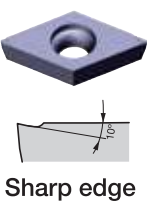
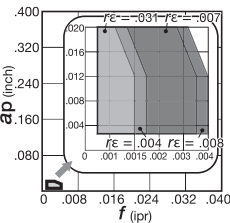
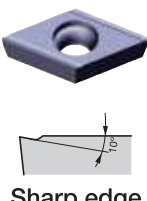
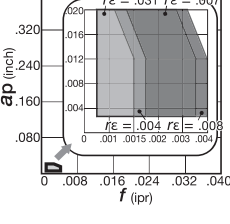
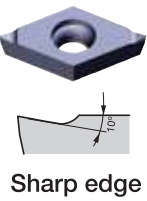
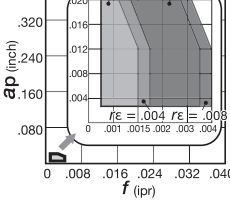


Standard cutting conditions JS types

Work material	chip-breaker	Grades	Cutting speed Vc (sfm)	Depth of cut ap (in)	Feed: f (ipr)			
					$r_{\epsilon} = .0012''$	$r_{\epsilon} = .004''$	$r_{\epsilon} = .008''$	$r_{\epsilon} = .016''$
Steels 1045, 4137 etc.	JS	AH725	150 - 480	.004 - .080	-	.0004 - .002	.0008 - .004	.002 - .008
Stainless steels 303, 304 etc.		SH730	100 - 500	.004 - .080	.0002 - .0008			.002 - .006
		AH725	160 - 500		-			.002 - .008
Titanium alloys (Ti-6AL-4v etc.)		SH730	100 - 330	.004 - .120	.0002 - .0008			.002 - .006
	AH725	-			.002 - .008			

Inserts (JRP / JPP / JSP type)

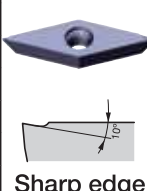
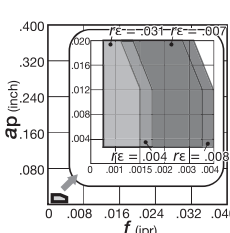
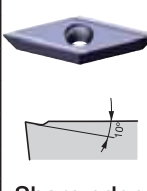
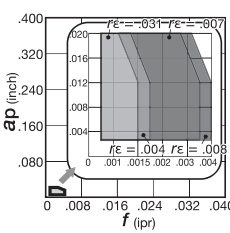
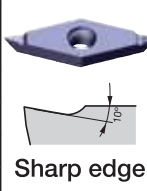
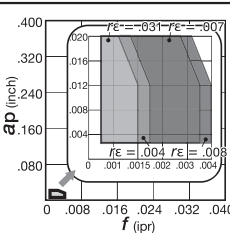
55° Rhombic, 7° Positive

