

Basic Selection Chipbreakers CP□□0903□□-□□

P Steel	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS530	AH725	T9115	T9125
	Page	2-102	2-102	2-102	2-103
Continuous	Chipbreaker	W20	PSF	PS	PM
	Vc (SFM)	(500-800)	(170-600)	(400-850)	(400-800)
	Ap (in)	(.002-.100)	(.005-.030)	(.010-.060)	(.040-.118)
	f (in/rev)	(.001-.005)	(.001-.005)	(.002-.008)	(.003-.012)
	fz (in)	.016	.016	.032	.032

M Stainless	Operation	Finishing	Finishing to medium cutting	Medium cutting
	Grade	AH725	AH725	T6030
	Page	2-102	2-103	2-103
Continuous	Chipbreaker	PSF	PSS	PM
	Vc (SFM)	(150-600)	(150-600)	(250-400)
	Ap (in)	(.005-.030)	(.010-.060)	(.040-.118)
	f (in/rev)	(.001-.006)	(.002-.008)	(.003-.012)
	fz (in)	.016	.032	.032

K Cast Iron	Operation	Finishing to medium cutting	Medium cutting
	Grade	TS115	TS115
	Page	2-103	2-104
Continuous	Chipbreaker	CM	No chipbreaker
	Vc (SFM)	(450-1300)	(450-1300)
	Ap (in)	(.001-.080)	(.001-.080)
	f (in/rev)	(.001-.008)	(.001-.008)
	fz (in)	.032	.032

N Non-ferrous	Operation	Finishing
	Grade	TH10
	Page	2-102
Continuous	Chipbreaker	W20
	Vc (SFM)	(300-3000)
	Ap (in)	(.001-.080)
	f (in/rev)	(.001-.006)
	fz (in)	.016

For other machining types, see "Selection System"

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Basic Selection Chipbreakers CC□□09T3□□-□□

P Steel	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH730	AH725	T9115	T9125
	Page	2-99	2-96	2-97	2-100
Continuous	Chipbreaker	JS	PSF	PS	PM
	Vc (SFM)	(170-600)	(170-600)	(400-850)	(400-800)
	Ap (in)	(.001-.120)	(.005-.030)	(.010-.060)	(.040-.118)
	f (in/rev)	(.0001-.003)	(.001-.006)	(.002-.008)	(.003-.012)
	fz (in)	.008	.016	.032	.032

M Stainless	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	GH330	AH725	AH725	T6030
	Page	2-97	2-96	2-97	2-100
Continuous	Chipbreaker	W20	PSF	PSS	PM
	Vc (SFM)	(100-150)	(150-600)	(150-600)	(250-400)
	Ap (in)	(.002-.078)	(.005-.030)	(.010-.060)	(.040-.118)
	f (in/rev)	(.001-.006)	(.001-.006)	(.002-.008)	(.003-.012)
	fz (in)	.016	.016	.032	.032

K Cast Iron	Operation	Precision finishing	Finishing to medium cutting	Medium cutting
	Grade	BX930	TS115	TS115
	Page	3-14	2-97	2-101
Continuous	Chipbreaker	T-CBN	CM	No chipbreaker
	Vc (SFM)	(600-1400)	(450-1300)	(450-1300)
	Ap (in)	(.001-.008)	(.001-.080)	(.001-.080)
	f (in/rev)	(.001-.008)	(.001-.008)	(.001-.008)
	fz (in)	.016	.032	.032

N Non-ferrous	Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	DX120	GH110	KS05F
	Page	3-24	2-97	2-98
Continuous	Chipbreaker	T-DIA With chipbreaker	W20	AL
	Vc (SFM)	(800-4000)	(300-3000)	(200-1500)
	Ap (in)	(.001-.006)	(.001-.080)	(.020-.180)
	f (in/rev)	(.001-.006)	(.001-.006)	(.007-.015)
	fz (in)	.016	.016	.016

S Superalloys	Operation	Precision finishing	Finishing
	Grade	BX470	BX930
	Page	3-12	3-14
Continuous	Chipbreaker	T-CBN	T-CBN
	Vc (SFM)	(300-800)	(230-900)
	Ap (in)	(.001-.006)	(.005-.030)
	f (in/rev)	(.001-.008)	(.001-.008)
	fz (in)	.016	.016

H Hard Materials	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-12	3-12
Continuous	Chipbreaker	T-CBN	T-CBN
	Vc (SFM)	(500-1100)	(400-750)
	Ap (in)	(.001-.006)	(.001-.006)
	f (in/rev)	(.0001-.003)	(.001-.006)
	fz (in)	.016	.016

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