06 | 1.70 | 0.08 | 0.08 | 0.13 |
| | TCMT090204-KF | 0.30 | 0.10 | 1.70 | 0.10 | 0.08 | 0.19 |
| | TCMT110302-KF | 0.30 | 0.06 | 1.70 | 0.08 | 0.08 | 0.13 |
| | TCMT110304-KF | 0.30 | 0.10 | 1.70 | 0.10 | 0.08 | 0.19 |
| TCMT110308-KF | 0.30 | 0.10 | 1.70 | 0.13 | 0.08 | 0.26 | |
| VBMT110302-KF | 0.30 | 0.06 | 1.70 | 0.08 | 0.08 | 0.13 | |
| VBMT110304-KF | 0.30 | 0.10 | 1.70 | 0.10 | 0.05 | 0.19 | |
| VBMT110308-KF | 0.30 | 0.10 | 1.70 | 0.13 | 0.07 | 0.26 | |
| VBMT110312-KF | 0.30 | 0.10 | 1.70 | 0.15 | 0.08 | 0.31 | |
| VBMT160402-KF | 0.30 | 0.07 | 1.80 | 0.08 | 0.08 | 0.14 | |
| VBMT160404-KF | 0.30 | 0.10 | 1.80 | 0.10 | 0.08 | 0.20 | |
| VBMT160408-KF | 0.30 | 0.10 | 1.80 | 0.14 | 0.08 | 0.27 | |
|  KM S ¹⁾ | CCMT060204-KM | 0.60 | 0.20 | 2.40 | 0.11 | 0.06 | 0.17 |
| | CCMT060208-KM | 0.60 | 0.40 | 2.40 | 0.15 | 0.08 | 0.23 |
| | CCMT09T304-KM | 0.60 | 0.30 | 3.00 | 0.15 | 0.08 | 0.23 |
| | CCMT09T308-KM | 0.80 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 |
| | DCMT070204-KM | 0.60 | 0.20 | 2.30 | 0.11 | 0.06 | 0.17 |
| | DCMT070208-KM | 0.60 | 0.40 | 2.30 | 0.15 | 0.08 | 0.23 |
| | DCMT11T304-KM | 0.80 | 0.30 | 3.00 | 0.15 | 0.08 | 0.23 |
| | DCMT11T308-KM | 0.80 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 |
| | DCMT11T312-KM | 0.80 | 0.60 | 3.00 | 0.24 | 0.12 | 0.36 |
| | TCMT090204-KM | 0.60 | 0.20 | 2.30 | 0.11 | 0.06 | 0.17 |
| | TCMT090208-KM | 0.60 | 0.40 | 2.30 | 0.15 | 0.08 | 0.23 |
| | TCMT110304-KM | 0.70 | 0.20 | 2.50 | 0.13 | 0.06 | 0.19 |
| | TCMT110308-KM | 0.70 | 0.40 | 2.50 | 0.17 | 0.09 | 0.26 |
| | TCMT110312-KM | 0.70 | 0.50 | 2.50 | 0.20 | 0.10 | 0.31 |
| | VBMT160404-KM | 0.70 | 0.20 | 2.70 | 0.14 | 0.07 | 0.20 |
| | VBMT160408-KM | 0.70 | 0.50 | 2.70 | 0.18 | 0.09 | 0.27 |
| | VBMT160412-KM | 0.70 | 0.50 | 2.70 | 0.22 | 0.11 | 0.32 |
|  KR S | CCMT060208-KR | 1.60 | 0.80 | 3.20 | 0.19 | 0.09 | 0.26 |
| | CCMT09T308-KR | 2.00 | 1.00 | 4.00 | 0.25 | 0.12 | 0.35 |
| | CCMT09T312-KR | 2.00 | 1.20 | 4.00 | 0.30 | 0.14 | 0.42 |
| | DCMT11T308-KR | 2.00 | 1.00 | 4.00 | 0.25 | 0.12 | 0.35 |
| | DCMT11T312-KR | 2.00 | 1.20 | 4.00 | 0.30 | 0.14 | 0.42 |
| | TCMT110308-KR | 1.50 | 0.80 | 3.00 | 0.21 | 0.10 | 0.30 |
| | TCMT110312-KR | 1.50 | 0.90 | 3.00 | 0.26 | 0.12 | 0.36 |
| | VBMT160408-KR | 1.80 | 0.90 | 3.60 | 0.23 | 0.11 | 0.32 |
| | VBMT160412-KR | 1.80 | 1.10 | 3.60 | 0.27 | 0.13 | 0.38 |
| |  UF P ¹⁾ M S | CCMT060202-UF | 0.40 | 0.20 | 1.50 | 0.07 | 0.05 |
| CCMT060204-UF | | 0.40 | 0.20 | 1.50 | 0.10 | 0.05 | 0.20 |
| CCMT060208-UF | | 0.40 | 0.20 | 1.50 | 0.10 | 0.05 | 0.25 |
| CCMT09T302-UF | | 0.40 | 0.20 | 2.00 | 0.07 | 0.05 | 0.15 |
| CCMT09T304-UF | | 0.40 | 0.20 | 2.00 | 0.10 | 0.05 | 0.20 |
| DCMT070202-UF | | 0.40 | 0.20 | 1.50 | 0.07 | 0.05 | 0.15 |
| DCMT070204-UF | | 0.40 | 0.20 | 1.50 | 0.10 | 0.05 | 0.20 |
| DCMT11T304-UF | | 0.40 | 0.20 | 2.00 | 0.10 | 0.05 | 0.20 |
| TCMT06T102-UF | | 0.40 | 0.20 | 1.50 | 0.07 | 0.05 | 0.15 |
| TCMT06T104-UF | | 0.40 | 0.20 | 1.50 | 0.10 | 0.05 | 0.20 |

