

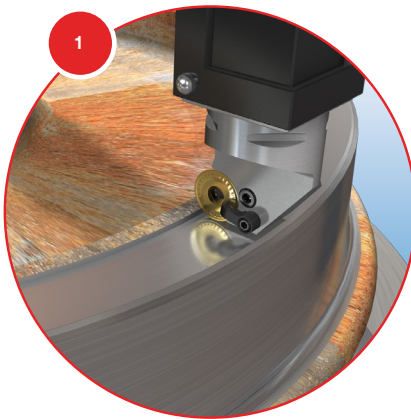
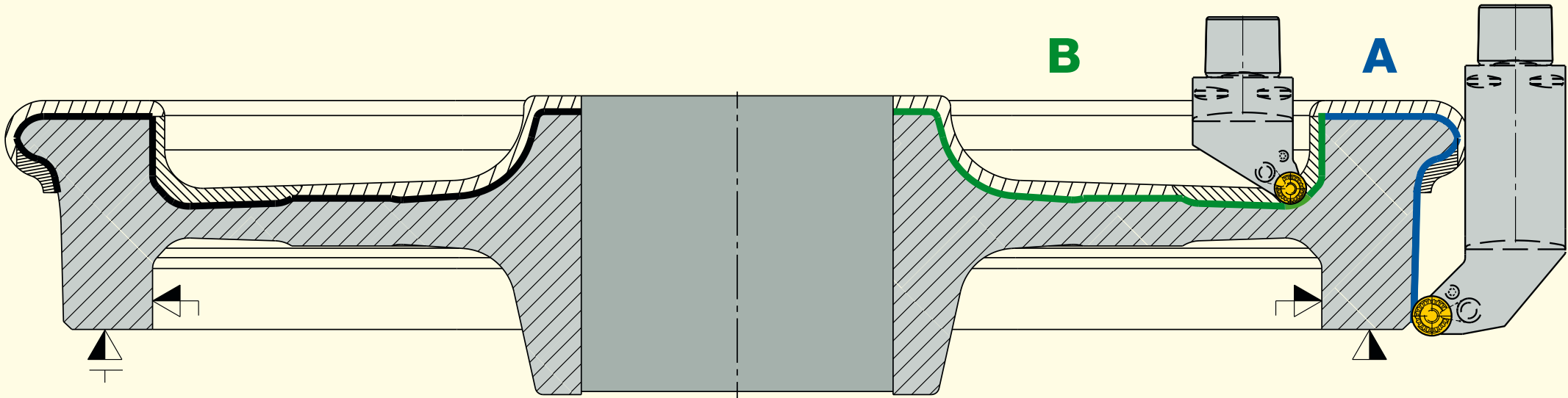
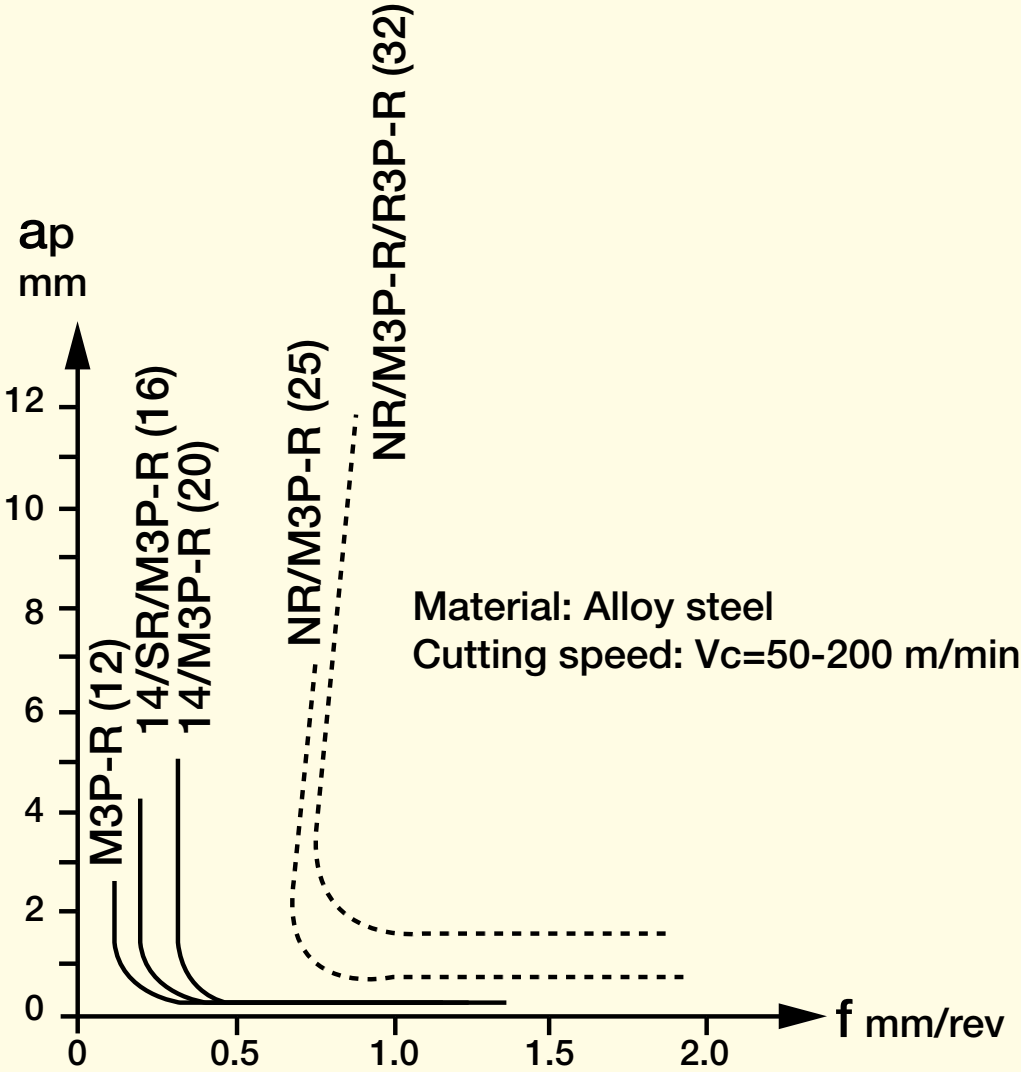
Cutting data by area:

