

MFK CUTTER FOR CAST IRON

3 Toolholder Lineup for Various Applications

Fine and Extra Fine Pitch Types Available.



Fine Pitch
(Example: 5000R-11-12T = 12 Inserts)

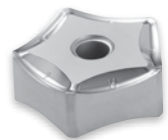
- Recommended for Unstable Setups
- General Purpose for Wide Application Ranges



Extra Fine Pitch
(Example: 5000R-11-18T = 18 Inserts)

- Recommended for Rigid Setups
- Finer Pitch for Higher Efficiency

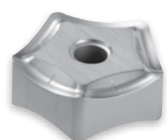
4 Chipbreaker Lineup for Wide Range of Applications



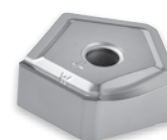
General Purpose:
GM Chipbreaker



Heavy Duty:
GH Chipbreaker





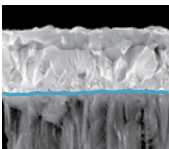
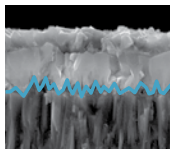
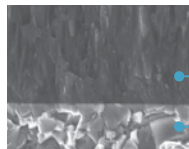
Finishing:
GL Ground
Chipbreaker



Wiper Edge:
W Ground
Wiper Edge

5 Long Tool Life and Stable Machining

CA420M Features Advanced CVD Coating Technology

Longer Tool Life	Prevents Film Peeling	Increased Edge Strength
Controlled α -Al ₂ O ₃ crystal growth for improving wear resistance and fracture resistance.	40 % improved film adhesion by optimized interface.	Higher film strength and fracture resistance with high aspect ratio TiCN.
 <p>CA420M</p>  <p>Conventional</p>	 <p>CA420M</p>  <p>Conventional</p>	 <p>CA420M</p> <ul style="list-style-type: none"> • TiCN Layer • Carbide Substrate

Insert Grade Lineup



CA420M
Long Tool Life
(1st Recommendation)

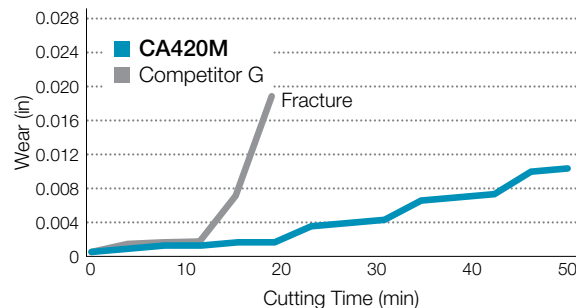


PR1510
Stable Machining



PR1525
Fracture
Resistance

Wear Resistance Comparison (Internal Evaluation)



Cutting Conditions: Vc = 670 sfm, fz = 0.012 ipt, ap x ae = 0.079" x 3.150", Dry Workpiece: Nodular Cast Iron (65-45-12)

GRADES	A
LINEUP / INSERTS	B
45° / 70° LEAD	C
75° LEAD	D
90° LEAD	E
HIGH FEED	F
MULTI-FUNCTION	G
SLOT MILLS	H
RADIUS / BALL-NOSE	J
OTHER APPLICATIONS	K
TOOL HOLDING	O
SPARE PARTS	P
TECHNICAL	R
INDEX	T