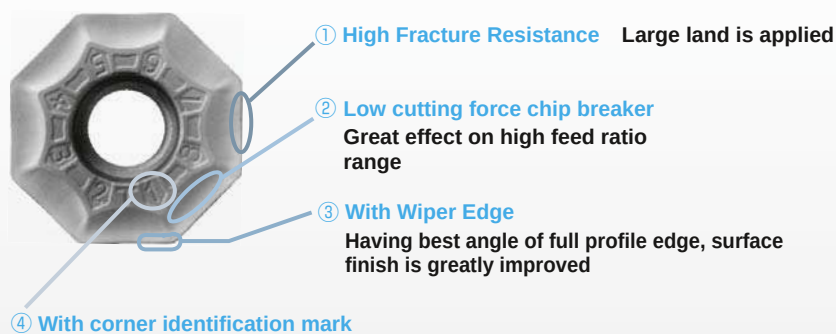


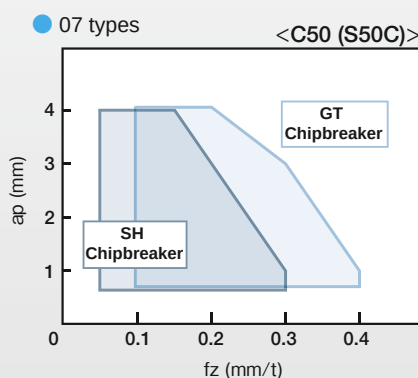
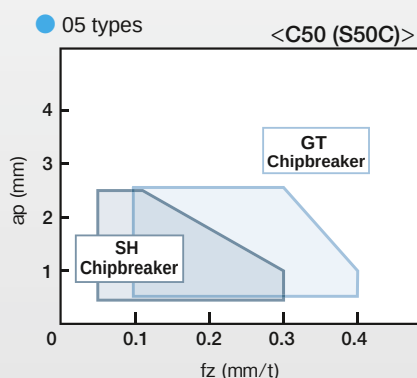
General purpose "SH Chipbreaker", Tough Edge type "GT Chipbreaker"



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

Note 1) OFMT07 type inserts cannot be used for MOFX type cutters (See M25).

Chipbreaker applicable range



Recommended Cutting Conditions (MOF / MOFX)

Workpiece Material	GT Chipbreaker (Tough Edge type)			SH Chipbreaker (General purpose type)			
	fz (mm/t)	Recommended Insert Grade (Cutting Speed Vc : m/min)		fz (mm/t)	Recommended Insert Grade (Cutting Speed Vc : m/min)		
		PVD Coated Carbide			PVD Coated Carbide		
		PR830	PR905		PR830	PR1025	PR905
Stainless Steel	-	-	-	0.08~ 0.12 ~0.25	-	★ 120~ 150 ~200	-
Carbon Steel	0.10~ 0.25 ~0.40	★ 120~ 150 ~200	-	0.10~ 0.15 ~0.30	★ 120~ 150 ~200	☆ 100~ 120 ~180	-
Alloy Steel	0.10~ 0.25 ~0.35	★ 100~ 150 ~180	-	0.10~ 0.15 ~0.30	★ 100~ 150 ~180	-	-
Mold Steel	0.10~ 0.20 ~0.35	★ 80~ 120 ~150	-	0.08~ 0.12 ~0.25	★ 80~ 120 ~150	-	-
Gray Cast Iron	0.10~ 0.25 ~0.40	-	★ 100~ 150 ~200	0.10~ 0.15 ~0.30	-	-	★ 100~ 150 ~200
Nodular Cast Iron	0.10~ 0.20 ~0.35	-	★ 80~ 100 ~120	0.08~ 0.12 ~0.25	-	-	★ 80~ 100 ~120

★: 1st Recommendation ☆: 2nd Recommendation

M



Milling