

# Technical Data and Settings

## Cutting Data GH-K

Material	Condition	Tensile stren.	Hardness	Cutting Speed (m/min.)	Feed (mm/rev.)
		(N/mm <sup>2</sup> )	HB		
Unalloyed steel		<500	<150	30-50	0.05/Blade
Cast steel		500 - 850	150 - 250	30-50	0.05/Blade
Grey cast iron		<500	<150	30-70	0.05/Blade
Ductile cast iron		300 - 800	90 - 240	30-50	0.05/Blade
Low alloy steel	annealed	<850	<250	30-50	0.05/Blade
	tempered	850 - 1000	250 - 300	20-30	0.05/Blade
	tempered	>1000 - 1200	>300 - 350	15-25	0.05/Blade
High alloy steel	annealed	<850	<250	20-30	0.05/Blade
	tempered	850 - 1100	250 - 320	15-25	0.05/Blade
Stainless steel	ferritic	450 - 650	130 - 190	15-25	0.05/Blade
	austenitic	650 - 900	190 - 270	10-20	0.05/Blade
	martensitic	500 - 700	150 - 200	15-25	0.05/Blade
Special alloy (Inconel, titanium, ...)		<1200	<350	10-20	0.05/Blade
Wrought or cast aluminium alloys				30-120	0.05/Blade
Copper alloy	Brass			30-50	0.05/Blade
	Bronze short-chipping			20-30	0.05/Blade
	Bronze long-chipping			15-25	0.05/Blade

### WARNING NOTICE

All listed cutting data are standard values only! The cutting values depend on the amount of slope of the uneven bore edge. (i.e. high slope ► low cutting value). The feed also depends on the sloping ratio. In case of hard to machine materials or uneven bore edges, we recommend to apply cutting speeds that are at the lower end of the range for uneven bore edges.

## Accessories

Size / Series	Angle	Re-Sharpening Device
		Part No.
GH-K 25	90°	GH-K-V-0020
GH-K 25	60°	GH-K-V-0023
GH-K 45	90°	GH-K-V-0021
GH-K 45	60°	GH-K-V-0024