Parting - Metric

				MGMN 2002 N					
Material					Cutting co	nditions			
Group	Sub Group	Hardness		Feed (mm/rev)			Speed Vc (m/min)		
	-	(HB)	Min	Max	Recommend	Min	Max	Recommen	
	Non Alloy	120	0.08	0.14	0.11	130	250	180	
P	Low Alloy	200	0.08	0.15	0.09	110	220	160	
	High Alloy	220	0.07	0.13	0.07	40	120	80	
	Austenitic	190	0.08	0.14	0.07	100	180	140	
	Ferritic & Martensitic	220	0.06	0.10	0.07	60	120	90	
	Nodular Cast Iron	150	0.06	0.12	0.08	120	210	120	
K	Grey Cast Iron	150	0.06	0.16	0.10	120	190	150	
	Heat resistant	150	0.00	0.10	0.10	120	150	150	
	and super alloys	240	0.06	0.10	0.06	40	70	50	
н	Hardened material	45HRc	0.04	0.08	0.06	30	70	50	
	Hardened material	45HKC	0.04		0.06	30	70	50	
				MGMN 2002 P					
	Material		Cutting conditions						
Group	Sub Group	Hardness		Feed (mm/rev)			Speed Vc (m/min)		
	-	(HB)	Min	Max	Recommend	Min	Max	Recommen	
	Non Alloy	120	0.08	0.14	0.10	120	250	180	
P	Low Alloy	200	0.08	0.15	0.09	110	220	160	
	High Alloy	220	0.07	0.13	0.08	40	120	80	
	Austenitic	190	0.08	0.14	0.08	100	180	140	
	Ferritic & Martensitic	220	0.06	0.10	0.08	60	120	90	
	Nodular Cast Iron	150	0.06	0.14	0.10	120	210	120	
K	Grey Cast Iron	150	0.06	0.12	0.10	120	190	150	
	Heat resistant				0.10			130	
		240	0.07	0.10	0.08	40	70	50	
	and super alloys	AFIID:	0.04	0.40	0.07	20	70		
Н	Hardened material	45HRc	0.04	0.10	0.07	30	70	50	
				MGMN 3004 N					
	Material				Cutting co	nditions			
C	Cub Corre	Hardness		Feed (mm/rev)			Speed Vc (m/min)		
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommen	
	Non Alloy	120	0.08	0.16	0.12	120	250	180	
P	Low Alloy	200	0.08	0.15	0.09	110	220	160	
- T		220	0.07	0.13	0.08	40	120	80	
	High Alloy								
	Austenitic	190	0.08	0.14	0.08	100	180	140	
	Ferritic & Martensitic	220	0.06	0.10	0.08	60	120	90	
К	Nodular Cast Iron	150	0.06	0.14	0.10	120	210	120	
	Grey Cast Iron	150	0.06	0.12	0.10	120	190	150	
	Heat resistant	240	0.07	0.10	0.08	40	70	50	
	and super alloys	240	0.07	0.10	0.08	40	70	50	
Н	Hardened material	45HRc	0.04	0.10	0.07	30	70	50	
				MGMN 3004 P					
	Material			IVIGIVIIV 3004 I	Cutting	ndisions.			
