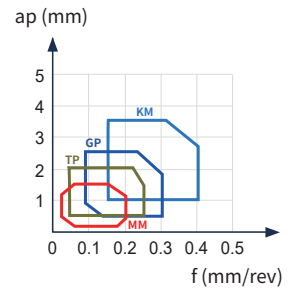


RECOMMENDATION FOR TURNING GRADE AND GEOMETRY CHOICE

Material	Coated	Grade	Vc (m/min)	Turning insert (Negative)					Turning insert (Positive)
				01	10	20	30	40	
P	CVD	GPT6110	140-400	01	10	20	30	40	
		GPT6120	80-320	01	10	20	30	40	
		GPT6130	70-320	01	10	20	30	40	
		GP1105	80-320	01	10	20	30	40	
		GP1115	120-360	01	10	20	30	40	
		GP1120	110-360	01	10	20	30	40	
		GP1225	70-320	01	10	20	30	40	
		GP1130	90-300	01	10	20	30	40	
		GP1135	60-300	01	10	20	30	40	
	Cermet	GP91TM	150-350	01	10	20	30	40	
Coated Cermet	GP31TM	180-380	01	10	20	30	40		
M	CVD	GM1115	180-300	01	10	20	30	40	
		GM1230	160-280	01	10	20	30	40	
		GM3315	100-250	01	10	20	30	40	
		GM3215	100-250	01	10	20	30	40	
		GM3220	60-180	01	10	20	30	40	
		GM3325	60-180	01	10	20	30	40	
	GM3225	60-180	01	10	20	30	40		
Cermet	GP91TM	150-350	01	10	20	30	40		
Coated Cermet	GP31TM	180-380	01	10	20	30	40		
K	CVD	GK1215	180-500	01	10	20	30	40	
		GK1220	160-360	01	10	20	30	40	
		GK1225	160-500	01	10	20	30	40	
		GK1115	180-500	01	10	20	30	40	
		GK1120	160-360	01	10	20	30	40	
		GK1125	160-500	01	10	20	30	40	
		GK1130	100-600	01	10	20	30	40	
	Cermet	GP91TM	150-350	01	10	20	30	40	
Coated Cermet	GP31TM	180-380	01	10	20	30	40		
CBN	BKN115P	400-1500	01	10	20	30	40		
CBN Coated	BKC120P	150-500	01	10	20	30	40		
N	PVD	GN3125	250-1500	01	10	20	30	40	
		GN9115	250-2100	01	10	20	30	40	
		GN9120	950-2050	01	10	20	30	40	
		GN9130	950-2000	01	10	20	30	40	
	PCD	DNN125P	10-3000	01	10	20	30	40	
S	PVD	GS3115	30-80	01	10	20	30	40	
		GS3125	30-80	01	10	20	30	40	
		GST7120	30-80	01	10	20	30	40	
		GST7115	15-70	01	10	20	30	40	
	GST7130	20-40	01	10	20	30	40		
CBN	BSN115P	150-260	01	10	20	30	40		
H	CBN Coated	BHC115P	120-220	01	10	20	30	40	
		BHC125P	100-180	01	10	20	30	40	
		BHC135P	80-150	01	10	20	30	40	

P M K



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