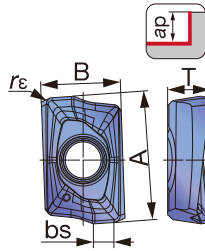


INSERTS

AVGT-MJ

AVGT-AJ



Designation	Max. ap	A	B	T	rε	bs	AH3135	AH120	KS05F
AVGT060302PBER-MJ	6	8	5	2.7	0.2	1.5	● ● ● ●	○ ● ● ●	●
AVGT060304PBER-MJ	6	8	5	2.7	0.4	1.3	● ● ● ●	○ ● ● ●	●
AVGT060308PBER-MJ	6	8	5	2.6	0.8	0.9	● ● ● ●	○ ● ● ●	●
AVGT060302PBFR-AJ	6	8	5	2.7	0.2	1.5	● ● ● ●	○ ● ● ●	●
AVGT060304PBFR-AJ	6	8	5	2.7	0.4	1.3	● ● ● ●	○ ● ● ●	●
AVGT060308PBFR-AJ	6	8	5	2.6	0.8	0.9	● ● ● ●	○ ● ● ●	●

● First choice

Note: See page 9 for more information about grades.

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness	Priority	Grades	Chip-breaker	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)	
P	Low carbon steel (S15C / C15E4, SS400 / E275A, etc.)	- 300 HB	First choice	AH3135	MJ	230 - 430	0.07 - 0.12	
	Carbon steel and alloy steel (S55C / C55, SCM440 / 42CrMo4, etc.)	- 300 HB	First choice	AH3135	MJ	150 - 350	0.07 - 0.12	
	Prehardened steel (NAK80, PX5, etc.)	30 - 40 HRC	First choice	AH120	MJ	100 - 230	0.07 - 0.12	
M	Stainless steel (SUS304 / X5CrNi18-9, SUS316 / X5CrNiMo17-12-3, etc.)	-	First choice	AH3135	MJ	150 - 220	0.06 - 0.1	
K	Grey cast iron (FC250 / 250, FC300 / 300, etc.)	150 - 250 HB	First choice	AH120	MJ	200 - 330	0.07 - 0.12	
	Ductile cast iron (FC400, FCD600 / 600-3, etc.)	150 - 250 HB	First choice	AH120	MJ	150 - 240	0.07 - 0.12	
N	Aluminium alloys (Si < 13%)	-	First choice	KS05F	AJ	650 - 1000	0.07 - 0.12	
S	Titanium alloys (Ti-6Al-4V, etc.)	-	First choice	AH120	MJ	70 - 90	0.06 - 0.10	
	Superalloys (Inconel718, etc.)	-	First choice	AH120	MJ	45 - 65	0.06 - 0.09	
H	Hardened steel	(SKD61 / X40CrMoV5-1, etc.)	40 - 50 HRC	First choice	AH120	MJ	45 - 70	0.05 - 0.08
		(SKD11 / X153CrMoV12, etc.)	50 - 60 HRC	First choice	AH120	MJ	40 - 65	0.04 - 0.06

Note: See page 9 for more information about grades.