| Insert | Rec. depth of cut | | | Rec. cutting feed | | | |
|--|-------------------|------|------|---------------------|------|------|------|
| | $a_p = \text{mm}$ | | | $f_n = \text{mm/r}$ | | | |
| | Min | Max | | Min | Max | | |
|  UM P ¹⁾ M S | TCMT090202-UF | 0.40 | 0.20 | 1.50 | 0.07 | 0.05 | 0.15 |
| | TCMT090204-UF | 0.40 | 0.20 | 1.50 | 0.10 | 0.05 | 0.20 |
| | TCMT110202-UF | 0.40 | 0.20 | 2.00 | 0.07 | 0.05 | 0.15 |
| | TCMT110204-UF | 0.40 | 0.20 | 2.00 | 0.10 | 0.05 | 0.20 |
| | TCMT110208-UF | 0.40 | 0.20 | 2.00 | 0.10 | 0.05 | 0.25 |
| | VBMT110202-UF | 0.40 | 0.20 | 1.50 | 0.07 | 0.05 | 0.15 |
| | VBMT110204-UF | 0.40 | 0.20 | 1.50 | 0.10 | 0.05 | 0.20 |
| | VBMT110208-UF | 0.40 | 0.20 | 1.50 | 0.10 | 0.05 | 0.25 |
| | CCGT060201-UM | 0.30 | 0.10 | 1.00 | 0.05 | 0.05 | 0.06 |
| | CCGT060202-UM | 0.50 | 0.10 | 1.50 | 0.07 | 0.05 | 0.12 |
| | CCGT060204-UM | 1.00 | 0.50 | 2.00 | 0.20 | 0.08 | 0.30 |
| | CCGT09T301-UM | 0.30 | 0.10 | 1.00 | 0.05 | 0.05 | 0.08 |
| | CCGT09T302-UM | 0.50 | 0.10 | 1.50 | 0.07 | 0.05 | 0.16 |
| | CCGT09T304-UM | 1.30 | 0.50 | 3.00 | 0.15 | 0.08 | 0.25 |
| | CCGT09T308-UM | 1.30 | 0.50 | 3.00 | 0.20 | 0.12 | 0.35 |
| | CCMT060204-UM | 1.00 | 0.50 | 2.50 | 0.20 | 0.08 | 0.30 |
| | CCMT060208-UM | 1.00 | 0.50 | 2.50 | 0.25 | 0.12 | 0.40 |
| | CCMT09T304-UM | 1.30 | 0.50 | 4.00 | 0.20 | 0.08 | 0.30 |
| | CCMT09T308-UM | 1.30 | 0.50 | 4.00 | 0.25 | 0.12 | 0.40 |
| | DCET070200-UM | 0.30 | 0.10 | 0.60 | 0.05 | 0.02 | 0.06 |
| | DCET070201-UM | 0.30 | 0.10 | 1.00 | 0.05 | 0.03 | 0.06 |
| | DCET11T301-UM | 0.30 | 0.10 | 1.00 | 0.05 | 0.03 | 0.08 |
| | DCET11T302-UM | 0.50 | 0.10 | 1.50 | 0.05 | 0.03 | 0.08 |
| | DCET11T304-UM | 0.80 | 0.40 | 1.50 | 0.05 | 0.03 | 0.08 |
| | DCGT070201-UM | 0.30 | 0.10 | 1.00 | 0.05 | 0.05 | 0.06 |
| | DCGT070202-UM | 0.50 | 0.10 | 1.50 | 0.07 | 0.05 | 0.12 |
| | DCGT070204-UM | 1.00 | 0.50 | 2.50 | 0.15 | 0.08 | 0.25 |
