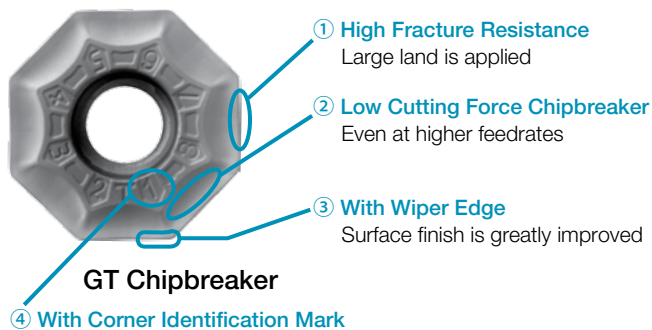


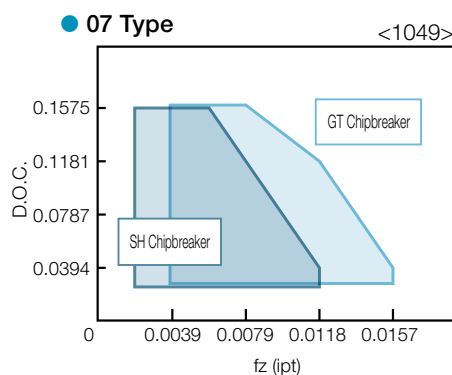
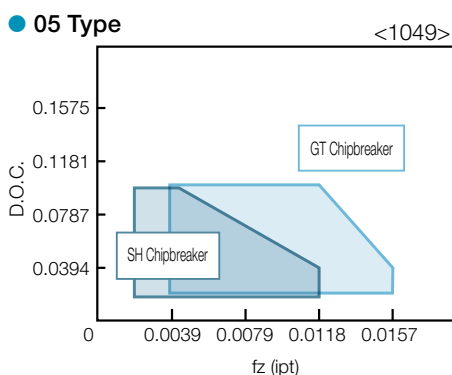
General Purpose “SH Chipbreaker”, Tough Edge Type “GT Chipbreaker”



	OFMT05 Type	OFMT07 Type
GT Chipbreaker (Tough Edge Type)		
SH Chipbreaker (General Purpose)		

Note 1) OFMT07 type inserts cannot be used for MOFX cutters (Ref. to page C16).

Applicable Chipbreaker Range



◆ Recommended Cutting Conditions (MOF / MOFX)

Workpiece Material	fz (ipt)		Recommended Insert Grades (Cutting Speed Vc : sfm)		
	GT Chipbreaker (Tough Edge type)	SH Chipbreaker (General Purpose)	MEGACOAT		PVD Coated Carbide
			PR1225	PR1210	PR830
Carbon Steel	0.0024 ~ <b>0.0047</b> ~ 0.0098	0.0024 ~ <b>0.0047</b> ~ 0.0098	★ 390 ~ <b>590</b> ~ 820	-	☆ 390 ~ <b>490</b> ~ 660
Alloy Steel	0.0024 ~ <b>0.0047</b> ~ 0.0098	0.0024 ~ <b>0.0047</b> ~ 0.0098	★ 330 ~ <b>520</b> ~ 720	-	☆ 330 ~ <b>490</b> ~ 590
Mold Steel	0.0024 ~ <b>0.0039</b> ~ 0.0079	0.0024 ~ <b>0.0039</b> ~ 0.0079	★ 260 ~ <b>460</b> ~ 590	-	☆ 260 ~ <b>390</b> ~ 490
Stainless Steel	0.0024 ~ <b>0.0047</b> ~ 0.0098	0.0024 ~ <b>0.0047</b> ~ 0.0098	★ 390 ~ <b>520</b> ~ 720	-	-
Gray Cast Iron	0.0024 ~ <b>0.0047</b> ~ 0.0098	0.0024 ~ <b>0.0047</b> ~ 0.0098	-	★ 390 ~ <b>590</b> ~ 820	-
Nodular Cast Iron	0.0024 ~ <b>0.0047</b> ~ 0.0098	0.0024 ~ <b>0.0047</b> ~ 0.0098	-	★ 330 ~ <b>490</b> ~ 660	-

★: 1st Recommendation ☆: 2nd Recommendation

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