

# IX12 CUTTING DATA



EXCHANGEABLE HEAD

P	●		●	●
M	○	●		
K	●			●
N	○			
S		●		
H			●	

Chipbreaker	Insert	RE (mm)	f <sub>n</sub> (mm/rev)	ET602	ET63P	ET73P	ET30P
				PVD			
-	IX10	-	0.09 - 0.24				●
	IX12	-	0.09 - 0.29				●
	IX14 (<15.0)	-					●
	IX14 (≥15.0)	-	0.12 - 0.41				●
	IX16	-					●
	IX18	-	0.20 - 0.45				●
	IX20	-					●
	IX22	-	0.22 - 0.57				●
	IX24	-					●
	IX26 (<27.0)	-					●
	IX26 (≥27.0)	-					●
	IX28	-	0.20 - 0.61				●
	IX30	-					●
	IX32	-					●

ISO		P			M		K		N	S	H
MATERIAL	Non-alloy steel <25 HRC	Low alloy steel 25-35 HRC	High alloy steel, Tool steel 35-45 HRC	Ferritic / Martensitic Stainless steel	Austenitic Stainless steel	Grey Cast iron	Nodular Cast iron	Aluminium & Non-ferrous material	Heat Resistant and Super Alloys	Hard materials <55 HRC	
VDI GROUP	1-5	6-9	10-11	12-13	14	15-16	17-20	21-30	31-37	38-41	
V <sub>c</sub> (m/min)	ET602	140 - 240	120 - 220	70 - 150	120 - 200	60 - 120	140 - 220	150 - 240	250 - 440	20 - 40	-
	ET63P	-	-	-	140 - 250	120 - 200	-	-	-	25 - 45	-
	ET73P	-	-	60 - 100	-	-	-	-	-	-	40 - 80
	ET30P	58 - 126	47 - 95	42 - 68	-	-	79 - 131	79 - 131	-	-	-