

CHIPBREAKERS FOR

STAINLESS STEEL & HRSA MATERIALS

Advanced geometries delivering excellent
surface finish and stable material removal

TURNING

HRSA-SS SERIES



CHIPBREAKER FAMILY ISO M AND S MATERIALS

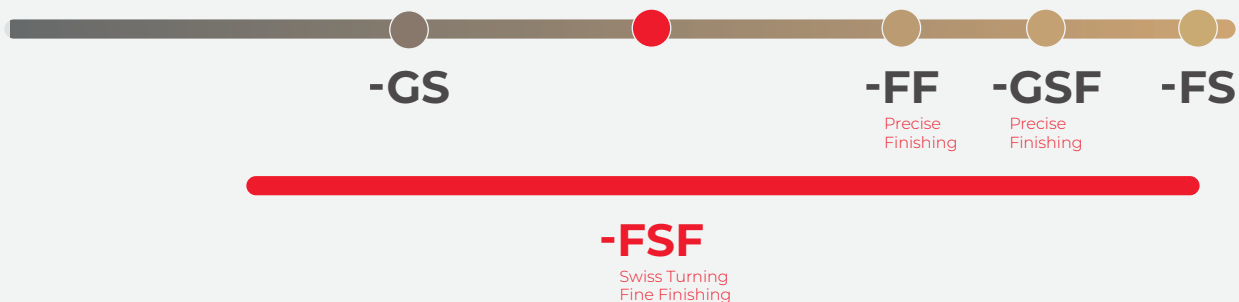
Turning SS and HRSA Geometries for every operation

Turning stainless steel and heat-resistant super alloys demands different chipbreaker geometries at different stages. From reliable chip control at higher depths of cut, to stability in swiss-type turning, to superior surface finish where tolerances are tight.

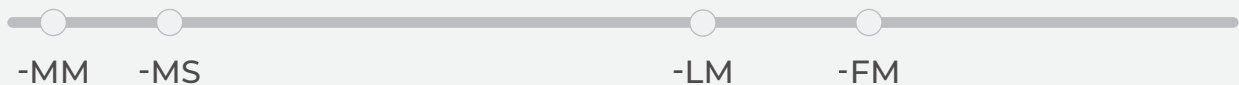
This range covers the full spectrum, and now the new -FSF geometry closes the gap between the two boundaries, combining swiss-type stability with fine finishing capability in a single chipbreaker.

ROUGHING

PRECISION FINISHING



ALSO AVAILABLE



-GS Semi-Roughing

The GS chipbreaker is designed for semi-finishing and semi-roughing, balancing cutting performance, chip control, and process stability across a wide range of machining conditions.



-FSF Versatility

NEW

Designed for fine finishing applications, the FSF geometry also delivers excellent stability in demanding swiss-type turning operations.



-FF, GSF & FS Precision Finishing

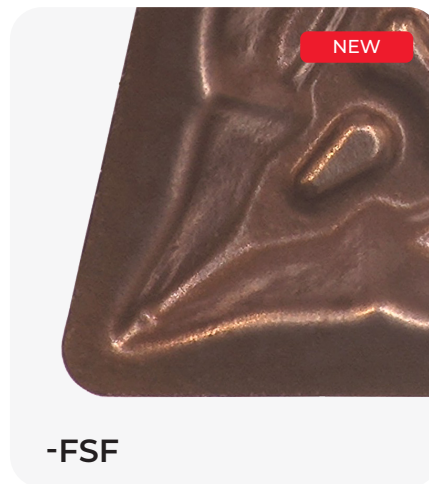
The FF and GSF chipbreakers are engineered for superior chip control and high-quality surface finish in precision finishing applications.



Geometry Detail

From stainless steel to high-temperature alloys, these chipbreakers are designed to perform where materials are most demanding, offering the right geometry for every operation.

These inserts are coated with PHP, our PVD coating specifically developed for efficient machining of HRSA and stainless steel materials.

