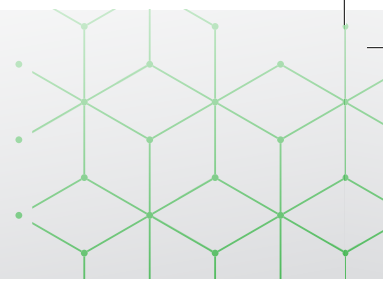


## STANDARD CUTTING CONDITIONS COATED GRADE



Work Materials	Work Condition	Grade	Cutting Speed (m/min)	ISO	Cutting Performance
<b>P</b> Steel	Continuous	QP710	150-360	P01	
		QP7110	150-360	P10	
		QC580	100-250	P20	
		QC230	100-250	P30	
		GQ301	100-250	P40	
		GQ601	100-250	P50	
	Interrupted	QP720	120-280		
		QP7220	120-280		
<b>M</b> Stainless Steel	Continuous	QM810	100-220	M01	
		QM8110	100-220	M10	
		QJ15	50-180	M20	
		QJ20U	50-180	M30	
	Interrupted	QM820	100-220	M40	
		QM8220	100-220	M50	
<b>K</b> Cast Iron	Continuous	QK910	200-400	K01	
	Interrupted	QK920	150-300	K10	
				K20	
				K30	
<b>N</b> Non-ferrous Metal	Continuous	QN320	100-1000	N10	
				N20	
<b>S</b> Superalloys Titanium	Continuous	QMS3115	40-70	S01	
				S10	
	Interrupted	QMS3125	45-65	S20	
				S30	
<b>H</b> Hard Materials	Continuous	QH510	60-150	H10	
				H20	



Work Materials	ISO	Coated Carbide			Cermets	Coated Cermets
		CVD	PVD	No Coated		
P Steel	P01				QC580 QC230	GQ301 GQ601
	P10	QP710				
	P20	QP710 QP720				
	P30	QP710 QP720				
	P40					
	P50					
M Stainless Steel	M01					
	M10					
	M20					
	M30					
	M40					
	M50					
K Cast Iron	K01				QC580 QC230	GQ301 GQ601
	K10	QK910				
	K20		QK920			
	K30					
N Non-ferrous Metal	N10				QN320	
	N20					
S Superalloys Titanium	S01					
	S10					
	S20					
	S30					
H Hard Materials	N10					
	N20					

