

RECOMMENDED CUTTING CONDITIONS | Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min)			Toughness →	Feed fz (mm/t)
				← Wear Resistance				
				PH5705	PH7910	PH7920	PH5740	PNH(K)X 1105...
P	1	Unalloyed Steel	125-220	-	190-280	180-250	-	0,15-0,30
	2	Low-Alloyed Steel	220-280	-	180-240	170-210	-	0,15-0,30
	3	High-Alloyed Steel	280-380	-	170-220	160-200	-	0,15-0,25
K	7	Malleable Cast Iron	130-230	190-340	-	-	170-300	0,12-0,35
	8	Grey Cast Iron	180-245	180-300	-	-	150-260	0,12-0,35
	9	Nodular Cast iron	160-250	140-250	-	-	130-220	0,12-0,30

(Note 1) Cutting conditions $a_e/DC=70\%$.
 (Note 2) Cutting conditions should be adjusted according to the machine and work rigidity.
 (Note 3) If chattering occurs, reduce a_p and V_c by 30% and keep the same f_z per tooth.

CHIP-BREAKER SELECTION GUIDE | Guia para aplicações do quebra- aparas | Guía para aplicación del rompevirutas

ISO	PSM	Material	HB (Brinell)	Chip-Breaker Application	
				1st choice	Difficult Operations
P	1	Unalloyed Steel	125-220	PNH(K)X 11... MK	-
	2	Low-Alloyed Steel	220-280	PNH(K)X 11... MK	-
	3	High-Alloyed Steel	280-380	PNH(K)X 11... MK	-
K	7	Malleable Cast Iron	130-230	PNH(K)X 11... MK	PNH(K)X 11... HK
	8	Grey Cast Iron	180-245	PNH(K)X 11... MK	PNH(K)X 11... HK
	9	Nodular Cast iron	160-250	PNH(K)X 11... MK	PNH(K)X 11... HK