



Recommended grades and chip breakers

(● : 1st Recommendation)

C/B	Cutting edge	P				M		K		N		S	
		Low carbon steel/ Mild steel		High carbon steel/ Alloy steel		Stainless steel		Cast iron		Non-ferrous metal		HRSA	
		C/B	Grade	C/B	Grade	C/B	Grade	C/B	Grade	C/B	Grade	C/B	Grade
ML		-	● PC3700 ○ PC5300 ○ PC5400 ○ NCM535	-	● PC3700 ○ PC5300 ○ PC5400 ○ NCM535	●	○ PC5300 ○ PC5400 ○ PC9540	-	● PC6510 ○ PC5300 ○ PC5400 ○ NCM535	-	-	●	● UPC845 ○ UNC840 ○ PC5300 ○ PC5400
MM		●	○ PC3700 ○ PC5300 ○ PC5400 ○ NCM535	●	○ PC3700 ○ PC5300 ○ PC5400 ○ NCM535	-	○ PC5300 ○ PC5400 ○ PC9540	●	○ PC6510 ○ PC5300 ○ PC5400 ○ NCM535	-	-	-	○ UPC845 ○ UNC840 ○ PC5300 ○ PC5400

Recommended cutting conditions

[In face machining and shouldering]

Workpiece	Grade	Cutting speed vc (m/min)	Feed, fz (mm/t)		
			ADKT17	ADKT12	ADKT10
P Steel	PC5300	150-240	0.3-0.05	0.25-0.05	0.2-0.05
	PC5400	130-210			
	PC3700	160-270			
	NCM535	250-350			
M Stainless steel	PC5300	90-150	0.25-0.05	0.2-0.05	0.15-0.05
	PC5400	70-120			
	PC9540	50-120			
K Cast iron	PC6510	150-200	0.35-0.08	0.3-0.08	0.25-0.08
	PC5300	120-200			
	NCM535	200-300			
S HRSA	PC5300	40-70	0.2-0.05	0.15-0.05	0.1-0.05
	PC5400	30-50			
	UPC845	20-60			
	UNC840	30-60			

※ The above data refer to general cutting conditions and can be adjustable up to 350 m/min and 0.4 mm/t depending on user environment.

[In grooving, ramping and helical machining]

Workpiece	Grade	Cutting speed vc (m/min)	Feed, fz (mm/t)		
			ADKT17	ADKT12	ADKT10
P Steel	PC5300	150-240	0.15-0.05	0.15-0.05	0.15-0.05
	PC5400	130-210			
	PC3700	160-270			
	NCM535	250-350			
M Stainless steel	PC5300	90-150	0.15-0.05	0.15-0.05	0.15-0.05
	PC5400	70-120			
	PC9540	50-120			
K Cast iron	PC6510	150-250	0.2-0.08	0.2-0.08	0.2-0.08
	PC5300	120-200			
	NCM535	200-300			
S HRSA	PC5300	40-70	0.15-0.05	0.15-0.05	0.1-0.05
	PC5400	30-50			
	UPC845	20-60			
	UNC840	30-60			

※ In deep grooving, set the ap under 5 mm and use coolant and air.