

DCMT

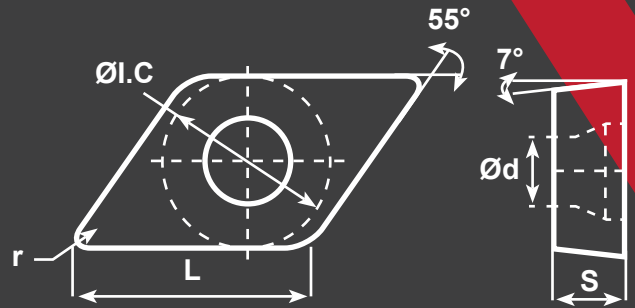
Compatible Workpiece Materials



Steel



Stainless Steel



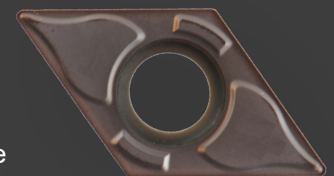
SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1223	DCMT-21.51-EF	DCMT070204EF	0.307	0.25	0.094	0.110	0.016	P Vc: 660sfm (520-790) fz: 0.004in/z (0.002-0.008)	M Vc: 590sfm (490-690) fz: 0.003in/z (0.002-0.008)
424-1225	DCMT-32.51-EF	DCMT11T304EF	0.457	0.375	0.156	0.173	0.016	P Vc: 660sfm (520-790) fz: 0.004in/z (0.002-0.008)	M Vc: 620sfm (360-890) fz: 0.004in/z (0.002-0.008)
424-1226	DCMT-32.52-EF	DCMT11T308EF	0.457	0.375	0.156	0.173	0.031	P Vc: 890sfm (590-1180) fz: 0.004in/z (0.002-0.008)	M Vc: 620sfm (360-890) fz: 0.004in/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	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

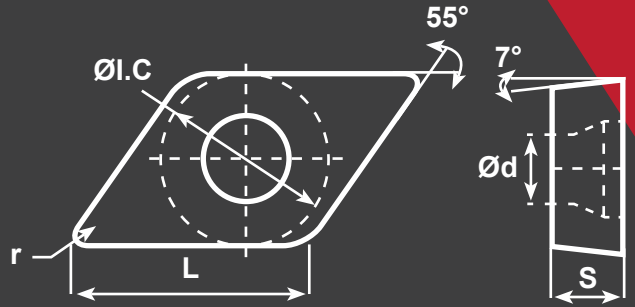
EF CHIP BREAKER

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.



DCMT

Compatible
Workpiece Materials



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1212	DCMT-21.51-HM	DCMT070204HM	0.307	0.25	0.094	0.11	0.016	P Vc: 1120sfm (920-1440)	fz: 0.006in/z (0.004-0.012)
424-1213	DCMT-21.52-HM	DCMT070204HM	0.307	0.25	0.094	0.11	0.031	P Vc: 1120sfm (920-1440)	fz: 0.008in/z (0.004-0.016)
424-1214	DCMT-32.51-HM	DCMT11T304HM	0.457	0.375	0.156	0.173	0.016	P Vc: 1120sfm (920-1440)	fz: 0.006in/z (0.004-0.012)
424-1215	DCMT-32.52-HM	DCMT11T308HM	0.457	0.375	0.156	0.173	0.031	P Vc: 1120sfm (920-1440)	fz: 0.008in/z (0.004-0.016)

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
P Steel	+	+	○	○	-	-	+		○	○													+	+		
M Stainless Steel							+		○	○		+	○	○	○								+	+		
K Cast Iron																	+	○	○	-	-					-
N Ferrite Materials																								○		-
S Heat-resistant steel							+	+				+				+								+		
SKU#	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	
424-1212				●																						
424-1213				●																						
424-1214				●																						
424-1215				●																						

+ 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.

