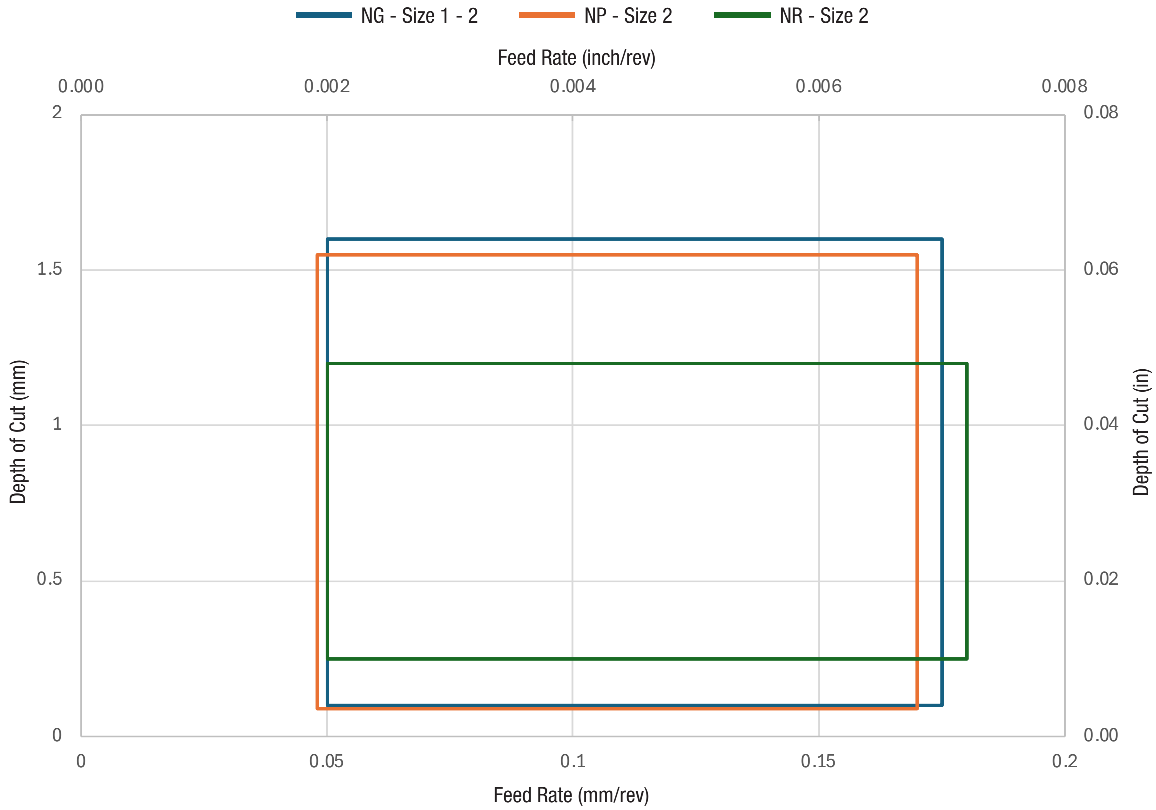
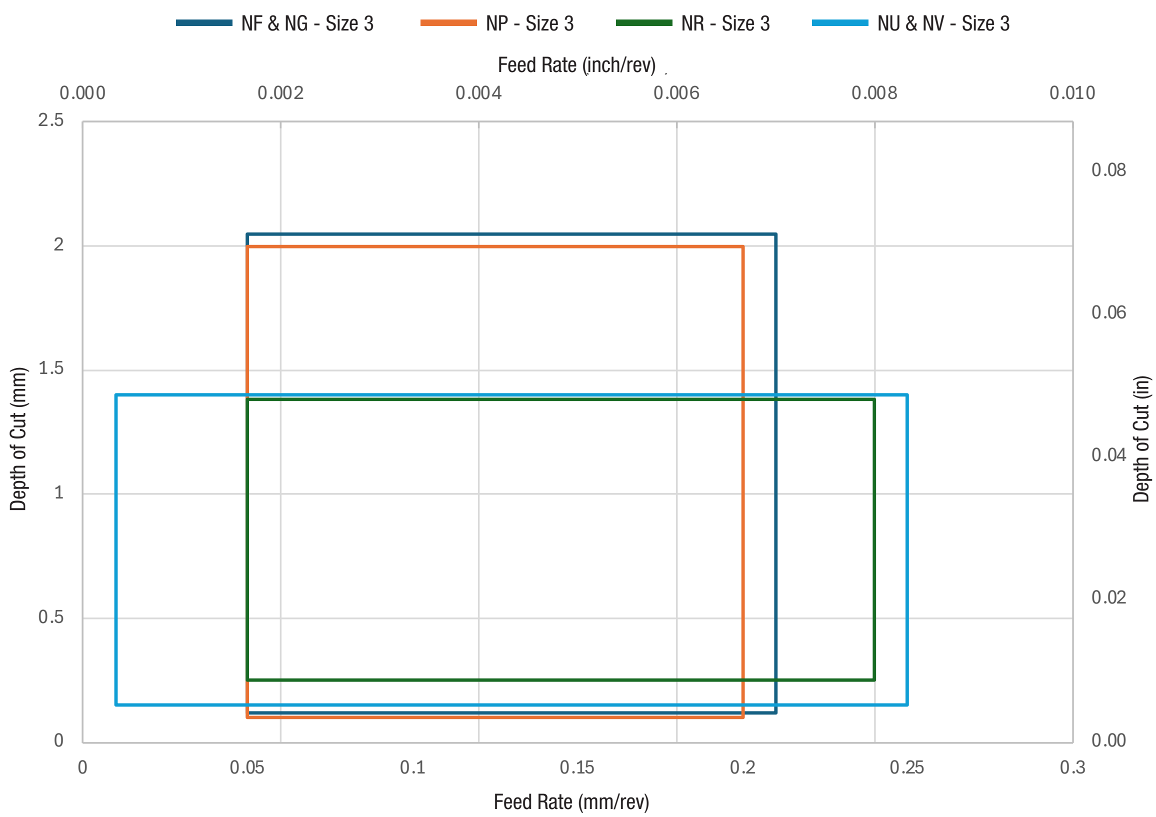
Top Notch • Application Data • Feed & Depth of Cut