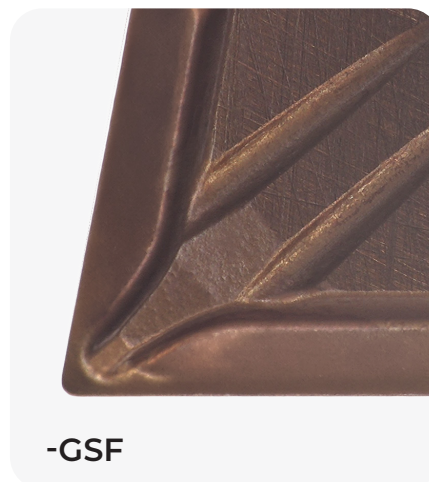
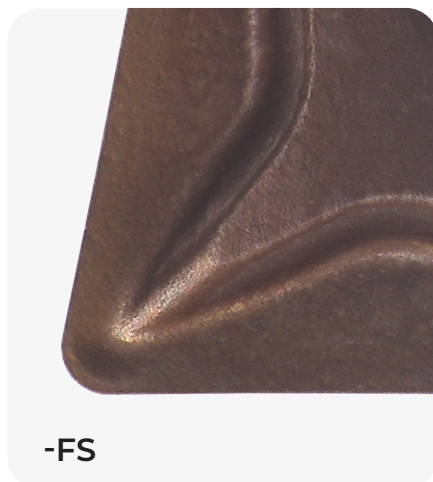


01.

The GS chipbreaker is designed for semi-finishing and semi-roughing, balancing cutting performance, chip control, and process stability across a wide range of machining conditions.

02.

Designed for fine finishing applications, the FSF geometry also delivers excellent stability in demanding swiss-type turning operations.



03.

The FS and FF chipbreakers are engineered for superior chip control and high-quality surface finish in precision finishing applications with positive insert geometries, while the GSF chipbreaker delivers the same finishing performance for negative insert geometries.

PVD COATING TECHNOLOGY ISO M AND S MATERIALS

PHH Grade PVD technology

An exceptionally durable PVD coating boasts superior thermal stability, ensuring outstanding wear resistance and performance.

The PHH family is built on three dedicated micro grain substrates, each in a specific hardness or toughness balance, combined with a thin, optimized nanostructure coating for excellent heat dissipation.

M01 - M05

S01 - S05

PHH905

Very hard micro grain substrate combined with a thin optimized nanostructure PVD coating with excellent heat dissipation.

Optimized for finishing and fine finishing operations in stainless steels and HRSA.



M05 - M10

S05 - S15

PHH910

An hard micro grain substrate combined with a thin optimized nanostructure PVD coating with excellent heat dissipation.

The solution for stainless steel and HRSA from medium turning to finishing. For continuous to semi-interrupted turning. First choice for HRSA.



M10 - M25

S15 - S30

PHH920

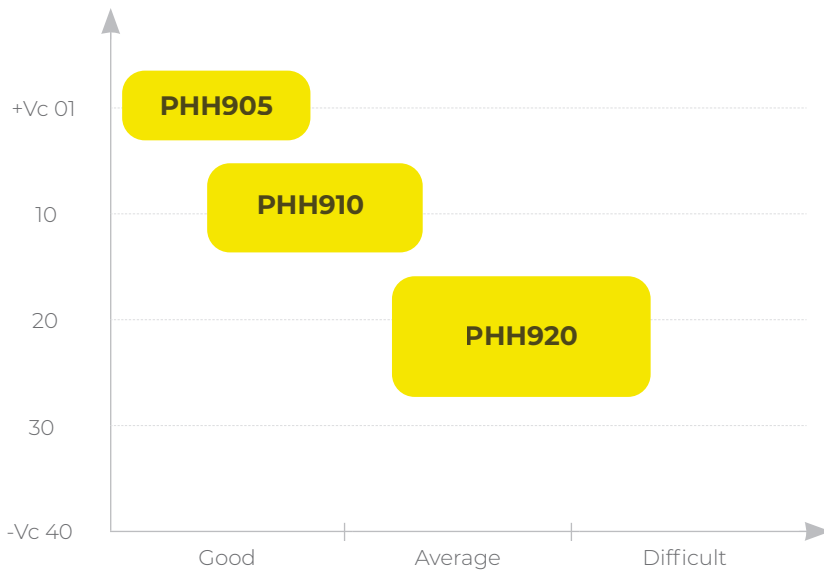
A micro grain substrate combined with a thin optimized nanostructure PVD coating with excellent heat dissipation.

Solution for general turning of stainless steels and HRSA.