Area	V _c	f
A	70 - 200 m/min	0.5 - 2.0 mm/rev
B	50 - 100 m/min	0.5 - 1.5 mm/rev

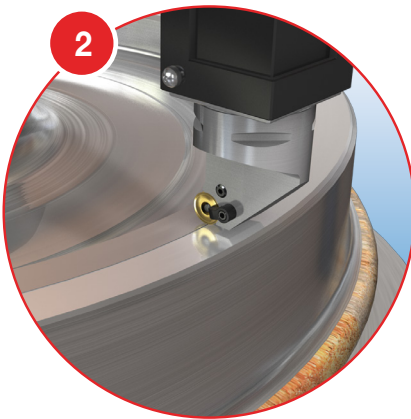
Depth of cut according to M3P-R (12) chipbreaker geometry:

14 / SR /M3P-R (16)	0.3 - 3.5 mm
14 / M3P-R (20)	1.5 - 7.0 mm
NR / M3P-R (25)	2.5 - 7.0 mm
NR / M3P-R/R3P-R (32)	3.0 - 12 mm

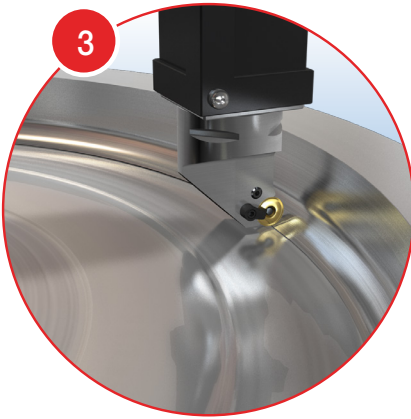
In case of worn wheels with skid flats, built-up shelled tread or thermal cracks, reduce the cutting speed to **ISCAR**'s recommended minimum machining speed. High carbon wheels should be machined at **ISCAR**'s recommended low range cutting speed. Feeds should be optimized within the recommended range per chipformer and actual chip formation.



Roughing Application



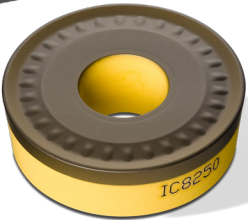
Finishing Application



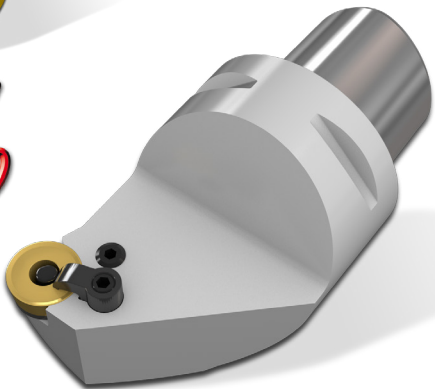
Finishing Application

ISOTURN

Round inserts and special **CAMFIX** holders with a screw and top lever for robust clamping.



SPECIALLY TAILORED



* Special holder per request