


# HATHYAR

## TOOL BITS



  
Now  
available  
in a branch  
near you!

### WHAT'S NEW IN OUR HATHYAR TOOL BIT :

- Homogenous Microstructure
- Improved Wear Resistance & Dimensional Accuracy
- Edge Retention at Heavy Depth of Cuts
- Sustain at Heavy Vibrations / Interrupted Cuts
- Smooth Cutting on Hard Material
- In built advantage of 12 deg. bevel for better end preparation
- Enhanced aesthetic look

Material	Grade	Cutting Speed Vc (M/min)
Mild Steel, Copper, Brass, Bronze and Aluminum with tensile strength of less than 20 tones per square inch	HATHYAR 20	50-70
Steel and Steel Castings such as Mild steel, Cast Iron & other soft materials like Copper, Brass & Aluminum with tensile strength up to 35 tones per square inch	HATHYAR 20	25-40
Steel & Steel Castings like Medium Carbon Steel, Medium Hard Cast Iron & other materials like Copper, Hard Brass, Bronze & Aluminum with tensile strength up to 45 tones per square inch	HATHYAR 50	20-30
Steel & Steel Castings like Hardened Steels, Chrome Steels, Hard Cast Iron, etc. with a tensile strength up to 48 tones per square inch	HATHYAR 50	20-30
Steel & Steel Castings like High Speed Steel with a tensile strength up to 60 tones per square inch	HATHYAR 51	15-20

RECOMMENDED DEPTH OF CUT (DOC)	
OPERATION	DEPTH OF CUT
Rough Turning	Depth of cut = Max possible cut
Semi Finish Turning	0.25 to 0.75mm
Finish Turning	0.15 to 0.40mm

RECOMMENDED FEED					
Surface Finish $\mu$	Work Material	Range of Cutting Speed m/min	Nose Radius in mm		
			0.5	1	2
			Feed in mm/rev		
10	Carbon Steel & Alloy Steel	<50	0.3-0.50	0.45-0.60	0.55-0.70
		>50	0.40-0.55	0.55-0.65	0.65-0.70
	Cast Iron, Bronze & Aluminum Alloys	All Range	0.25-0.4	0.40-0.50	0.50-0.60
5	Carbon Steel & Alloy Steel	<50	0.18-0.25	0.25-0.30	0.30-0.40
		>50	0.25-0.30	0.30-0.35	0.35-0.50
	Cast Iron, Bronze & Aluminum Alloys	All Range	0.15-0.25	0.25-0.40	0.40-0.60
2.5	Carbon Steel & Alloy Steel	<50	0.1	0.11-0.15	0.15-0.22
		50-100	0.11-0.16	0.16-0.25	0.25-0.35
		>100	0.16-0.20	0.20-0.25	0.25-0.35
	Cast Iron, Bronze & Aluminum Alloys	All Range	0.10-0.15	0.15-0.20	0.20-0.35



## BIRLA PRECISION TECHNOLOGIES LIMITED

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