Seat Size 1 and 2 • NG - NP - NR • OD Groove & Turn

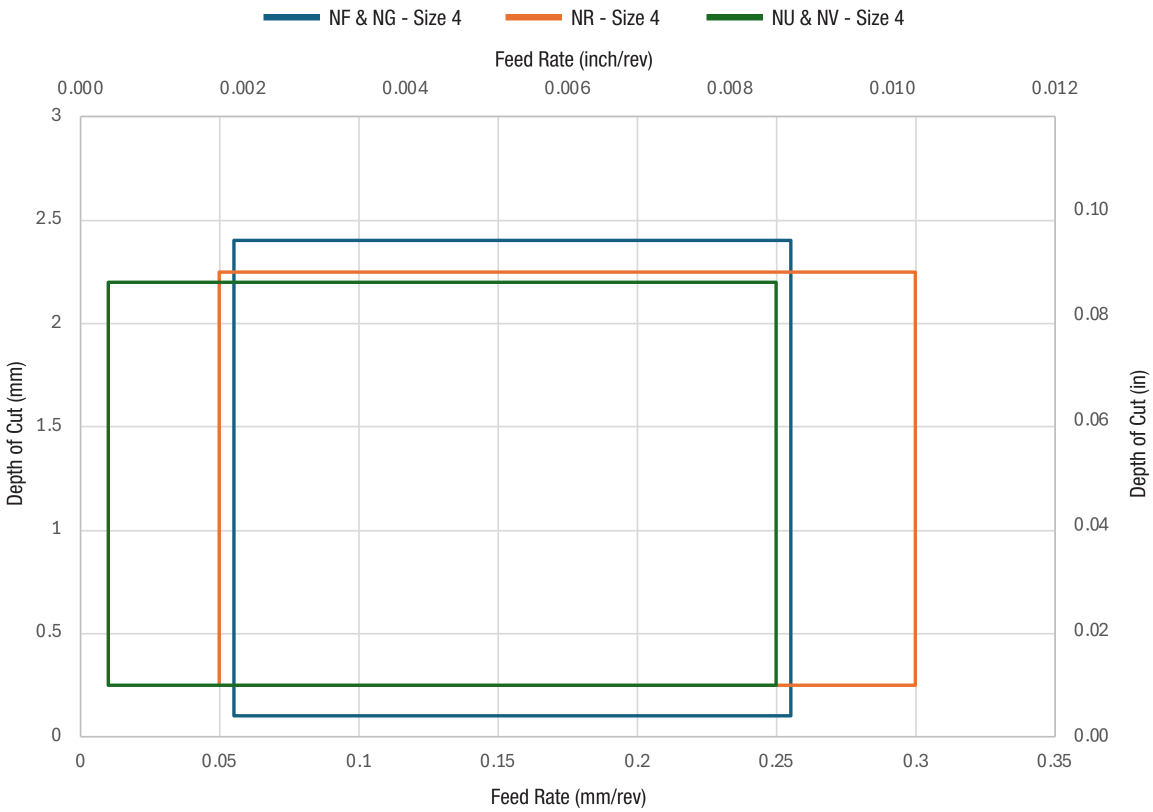


Seat Size 3 • NG - NF - NP - NR - NU - NV • Groove & Turn

