

## Parting - Metric

MGMN 2002 N								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.08	0.14	0.11	130	250	180
	Low Alloy	200	0.08	0.15	0.09	110	220	160
	High Alloy	220	0.07	0.13	0.07	40	120	80
M	Austenitic	190	0.08	0.14	0.07	100	180	140
	Ferritic & Martensitic	220	0.06	0.10	0.07	60	120	90
K	Nodular Cast Iron	150	0.06	0.12	0.08	120	210	120
	Grey Cast Iron	150	0.06	0.16	0.10	120	190	150
S	Heat resistant and super alloys	240	0.06	0.10	0.06	40	70	50
H	Hardened material	45HRc	0.04	0.08	0.06	30	70	50

  

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MGMN 3004 N								
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P	Non Alloy	120	0.08	0.16	0.12	120	250	180
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	Grey Cast Iron	150	0.06	0.12	0.10	120	190	150
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