










## Basic Selection Chipbreakers TC□□1102□□-□□

<b>P</b> Steel  Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH730	AH725	T9115	T9125
	Page	2-120	2-118	2-118	2-122
	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)
ra (in)	.008	.016	.016	.032	

<b>M</b> Stainless  Continuous	Operation	Finishing	Finishing to medium cutting	Medium cutting
	Grade	AH725	AH725	T6030
	Page	2-118	2-119	2-122
	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)
ra (in)	.016	.032	.032	

<b>N</b> Non-ferrous  Continuous	Operation	Precision finishing	Finishing to medium cutting
	Grade	DX120	KS05F
	Page	3-24	2-120
	Chipbreaker	T-DIA with chipbreaker 	AL 
	Vc (SFM)	(800-4000)	(200-1500)
	ap (in)	(.001-.006)	(.020-.180)
	f (in/rev)	(.001-.008)	(.007-.015)
ra (in)	.016	.032	

For other machining types, see "Selection System"