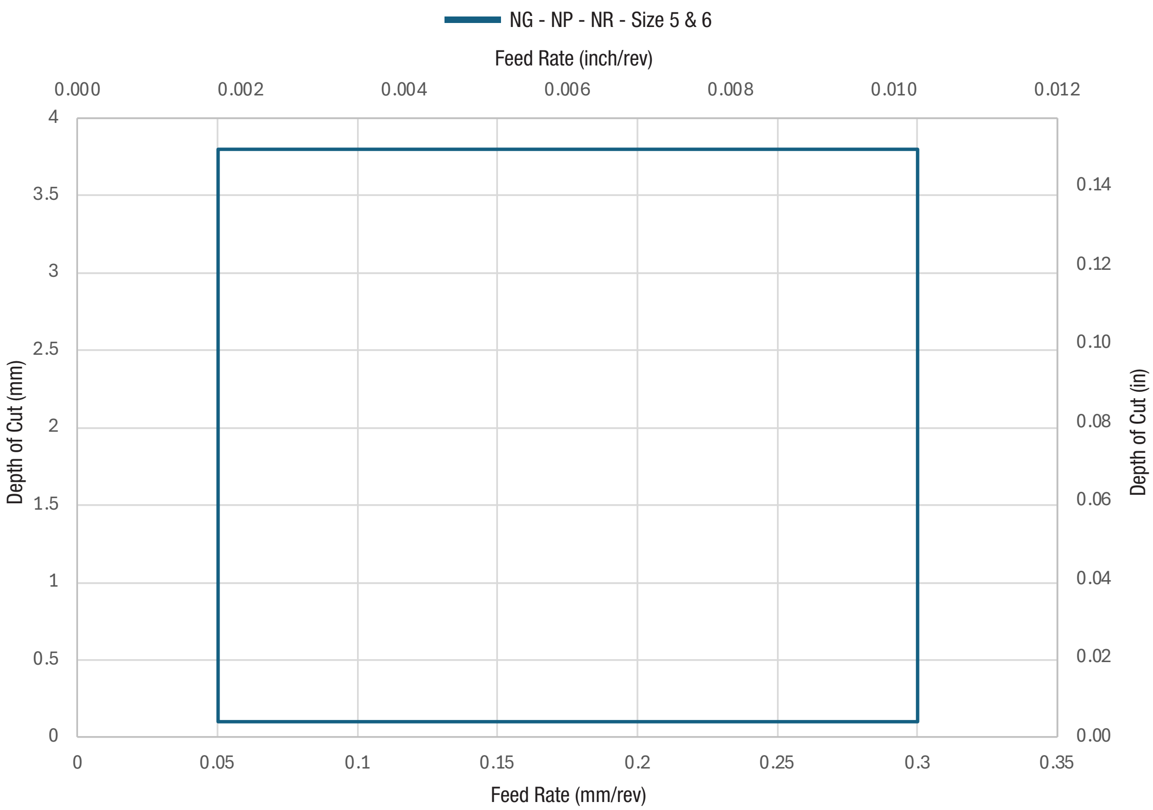


Top Notch • Application Data • Feed & Depth of Cut

Seat Size 4 • NG - NP - NR - NU - NV - NF • Groove & Turn

