











Basic Selection Chipbreakers VB□□1103□□-□□

P Steel	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	SH730	AH725	T9115	T9125
	Page	2-134	2-133	2-133	2-134
	Chipbreaker	JS 	PSF 	PS 	24 
Continuous	Vc (SFM)	(170-600)	(170-600)	(400-850)	(350-750)
	ap (in)	(.001-.120)	(.005-.030)	(.010-.080)	(.015-.080)
	f (in/rev)	(.0001-.003)	(.001-.006)	(.002-.008)	(.002-.008)
	rz (in)	.008	.016	.016	.032

M Stainless	Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	J740	AH725	AH725
	Page	2-134	2-133	2-133
	Chipbreaker	FR/L-J10  Sharp edges	PSF 	PSS 
Continuous	Vc (SFM)	(400-1300)	(150-600)	(150-600)
	ap (in)	(.001-.080)	(.005-.030)	(.010-.060)
	f (in/rev)	(.0001-.003)	(.001-.006)	(.002-.008)
	rz (in)	.008	.016	.032

K Cast Iron	Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	BX930	TH10	T5115
	Page	3-14	2-134	2-133
	Chipbreaker	T-CBN 	J10 	CM 
Continuous	Vc (SFM)	(600-1400)	(100-400)	(450-1300)
	ap (in)	(.001-.006)	(.001-.080)	(.001-.080)
	f (in/rev)	(.001-.008)	(.0001-.003)	(.001-.006)
	rz (in)	.016	.016	.031

H Hard Materials	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-13	3-13
	Chipbreaker	T-CBN 	T-CBN 
Continuous	Vc (SFM)	(500-1100)	(400-750)
	ap (in)	(.001-.006)	(.001-.006)
	f (in/rev)	(.0001-.003)	(.001-.006)
	rz (in)	.016	.016

● : Stocked items.

For other machining types, see "Selection System"

Most unmarked items are available on a RFQ basis, contact your sales rep for more information.