	Material				Cutting co	naitions			
Group	Sub Group	Hardness		Feed (mm/rev)			Speed Vc (m/min)		
		(HB)	Min	Max	Recommend	Min	Max	Recommen	
	Non Alloy	120	0.08	0.16	0.10	120	250	180	
P	Low Alloy	200	0.08	0.15	0.09	110	220	160	
	High Alloy	220	0.07	0.13	0.08	40	120	80	
	Austenitic	190	0.08	0.14	0.08	100	180	140	
	Ferritic & Martensitic	220	0.06	0.10	0.08	60	120	90	
	Nodular Cast Iron	150	0.06	0.14	0.10	120	210	120	
K	Grey Cast Iron	150	0.06	0.12	0.10	120	190	150	
		130	0.06	0.12	0.10	120	150	130	
	Heat resistant	240	0.07	0.10	0.08	40	70	50	
	and super alloys								
н	Hardened material	45HRc	0.04	0.10	0.07	30	70	50	
				MGMN 4004 N					
	Material				Cutting co	nditions			
-		Hardness		Feed (mm/rev)			Speed Vc (m/min)		
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommen	
	Non Alloy	120	0.08	0.16	0.10	120	250	180	
P	Low Alloy	200	0.08	0.15	0.09	110	220	160	
	· · · · · · · · · · · · · · · · · · ·			_		40		80	
	High Alloy	220	0.07	0.13	0.08	-	120		
	Austenitic	190	0.08	0.14	0.08	100	180	140	
	Ferritic & Martensitic	220	0.06	0.10	0.08	60	120	90	
К	Nodular Cast Iron	150	0.06	0.14	0.10	120	210	120	
	Grey Cast Iron	150	0.06	0.12	0.10	120	190	150	
c	Heat resistant	340	0.07	0.10	0.00	40	70		
S	and super alloys	240	0.07	0.10	0.08	40	70	50	
н	Hardened material	45HRc	0.04	0.10	0.07	30	70	50	
				MGMN 4004 P					
	Material			WOWIN 4004 I	Cutting co	nditions			
	iviaterial	Hardness		Feed (mm/rev)	Cutting CO		Speed Valor Inclus		
Group	Sub Group		p.at		December 1	8.61	Speed Vc (m/min)	D	
	· · ·	(HB)	Min	Max	Recommend	Min	Max	Recommen	
	Non Alloy	120	0.08	0.16	0.10	120	250	180	
P	Low Alloy	200	0.08	0.15	0.09	110	220	160	
	High Alloy	220	0.07	0.13	0.08	40	120	80	
	Austenitic	190	0.08	0.14	0.08	100	180	140	
	Ferritic & Martensitic	220	0.06	0.10	0.08	60	120	90	
	Nodular Cast Iron	150	0.06	0.14	0.10	120	210	120	
		150							
M K		150	0.06	0.12	0.10	120	190	150	
	Grey Cast Iron			1	1	40	70	50	
	Grey Cast Iron Heat resistant	240	0.07	0.10	0.08	40	/0	30	
K S	Grey Cast Iron Heat resistant and super alloys	240							
к	Grey Cast Iron Heat resistant		0.07 0.04	0.10	0.08	30	70	50	
K S	Grey Cast Iron Heat resistant and super alloys	240							
K S	Grey Cast Iron Heat resistant and super alloys	240		0.10		30			
к s н	Grey Cast Iron Heat resistant and super alloys Hardened material Material	240 45HRc		0.10 MGMN 5008 N	0.07	30	70		
K S	Grey Cast Iron Heat resistant and super alloys Hardened material	240		0.10	0.07	30			

P	Low Alloy	200	0.12	0.18	0.14	110	220	160		
	High Alloy	220	0.08	0.14	0.10	40	120	80		
М	Austenitic	190	0.08	0.14	0.08	100	180	140		
	Ferritic & Martensitic	220	0.08	0.12	0.10	60	120	90		
К	Nodular Cast Iron	150	0.06	0.14	0.10	120	210	120		
	Grey Cast Iron	150	0.06	0.12	0.10	120	190	150		
S	Heat resistant	240	0.06	0.12	0.08	40	70	50		
	and super alloys									
Н	Hardened material	45HRc	0.04	0.10	0.10	30	70	50		
				MGMN 5008 P						
	Material		Cutting conditions							
6	Sub Group	Hardness	Feed (mm/rev) Speed Vc (m/min)							
Group		(HB)	Min	Max	Recommend	Min	Max	Recommend		
	Non Alloy	120	0.12	0.20	0.16	120	250	180		
P	Low Alloy	200	0.12	0.18	0.14	110	220	160		
	High Alloy	220	0.08	0.14	0.10	40	120	80		
М	Austenitic	190	0.08	0.14	0.08	100	180	140		
	Ferritic & Martensitic	220	0.08	0.12	0.10	60	120	90		
	Nodular Cast Iron	150	0.06	0.14	0.10	120	210	120		
К	Grey Cast Iron	150	0.06	0.12	0.10	120	190	150		
S	Heat resistant and super alloys	240	0.06	0.12	0.08	40	70	50		
н	Hardened material	45HRc	0.04	0.10	0.10	30	70	50		