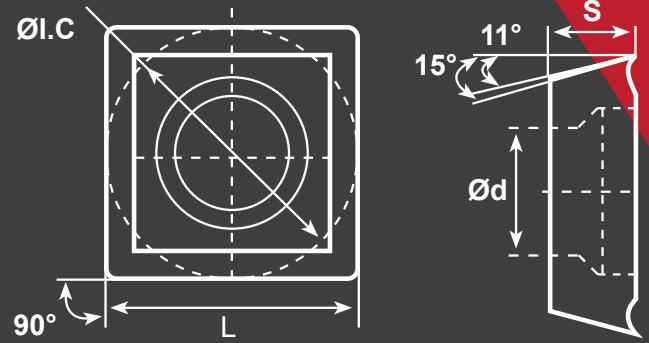


SCGX

Compatible
Workpiece Materials



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1606	SCGX32.51-LH	SCGX09T304-LH	0.375	0.375	0.156	0.173	0.016	N Vc: 3940sfm (980-4920)	fz: 0.006in/z (0.002-0.012)
424-1607	SCGX32.52-LH	SCGX09T308-LH	0.375	0.375	0.156	0.173	0.031	N Vc: 3280sfm (980-4920)	fz: 0.004in/z (0.002-0.012)
424-1609	SCGX432-LH	SCGX120408-LH	0.5	0.5	0.187	0.11	0.016	N Vc: 3280sfm (980-4920)	fz: 0.010in/z (0.004-0.020)

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							+	+				+					+								+	

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

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.