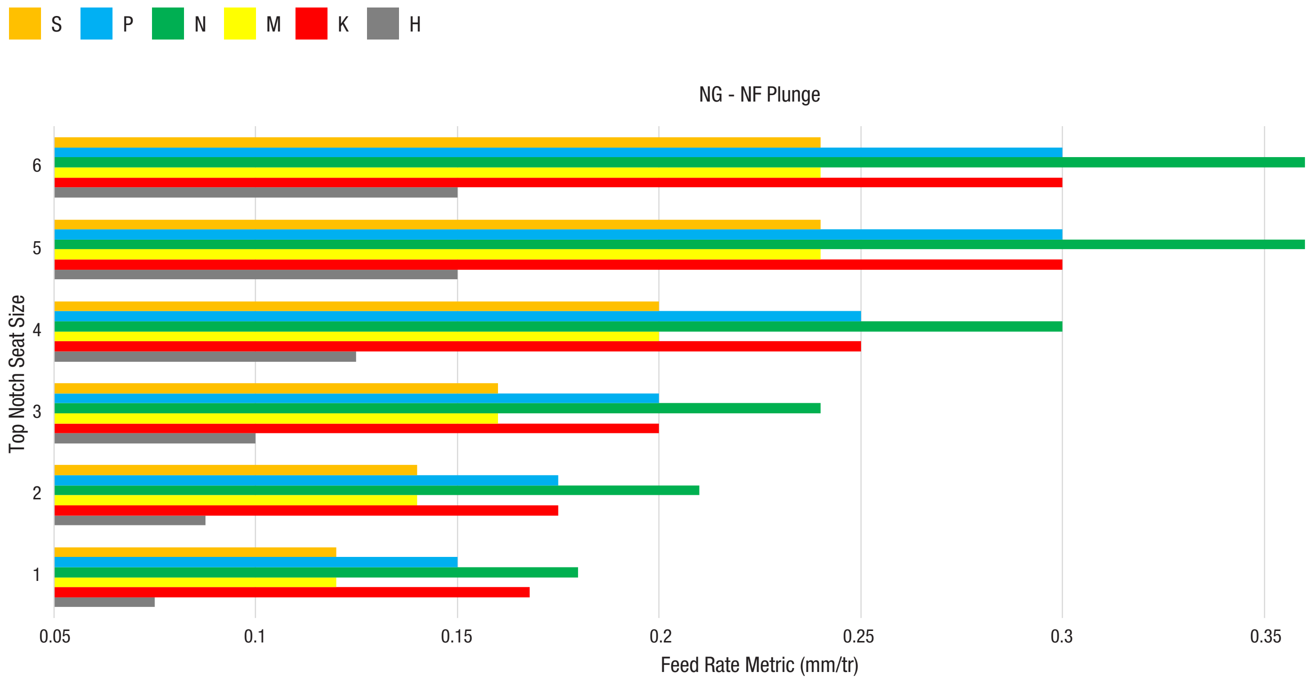


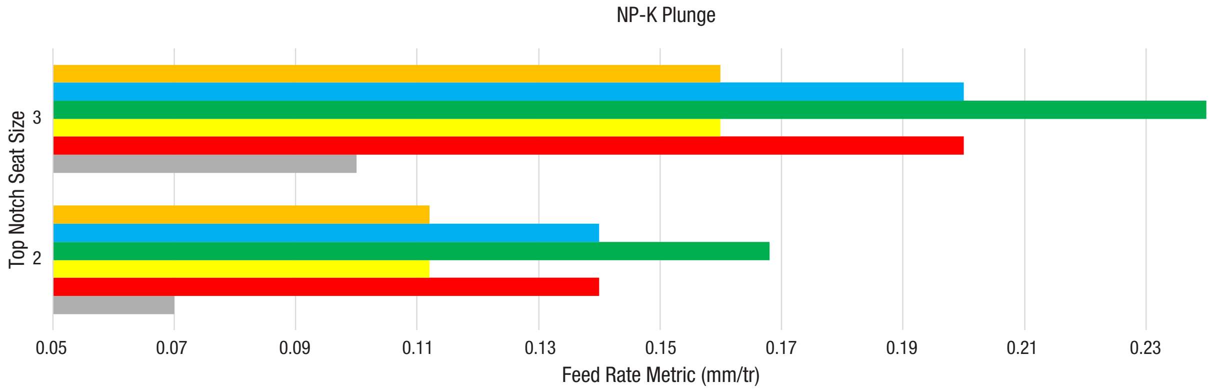
Seat Size 5-6 • NG - NP - NR • Groove & Turn



