

➤ Recommended cutting parameters

Workpiece material	Hardness HB	Insert grade	Cutting parameters		
			V _c (m/min)	f _z (mm/z)	
P	Low-carbon steel, Soft steel	YNG151	430 (340-500)	0.2 (0.1-0.4)	
		YBM251 YBC301 YBG205	270 (220-350)	0.2 (0.1-0.4)	
		YBM351	220 (180-300)	0.25 (0.15-0.3)	
		YBG202 YBG302	270 (200-360)	0.2 (0.1-0.3)	
		YC30S	140 (100-220)	0.27 (0.1-0.4)	
	High-carbon steel, Alloy steel	180-280	YNG151	400 (320-480)	0.2 (0.1-0.4)
			YBM251 YBC301 YBG205	240 (200-320)	0.2 (0.1-0.4)
			YBM351	200 (160-280)	0.25 (0.15-0.3)
			YBG202 YBG302	240 (180-350)	0.2 (0.1-0.3)
			YC30S	120 (80-200)	0.27 (0.1-0.4)
	Alloy tool steel	280-350	YNG151	350 (300-450)	0.2 (0.1-0.4)
			YBM251 YBC301 YBG205	220 (180-300)	0.2 (0.1-0.4)
			YBM351	180 (150-250)	0.25 (0.15-0.3)
			YBG202 YBG302	220 (170-340)	0.2 (0.1-0.3)
			YC30S	100 (60-180)	0.27 (0.1-0.4)
M	Stainless steel	YNG151	220 (160-280)	0.2 (0.1-0.4)	
		YBM251 YBG205	130 (100-220)	0.2 (0.1-0.4)	
		YBM351	140 (100-240)	0.25 (0.15-0.3)	
		YBG202 YBG302	140 (100-250)	0.2 (0.1-0.3)	
K	Cast iron	YBG102	210 (120-300)	0.2 (0.1-0.3)	
		YBD252	200 (150-250)	0.2 (0.1-0.4)	
		YD201	100 (80-160)	0.25 (0.1-0.4)	