

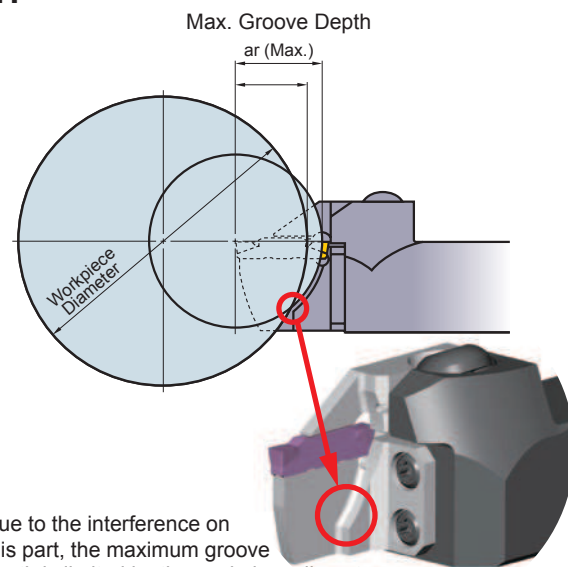
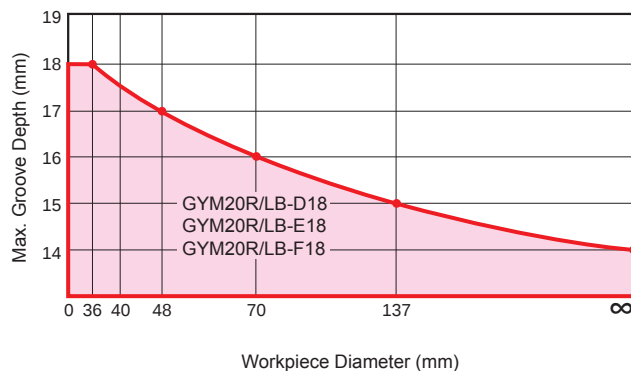
LIMITATION OF THE MAXIMUM GROOVE DEPTH

•When using the modular blade GYM○○R/LA-○○○

The maximum groove depth is not limited by the workpiece diameter.

•When using the modular blade GYM○○R/LB-○○○

The maximum groove depth is limited by the workpiece diameter.



Due to the interference on this part, the maximum groove depth is limited by the workpiece diameter.

RECOMMENDED CUTTING SPEED (m/min)

Work Material	Hardness	Grade	Cutting Speed (m/min)					
			50	100	150	200	250	300
P	Mild Steel	VP20RT		100		220		
		VP10RT		110		230		
		NX2525		90		210		
	Carbon Steel Alloy Steel	VP20RT		80		180		
		VP10RT		90		190		
		MY5015		110		250		
		NX2525		70		170		
	280HB≤	VP20RT		60		140		
		VP10RT		70		150		
		MY5015		90		210		
		NX2525		55		135		
M	Stainless Steel	VP20RT		60		140		
		VP10RT		70		150		
K	Gray Cast Iron	VP20RT		80		180		
		VP10RT		90		190		
		MY5015			140		300	
	Ductile Cast Iron	VP20RT		60		140		
		VP10RT		70		150		
		MY5015		90		210		
S	Heat Resistant Alloy Titanium Alloy	VP20RT	30	60				
		VP10RT	40	70				
		RT9010	40	70				
H	Hardened steel	50HRC≤			80	120		

(Note 1) VP20RT is the first recommended grade for materials other than hardened steel.

(Note 2) For VP10RT, VP20RT and MY5015, wet cutting is recommended.