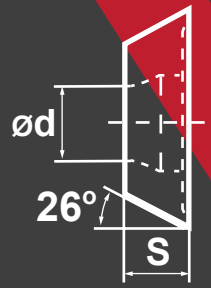
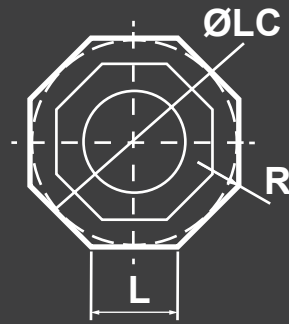


OFKT



Heat-resistant Steel



Compatible Workpiece Materials



Steel



Stainless Steel

SKU#	ANSI#	ISO#	L	ØI.C	bs	S	R	START SPEED	START FEED
427-1065	OFKT05T3-DF	OFKT05T3-DF	0.207	0.500	0.156	0.173	0.020	P Vc: 890sfm (590-1180)	fz: 0.006in/z (0.004-0.012)
								M Vc: 620sfm (360-890)	fz: 0.006in/z (0.004-0.012)
427-1069	OFKT05T3-DM	OFKT05T3-DM	0.207	0.500	0.156	0.173	0.020	P Vc: 890sfm (590-1180)	fz: 0.008in/z (0.004-0.016)
								M Vc: 620sfm (360-890)	fz: 0.008in/z (0.004-0.016)

	Coated cemented carbide														Cermet	Cemented Carbide						
Material	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YBS203	YBG303	YNG151C	YC30S	YD051	YD101	YD201	
P Steel	+	+	+	-				+	+	+	+	+	+			+	+	-				
M Stainless Steel	+	+	+	-				+	+	+	+	+	+			+	+	-				
K Cast Iron					+	-	+					+	+					+				-
N Ferrite Materials																				+		-
S Heat-resistant steel							+	+	+						+	-						
SKU#	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YBS203	YBG303	YNG151C	YC30S	YD051	YD101	YD201	
427-1065								•														
427-1069								•														

+ Good Working Conditions

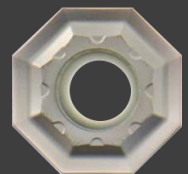
○ General Working Conditions

- Adverse Working Conditions



DF CHIP BREAKER

For finishing machining on carbon alloy steels

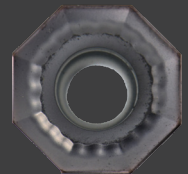


DF Chip Breaker



DM CHIP BREAKER

The DM chip breaker is the preferred choice chip breaker on P category material semi-finish M Class tolerance double sided chip breaker, light cutting force with wide chipping range, can achieve better result on high adhesive alloy steels



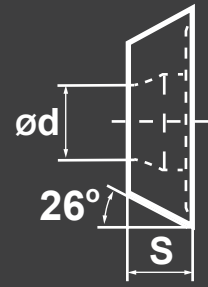
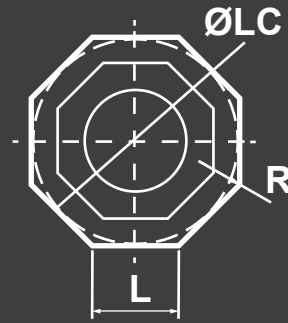
DM Chip Breaker

OFKT

Compatible
Workpiece Materials



Ferrite Materials



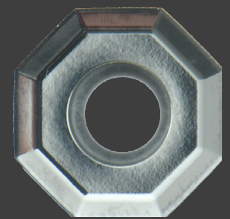
SKU#	ANSI#	ISO#	L	ØLC	bs	S	R	START SPEED	START FEED
428-0623	OFKT05T3-LH	OFKT05T3-LH	0.207	0.500	0.156	0.173	0.020	N Vc: 1000-sfm	fz: 0.006in/z (0.002-0.012)

	P	M	K	N	S	Coated cemented carbide								Cermet	Cemented Carbide											
	Steel	Stainless Steel	Cast Iron	Ferrite Materials	Heat-resistant steel	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YB9320	YBG302	YBG152	YBG252	YNG151	YBS203	YBG303	YNG151C	YC30S	YD051	YD101	YD201
+	+	+	-	-	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
SKU#	428-0623																								●	

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

LH CHIP BREAKER

LH chip breaker G class tolerance with big rake angle, polish and ground on surface, LH geometry is resistant to chip built-up on the insert edge, maximize surface finish on aluminum machining and insert tool life.



RECOMMENDED CUTTING PARAMETERS

WORKPIECE MATERIAL	HARDNESS HB	INSERT GRADE	CUTTING PARAMETERS		
			V(SFPM)	f(IPT)	
				-DF	-DM
P Low-carbon steel, soft steel	≤180	YBG202	900 (650-1200)	0.008 (0.004-0.012)	0.01 (0.004-0.016)
	180-280	YBG202	800 (600-1100)	0.006 (0.004-0.012)	0.008 (0.004-0.016)
	280-350	YBG202	700 (550-1100)	0.008 (0.004-0.012)	0.008 (0.004-0.016)
M Stainless steel	≤270	YBG202	450 (300-800)	0.006 (0.004-0.012)	0.008 (0.004-0.016)
N Aluminum Alloy	--	YD101	1000-	-LH	
				0.006 (0.002-0.012)	