TURNING

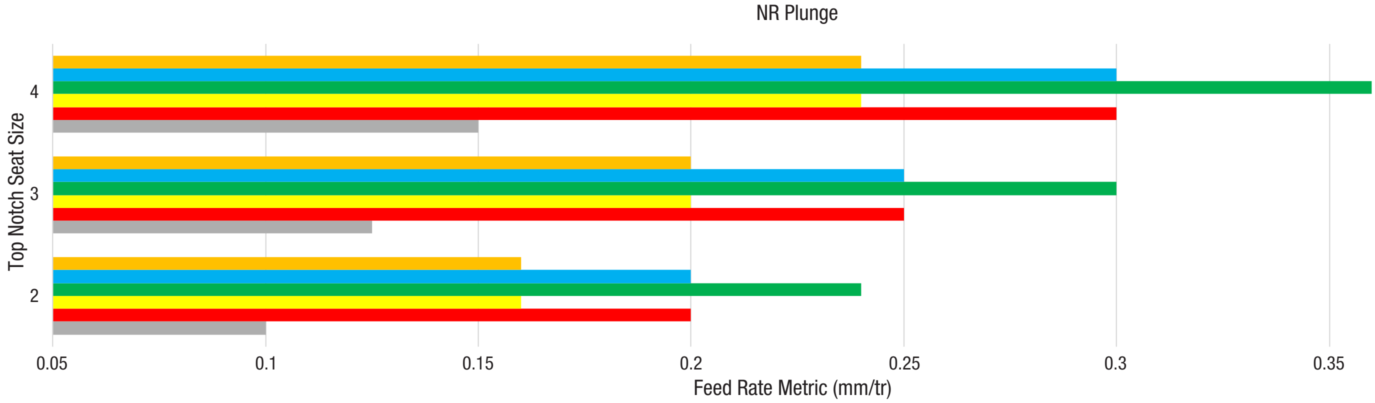
Top Notch
Application Data • Plunging Data • Metric

