**Turbine Wheel/Shaft**

**Shaft Material:** Steel  
**Wheel Material:** Inconell, TiAl Alloy

1. **High Pressure Rough Turn**
   - High pressure coolant directed right to the cutting edge
   - Shiftable telescopic coolant tube for easy and fast insert replacement
   - Quick change lever lock mechanism

   **Cutting conditions**
   - \( V_c = 180 \text{ m/min (590 sfm)} \)
   - \( f = 0.25 \text{ mm/rev (0.0098 inch/rev)} \)

2. **High Pressure Finish Turn**
   - High pressure coolant directed right to the cutting edge
   - Shiftable telescopic coolant tube for easy and fast insert replacement
   - Quick change lever lock mechanism

   **Cutting conditions**
   - \( V_c = 180 \text{ m/min (590 sfm)} \)
   - \( f = 0.1 \text{ mm/rev (0.0039 inch/rev)} \)

3. **Slot - Groove-Turn**
   - Excellent surface finish
   - High grooving repeatability
   - High pressure coolant for chip evacuation and longer tool life

   **Cutting conditions**
   - \( V_c = 160 \text{ m/min (525 sfm)} \)
   - \( f = 0.08 \text{ mm/rev (0.0031 inch/rev)} \)

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**Cutting Conditions**
- \( V_c = 180 \text{ m/min (590 sfm)} \)
- \( f = 0.25 \text{ mm/rev (0.0098 inch/rev)} \)
**PENTACUT**

**Threading Line**

**PENTA 24... IC908**
- 5 cutting corners
- High cutting speed
- Unique pressed chipformer
- Wide range of threading types

**Cutting conditions**
Vc=15 m/min (50 sfm)
f=Pitch

**High Pressure Threading**
- Extreme accuracy
- Excellent surface finish
- High pressure coolant for effective chip control and longer tool life

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**ISCAR MILL**

**RXCR 07... IC808**
- Low cutting forces
- High stability cutting
- Moderated chipbreaker

**Cutting conditions**
Vc=35 m/min (115 sfm)
fz=0.1 mm/t (0.0039 inch/t)

**Milling (Dynamic balance)**
- Indexable profiling tool
- High material removal rate

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**Shaft Material: Steel**
**Wheel Material: Inconell, TiAl Alloy**