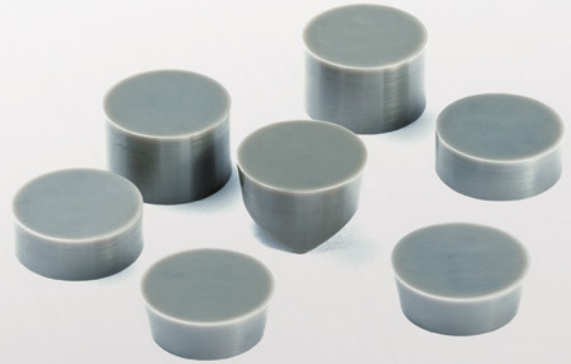




KXW1

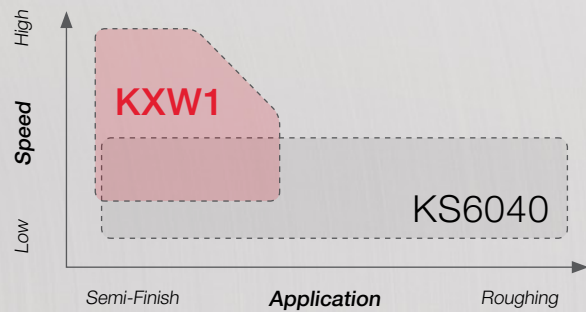
Whisker-Reinforced CERAMIC

for Plunging & Semi-Finish Work



When to choose Whisker (KXW1)

- First choice for plunging operations
- Can be used at higher cutting speeds and lower feed rates than SiAlON (KS6040)
- Stable choice for roughing and semi-finishing operations



KXW1 Recommended Applications

Purpose	Cutting Speed (sfm)	Feed (ipr)	Depth of Cut (in)
Roughing	600 ~ 1200	0.004 ~ 0.010	0.040 ~ 0.125
Semi-Finish / Profiling	600 ~ 1500	0.004 ~ 0.008	0.020 ~ 0.080
Plunging	600 ~ 1200	0.003 ~ 0.006	-

KYOCERA Precision Tools, Inc.

P : 800.823.7284 | F : 828.692.1344 | E : CTSales@kyocera.com
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KS6040

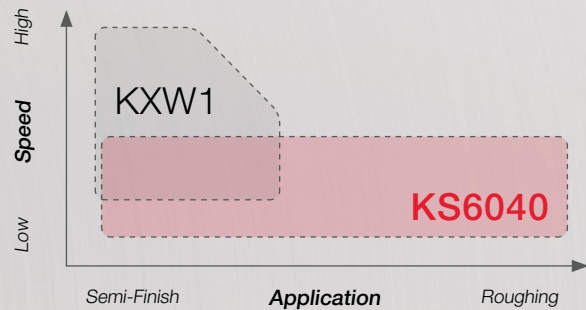
SiAlON CERAMIC

for Roughing



When to choose SiAlON (KS6040)

- First choice for rough machining of inconel and waspaloy forgings
- Economical alternative to whisker-reinforced ceramics with lower cost per part for roughing operations
- Recommended at lower cutting speeds and higher feed rates than whisker (KXW1)
- Not recommended for plunging operations



KS6040 Recommended Applications

Purpose	Cutting Speed (sfm)	Feed (ipr)	Depth of Cut (in)
Roughing, with Scale	450 ~ 800	0.008 ~ 0.012	0.040 ~ 0.200
Roughing, without Scale	600 ~ 900	0.008 ~ 0.014	0.040 ~ 0.200

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