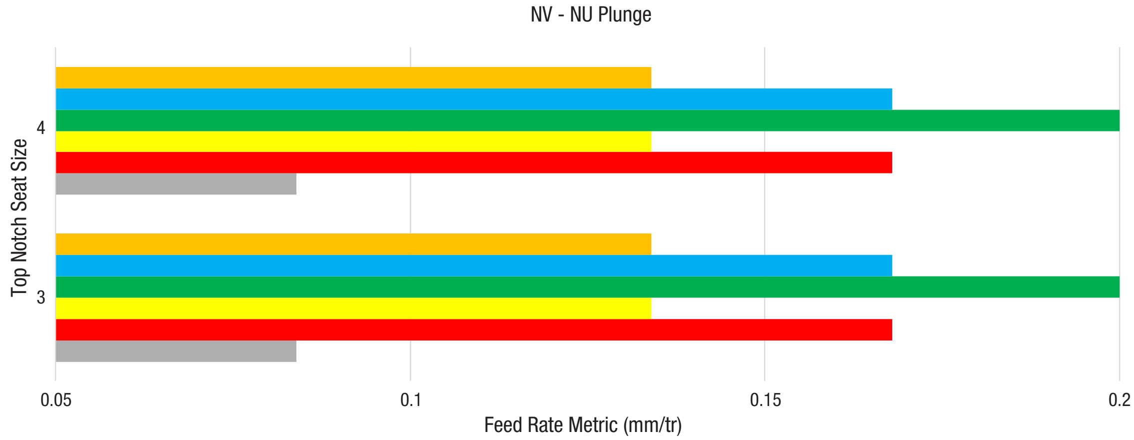




Top Notch
Application Data • Plunging Data • Metric • Continued

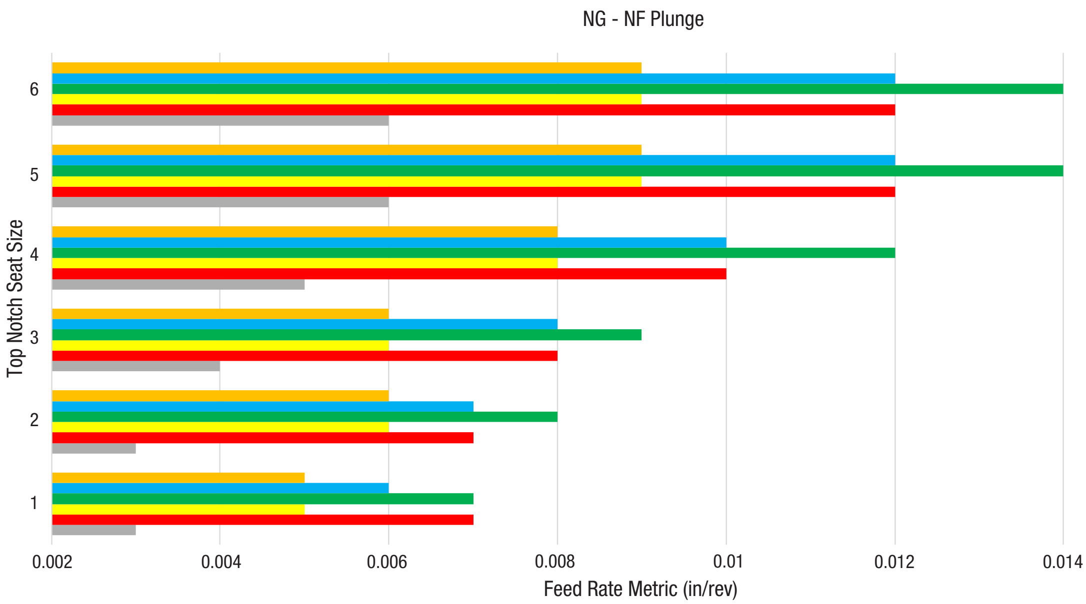
S P N M K H

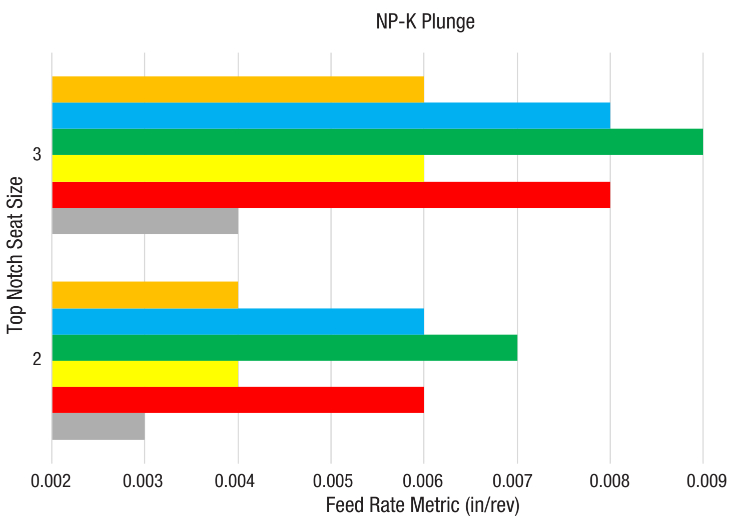




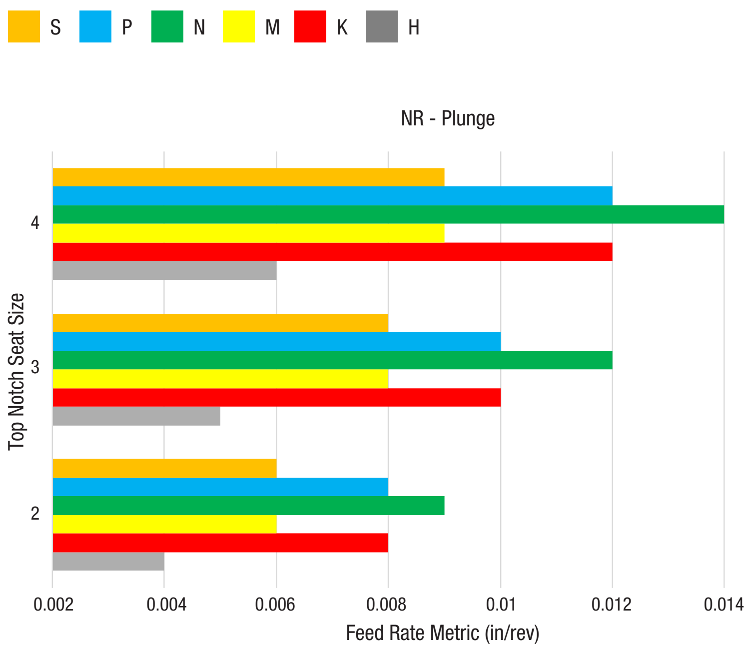
Top Notch
Application Data • Plunging Data • Inch

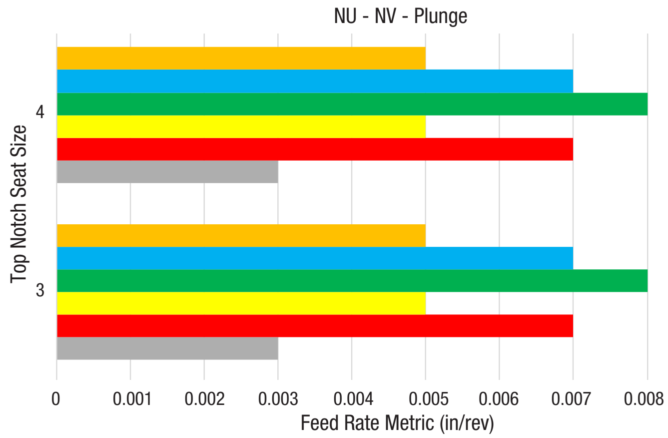
S P N M K H





Top Notch
Application Data • Plunging Data • Inch • Continued





KCU10B - KCU25B: Top Notch Application Data • Metric (General Machining)

Groove & Turn and Cut-Off • Application Data • Recommended Starting Speed (m/min)				
Material Group	KCU10B		KCU25B	
	MIN	MAX	MIN	MAX
P0	140	350	90	230
P1	140	295	90	230
P2	140	255	90	165
P3	140	255	90	165
P4	75	180	50	115
P5	120	275	80	180
P6	110	240	70	160
M1	110	220	100	205
M2	95	205	75	180
M3	95	205	50	125
K1	75	165	90	255
K2	55	140	90	255
K3	40	100	90	220
N1	150	1025	100	655
N2	150	1025	100	655
N3	-	-	80	410
N4	90	640	80	410
N5	90	255	60	165
N6	120	320	80	205