| | DCGT070208-UM | 1.00 | 0.50 | 2.50 | 0.20 | 0.12 | 0.35 |
| DCGT11T301-UM | 0.30 | 0.10 | 1.00 | 0.05 | 0.05 | 0.08 | |
| DCGT11T302-UM | 0.50 | 0.10 | 1.50 | 0.05 | 0.05 | 0.08 | |
| DCGT11T304-UM | 1.30 | 0.50 | 3.00 | 0.15 | 0.08 | 0.25 | |
| DCGT11T308-UM | 1.30 | 0.50 | 3.00 | 0.20 | 0.12 | 0.35 | |
| DCMT070204-UM | 1.00 | 0.50 | 2.50 | 0.20 | 0.08 | 0.30 | |
| DCMT070208-UM | 1.00 | 0.50 | 2.50 | 0.25 | 0.12 | 0.35 | |
| DCMT11T304-UM | 1.30 | 0.50 | 4.00 | 0.20 | 0.08 | 0.30 | |
| DCMT11T308-UM | 1.30 | 0.50 | 4.00 | 0.25 | 0.12 | 0.40 | |
| TCGT090204-UM | 1.00 | 0.50 | 2.00 | 0.20 | 0.08 | 0.25 | |
| TCGT110201-UM | 0.30 | 0.10 | 1.00 | 0.05 | 0.05 | 0.08 | |
| TCGT110202-UM | 0.50 | 0.10 | 1.50 | 0.07 | 0.05 | 0.16 | |
| TCGT110204-UM | 1.30 | 0.50 | 2.50 | 0.15 | 0.08 | 0.25 | |
| TCGT110208-UM | 1.30 | 0.50 | 2.50 | 0.20 | 0.12 | 0.35 | |
| TCGT110301-UM | 0.30 | 0.10 | 1.00 | 0.03 | 0.02 | 0.06 | |
| TCGT110302-UM | 0.50 | 0.10 | 1.50 | 0.07 | 0.02 | 0.12 | |
| TCGT110304-UM | 1.30 | 0.50 | 2.00 | 0.15 | 0.08 | 0.25 | |
| TCGT110308-UM | 1.30 | 0.50 | 2.00 | 0.20 | 0.12 | 0.25 | |
| TCGT16T308-UM | 1.50 | 0.50 | 2.80 | 0.14 | 0.12 | 0.25 | |
| TCMT090204-UM | 1.00 | 0.50 | 2.50 | 0.20 | 0.08 | 0.30 | |
| TCMT090208-UM | 1.00 | 0.50 | 2.50 | 0.25 | 0.12 | 0.40 | |
| TCMT110204-UM | 1.30 | 0.50 | 3.00 | 0.20 | 0.08 | 0.30 | |
| TCMT110208-UM | 1.30 | 0.50 | 3.00 | 0.25 | 0.12 | 0.40 | |
| VBMT160404-UM | 1.30 | 0.50 | 4.00 | 0.20 | 0.08 | 0.30 | |
| VBMT160408-UM | 1.30 | 0.50 | 4.00 | 0.25 | 0.12 | 0.40 | |
| VCET110301-UM | 0.30 | 0.05 | 1.00 | 0.05 | 0.03 | 0.06 | |
| VCET110302-UM | 0.50 | 0.05 | 1.50 | 0.07 | 0.03 | 0.10 | |
| VCGT110301-UM | 0.30 | 0.10 | 1.00 | 0.05 | 0.05 | 0.06 | |
| VCGT110302-UM | 0.50 | 0.10 | 1.50 | 0.07 | 0.05 | 0.12 | |
| VCGT110304-UM | 1.30 | 0.50 | 3.00 | 0.15 | 0.08 | 0.25 | |






