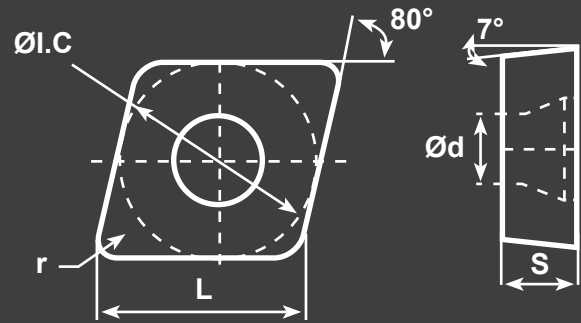


CCMT

Compatible
Workpiece Materials



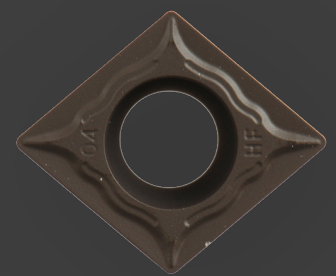
SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1017	CCMT-21.51-HF	CCMT060204HF	0.252	0.25	0.094	0.11	0.016	P Vc: 1310sfm (980-1640) fz: 0.004in/z (0.002-0.008)	
424-1018	CCMT-21.52-HF	CCMT060208HF	0.252	0.25	0.094	0.11	0.031	P Vc: 1310sfm (980-1640) fz: 0.006in/z (0.002-0.012)	
424-1019	CCMT-32.51-HF	CCMT09T304HF	0.382	0.375	0.156	0.173	0.016	P Vc: 1310sfm (980-1640) fz: 0.004in/z (0.002-0.012)	
424-1020	CCMT-32.52-HF	CCMT09T308HF	0.382	0.375	0.156	0.173	0.031	P Vc: 1310sfm (980-1640) fz: 0.004in/z (0.002-0.012)	
424-1021	CCMT-431-HF	CCMT120404HF	0.508	0.5	0.187	0.219	0.016	P Vc: 1310sfm (980-1640) fz: 0.004in/z (0.002-0.012)	

Material	Coated cemented carbide														Cermet	Coated Cermet	Cemented Carbide														
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM151	YBM251	YBM253			YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	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

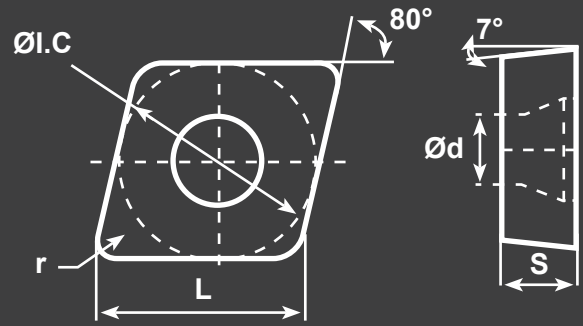
HF CHIP BREAKER

HF is the preferred choice chip breaker on General Purpose Finishing. M Class tolerance double sided chip breaker, suitable for alloy steel and cast iron's boring and outside turning in finishing cut.



CCMT

Compatible
Workpiece Materials



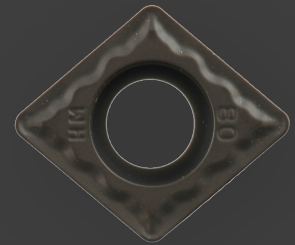
SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1022	CCMT-21.51-HM	CCMT060204HM	0.252	0.25	0.094	0.11	0.016	P Vc: 1120sfm (650-1300) fz: 0.008in/z (0.004-0.031)	
424-1023	CCMT-21.52-HM	CCMT060208HM	0.252	0.25	0.094	0.11	0.031	P Vc: 1120sfm (650-1300) fz: 0.008in/z (0.004-0.031)	
424-1024	CCMT-32.51-HM	CCMT09T304HM	0.382	0.375	0.156	0.173	0.016	P Vc: 1120sfm (650-1300) fz: 0.008in/z (0.004-0.031)	
424-1025	CCMT-32.52-HM	CCMT09T308HM	0.382	0.375	0.156	0.173	0.031	P Vc: 1120sfm (650-1300) fz: 0.008in/z (0.004-0.031)	
424-1030	CCMT-431-HM	CCMT120404-HM	0.508	0.5	0.187	0.219	0.016	P Vc: 1000sfm (500-1200) fz: 0.008in/z (0.004-0.031)	
424-1040	CCMT-431-HM	CCMT120404-HM	0.508	0.5	0.187	0.219	0.016	P Vc: 1120sfm (650-1300) fz: 0.008in/z (0.004-0.031)	
424-1041	CCMT-432-HM	CCMT120408HM	0.508	0.5	0.187	0.219	0.031	P Vc: 1120sfm (650-1300) fz: 0.008in/z (0.004-0.031)	

