






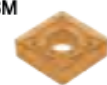


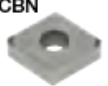




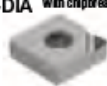





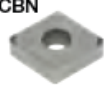


Basic Selection Chipbreakers CN□□1204□□-□□




P Steel  Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS530	GT730	T9115	T9115
	Page	2-42	2-42	2-45	2-49
	Chipbreaker	TF 	TSF 	TM 	TH 
	Vc (SFM)	(500-800)	(500-800)	(500-800)	(500-800)
	ap (in)	(.001-.020)	(.007-.060)	(.020-.180)	(.100-.220)
	f (in/rev)	(.001-.006)	(.003-.011)	(.007-.015)	(.008-.020)
ƒε (in)	.016	.016	.032	.047	

M Stainless  Continuous	Operation	Finishing	Finishing to medium cutting	Medium cutting
	Grade	T6020	T6030	T6030
	Page	2-43	2-45	2-49
	Chipbreaker	SS 	SM 	TH 
	Vc (SFM)	(300-550)	(250-400)	(250-400)
	ap (in)	(.010-.040)	(.020-.120)	(.100-.220)
	f (in/rev)	(.001-.006)	(.007-.015)	(.008-.016)
ƒε (in)	.016	.032	.047	

K Cast Iron  Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX930	T5115	T5115	T5115
	Page	3-7	2-43	2-46	2-48
	Chipbreaker	T-CBN 	CF 	CM 	CH 
	Vc (SFM)	(300-1200)	(450-1300)	(400-1300)	(450-1300)
	ap (in)	(.001-.020)	(.015-.040)	(.020-.180)	(.080-.230)
	f (in/rev)	(.001-.006)	(.001-.006)	(.004-.010)	(.008-.020)
ƒε (in)	.016	.016	.032	.047	

N Non-ferrous  Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting
	Grade	DX120	TH10	GH110
	Page	3-23	2-42	2-48
	Chipbreaker	T-DIA With chipbreaker 	01 	P 
	Vc (SFM)	(1500-4000)	(400-3000)	(400-3000)
	ap (in)	(.001-.030)	(.001-.030)	(.020-.120)
	f (in/rev)	(.001-.006)	(.001-.006)	(.007-.015)
ƒε (in)	.016	.016	.032	

S Superalloys  Continuous	Operation	Precision finishing	Finishing to medium cutting	Medium cutting
	Grade	BX470	AH905	AH120
	Page	3-7	2-47	2-48
	Chipbreaker	T-CBN 	HMM 	SA 
	Vc (SFM)	(300-800)	(100-300)	(100-300)
	ap (in)	(.002-.006)	(.010-.100)	(.010-.100)
	f (in/rev)	(.001-.006)	(.003-.010)	(.003-.010)
ƒε (in)	.016	.032	.032	

H Hard Materials  Continuous	Operation	Precision finishing	Finishing
	Grade	BXM10	BXM20
	Page	3-7	3-7
	Chipbreaker	T-CBN 	T-CBN 
	Vc (SFM)	(800-900)	(400-800)
	ap (in)	(.001-.006)	(.001-.006)
	f (in/rev)	(.001-.006)	(.001-.006)
ƒε (in)	.016	.016	