

## Arno Turning Inserts

### Recommended Cutting Data - Carbide

WORK MATERIAL		CUTTING SPEED (SFM)		
		AK10, AK20	PVD1, PVD2, AT10, AT20	PVD1, PVD2, AT10, AT20 AL10, AL20
PURE ALUMINUM		2,100 ~ 4,000	2,300 ~ 4,250	
A L U M I N U M  A L L O Y	UN-HEAT TREATED	2,100 ~ 3,300	2,300 ~ 3,600	
	HEAT TREATED	1,000 ~ 2,300	1,100 ~ 2,500	
	Si < 13%	650 ~ 2,000	720 ~ 2,150	
	Si > 13%	500 ~ 1,300	560 ~ 1,500	
STAINLESS STEEL SUS 300 SERIES				~ 650
STAINLESS STEEL SUS 400 SERIES				~ 820
CARBON STEEL ALLOY STEEL				~ 980

### Recommended Cutting Data - Diamond

WORK MATERIAL	JDA715	
	SFM	FEED RATE/REVOLUTION
ALUMINUM ALLOY	1,640 ~ 5,000	.002 ~ .008
COPPER ALLOY	3,300	.0009 ~ .008
SYNTHETIC RESIN	3,600	.0009 ~ .008