






Basic Selection Chipbreakers VN003300-00



 P Steel 	Operation	Precision finishing	Finishing	Finishing to medium cutting	
	Grade	NS730	G1730	T9115	
	Page	2-87	2-87	2-88	
Chipbreaker	TF	TSF	TM		
Vc (SFM)	(400-800)	(400-900)	(400-900)		
Sp (m)	(.001-.020)	(.010-.060)	(.040-.157)		
f (in/rev)	(.001-.006)	(.003-.010)	(.003-.012)		
rz (in)	.016	.016	.032		



 K Cast Iron 	Operation	Precision finishing	Finishing	Finishing to medium cutting	
	Grade	BX930	T5115	T5115	
	Page	3-9	2-88	2-89	
Chipbreaker	T-CBN	CF	CM		
Vc (SFM)	(300-1200)	(450-1300)	(400-1300)		
Sp (m)	(.001-.020)	(.010-.040)	(.040-.157)		
f (in/rev)	(.001-.006)	(.001-.006)	(.006-.012)		
rz (in)	.016	.016	.032		

 S Super Steel 	Operation	Precision finishing	Finishing	Finishing to medium cutting	
	Grade	BX470	BX480	AH906	
	Page	3-9	3-9	2-90	
Chipbreaker	T-CBN	T-CBN	HMM		
Vc (SFM)	(300-800)	(230-900)	(120-350)		
Sp (m)	(.003-.008)	(.003-.008)	(.010-.040)		
f (in/rev)	(.001-.006)	(.001-.010)	(.004-.010)		
rz (in)	.016	.016	.032		

For other machining types, see "Selection System" [2-4](#)

 M Ductile Iron 	Operation	Finishing	Finishing to medium cutting	
	Grade	Y6020	Y6030	
	Page	2-87	2-89	
Chipbreaker	SS	SM		
Vc (SFM)	(300-550)	(250-400)		
Sp (m)	(.010-.040)	(.010-.150)		
f (in/rev)	(.001-.006)	(.003-.012)		
rz (in)	.016	.032		

 N No Ferrite 	Operation	Precision finishing	Finishing	
	Grade	DX120	GH110	
	Page	3-23	2-87	
Chipbreaker	T-DIA With Chipbreaker	01		
Vc (SFM)	(1500-4000)	(400-3000)		
Sp (m)	(.001-.025)	(.001-.025)		
f (in/rev)	(.001-.006)	(.001-.006)		
rz (in)	.016	.008		

 H Hard Material 	Operation	Precision finishing	Finishing	
	Grade	BXM10	BXM20	
	Page	3-9	3-9	
Chipbreaker	T-CBN	T-CBN		
Vc (SFM)	(800-900)	(400-800)		
Sp (m)	(.001-.010)	(.001-.010)		
f (in/rev)	(.001-.006)	(.001-.006)		
rz (in)	.016	.016		

4

TAC External Toolholders

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

Relating pages

Parts (14-1-)

4-31