TJCHAI PRECISION CO.,LTD.

Recommended chip breaker for workpiece

- **Materials : Inconel, Nimonic, Stellite, Ti alloy**
  Hardness : 160~350HB

Workpiece **S** Heat resistant alloy

	Depth of cut (mm)	C/B	Cutting edge	Feed (mm/rev)	Grades	Cutting Speed (m/min)	Insert shape 80°	55°	90°	60°	35°	80°
Negative	0.5 ~ 1.5 ~ 2.5 medium to finishing	HA		0.03 ~ 0.15 ~ 0.30	PC8110 NC9025 PC5300	70 60 50	CNMG p.B16	DNMG p.B19	SNMG p.B23	TNMG p.B27	VNMG p.B30	WNMG p.B31
	1.0 ~ 2.5 ~ 4.0 medium machining	HS		0.1 ~ 0.25 ~ 0.40	PC8110 NC9025 PC5300	80 50 30	CNMG p.B17	DNMG p.B20	SNMG pB24	TNMG p.B28	VNMG p.B30	WNMG p.B31
	1.5 ~ 3.0 ~ 5.5 Interrupred heavy roughing	GS		0.15 ~ 0.3 ~ 0.50	PC8110 NC9025 PC5300	80 50 30	CNMG p.B16	DNMG p.B19	SNMG p.B23	TNMG p.B27		WNMG p.B31
	2.0 ~ 4.5 ~ 6.5 continuous heavy roughing	VM		0.20 ~ 0.40 ~ 0.60	PC8110 NC5330 PC5300	80 50 30	CNMG p.B18	DNMG p.B20	SNMG p.B24	TNMG pB28	VNMG p.B30	WNMG p.B32
Positive	0.1 ~ 0.5 ~ 1.5 finishing	HFP		0.05 ~ 0.15 ~ 0.25	PC8110 NC9025 PC5300	80 50 30	CCG(M)T p.B33, B34	DCG(M)T p.B35	SCG(M)T p.B36	TCG(M)T p.B39	VCG(M)T p.B43	
	0.5 ~ 1.5 ~ 3.0 medium to finishing	HMP		0.10 ~ 0.20 ~ 0.30	PC8110 NC9025 PC5300 PC9030	80 50 30	CCMT p.B34	DCMT p.B35	SCMT p.B36	TCMT p.B39	VCMT p.B43	
	1.0 ~ 1.5 ~ 3.0 medium machining	C25		0.15 ~ 0.25 ~ 0.35	PC8110 NC9025 PC5300	80 50 30	CCMT p.B33	DCMT p.B35	SCMT p.B36	TCMT p.B39		

● : The first recommended cutting condition

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