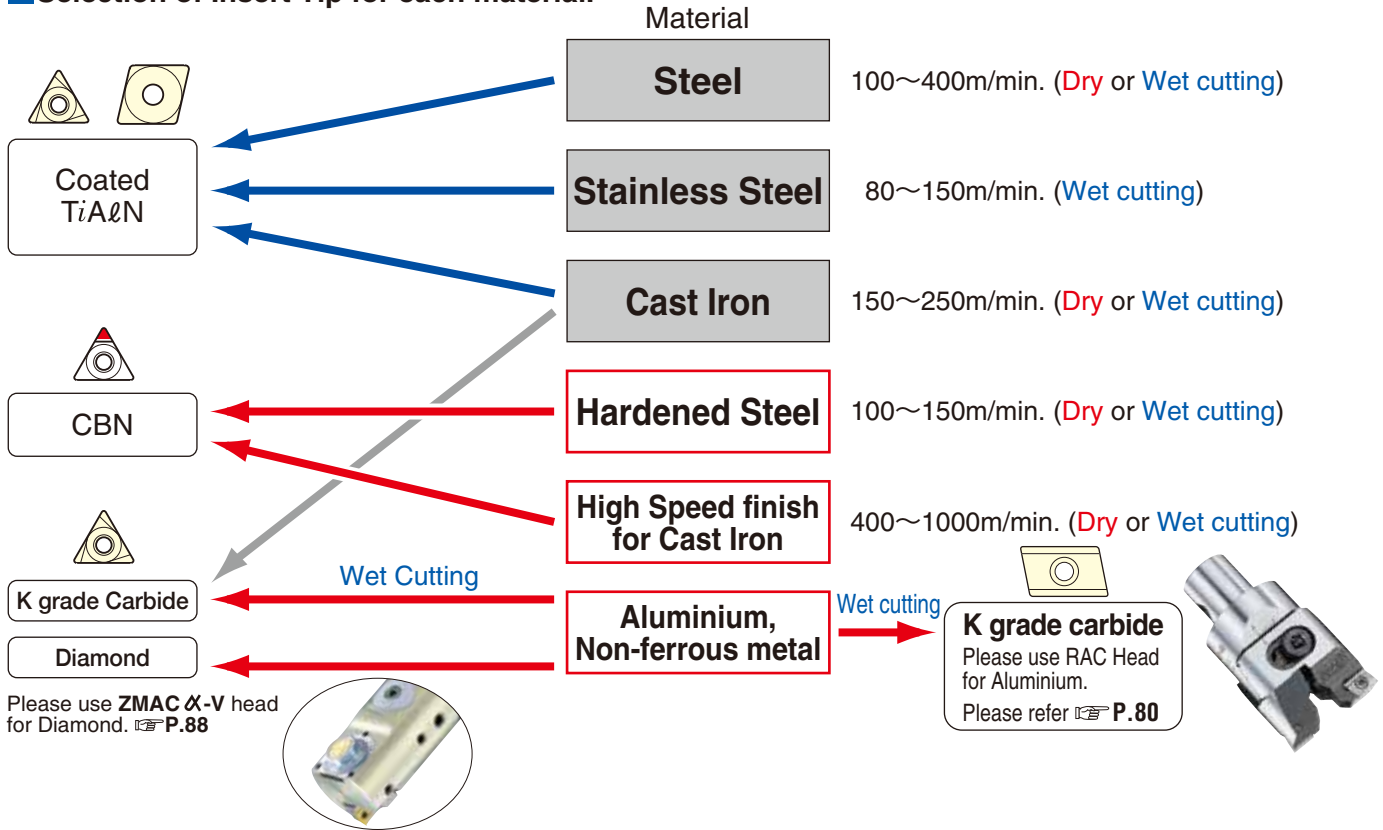


ZMAC ADVANCED BORING SYSTEM CUTTING DATA **NIKKEN**

Selection of Insert Tip for each material.



Recommended cutting Speed ○...Best ○...Good ---Unsuitable

Insert	Code No.	Grade	SS41	S55C	SCM	SKD	SC	FC,FCD	SUS	AL,ALC	Hardened Steel			Interrupted Cutting
											SCM	SKD	SUJ	
	C	Coated	○	○	○	○	○	○	○	-	-	-	-	○
	E	P10	○	○	○	○	○	-	○	-	-	-	-	○
	F	K10	-	-	-	-	-	○	-	○	-	-	-	○
	T	Cermet	○	○	○	○	○	-	○	-	-	-	-	○
	B	CBN	-	-	-	-	-	○	-	-	○	○	○	○
	D	Diamond	-	-	-	-	-	-	-	○	○	-	-	-
	C	Coated Carbide M	○	○	○	○	○	○	○	-	-	-	-	○
		Coated Carbide K	○	○	○	○	○	○	○	-	-	-	-	○

- ★ Existing Inserts (Cermet, P grade Carbide & K grade Carbide) are available.
- ★ The cutting speed is recommended to be reduced to 50% for the interrupted cutting.
- ★ When L/D is longer, the insert tip with small Nose R is recommended.
- ★ When L/D is longer, the feed rate at the entrance is recommended to be reduced to 60 to 70%.

Recommended Cutting Condition (removal, feed)

Boring Range	Type								
		Best Condition		MAX. Condition		Best Condition		MAX. Condition	
		Removal mm/φ	Feed mm/rev.	Removal mm/φ	Feed mm/rev.	Removal mm/φ	Feed mm/rev.	Removal mm/φ	Feed mm/rev.
φ16~20	ZMAC16-V	0.2~0.4	0.05~0.07	1.0	0.1				
φ20~25	ZMAC20-V	0.2~0.4	0.05~0.07	1.5	0.1				
φ25~32	ZMAC25-V	0.2~0.4	0.05~0.07	2.0	0.1				
φ32~42	ZMAC32-V	0.2~0.4	0.05~0.08	2.0	0.2	1.0~3.0	0.1~0.15	5.0	0.2
φ42~55	ZMAC42-V	0.2~0.5	0.05~0.08	4.0	0.2	1.0~3.0	0.1~0.15	5.0	0.2
φ55~70	ZMAC55-V	0.2~0.5	0.05~0.08	4.0	0.2	1.0~3.0	0.1~0.15	5.0	0.2
φ70~85	ZMAC70-V	0.2~0.8	0.05~0.1	4.0	0.25	1.0~4.0	0.1~0.2	8.0	0.25
φ85~	ZMAC85-V~	0.2~0.8	0.05~0.1	4.0	0.25	1.0~4.0	0.1~0.2	8.0	0.25

In case of CBN insert, reduce L/D as small as possible : MAX. 3 times.
Stock removal on diameter.
D<32mm : less than 0.25mm
D>32mm : less than 0.3mm

Feed per rev. depends on Nose/R and accuracy required.
Logical Surface Finish : $\frac{(\text{Feed per rev.})^2}{8 \times \text{Nose/R}}$