Material	Coated cemented carbide														Cemented Carbide											
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM151	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	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

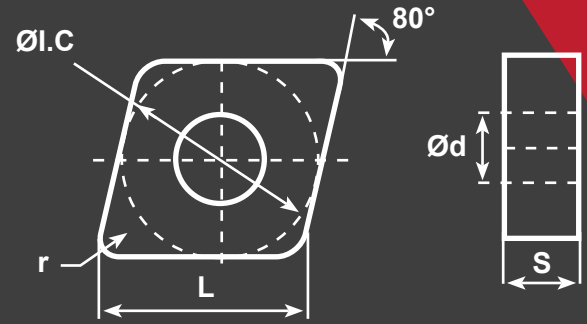
HM CHIP BREAKER

The HM chip breaker is the preferred choice chip breaker for General Purpose. M Class tolerance double sided chip breaker, suitable for inside boring and outside turning semi-finish/medium on alloy steel and cast iron.



CCMT

Compatible
Workpiece Materials



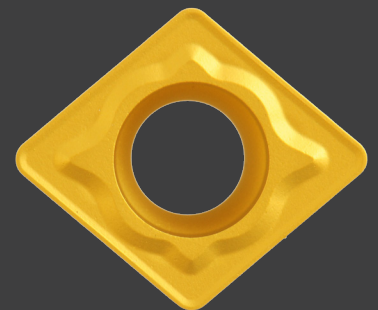
SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1045	CCMT-32.52-HR	CCMT09T308HR	0.382	0.375	0.156	0.173	0.031	P Vc: 920sfm (720-1180)	fz: 0.012in/z (0.008-0.024)
424-3505	CCMT-21.52-HR	CCMT060208HR	0.252	0.250	0.094	0.110	0.031	P Vc: 1050sfm (850-1310)	fz: 0.010in/z (0.004-0.020)
424-3506	CCMT-32.52-HR	CCMT09T308HR	0.382	0.375	0.156	0.173	0.031	P Vc: 1050sfm (850-1310)	fz: 0.010in/z (0.004-0.020)

Material	Coated cemented carbide																		Cernert	Coated Cernert	Cemented Carbide				
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM151	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152			YBD252	YC10	YC40	YD051	YD101
P Steel	+	+	○	○	-	-	+		○	○										+	+	+	-		
M Stainless Steel							+		○	○		○	○	○						+	+				
K Cast Iron																+	○	○	-	-			+		-
N Ferrite Materials																							○		-
S Heat-resistant steel							+	+			+												+		

+ Good Working Conditions
 ○ General Working Conditions
 - Adverse Working Conditions

HR CHIP BREAKER

The HR chip breaker is the preferred choice chip breaker for General Purpose. M Class tolerance double sided chip breaker, suitable for inside boring and outside turning semi-finish/medium on alloy steel and cast iron.



CCMT

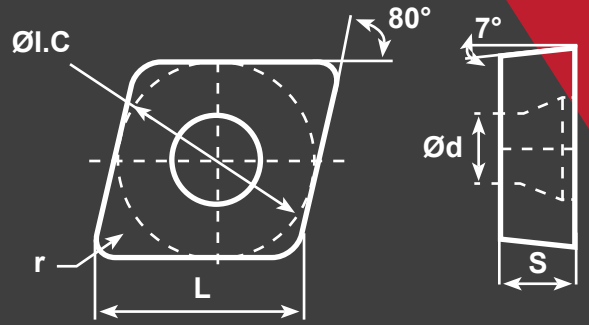
Compatible
Workpiece Materials



Steel



Stainless Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1049	CCMT-21.51-EF	CCMT060204EF	0.252	0.25	0.094	0.11	0.016	P Vc: 660fsm (520-790) fz: 0.004in/z (0.002-0.008)	M Vc: 620fsm (360-890) fz: 0.003in/z (0.002-0.008)
424-1051	CCMT-32.51-EF	CCMT09T304EF	0.382	0.375	0.156	0.173	0.016	P Vc: 660fsm (520-790) fz: 0.004in/z (0.002-0.008)	M Vc: 620fsm (360-890) fz: 0.004in/z (0.002-0.008)
424-1052	CCMT-32.52-EF	CCMT09T308EF	0.382	0.375	0.156	0.173	0.031	P Vc: 660fsm (520-790) fz: 0.004in/z (0.002-0.008)	M Vc: 620fsm (360-890) fz: 0.003in/z (0.003-0.012)