1) Above recommendations are valid for first choice grade in main ISO area


Continued

Recommended depth of cut and cutting feed

General turning

CoroTurn® 107 positive basic-shape inserts

| Insert | Rec. depth of cut | | | Rec. cutting feed | | | |
|---|--|----------------|------|---------------------|------|------|------|
| | $a_p = \text{mm}$ | | | $f_n = \text{mm/r}$ | | | |
| | Min | Max | | Min | Max | | |
|  UR P ¹⁾ M N S | CCMT060204-UR | 1.50 | 1.00 | 2.50 | 0.25 | 0.15 | 0.30 |
| | CCMT060208-UR | 1.50 | 1.00 | 2.50 | 0.30 | 0.15 | 0.40 |
| | CCMT09T304-UR | 2.00 | 1.00 | 4.00 | 0.25 | 0.15 | 0.30 |
| | CCMT09T308-UR | 2.00 | 1.00 | 4.00 | 0.30 | 0.15 | 0.50 |
| | DCMT11T304-UR | 2.00 | 1.00 | 4.00 | 0.25 | 0.15 | 0.30 |
| | DCMT11T308-UR | 2.00 | 1.00 | 4.00 | 0.30 | 0.15 | 0.50 |
| | DCMT11T312-UR | 2.00 | 1.00 | 4.00 | 0.30 | 0.20 | 0.50 |
| | TCMT110204-UR | 2.00 | 1.00 | 3.00 | 0.25 | 0.15 | 0.30 |
| | TCMT110208-UR | 2.00 | 1.00 | 3.00 | 0.30 | 0.15 | 0.40 |
| | VBMT160404-UR | 2.00 | 1.00 | 4.00 | 0.25 | 0.15 | 0.30 |
| | VBMT160408-UR | 2.00 | 1.00 | 4.00 | 0.30 | 0.15 | 0.50 |
| | VBMT160412-UR | 2.00 | 1.00 | 4.00 | 0.30 | 0.20 | 0.50 |
| |  WK M ¹⁾ P S | TCGX06T104L-WK | 0.50 | 0.20 | 1.00 | 0.15 | 0.03 |
| TCGX06T104R-WK | | 0.50 | 0.20 | 1.00 | 0.15 | 0.03 | 0.25 |
| TCGX090204L-WK | | 0.50 | 0.20 | 1.20 | 0.20 | 0.04 | 0.28 |
| TCGX090204R-WK | | 0.50 | 0.20 | 1.20 | 0.20 | 0.04 | 0.28 |
| TCGX110204L-WK | | 0.50 | 0.20 | 1.50 | 0.20 | 0.05 | 0.30 |
| TCGX110204R-WK | | 0.50 | 0.20 | 1.50 | 0.20 | 0.05 | 0.30 |
| TCGX110304L-WK | | 0.50 | 0.20 | 1.50 | 0.20 | 0.05 | 0.30 |
| TCGX110304R-WK | | 0.50 | 0.20 | 1.50 | 0.20 | 0.05 | 0.30 |
|  VCEX M ¹⁾ P S | VCEX110300L-F | 1.00 | 0.03 | 4.00 | 0.05 | 0.05 | 0.20 |
| | VCEX110300R-F | 1.00 | 0.03 | 4.00 | 0.05 | 0.05 | 0.20 |
| | VCEX110301L-F | 1.00 | 0.05 | 4.00 | 0.10 | 0.05 | 0.30 |
| | VCEX110301R-F | 1.00 | 0.05 | 4.00 | 0.10 | 0.05 | 0.30 |
| | | | | | | | |
|  TCGT M ¹⁾ P S | TCGT06T102L-K | 0.30 | 0.10 | 1.00 | 0.05 | 0.03 | 0.15 |
| | TCGT06T102R-K | 0.30 | 0.10 | 1.00 | 0.05 | 0.03 | 0.15 |
| | TCGT06T104L-K | 0.50 | 0.20 | 1.00 | 0.07 | 0.03 | 0.20 |
| | TCGT06T104R-K | 0.50 | 0.20 | 1.00 | 0.07 | 0.03 | 0.20 |
| | TCGT090202L-K | 0.30 | 0.10 | 1.20 | 0.05 | 0.03 | 0.15 |
| | TCGT090202L-K | 0.30 | 0.10 | 1.20 | 0.05 | 0.05 | 0.15 |
| | TCGT090202R-K | 0.30 | 0.10 | 1.20 | 0.05 | 0.03 | 0.15 |
| | TCGT090204L-K | 0.50 | 0.20 | 1.20 | 0.10 | 0.03 | 0.20 |
| | TCGT090204L-K | 0.50 | 0.20 | 1.20 | 0.10 | 0.05 | 0.20 |
| | TCGT090204R-K | 0.50 | 0.20 | 1.20 | 0.10 | 0.03 | 0.20 |
| | TCGT110202L-K | 0.30 | 0.10 | 1.50 | 0.05 | 0.05 | 0.15 |
| | TCGT110202R-K | 0.30 | 0.10 | 1.50 | 0.05 | 0.03 | 0.15 |
| | TCGT110204L-K | 0.50 | 0.20 | 1.50 | 0.10 | 0.03 | 0.25 |
| | TCGT110204R-K | 0.50 | 0.20 | 1.50 | 0.10 | 0.03 | 0.25 |
| | TCGT110302L-K | 0.30 | 0.10 | 1.50 | 0.05 | 0.03 | 0.15 |
| TCGT110302R-K | 0.30 | 0.10 | 1.50 | 0.05 | 0.03 | 0.15 | |
| TCGT110304L-K | 0.50 | 0.20 | 1.50 | 0.10 | 0.03 | 0.25 | |
| TCGT110304R-K | 0.50 | 0.20 | 1.50 | 0.10 | 0.03 | 0.25 | |
|  .CMW M ¹⁾ S P N | CCMW060204 | 1.50 | 0.10 | 3.00 | 0.20 | 0.08 | 0.30 |
| | CCMW09T304 | 2.00 | 0.10 | 4.00 | 0.20 | 0.08 | 0.30 |
| | DCMW11T304 | 2.00 | 0.10 | 4.00 | 0.20 | 0.08 | 0.30 |
| | TCMW110204 | 1.50 | 0.10 | 3.00 | 0.20 | 0.08 | 0.30 |
| | TCMW110304 | 1.50 | 0.10 | 3.00 | 0.20 | 0.05 | 0.30 |
| | VBMW160404 | 2.00 | 0.10 | 4.00 | 0.20 | 0.08 | 0.30 |

