

CCGT



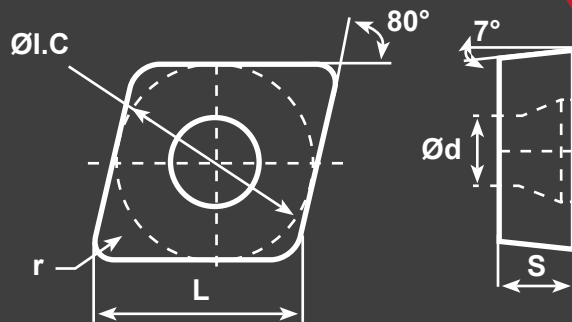
Stainless Steel



Cast Iron



Steel



Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1003	CCGT-21.51-SF	CCGT060204SF	0.252	0.25	0.094	0.11	0.016	P Vc: 1310sfm (1050-1580) fz: 0.008in/z (0.002-0.014)	
								M Vc: 720sfm (530-920) fz: 0.008in/z (0.002-0.014)	
								K Vc: 690sfm (530-850) fz: 0.008in/z (0.002-0.014)	
424-1004	CCGT-32.51-SF	CCGT09T304SF	0.382	0.375	0.156	0.173	0.016	P Vc: 1310sfm (1050-1580) fz: 0.008in/z (0.002-0.014)	
								M Vc: 720sfm (530-920) fz: 0.008in/z (0.002-0.014)	
								K Vc: 690sfm (530-850) fz: 0.008in/z (0.002-0.014)	
427-2929	CCGT-21.50-SF	CCGT060202SF	0.252	0.25	0.094	0.11	0.008	P Vc: 1310sfm (1050-1580) fz: 0.008in/z (0.002-0.014)	
								M Vc: 720sfm (530-920) fz: 0.008in/z (0.002-0.014)	
								K Vc: 690sfm (530-850) fz: 0.008in/z (0.002-0.014)	

Material	Coated cemented carbide																Cermet	Coated Cermet	Cemented Carbide												
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103				YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YD101	YD201			
P Steel	+	+	○	○	-	-	+																				+	+			
M Stainless Steel							+							+	○	○												+	+		
K Cast Iron																															-
N Ferrite Materials																															-
S Heat-resistant steel							+	+						+														+			

+ Good Working Conditions

○ General Working Conditions

- Adverse Working Conditions



SF CHIP BREAKER

Extra Fine Finishing on P soft steel. Unique nose design and sharp cutting edge lead to small cutting resistance and reduce vibration. Outstanding performance of chip breaking and chip flowing on machining P soft steel and medium carbon steel to ensure high quality surface finish.

