

LNMX 191940-F3P
For finish operation



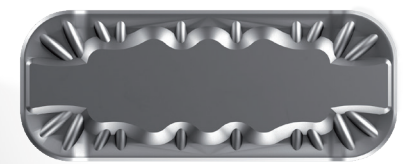
LNMX 191940-WF
For semi-finish operation



LNMX 191940-WM
For medium/
semi-finishing operations



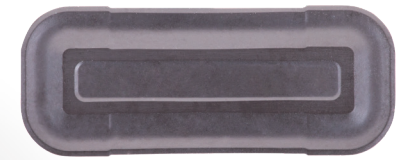
LNMX 1919-WKR
For roughing operations
- Unstable conditions



LNMX 301940-WM
For medium/
semi-finishing operations



LNMX 301940-WR
For roughing operations



LNMX 301940-WKR
For roughing operations
- Unstable conditions

Cutting Data Recommendations



Cutting Data by Area:

Area	V_c	f
A	30 - 70 m/min	0.3 - 1.8 mm/rev
B	50 - 100 m/min	0.5 - 2.0 mm/rev
C	50 - 100 m/min	0.5 - 2.0 mm/rev

Depth of cut according to chipbreaker geometry:

F3P	0.20-1.50
WF	1.00-3.50
WM (19)	1.50-5.00
WKR (19)	3.00-6.00
WKR/WR (30)	3.00-12.00

In case of worn wheels with skid flats, built-up and shelled tread or thermal cracks, reduce the cutting speed to **ISCAR's** recommended minimum speed.

High carbon wheels should be machined at **ISCAR's** recommended low range cutting speed. Feeds should be optimized within the recommended range per chipformer and actual chip formation.

