

Insert	Size	Chipbreaker Geometry	Process type	Chipbreaker Type	Ground Wiper	Ground Edge	Ground Clamping Base
HM390 TDCR 1505...PDFR-P	15	PDFR-P	SEMI AND FINISH	High Positive	Yes	Yes	Yes
HM390 TDCR 1505.. FW-P		FW-P	ROUGH	High Positive	Yes	Yes	Yes

Table - Average Cutting Data for HM390 TDCR 1505... FW-P Inserts

ISO Class DIN/ISO 513	Workpiece Material						Carbide Grade	Cutting Speed V <sub>c</sub> [m/min]	Max. D.O.C. A <sub>p</sub> [mm]	Feed F <sub>z</sub> [mm/tooth]	Coolant
	Material No.	Material	Condition	Hardness HB	Typical Representative						
					AISI/SAE/ ASTM	DIN W.-Nr.					
N	21	aluminum-wrought alloys	not hardenable	60 HB	1000	3.0255	IC28	13	0.08-0.22	wet	480-640
	22		hardenable	100 HB	7050	3.4345					400-560
	23	Aluminum-cast, alloyed <12% Si	not hardenable	75 HB	A360.2	3.2383					480-640
	24	Aluminum-cast, alloyed	hardenable	90 HB	4218B	3.2371					400-560
	25	Aluminum-cast, alloyed >12% Si	high temperature	130 HB	A390.0	EN AB-48100**					240-320
	26	Copper alloys >1% Pb	free cutting	110 HB	C 93800	2.1182					240-320
	27	Copper alloys	brass	90 HB	C 86500	2.0592					240-320
	28		electrolytic copper	100 HB	C 63000	2.0966					160-240

\* ISCAR material group in accordance with VDI 3323 standard

\*\* Euro norm

For machining in unstable conditions, the recommended cutting data should be reduced by 20-30%