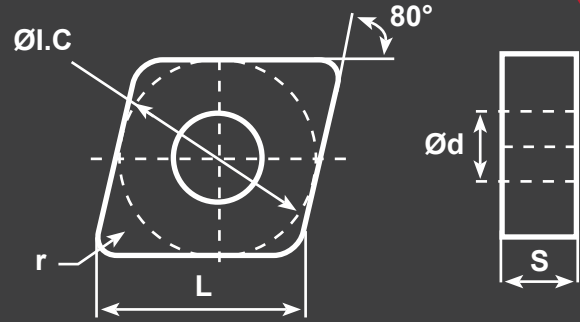


CNMM

Compatible
Workpiece Materials



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1178	CNMM-433-DR	CNMM120412DR	0.508	0.50	0.187	0.203	0.047	P Vc: 720sfm (590-980)	fz: 0.012in/z (0.008-0.024)
424-1179	CNMM-543-DR	CNMM16012DR	0.634	0.625	0.25	0.25	0.047	P Vc: 720sfm (590-980)	fz: 0.014in/z (0.01-0.028)
424-1183	CNMM-544-DR	CNMM160616DR	0.634	0.625	0.25	0.25	0.063	P Vc: 660sfm (530-920)	fz: 0.014in/z (0.010-0.031)
424-1184	CNMM-643-DR	CNMM190612DR	0.76	0.75	0.25	0.313	0.047	P Vc: 1050sfm (850-1310)	fz: .014in/z (0.01-0.028)
424-1185	CNMM-644-DR	CNMM190616DR	0.76	0.75	0.25	0.313	0.063	P Vc: 660sfm (530-920)	fz: 0.016in/z (0.012-0.004)

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
P Steel	+	+	○	○	-	-	+		○	○														+	+		
M Stainless Steel							+		○	○		+	○	○	○									+	+		
K Cast Iron																	+	○	○	-	-						-
N Ferrite Materials																								○	-		
S Heat-resistant steel							+	+			+					+								+			
SKU#	424-1178	424-1179	424-1183	424-1184	424-1185																						

+ Good Working Conditions

○ General Working Conditions

- Adverse Working Conditions



DR CHIP BREAKER

DR 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.