| Insert | Rec. depth of cut | | | Rec. cutting feed | | | |
|---|-------------------|------|------|---------------------|------|------|------|
| | $a_p = \text{mm}$ | | | $f_n = \text{mm/r}$ | | | |
| | Min | Max | | Min | Max | | |
|  AL N ¹⁾ | DCGX11T302-AL | 1.00 | 0.30 | 5.50 | 0.12 | 0.05 | 0.15 |
| | DCGX11T304-AL | 1.50 | 0.50 | 5.50 | 0.20 | 0.10 | 0.30 |
| | CCGX060202-AL | 1.00 | 0.30 | 3.00 | 0.12 | 0.05 | 0.15 |
| | CCGX060204-AL | 1.50 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 |
| | CCGX09T304-AL | 1.50 | 0.50 | 5.00 | 0.20 | 0.10 | 0.30 |
| | CCGX09T308-AL | 1.50 | 0.50 | 5.00 | 0.30 | 0.15 | 0.60 |
| | DCGX070202-AL | 1.00 | 0.30 | 4.00 | 0.12 | 0.05 | 0.15 |
| | DCGX070204-AL | 1.50 | 0.50 | 4.00 | 0.20 | 0.10 | 0.30 |
| | DCGX11T308-AL | 1.50 | 0.50 | 5.50 | 0.30 | 0.15 | 0.60 |
| | TCGX06T104-AL | 1.00 | 0.50 | 2.00 | 0.20 | 0.10 | 0.30 |
| | TCGX090202-AL | 1.00 | 0.30 | 4.00 | 0.12 | 0.05 | 0.15 |
| | TCGX090204-AL | 1.50 | 0.50 | 4.00 | 0.20 | 0.10 | 0.30 |
| | TCGX110202-AL | 1.00 | 0.30 | 5.00 | 0.12 | 0.05 | 0.15 |
| | TCGX110204-AL | 1.50 | 0.50 | 5.00 | 0.20 | 0.10 | 0.30 |
| | TCGX110208-AL | 1.50 | 0.50 | 5.00 | 0.30 | 0.15 | 0.60 |
| | TCGX110302-AL | 1.00 | 0.30 | 5.00 | 0.12 | 0.05 | 0.15 |
| | TCGX110304-AL | 1.50 | 0.50 | 5.00 | 0.20 | 0.10 | 0.30 |
| | TCGX110308-AL | 1.50 | 0.50 | 5.00 | 0.30 | 0.15 | 0.60 |
| VCGX110202-AL | 1.00 | 0.30 | 3.00 | 0.12 | 0.05 | 0.15 | |
| VCGX110204-AL | 1.50 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 | |
| VCGX110302-AL | 1.00 | 0.30 | 3.00 | 0.12 | 0.05 | 0.15 | |
| VCGX110304-AL | 1.50 | 0.50 | 3.00 | 0.20 | 0.10 | 0.30 | |
| VCGX160404-AL | 1.50 | 0.50 | 5.00 | 0.20 | 0.10 | 0.30 | |
| VCGX160408-AL | 1.50 | 0.50 | 5.00 | 0.30 | 0.15 | 0.60 | |
| VCGX160412-AL | 1.50 | 0.50 | 5.00 | 0.40 | 0.15 | 0.80 | |

1) Above recommendations are valid for first choice grade in main ISO area

Cutting speed recommendations

The recommendations are valid for use with cutting fluid.

| ISO | CMC No. | Material | Specific cutting force k_c 0.4 N/mm ² | Hardness Brinell HB | <<<< WEAR RESISTANCE | | | |
|--------------------------------|----------------------|--|---|------------------------|---------------------------------------|--------------|-------------|---|
| | | | | | CT5015 | GC1525 | GC1025 | |
| | | | | | h_{ex} mm \approx feed f_m mm/r | | | |
| | | | | | 0.05-0.1-0.2 | 0.05-0.1-0.2 | 0.1-0.3-0.5 | |
| Cutting speed (v_c), m/min | | | | | | | | |
| P | 01.1 01.2 01.3 | Unalloyed steel C = 0.1–0.25% C = 0.25–0.55% C = 0.55–0.80% | 2000 | 125 | 650-540-440 | 560-465-380 | 310-255-195 | |
| | | | 2100 | 150 | 570-480-385 | 495-415-335 | 280-225-180 | |
| | | | 2200 | 170 | 510-425-340 | 430-365-295 | 260-210-170 | |
| | Steel | 02.1 02.12 02.2 02.2 | Low-alloy steel (alloying elements \leq 5%) Non-hardened Ball bearing steel Hardened and tempered Hardened and tempered | 2150 | 180 | 480-400-320 | 375-320-255 | - |
| | | | | 2300 | 210 | - | - | - |
| | | | | 2550 | 275 | 285-235-190 | 200-165-135 | - |
| | | | | 2850 | 350 | 230-190-150 | 160-135-110 | - |
| | | | | 2500 | 200 | 395-330-250 | 260-215-175 | - |
| | 03.11 03.21 | High-alloy steel (alloying elements $>$ 5%) Annealed Hardened tool steel | 3900 | 325 | 195-165-130 | 145-115-90 | - | |
| | | | 2500 | 200 | 395-330-250 | 260-215-175 | - | |
| | 06.1 06.2 06.3 | Steel castings Unalloyed Low-alloy (alloying elements \leq 5%) High-alloy (alloying elements $>$ 5%) | 2000 | 180 | 260-215-175 | 225-185-145 | - | |
| | | | 2100 | 200 | 270-225-170 | 175-145-105 | - | |
| 2650 | | | 225 | 200-165-125 | 140-115-85 | - | | |

