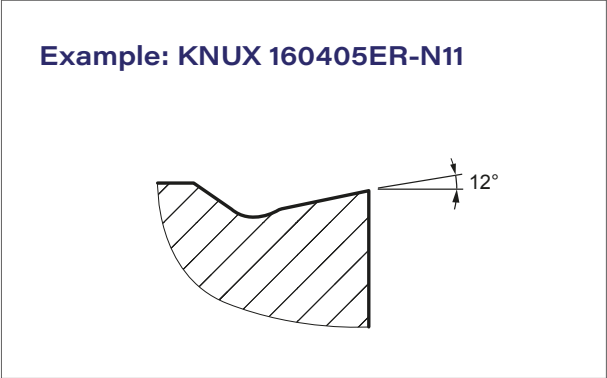


Cutting Data



General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide			
				GTCP115 V _c [m/min]	GTCP125 V _c [m/min]	LP2002 V _c [m/min]	LP4002 V _c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	220 – 400	170 – 240	170 – 200	170 – 190
		Low-alloyed steel	250 – 300	200 – 320	100 – 190	90 – 160	90 – 150
		High-alloyed steel	200	180 – 320	130 – 210	130 – 170	120 – 200
		Corrosion-resistant steel	200	200 – 320	130 – 210	130 – 180	140 – 180
M	Stainless steel	Ferritic	200	220 – 320	140 – 210	140 – 180	140 – 200
		Austenitic	180	–	100 – 210	100 – 170	110 – 190
		Duplex	230 – 260	–	–	–	80 – 150
		Martensitic	330	–	70 – 100	–	55 – 75
K	Cast iron	Grey cast iron	180	140 – 370	130 – 210	–	–
		Spheroidal cast iron	160	190 – 430	120 – 240	–	–
		Malleable/tempered iron	130	180 – 520	150 – 250	–	–

Consistent cutting depth	Incon - sistent cutting depth	Inter - rupted cut
●	○	X

Available Range

Turning steel neg medium "P25":



Insert	Designation		Chipbreaker	Material number	Available
	KNUX 160405-EL-N11	GTCP125	...-N11	MM11750418	●
	KNUX 160405-ER-N11	GTCP125		MM11750419	●
	KNUX 160410-EL-N11	GTCP125		MM12030582	●
	KNUX 160410-EL-N11	GTCP125		MM12030589	●
	KNUX 160405-ER-N11	LP2002		MM11246906	●
	KNUX 160405-EL-N11	LP2002		MM11246899	●
	KNUX 160405-ER-N11	LP4002		MM11247268	●
	KNUX 160405-EL-N11	LP4002		MM11247265	●

● available from stock, ○ available upon request