



April 16, 2021



YG401 + SF, SM, SR

Cutting Conditions

ISO	Work-Piece	Parameter	YG401-SF	YG401-SM	YG401-SR
S	Super Alloy	Vc(m/min.)	40~90	40~90	40~90
	Fe Based	fn(mm/rev)	0.1~0.25	0.1~0.25	0.2~0.35
		ap(mm)	0.2~1	0.5~3.0	1.0~4.5
S	Super Alloy	Vc(m/min.)	35~70	35~70	35~70
	Ni or Co Based	fn(mm/rev)	0.1~0.25	0.1~0.25	0.2~0.35
		ap(mm)	0.2~1	0.5~3.0	1.0~4.5
S	Titanium	Vc(m/min.)	80~150	80~150	80~150
		fn(mm/rev)	0.1~0.25	0.1~0.25	0.2~0.35
		ap(mm)	0.2~1	0.5~3.0	1.0~4.5
S	Titanium Alloy	Vc(m/min.)	40~80	40~80	40~80
		fn(mm/rev)	0.1~0.25	0.1~0.25	0.2~0.35
		ap(mm)	0.2~1	0.5~3.0	1.0~4.5