

Multi Turn

➔ Recommended cutting condition

Workpiece		Hardness (HB)	PC5300		NC3225		NC6315		H01	
			Turning	Drilling	Turning	Drilling	Turning	Drilling	Turning	Drilling
P	Low-carbon steel ($\leq 0.25\% C$)	80-180	100-180	100-150	150-300	100-150	-	-	-	-
	High-carbon steel ($> 0.25\% C$)	180-280	90-160	60-140	100-180	70-120	-	-	-	-
	Low alloy steel	140-260	70-120	50-120	100-180	70-120	-	-	-	-
	High alloy steel	200-350	60-110	50-100	80-150	60-100	-	-	-	-
M	Austenite	135-275	80-150	50-110	-	-	-	-	-	-
	Martensite	135-275	90-170	60-120	-	-	-	-	-	-
K	Gray cast iron	150-220	120-240	120-200	-	-	100-200	70-140	-	-
	Ductile cast iron	130-240	120-200	100-180	-	-	100-180	70-120	-	-
N	Aluminium alloy	30-150	-	-	-	-	-	-	200-500	140-220
	Copper alloy	150-160	-	-	-	-	-	-	150-300	140-200
S	HRSA	130-400	30-70	30-90	-	-	-	-	-	-