| ISO | CMC No. | Material | Specific cutting force k_c 0.4 N/mm ² | Hardness Brinell HB | <<<< WEAR RESISTANCE | | |
|--------------------------------|---|--|---|------------------------|---------------------------------------|-------------|-------------|
| | | | | | GC1525 | GC1005 | GC1025 |
| | | | | | h_{ex} mm \approx feed f_m mm/r | | |
| | | | | | 0.1-0.2 | 0.1-0.2 | 0.1-0.2-0.3 |
| Cutting speed (v_c), m/min | | | | | | | |
| M | 05.11 05.12 05.13 | Ferritic/martensitic Bars/forged Non-hardened PH-hardened Hardened | 2300 | 200 | 290-240 | 380-305-245 | 280-215-170 |
| | | | 3550 | 330 | 170-150 | 350-280-225 | 155-125-100 |
| | | | 2850 | 330 | 170-150 | 245-195-160 | 165-135-120 |
| | 05.21 05.22 05.23 | Austenitic Bars/forged Austenitic PH-hardened Super austenitic | 2300 | 180 | 220-195 | 410-330-265 | 265-220-170 |
| | | | 3550 | 330 | 195-170 | 220-175-145 | 155-125-100 |
| | | | 2950 | 200 | 145-130 | 245-200-160 | 185-160-130 |
| | 05.51 05.52 | Austenitic-ferritic (Duplex) Bars/forged Non-weldable \geq 0.05%C Weldable $<$ 0.05%C | 2550 | 230 | - | 315-255-205 | 210-170-130 |
| | | | 3050 | 260 | - | 280-225-185 | 190-140-110 |
| | 15.11 15.12 15.13 | Ferritic/martensitic Cast Non-hardened PH-hardened Hardened | 2100 | 200 | - | - | 265-220-170 |
| | | | 3150 | 330 | - | - | 135-110-80 |
| | | | 2650 | 330 | - | - | 145-120-90 |
| | 15.21 15.22 15.23 15.51 15.52 | Austenitic Cast Austenitic PH-hardened Super austenitic Austenitic-ferritic (Duplex) Cast Non-weldable \geq 0.05%C Weldable $<$ 0.05%C | 2200 | 180 | - | - | 235-180-150 |
| 3150 | | | 330 | - | - | 135-110-80 | |
| 2700 | | | 200 | - | - | 175-150-125 | |
| 2250 | | | 230 | - | - | 190-140-100 | |
| 2750 | | | 260 | - | - | 170-130-90 | |

