

Recommended chip breaker for workpiece

● **Materials : Aluminum alloy**
Hardness : 20~110HB

Workpiece
N
Aluminum 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 ~ 2.0 ~ 6.0 roughing	HA		0.1 ~ 0.2 ~ 0.5	H01	500	CNMG p.B16	DNMG p.B19	SNMG p.B23	TNMG p.B27	VNMG p.B30	WNMG p.B31
Positive	0.1 ~ 1.0 ~ 4.0 medium to finishing	AK		0.03 ~ 0.2 ~ 0.4	H01 ND1000 PD1000	1000 1000 1000	CCGT p.B46	DCGT p.B46	SCGT p.B47	TCGT p.B48	VCGT p.B48	VCGT p.B47
	0.5 ~ 1.5 ~ 4.0 roughing	AR		0.05 ~ 0.3 ~ 0.5	H01 ND1000 PD1000	1000 1000 1000	CCGT p.B46	DCGT p.B46	SCGT p.B47	TCGT p.B48	VBGT p.B48	RCGT p.B47

● : The first recommended cutting condition

● **Materials : Copper Bronze alloy**
Hardness : 20~110HB

Workpiece
N
Aluminum 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 ~ 2.0 ~ 4.0 roughing	HA		0.1 ~ 0.2 ~ 0.5	PC130 PC230 H01	500 500 1000	CNMG p.B16	DNMG p.B19	SNMG p.B23	TNMG p.B27	VNMG p.B30	WNMG p.B31
Positive	0.1 ~ 1.0 ~ 3.0 medium to finishing	AK		0.03 ~ 0.2 ~ 0.3	PC130 PC230 H01	500 500 1000	CCGT p.B46	DCGT p.B46	SCGT p.B47	TCGT p.B48	VCGT p.B48	VCGT p.B47
	0.5 ~ 1.5 ~ 3.0 roughing	AR		0.05 ~ 0.25 ~ 0.4	PC130 PC230 H01	500 500 1000	CCGT p.B46	DCGT p.B46	SCGT p.B47	TCGT p.B48	VBGT p.B48	RCGT p.B47

● : The first recommended cutting condition