Applica- tion	Chipbreaker Appearance (Cross section)	f - ap	Cat. No.		Grades Coated SH730	Dimensions (inch)			
			Inch	Metric		I.C. dia ød	Thick- ness s	Hole dia ød1	Corner radius rε
For external turning on small lathes	 <p>Sharp edge</p>		DCET21.5YMFR-JRP	DCET0702008MFR-JRP	●	.250	.094	.110	.003
			DCET21.5YMFL-JRP	DCET0702008MFL-JRP	●				.004
			DCET21.50MFR-JRP	DCET070201 MFR-JRP	●				.007
			DCET21.50MFL-JRP	DCET070201 MFL-JRP	●				.008
			DCET21.50.4MFR-JRP	DCET0702018MFR-JRP	●				.003
			DCET21.50.4MFL-JRP	DCET0702018MFL-JRP	●				.004
			DCET21.50.5MFR-JRP	DCET070202 MFR-JRP	●				.007
			DCET21.50.5MFL-JRP	DCET070202 MFL-JRP	●	.008			
			DCET32.5YMFR-JRP	DCET11T3008MFR-JRP	●	.375	.156	.173	.003
			DCET32.5YMFL-JRP	DCET11T3008MFL-JRP	●				.004
			DCET32.50MFR-JRP	DCET11T301 MFR-JRP	●				.007
			DCET32.50MFL-JRP	DCET11T301 MFL-JRP	●				.008
			DCET32.50.4MFR-JRP	DCET11T3018MFR-JRP	●				.003
			DCET32.50.4MFL-JRP	DCET11T3018MFL-JRP	●				.004
*DCET32.50.5MFR-JRP	DCET11T302 MFR-JRP	●	.007						
DCET32.50.5MFL-JRP	DCET11T302 MFL-JRP	●	.008						
For external turning on small lathes	 <p>Sharp edge</p>		DCET21.5YMFR-JPP	DCET0702008MFR-JPP	●	.250	.094	.110	.003
			DCET21.5YMFL-JPP	DCET0702008MFL-JPP	●				.004
			DCET21.50MFR-JPP	DCET070201 MFR-JPP	●				.007
			DCET21.50MFL-JPP	DCET070201 MFL-JPP	●				.008
			DCET21.50.4MFR-JPP	DCET0702018MFR-JPP	●				.003
			DCET21.50.4MFL-JPP	DCET0702018MFL-JPP	●				.004
			DCET21.50.5MFR-JPP	DCET070202 MFR-JPP	●				.007
			DCET21.50.5MFL-JPP	DCET070202 MFL-JPP	●	.008			
			DCET32.5YMFR-JPP	DCET11T3008MFR-JPP	●	.375	.156	.173	.003
			DCET32.5YMFL-JPP	DCET11T3008MFL-JPP	●				.004
			DCET32.50MFR-JPP	DCET11T301 MFR-JPP	●				.007
			DCET32.50MFL-JPP	DCET11T301 MFL-JPP	●				.008
			DCET32.50.4MFR-JPP	DCET11T3018MFR-JPP	●				.003
			DCET32.50.4MFL-JPP	DCET11T3018MFL-JPP	●				.004
*DCET32.50.5MFR-JPP	DCET11T302 MFR-JPP	●	.007						
DCET32.50.5MFL-JPP	DCET11T302 MFL-JPP	●	.008						
For external turning on small lathes	 <p>Sharp edge</p>		DCET21.5YMFN-JSP	DCET0702008MFN-JSP	●	.250	.094	.110	.003
			DCET21.50MFN-JSP	DCET070201 MFN-JSP	●				.004
			DCET21.50.4MFN-JSP	DCET0702018MFN-JSP	●				.007
			DCET21.50.5MFN-JSP	DCET070202 MFN-JSP	●				.008
			DCET32.5YMFN-JSP	DCET11T3008MFN-JSP	●	.375	.156	.173	.003
			DCET32.50MFN-JSP	DCET11T301 MFN-JSP	●				.004
			DCET32.50.4MFN-JSP	DCET11T3018MFN-JSP	●				.007
			*DCET32.50.5MFN-JSP	DCET11T302 MFN-JSP	●				.008