S1	10	115	8	65
S2	10	115	8	80
S3	10	115	15	80
S4	10	140	8	115
H1	30	65	-	-

KCU10B - KCU25B: Top Notch Application Data • Inch (General Machining)

Groove & Turn and Cut-Off • Application Data • Recommended Starting Speed (sfm)				
Material Group	KCU10B		KCU25B	
	MIN	MAX	MIN	MAX
P0	459	1148	295	755
P1	459	968	295	755
P2	459	837	295	541
P3	459	837	295	541
P4	246	591	164	377
P5	394	902	262	591
P6	361	787	230	525
M1	361	722	328	673
M2	312	673	246	591
M3	312	673	164	410
K1	246	541	295	837
K2	180	459	295	837
K3	131	328	295	722
N1	492	3363	328	2149
N2	492	3363	328	2149
N3	-	-	262	1345
N4	295	2100	262	1345
N5	295	837	197	541
N6	394	1050	262	673
S1	33	377	26	213
S2	33	377	26	262
S3	33	377	49	262
S4	33	459	26	377
H1	98	213	-	-

Maximum Feed Rate Values

Material Group	Feed Factor
M	0.8
N	1.2
S	0.8
H	0.5

Data above is for P and K material groups. Maximum feed rates should be adjusted by multiplying max feed rate values by following factors for shown material groups.