Cutting speed recommendations

| TOUGHNESS >>>> | | | | | | | | |
|--|--|--|--|--|---|---|--|--|
| GC4005 | GC4015 | GC4025 | GC4225 | GC2015 | GC4035 | GC2025 | GC235 | |
| 0.1-0.4-0.8 | 0.1-0.4-0.8 | 0.1-0.4-0.8 | 0.1-0.4-0.8 | 0.1-0.4-0.8 | 0.1-0.4-0.8 | 0.1-0.4-0.8 | 0.1-0.4-0.8 | |
| 590-430-315 530-385-280 510-365-265 | 540-390-285 485-350-255 460-330-240 | 485-330-230 430-290-205 405-275-195 | 510-345-245 455-305-215 425-290-205 | 440-300-210 390-265-185 370-250-175 | 405-260-190 365-235-170 345-220-160 | 295-200-145 265-180-130 250-170-120 | 185-135-95 165-120-85 155-115-80 | |
| 580-390-270 510-335-235 315-220-165 250-175-135 | 530-355-245 460-305-215 285-200-150 230-160-120 | 435-290-205 380-255-180 255-180-140 205-145-115 | 460-305-215 395-265-190 270-190-145 215-150-120 | 395-265-185 345-230-160 255-180-140 205-145-115 | 285-175-130 250-155-110 175-115-80 140-90-65 | 220-145-100 195-125-85 145-95-65 115-75-50 | 155-110-70 - 110-70-50 85-55-39 | |
| 425-280-205 210-135-100 | 385-255-190 190-120-90 | 285-195-145 130-90-70 | 300-205-150 135-95-75 | 260-180-130 115-85-65 | 225-145-100 105-65-45 | 185-125-85 85-55-338 | 145-100-65 65-45-30 | |
| 320-225-175 275-195-150 210-145-110 | 285-205-160 250-175-135 195-130-100 | 230-170-125 200-135-95 175-120-85 | 240-180-130 210-140-100 185-125-90 | 210-255-110 180-120-85 160-110-75 | 175-130-95 155-95-65 135-90-65 | 140-105-80 125-80-55 110-75-50 | 100-80-60 95-65-45 80-60-39 | |
| TOUGHNESS >>>> | | | | | | | | |
| GC2015 | GC4225 | GC4035 | GC2025 | GC2035 | GC235 | | | |
| 0.2-0.4-0.6 | 0.2-0.4-0.6 | 0.2-0.4-0.6 | 0.2-0.4-0.6 | 0.2-0.4-0.6 | 0.2-0.4-0.6 | | | |
| 240-205-185 115-90-70 135-115-80 | 280-235-210 130-105-80 160-130-95 | 225-190-170 85-65-50 100-70-50 | 210-175-135 100-70-50 110-80-55 | 180-160-130 85-65-45 95-70-50 | 130-110-90 70-55-45 75-60-50 | | | |
| 255-205-175 115-90-75 155-135-100 | 295-235-200 130-100-85 180-160-115 | 195-155-120 95-70-55 130-105-80 | 200-160-120 100-70-55 120-100-75 | 170-145-115 85-65-45 100-90-70 | 115-100-85 70-55-45 85-70-60 | | | |
| 220-185-145 180-150-120 | 250-215-170 210-175-135 | 180-140-110 130-115-105 | 190-150-110 150-120-90 | 160-135-105 130-110-85 | 105-95-80 95-80-70 | | | |
| 230-195-160 95-70-55 105-85-60 | 270-225-185 110-80-65 120-100-70 | 195-160-150 75-55-40 85-60-45 | 200-160-120 80-55-40 90-60-45 | 170-145-115 70-50-40 75-60-50 | 115-100-85 60-45-35 65-50-40 | | | |
| 200-165-135 95-70-55 145-115-95 | 230-190-155 110-80-65 170-130-110 | 155-120-95 75-55-40 115-90-70 | 175-135-100 80-55-40 120-90-65 | 150-120-95 70-50-40 100-80-60 | 100-90-75 65-45-33 80-65-55 | | | |
| 185-150-135 160-140-105 | 215-175-150 185-165-120 | 165-125-100 115-100-95 | 150-120-90 125-105-80 | 130-110-85 105-95-75 | 95-80-70 90-75-65 | | | |

A Introduction
 B External machining
 C Internal machining
 D Milling
 E Drilling
 F Cutting data
 G Grades
 H General Information

Cutting speed recommendations

The recommendations are valid for use with cutting fluid.

