RECOMENDED CUTTING DATA FOR CARBIDE BLADES									
Material	**External Coolant Supply Cutting Lead A**			**Through Coolant Supply Cutting Lead B**			**Through Coolant Supply Cutting Lead C, D**		
	V_s	**f**	**R**	**V_s**	**f**	**R**	**V_s**	**f**	**R**
Group A									
STEEL<400N/mm^2	40-60	0.06-0.1	6°	80-120	0.06-0.1	6°	80-120	0.07-0.1	6°
STEEL<750N/mm^2	40-60	0.06-0.1	6°	80-120	0.06-0.1	6°	80-120	0.07-0.1	6°
STEEL>750N/mm^2	40-60	0.06-0.1	6°	80-120	0.06-0.1	6°	80-120	0.07-0.1	6°
Group B									
CAST IRON	40-60	0.1-0.12	0°	80-140	0.06-0.15	0°	80-140	0.06-0.15	0°
MALLEABLE C.I.	40-60	0.1-0.12	0°	80-140	0.06-0.15	0°	80-140	0.06-0.15	0°
Group C									
ALUMINIUM	40-70	0.1-0.15	12°	90-140	0.08-0.16	12°	80-140	0.08-0.16	12°
COPPER	40-70	0.1-0.12	12°	80-140	0.08-0.15	12°	80-140	0.1-0.15	12°
BRASS	40-70	0.08-0.12	12°	80-140	0.08-0.15	12°	80-140	0.08-0.15	12°
PHOSPHORUS BRZE	40-70	0.08-0.2	12°	80-140	0.1-0.15	12°	80-130	0.1-0.15	12°
HARD PLASTIC	40-70	0.08-0.15	0°	80-140	0.06-0.1	0°	80-140	0.1-0.15	0°
V_s – Cutting Speed in m/min F– Feed Rate in mm/rev R–Rake angle									

MODIFICATIONS ON REQUEST