
























Basic Selection Chipbreakers SN□□43□□-□□




 P Steel  Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	NS730	GT730	T9115	T9115
	Page	2-61	2-61	2-64	2-67
	Chipbreaker				
	Vc (SFM)	(400-800)	(400-900)	(400-900)	(400-900)
	ap (in)	(.001-.020)	(.010-.060)	(.020-.180)	(.100-.220)
	f (in/rev)	(.001-.008)	(.003-.010)	(.008-.016)	(.008-.016)
fe (in)	.016	.016	.032	.047	

 M Stainless  Continuous	Operation	Finishing	Finishing to medium cutting	Medium cutting
	Grade	T6020	T6030	T6030
	Page	2-62	2-64	2-67
	Chipbreaker			
	Vc (SFM)	(300-550)	(250-400)	(250-400)
	ap (in)	(.010-.040)	(.010-.150)	(.100-.220)
	f (in/rev)	(.001-.008)	(.003-.012)	(.008-.016)
fe (in)	.016	.032	.047	

 K Cast Iron  Continuous	Operation	Precision finishing	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX930	T5115	T5115	T5115
	Page	3-8	2-62	2-65	2-67
	Chipbreaker				
	Vc (SFM)	(300-1200)	(450-1300)	(400-1300)	(450-1300)
	ap (in)	(.001-.020)	(.010-.040)	(.020-.180)	(.040-.230)
	f (in/rev)	(.001-.006)	(.001-.006)	(.006-.012)	(.008-.020)
fe (in)	.016	.016	.032	.047	

 N Non-ferrous  Continuous	Operation	Precision finishing	Finishing to medium cutting
	Grade	DX140	GH110
	Page	3-23	2-67
	Chipbreaker		
	Vc (SFM)	(1500-4000)	(400-3000)
	ap (in)	(.001-.025)	(.010-.150)
	f (in/rev)	(.001-.006)	(.008-.016)
fe (in)	.016	.032	

 S Superalloys  Continuous	Operation	Finishing	Finishing to medium cutting	Medium cutting
	Grade	BX480	AH905	AH120
	Page	3-8	2-65	2-66
	Chipbreaker			
	Vc (SFM)	(230-900)	(120-350)	(120-300)
	ap (in)	(.003-.008)	(.010-.040)	(.040-.157)
	f (in/rev)	(.001-.010)	(.004-.010)	(.008-.016)
fe (in)	.016	.032	.032	

 H Hard Materials  Continuous	Operation	Finishing
	Grade	BXM20
	Page	3-8
	Chipbreaker	
	Vc (SFM)	(400-800)
	ap (in)	(.001-.010)
	f (in/rev)	(.001-.006)
fe (in)	.016	

For other machining types, see "Selection System"