

# RCKT



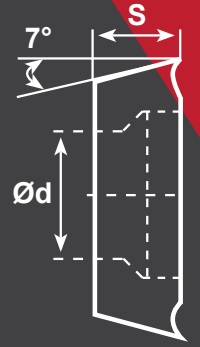
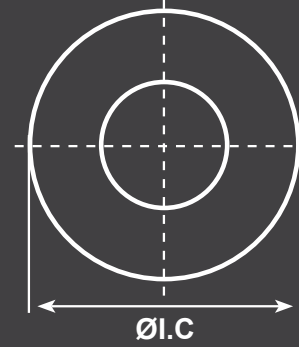
High-Temperature Alloy



Steel



Stainless Steel



Compatible Workpiece Materials

SKU#	ANSI#	ISO#	ØI.C	S	Ød
427-1074	RCKT43MO-DM	RCKT1204MO-DM	0.472	0.187	0.157

	Coated cemented carbide															Cermet		Cemented Carbide					
SKU#	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG212	YB9320	YBG302	YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051	YD101	YD201	
427-1074							●																

+ Good Working Conditions

○ General Working Conditions

— Adverse Working Conditions

## 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.



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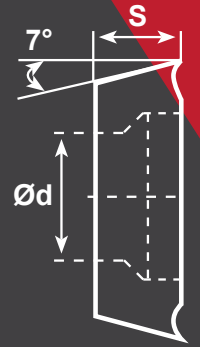
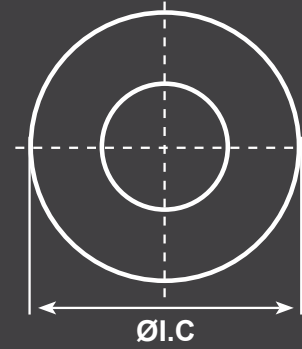
High-Temperature Alloy



Steel



Stainless Steel



Compatible Workpiece Materials

SKU#	ANSI#	ISO#	ØI.C	S	Ød
427-1679	RCKT43MO-DR	RCKT1204MO-DR	0.472	0.187	0.157

	P Steel	M Stainless Steel	K Cast Iron	N Ferrite Materials	S Heat-resistant steel	Coated cemented carbide										Cermet		Cemented Carbide					
SKU#	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG212	YB9320	YBG302	YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051	YD101	YD201	
427-1679	+	+	+	-	+	-	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+

+ 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.



# RCKT

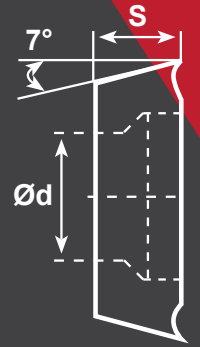
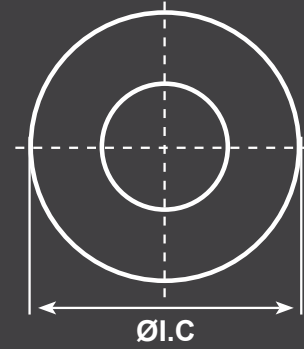
Compatible  
Workpiece Materials



Steel



Stainless Steel



**SKU#** **ANSI#** **ISO#** **ØI.C** **S** **Ød**  
 427-0172 RCKT43MO-ER RCKT1204MO-ER 0.472 0.187 0.157

	Coated cemented carbide													Cermet		Cemented Carbide						
<b>SKU#</b>	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG212	YB9320	YBG302	YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051	YD101	YD201
<b>P</b> Steel	+	+	+	-				+	+	+	+	+		+			+	+	-			
<b>M</b> Stainless Steel	+	+	+	-				+	+	+	+	+		+			+	+	-			
<b>K</b> Cast Iron					+	-	+						+	+					+			-
<b>N</b> Ferrite Materials																				+		-
<b>S</b> Heat-resistant steel								+	+	+				+	+							

**+** Good Working Conditions

**○** General Working Conditions

**-** Adverse Working Conditions



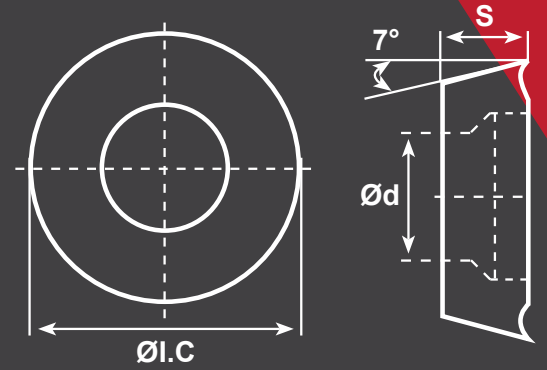
## ER CHIP BREAKER

The ER chipbreaker's cutting edge is designed to balance security and sharpness, reduce edge build-up and reducing heat when roughing stainless steel.



# RCKT

Compatible  
Workpiece Materials



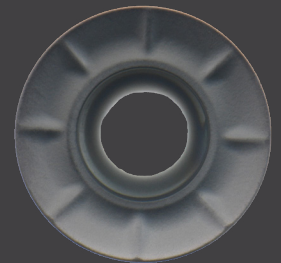
**SKU#** 427-2847   **ANSI#** RCKT43MO-NM   **ISO#** RCKT1204MONM   **ØI.C** 0.472   **S** 0.187   **Ød** 0.157

	Coated cemented carbide													Cermet		Cemented Carbide						
<b>SKU#</b>	YBC302	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG212	YB9320	YBG302	YBG152	YBG252	YBS203	YBS303	YNG151	YNG151C	YC30S	YD051	YD101	YD201
<b>P</b> Steel	+	+	+	-				+	+	+	+	+		+			+	+	-			
<b>M</b> Stainless Steel	+	+	+	-				+	+	+	+	+		+			+	+	-			
<b>K</b> Cast Iron					+	-	+						+	+					+			-
<b>N</b> Ferrite Materials																					+	-
<b>S</b> Heat-resistant steel							+	+	+						+	-						

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

## NM CHIP BREAKER

NM Chipbreaker with high cutting edge strength is designed to semi-finish machining on Ni-based super alloy. Smooth surface of chipbreaker ensures unobstructed chip flow and high wear resistance of cutting edge after treatment.



## RECOMMENDED CUTTING PARAMETERS

WORKPIECE MATERIAL	HARDNESS HB	INSERT GRADE	CUTTING PARAMETERS				
			V(SFPM)	f(IPT)			
				-DM	-DR	-ER	
<b>P</b> Low-carbon steel, soft steel	≤180	YBG202	900 (650-1200)	0.008 (0.004-0.02)	0.012(0.008-0.032)	--	
	High-carbon steel, alloy steel	180-280	YBG202	800 (650-1100)	0.008 (0.004-0.02)	0.012 (0.008-0.032)	--
	Alloy tool steel	280-350	YBG202	700 (550-1100)	0.008 (0.004-0.016)	0.012 (0.008-0.024)	--
<b>M</b> Stainless steel	≤270	YBG253	500 (300-800)	0.008 (0.004-0.016)	0.012 (0.008-0.024)	0.012 (0.008-0.024)	
		YBG202	500 (350-900)	0.008 (0.004-0.016)	0.012 (0.008-0.024)	--	
		YBG205	500 (350-900)	0.008 (0.004-0.016)	0.012 (0.008-0.024)	--	
<b>S</b> High-Temperature Alloy	≤400	YBS203	300 (200-400)	-NM			
		YBS303		0.006 (0.004-0.012)			