	Coated cemented carbide														Cermet	Coated Cermet	Cemented Carbide									
Material	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM151	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
P Steel	+	+	○	○	-	-	+		○	○											+	+	+	-		
M Stainless Steel							+		○	○		○	○	○							+	+				
K Cast Iron															+	○	○	-	-					+		-
N Ferrite Materials																									○	-
S Heat-resistant steel							+	+			+													+		
SKU#	424-1049								●																	
424-1051									●																	
424-1052									●																	

+ Good Working Conditions

○ General Working Conditions

- Adverse Working Conditions

EF CHIP BREAKER

EF is the preferred choice chip breaker on M category material finish. M Class tolerance double sided chip breaker. With a specially design rake angle and an inclined edge angle aimed at machining material that is highly adhesive and plasticity, such as stainless steel, EF chip breaker has a sharp edge making the cutting light and smooth, stability control chip flows and maintain surface finish, making it suitable for ultra fine and fine machining of stainless steel.



CCMT

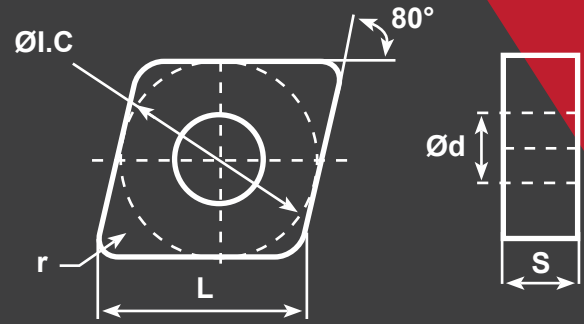
Compatible Workpiece Materials



Steel



Stainless Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1033	CCMT-21.51-EM	CCMT060204EM	0.252	0.25	0.094	0.11	0.016	P Vc: 890sfm (590-1180) fz: 0.008in/z (0.004-0.012)	M Vc: 620sfm (360-890) fz: 0.004in/z (0.002-0.008)
424-1034	CCMT-21.52-EM	CCMT060208EM	0.252	0.25	0.094	0.11	0.031	P Vc: 660sfm (520-790) fz: 0.004in/z (0.002-0.008)	M Vc: 620sfm (360-890) fz: 0.004in/z (0.003-0.012)
424-1035	CCMT-32.51-EM	CCMT09T304EM	0.382	0.375	0.156	0.173	0.016	P Vc: 660sfm (520-790) fz: 0.004in/z (0.002-0.008)	M Vc: 620sfm (360-890) fz: 0.004in/z (0.002-0.008)
424-1036	CCMT-32.52-EM	CCMT09T308EM	0.382	0.375	0.156	0.173	0.031	P Vc: 890sfm (590-1180) fz: 0.006in/z (0.002-0.008)	M Vc: 590sfm (490-690) fz: 0.004in/z (0.003-0.012)

Material	Coated cemented carbide															Cermets	Cemented Carbide									
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM151	YBM251	YBM253	YBD052			YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051
P Steel	+	+	○	○	-	-	+		○	○											+	+	+	-		
M Stainless Steel							+		○	○		○	○	○							+	+				
K Cast Iron																	+	○	○	-	-				+	
N Ferrite Materials																									○	-
S Heat-resistant steel							+	+			+														+	

+ Good Working Conditions
 ○ General Working Conditions
 - Adverse Working Conditions

EM CHIP BREAKER

EM is the preferred choice chip breaker on M category material Medium. EM chip breaker is designed with sharp cutting edge which is required for machining highly adhesive material such as stainless steel while reinforced the impact resistance on the edge, which makes it suitable for semi-finishing and intermittent machining of adhesive materials, such as austenitic stainless steel.

