
















Basic Selection Chipbreakers DC□□11T3□□-□□



<b>P</b> Steel	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH730	AH725	T9115	T9125
	Page	2-108	2-105	2-106	2-109
	Chipbreaker				
	Vc (SFM)	(170-600)	(170-600)	(400-800)	(400-800)
	ap (in)	(.001-.120)	(.005-.030)	(.010-.060)	(.040-.118)
f (in/rev)	(.0001-.003)	(.001-.006)	(.002-.008)	(.003-.012)	
Continuous	ra (in)	.008	.016	.032	.032

<b>M</b> Stainless	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	GH330	AH725	AH725	T9015
	Page	2-105	2-105	2-106	2-109
	Chipbreaker				
	Vc (SFM)	(100-150)	(150-600)	(150-600)	(250-400)
	ap (in)	(.001-.080)	(.005-.030)	(.010-.060)	(.040-.118)
f (in/rev)	(.001-.006)	(.001-.006)	(.002-.008)	(.003-.012)	
Continuous	ra (in)	.016	.016	.032	.032

<b>H</b> Hard Materials	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-12	3-12
	Chipbreaker		
	Vc (SFM)	(500-1100)	(400-750)
	ap (in)	(.001-.006)	(.001-.006)
f (in/rev)	(.0001-.003)	(.001-.006)	
Continuous	ra (in)	.016	.016

<b>K</b> Cast Iron	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX930	TH10	T5115	T5115
	Page	3-14	2-105	2-106	2-110
	Chipbreaker				No chipbreaker
	Vc (SFM)	(600-1400)	(100-400)	(450-1300)	(450-1300)
	ap (in)	(.001-.006)	(.001-.080)	(.001-.080)	(.001-.080)
f (in/rev)	(.001-.008)	(0.0.3-0.15)	(.001-.008)	(.001-.008)	
Continuous	ra (in)	.016	.016	.032	.032

<b>N</b> Non-ferrous	Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	DX120	TH10	KF05F
	Page	3-24	2-105	2-106
	Chipbreaker			
	Vc (SFM)	(800-4000)	(300-3000)	(200-1500)
	ap (in)	(.001-.006)	(.001-.080)	(.020-.180)
f (in/rev)	(.001-.008)	(.001-.006)	(.007-.015)	
Continuous	ra (in)	.016	.016	.032

<b>S</b> Superalloys	Operation	Precision finishing	Finishing
	Grade	BX470	BX950
	Page	3-12	3-14
	Chipbreaker		
	Vc (SFM)	(300-800)	(230-900)
	ap (in)	(.001-.006)	(.005-.030)
f (in/rev)	(.001-.008)	(.001-.008)	
Continuous	ra (in)	.016	.016