


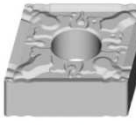


Basic Geometry (Cast Iron)


1 - Select Geometry




-CFC
▼▼▼ Super finishing



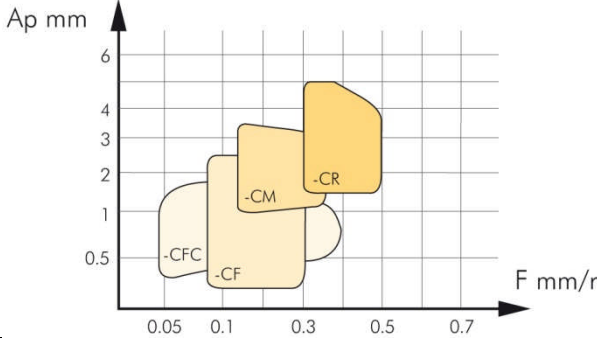
-CF
▼▼▼ Finishing



-CM
▼▼ Medium machining



-CR
▼ Roughing




2 - Select Grade

Cutting condition	▼▼▼ Super finishing	▼▼▼ Finishing	▼▼ Medium machining	▼ Roughing
○ Interrupted cut	-	TIC15	TIC15-TIC17	TIC15-TIC17
○ Inconsistent cut	CK30	TIC15	TIC15-TIC17	TIC15-TIC17
○ Consistent cut	CK30	TIC15	TIC15-TIC17	TIC15-TIC17


3 - Select Cutting Speed
siehe separate Information

Complementary Geometry (Cast Iron)


1 - Select Geometry




-CFM
▼▼▼ Finishing




-CMF



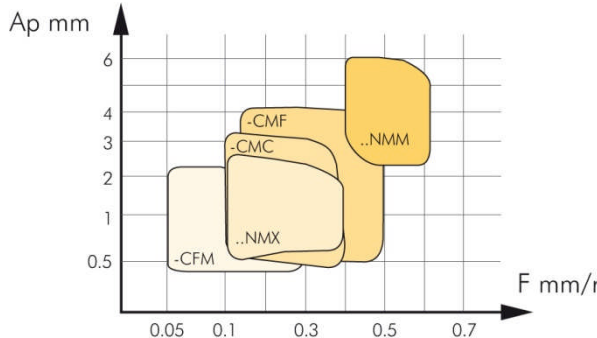
-CMC
▼▼ Medium machining



..NMX



..NMM
▼ Roughing



2 - Select Grade

Cutting condition	▼▼▼ Finishing	▼▼ Medium machining	▼ Roughing
○ Interrupted cut	TIC30	TIC30	TIC30
○ Inconsistent cut	TIC15-TIC30	CK30-TIC20-TIC30	TIC30
○ Consistent cut	TIC15	CK30-TIC15-TIC30	TIC30

3 - Select Cutting Speed
siehe separate Information





Basic Geometry (Stainless Steel)

1 - Select Geometry

-CFC **-CF** **-CS** **-CS** **-CS**

Super finishing Finishing Medium machining Roughing

2 - Select Grade

Cutting condition	Super finishing	Finishing	Medium machining	Roughing
Interrupted cut	-	TIC30-TIC35	TIC30-TIC35	TIC35
Inconsistent cut	CK30	TIC15-TIC30-TIC35	TIC30-TIC35	TIC35
Consistent cut	CK30	TIC15-TIC30-TIC35	TIC30-TIC35	TIC35

3 - Select Cutting Speed
siehe separate Information

Complementary Geometry (Stainless Steel)

1 - Select Geometry

-CFM **..NGP** **-CMF** **..NGP** **..NMX**

Finishing Medium machining

2 - Select Grade

Cutting condition	Finishing	Medium machining
Interrupted cut	TIC30	TIC30
Inconsistent cut	TIC17-TIC30	CK30-TIC17-TIC30
Consistent cut	TIC17-TIC30	CK30-TIC17-TIC30

3 - Select Cutting Speed
siehe separate Information





Basic Geometry (Cast Iron)

1 - Select Geometry

-CFC
 -CF
 ..NMA
 -CM
 ..NMA

Super finishing
 Finishing
 Medium machining
 Roughing

2 - Select Grade

Cutting condition	Super finishing	Finishing	Medium machining	Roughing
○ Interrupted cut	-	TIC15	TIC15-TIC17	TIC15-TIC17
○ Inconsistent cut	CK30	TIC15	TIC15-TIC17	TIC15-TIC17
○ Consistent cut	CK30	TIC15	TIC15-TIC17	TIC15-TIC17

3 - Select Cutting Speed
siehe separate Information

Complementary Geometry (Cast Iron)

1 - Select Geometry

..NGP
 -CMF
 ..NMX
 ..NGP

Finishing
 Medium machining

2 - Select Grade

Cutting condition	Finishing	Medium machining
○ Interrupted cut	TIC15-TIC17	CK30-TIC15-TIC17
○ Inconsistent cut	CK30-TIC15-TIC17	CK30-TIC15-TIC17
○ Consistent cut	CK30-TIC15-TIC17	CK30-TIC15-TIC17

3 - Select Cutting Speed
siehe separate Information





Basic Geometry (Non Ferrous Materials)

1 - Select Geometry

..NGP -CFM ..NGP ..NMX ..NGP ..NMX
 ▼▼▼ Finishing ▼▼ Medium machining ▼ Roughing

2 - Select Grade

Cutting condition	▼▼▼ Finishing	▼▼ Medium machining	▼ Roughing
Interrupted cut	K15K-TIC15-TIC17-Z10R	CK30-TIC17-Z10R	CK30-TIC17-Z10R
Inconsistent cut	K15K-TIC15-TIC17-Z10R	CK30-TIC17-Z10R	CK30-TIC17-Z10R
Consistent cut	K15K-TIC15-TIC17-Z10R	CK30-TIC17-Z10R	CK30-TIC17-Z10R

3 - Select Cutting Speed
siehe separate Information

Basic Geometry (Heart Resistant Alloys)

1 - Select Geometry

..NGP -CM -CS ..NGP -CS
 ▼▼▼ Finishing ▼▼ Medium machining ▼ Roughing

2 - Select Grade

Cutting condition	▼▼▼ Finishing	▼▼ Medium machining	▼ Roughing
Interrupted cut	TIC17	TIC17-TIC30-TIC35	TIC35
Inconsistent cut	TIC17	TIC17-TIC30-TIC35	TIC35
Consistent cut	TIC17	TIC17-TIC30-TIC35	TIC35

3 - Select Cutting Speed
siehe separate Information

