HAAS CARBIDE CUT-OFF INSERTS

Cut-Off Inserts Feeds and Speeds

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How To Use This Chart:

1) Select your material in the ISO colored chart
2) Select your Insert Cutting Width in the columns
3) Start with the middle range of the recommended sfm (vc) and feed (inch/rev)
   -Adjust the sfm and/or feed rate based on your cutting conditions.
   -For Non-ferrous metals a pecking cycle is recommended for help with breaking the chips

ISO	VDI 3323	Material Description		Insert Grade	Cutting Width (inch)		
				HU30	0.079	0.118	0.157
P	P1-5	Non-alloy steel	●	Cutting Speed (vc = sfm)	260 - 590	260 - 590	260 - 590
				Feed (fn = Ipr)	0.001 - 0.006	0.001 - 0.008	0.003 - 0.012
P	P6-9	Low alloy steel	●	Cutting Speed (vc = sfm)	230 - 490	230 - 490	230 - 490
				Feed (fn = Ipr)	0.001 - 0.006	0.001 - 0.008	0.003 - 0.012
M	M12-14	Stainless steel	●	Cutting Speed (vc = sfm)	200 - 460	200 - 460	200 - 460
				Feed (fn = Ipr)	0.001 - 0.004	0.001 - 0.006	0.003 - 0.010
K	K15-20	Grey cast iron	●	Cutting Speed (vc = sfm)	160 - 330	160 - 330	160 - 330
				Feed (fn = Ipr)	0.002 - 0.005	0.004 - 0.010	0.004 - 0.012
N	N21-28	Non-ferrous metals	○	Cutting Speed (vc = sfm)	660-1480	660-1480	660-1480
				Feed (fn = Ipr)	0.002 - 0.005	0.004 - 0.010	0.004 - 0.012

● Optimal ○ Secondary