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

35° Rhombic, 11° Positive

Application	Chipbreaker Appearance (Cross section)	f - ap	Cat. No.		Grades Coated SH730	Dimensions (inch)			
			Inch	Metric		I.C. dia ød	Thick- ness s	Hole dia ød1	Corner radius rε
For external turning on small lathes	 <p>Sharp edge</p>		VPET53YMFR-JRP	VPET0802008MFR-JRP	●	.187	.094	.091	.003
			VPET53YMFL-JRP	VPET0802008MFL-JRP	●				.004
			VPET530MFR-JRP	VPET080201 MFR-JRP	●				.007
			VPET530MFL-JRP	VPET080201 MFL-JRP	●				.008
			VPET530.4MFR-JRP	VPET0802018MFR-JRP	●				.003
			VPET530.4MFL-JRP	VPET0802018MFL-JRP	●				.004
			VPET530.5MFR-JRP	VPET080202 MFR-JRP	●				.007
			VPET530.5MFL-JRP	VPET080202 MFL-JRP	●				.008
			VPET22YMFR-JRP	VPET1103008MFR-JRP	●	.250	.125	.110	.003
			VPET22YMFL-JRP	VPET1103008MFL-JRP	●				.004
			VPET220MFR-JRP	VPET110301 MFR-JRP	●				.007
			VPET220MFL-JRP	VPET110301 MFL-JRP	●				.008
			VPET220.4MFR-JRP	VPET1103018MFR-JRP	●				.003
			VPET220.4MFL-JRP	VPET1103018MFL-JRP	●				.004
			*VPET220.5MFR-JRP	VPET110302 MFR-JRP	●				.007
			VPET220.5MFL-JRP	VPET110302 MFL-JRP	●				.008
For external turning on small lathes	 <p>Sharp edge</p>		VPET53YMFR-JPP	VPET0802008MFR-JPP	●	.187	.094	.091	.003
			VPET53YMFL-JPP	VPET0802008MFL-JPP	●				.004
			VPET530MFR-JPP	VPET080201 MFR-JPP	●				.007
			VPET530MFL-JPP	VPET080201 MFL-JPP	●				.008
			VPET530.4MFR-JPP	VPET0802018MFR-JPP	●				.003
			VPET530.4MFL-JPP	VPET0802018MFL-JPP	●				.004
			VPET530.5MFR-JPP	VPET080202 MFR-JPP	●				.007
			VPET530.5MFL-JPP	VPET080202 MFL-JPP	●				.008
			VPET22YMFR-JPP	VPET1103008MFR-JPP	●	.250	.125	.110	.003
			VPET22YMFL-JPP	VPET1103008MFL-JPP	●				.004
			VPET220MFR-JPP	VPET110301 MFR-JPP	●				.007
			VPET220MFL-JPP	VPET110301 MFL-JPP	●				.008
			VPET220.4MFR-JPP	VPET1103018MFR-JPP	●				.003
			VPET220.4MFL-JPP	VPET1103018MFL-JPP	●				.004
			*VPET220.5MFR-JPP	VPET110302 MFR-JPP	●				.007
			VPET220.5MFL-JPP	VPET110302 MFL-JPP	●				.008
For external turning on small lathes	 <p>Sharp edge</p>		VPET53YMFN-JSP	VPET0802008MFN-JSP	●	.187	.094	.091	.003
			VPET530MFN-JSP	VPET080201 MFN-JSP	●				.004
			VPET530.4MFN-JSP	VPET0802018MFN-JSP	●				.007
			VPET530.5MFN-JSP	VPET080202 MFN-JSP	●				.008
			VPET22YMFN-JSP	VPET1103008MFN-JSP	●	.250	.125	.110	.003
			VPET220MFN-JSP	VPET110301 MFN-JSP	●				.004
			VPET220.4MFN-JSP	VPET1103018MFN-JSP	●				.007
			*VPET220.5MFN-JSP	VPET110302 MFN-JSP	●				.008

Note: Chipbreaker Cross section is marked * next to the Cat. No.

● : Stocked items

Standard cutting conditions JPP / JRP / JSP types

Work material	chip-breaker	Grade	Cutting speed Vc (sfm)	Depth of cut ap (inch)	Feed: f (ipr)			
					rε = .003"	rε = .004"	rε = .007"	rε = .008"
Steels 1045, 4137 etc.	JPP JRP JSP	SH730	160 - 500	.004 - .020	.0004 - .0016	.0004 - .002	.0008 - .0036	.0008 - .004
Stainless steels 303, 304 etc.			100 - 500					
Titanium alloys (Ti-6AL-4v etc.)			100 - 330					

● : Stocked items