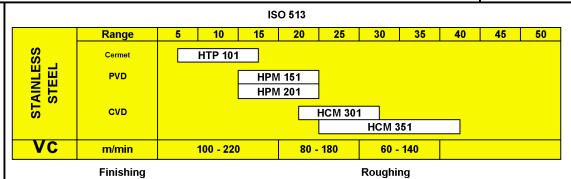
TECHNICAL GUIDE

TURNING GRADE OVERVIEW IN STAINLESS STEEL OPERATION





Vc increasing
Vf small
ap small
Wear resistance increasing
Toughness decreasing

Vc decreasing
Vf large
ap large
Wear resistance decreasing
Toughness increasing

	SCALE 0-10=RANGE OF							OF		APPLICATION				APPLICATION		
	TN Toughness / WR Wear resistance							stand	:e	Cutting condition				Machining condition		
HM - GRADE	2	3	4	5	6	7	8	9	10	0	0	¤	♦	F	М	R
HTP 101 TN										•	0			•	0	
HPM 151 TN										0	•	0		•	•	
HPM 201 TN										•	0	0		•	0	
HCM 301 TN										0	0	•	•	0	0	•
HCM 351 TN										0	0	•	•	0	0	•

		Recommendation		
Excellent; continious cutting with continious thicknes of chips	Finishing	● Ideal		
Good; continious cutting with different thickness of chips	Medium machining	O Stil recommended		
Fair; lichty interrupted cutting Difficult; heavy interrupted cutting	Roughing	Not recommended		