| ISO | CMC No. | Material | Specific cutting force k_c 0.4 N/mm ² | Hardness Brinell HB | <<<< WEAR RESISTANCE | | |
|---|-------------------------|---|---|---|---|--------------------------------|--------------------------------|
| | | | | | 1810 | H10 | H13A |
| | | | | | h_{ex} , mm \approx feed f_n , mm/r | | |
| | | | | | Cutting speed (v_c), m/min | | |
| N Non-ferrous metals | 30.11 | Aluminium alloys Wrought or wrought and coldworked, non-aging | 500 | 60 | 2 000 (2500-250) ¹⁾ | 2 000 (2500-250) ¹⁾ | 1 900 (2400-240) ¹⁾ |
| | 30.12 | Wrought or wrought and aged | 800 | 100 | 2 000 (2500-250) ¹⁾ | 2 000 (2500-250) ¹⁾ | 1 900 (2400-240) ¹⁾ |
| | 30.21 30.22 | Aluminium alloys Cast, non-aging | 750 | 75 | 2 000 (2500-250) ¹⁾ | 2 000 (2500-250) ¹⁾ | 1 900 (2400-240) ¹⁾ |
| | | Cast or cast and aged | 900 | 90 | 2 000 (2500-250) ¹⁾ | 2 000 (2500-250) ¹⁾ | 1 900 (2400-240) ¹⁾ |
| | 30.41 30.42 | Aluminium alloys Cast, 13-15% Si | 950 | 130 | 770 (960-95) ¹⁾ | 450 (560-55) ¹⁾ | 400 (500-50) ¹⁾ |
| | | Cast, 16-22% Si | 950 | 130 | 510 (640-65) ¹⁾ | 300 (375-38) ¹⁾ | 250 (315-31) ¹⁾ |
| | 33.1 33.2 33.3 | Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb | 700 | 110 | 500 (630-65) ¹⁾ | 500 (630-65) ¹⁾ | 450 (560-55) ¹⁾ |
| | | Brass, leaded bronzes, $\leq 1\%$ Pb | 700 | 90 | 500 (630-65) ¹⁾ | 500 (630-65) ¹⁾ | 450 (560-55) ¹⁾ |
| | | Bronze and non-leaded copper incl. electrolytic copper | 1750 | 100 | 300 (375-38) ¹⁾ | 300 (375-38) ¹⁾ | 270 (340-34) ¹⁾ |
| | ISO | CMC No. | Material | Specific cutting force k_c 0.4 N/mm ² | Hardness Brinell HB | <<<< WEAR RESISTANCE | |
| S05F | | | | | | GC1105 | GC1005 |
| h_{ex} , mm \approx feed f_n , mm/r | | | | | | | |
| Cutting speed (v_c), m/min | | | | | | | |
| S Heat resistant material | 20.11 20.12 | Heat resistant super alloys Iron base | 3000 3050 | 200 280 | 160-135-110 125-105-85 | - | 175-120-80 150-100-70 |
| | | Nickel base | | | | | |
| | 20.21 20.22 20.24 | Annealed or solution treated | 3300 | 250 | 100-85-70 | 90-55-30 | 90-55-30 |
| | | Aged or solution treated and aged | 3600 | 350 | 90-75-60 | 80-50-27 | 80-50-27 |
| | | Cast or cast and aged | 3700 | 320 | 80-65-55 | 70-45-24 | 70-45-24 |
| | 20.31 20.32 20.33 | Cobalt base Annealed or solution treated | 3300 | 200 | 100-85-70 | 90-60-30 | 90-60-30 |
| | | Solution treated and aged | 3700 | 300 | 90-75-60 | 80-50-27 | 80-50-27 |
| | | Cast or cast and aged | 3800 | 320 | 80-65-55 | 70-45-24 | 70-45-24 |
| | 23.1 23.21 23.22 | Titanium alloys²⁾ Commercial pure (99.5% Ti) | 1550 | Rm ³⁾ 400 | 0.1-0.2-0.3 | 0.1-0.3-0.5 | 0.1-0.3-0.5 |
| | | α , near α and $\alpha+\beta$ alloys, annealed | 1700 | 950 | 205-170-145 | 180-150-125 | 195-160-135 |
| | | α , near α and $\alpha+\beta$ alloys, annealed | 1700 | 950 | 85-70-55 | 75-60-50 | 80-65-55 |
| | | β alloys, annealed or aged | 1700 | 1050 | 80-60-50 | 70-55-45 | 80-60-50 |

1) The cutting speeds, shown in the table, are valid for all feeds within the feed range.

2) 45-60° entering angle, positive cutting geometry and coolant should be used.

3) Rm = ultimate tensile strength measured in MPa.

Cutting speed recommendations

| TOUGHNESS >>>> | | | | | | |
|--|-------------------------------------|----------------------------------|----------------------------------|--|--|--|
| GC1005 | | | | | | |
| 0.15-0.8 | | | | | | |
| 2 000 (2500-250) ¹⁾ | | | | | | |
| 2 000 (2500-250) ¹⁾ | | | | | | |
| 2 000 (2500-250) ¹⁾ | | | | | | |
| 2 000 (2500-250) ¹⁾ | | | | | | |
| 450 (560-55) ¹⁾ 300 (375-38) ¹⁾ | | | | | | |
| 500 (630-65) ¹⁾ 500 (630-65) ¹⁾ 300 (375-38) ¹⁾ | | | | | | |
| TOUGHNESS >>>> | | | | | | |
| H10A | H13A | GC1025 | H10F | | | |
| 0.1-0.3-0.5 | | | | | | |
| 0.1-0.3-0.5 | 0.1-0.3-0.5 | 0.1-0.3-0.5 | 0.1-0.3-0.5 | | | |
| 85-70-55 65-55-40 | 80-65-50 60-50-40 | 75-60-45 55-45-35 | 70-55-40 50-40-30 | | | |
| 55-40-32 40-32-21 26-21-16 | 50-40-30 40-30-20 25-20-15 | 45-35-25 35-25-15 23-17-12 | 40-30-20 30-20-10 20-15-10 | | | |
| 55-40-32 40-32-21 26-21-16 | 50-40-30 40-30-20 25-20-15 | 45-35-25 35-25-15 23-17-12 | 40-30-20 30-20-10 20-15-10 | | | |
| H10F | GC1025 | | | | | |
| 0.1-0.3-0.5 | 0.1-0.3-0.5 | | | | | |
| 160-135-115 65-55-45 65-50-40 | 160-135-115 65-55-45 65-50-40 | | | | | |

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