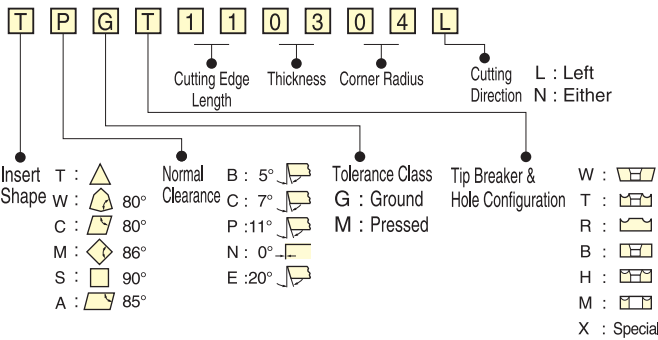


## Code No. of ISO standard Insert Tip



Please add the grade indication into ○, and add the insert tip material indication at the end of the Code No.  
 e.g. EM09-T4(NX)

## Grade & Material

Grade	Grade Indication	Insert Tip Material Indication	Specification
Cermet (w/o coating)	T	NX	The general material for the steel and the cast iron with the heat resistance and the toughness.
Carbide K	F	HTI	Toughness and the excellent wear resistance. Applicable for the cast iron, non-ferrous metal and the non-metal.

## Recommended Cutting Speed ○...Best ○...Good —...Unsuitable

Insert or	Insert		SS41	S55C	SCM	SKD	SC	FC,FCD	SUS	ALC	Ti
	Code No.	Material									
	T	NX	100~300	100~300	100~300	80~150	80~150	150~160	80~150	-	-
	F	HTI	-	-	-	-	-	60~130	-	300~500	30~40

★The cutting speed is recommended to be reduced to 50% for the interrupted cutting. ★Rapid speed : ~6000min-1.  
 ★Please be sure to make a test run and confirm of no deflection, vibration and unusual sound.

## Recommended Cutting Condition(removal,feed)

Boring Range	Boring head type			Best Condition		MAX. Condition	
	Boring bit	Solid carbide bit	Cartridge	Removal mm/φ	Feed mm/rev	Removal mm/φ	Feed mm/rev
φ 6~ 12	EJ16- 6-21 - 8-28	EJX16- 6- 45 - 8- 60		0.1~0.2	0.03~0.07	-	-
φ 10~ 30	EJ16-10-35 -11-40 -12-42 -14-50 -16-50 -18-63 -22-68	EJX16-10- 75  -12- 90 -14-105 -16-120		0.1~0.3	0.05~0.07	-	-
φ 28~ 56			ECC-28-10 -36-11.5	0.2~0.4	0.05~0.08	1.0	0.1
φ 54~200			ECC-54-19	0.2~0.5	0.05~0.08	2.0	0.15

$$\text{Speed } n(\text{min}^{-1}) = \frac{V_c \cdot 1000}{\pi D}$$

Vc: Cutting Speed(m/min)

π : 3.14

D : Boring dia(mm)

$$\text{Feed } V_f(\text{mm/min}) = n \cdot f$$

f : Feed(mm/rev)

$$\text{Logical Surface Finish (min)} = \frac{(\text{Feed per rev.})^2}{8 \times \text{Nose/R}}$$

Feed per rev. depends on Nose/R and accuracy required.