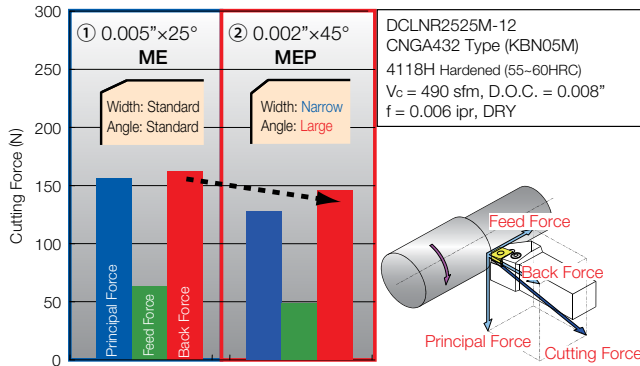


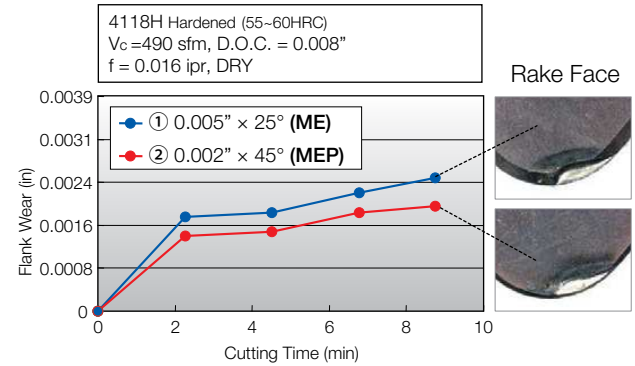
■ Negative Inserts, Features of New Edge Prep. (Machining of Hard Materials)

① MEP (High Speed / Continuous Machining)

● Cutting Force Comparison

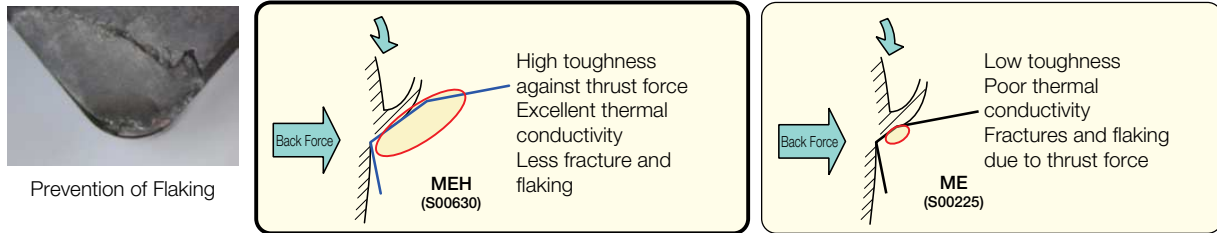


● Wear Comparison

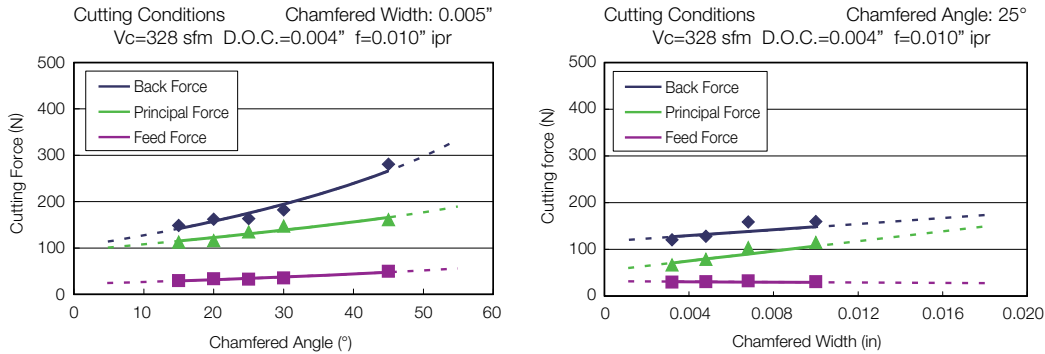


② MEH (Interruption / High Feed Machining)

● Toughness and Controls Flaking



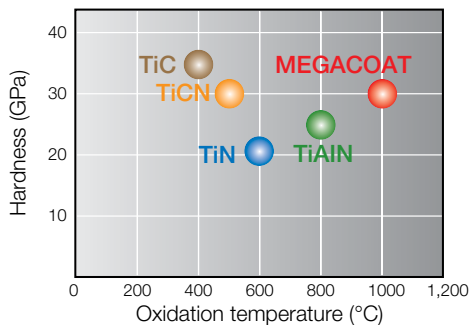
● Cutting Force and Chamfered Angle / Width



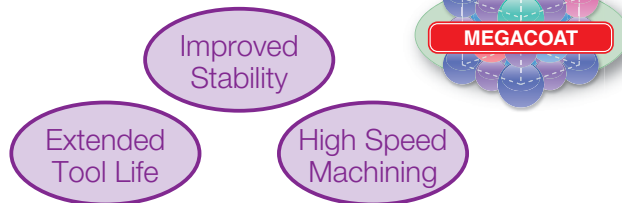
Cutting force is influenced by chamfered angle more than chamfered width. Though enlarging chamfered angle is more effective for fracture resistance improvement than changing chamfered width, the cutting force increases as well. Please refer to the graph for details.

■ MEGACOAT CBN

● PVD Layer Coating Properties



● Advantages of MEGACOAT



- Long tool life and stable machining due to superior heat-resistance and hardness
- Stability improvement through prevention of crater wear (oxidation, diffusional wear)
- High thermal stability and surface smoothness provide excellent surface finish

GRADES A
INSERTS B
CBN & PCD C
TOOLHOLDERS D
SMALL TOOLS E
BORING F
GROOVING G
CUT-OFF H
THREADING J
HSK TOOLING N
SPARE PARTS P
TECHNICAL R
INDEX T