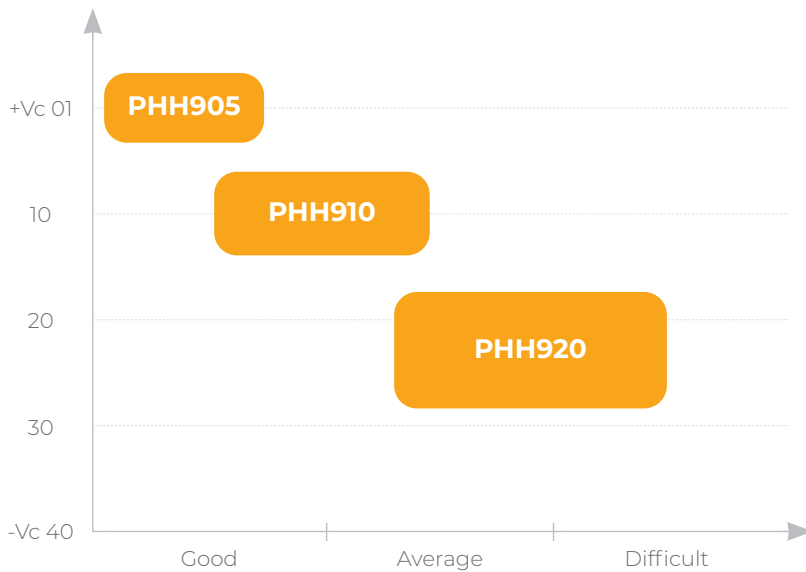
Stainless Steel

M



Heat Resistant / Titanium Alloys

S

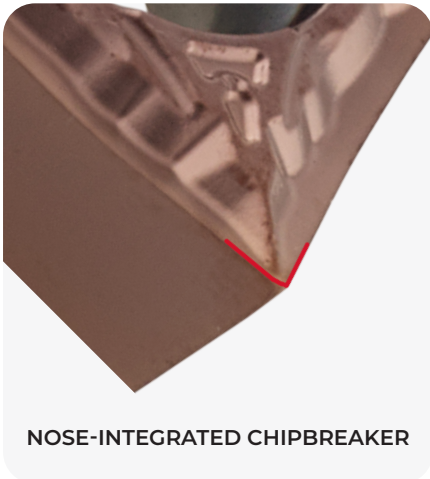


PVD coating specifically developed for **efficient machining** of **HRSA and stainless steel materials**.

Available in CCGT, DCGT and VCGT formats, FSF adapts to different component geometries, accessibility requirements and machining strategies.

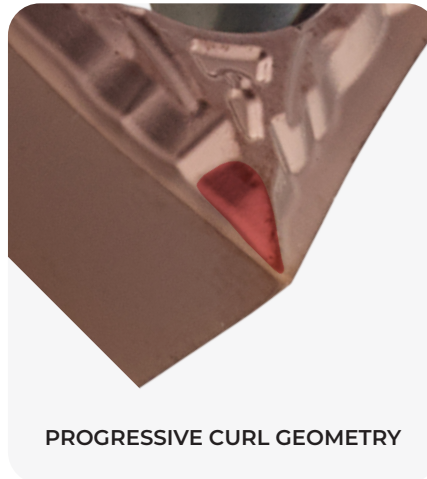
Engineered for finishing and super-finishing operations, it delivers a superior surface finish and extended tool life in standard turning. In swiss-type machining, that same geometry adds the process stability needed to control chip formation under limited rigidity.

FSF is the right choice across a wide range of machining conditions, from conventional to swiss-type turning.



01.

Chip formation remains controlled across a wider range of feeds and cutting depths.



02.

The curved chipbreaker ridge promotes controlled chip curling, increasing chip deformation and ensuring consistent chip breaking even at higher depths of cut.

Versatile Chipbreaker Built for the demands of swiss turning

The FSF geometry is suited to operate under limited rigidity and small-diameter workpieces that amplify vibration and cutting forces conditions. This new chipbreaker delivers stable chip formation and fine surface finish even at higher depths of cut.

Minimal cutting pressure

Essential to prevent deflection on workpieces.



Dimensional accuracy

Reduced radial forces protect tight tolerances on small turned components.



Chatter-free performance

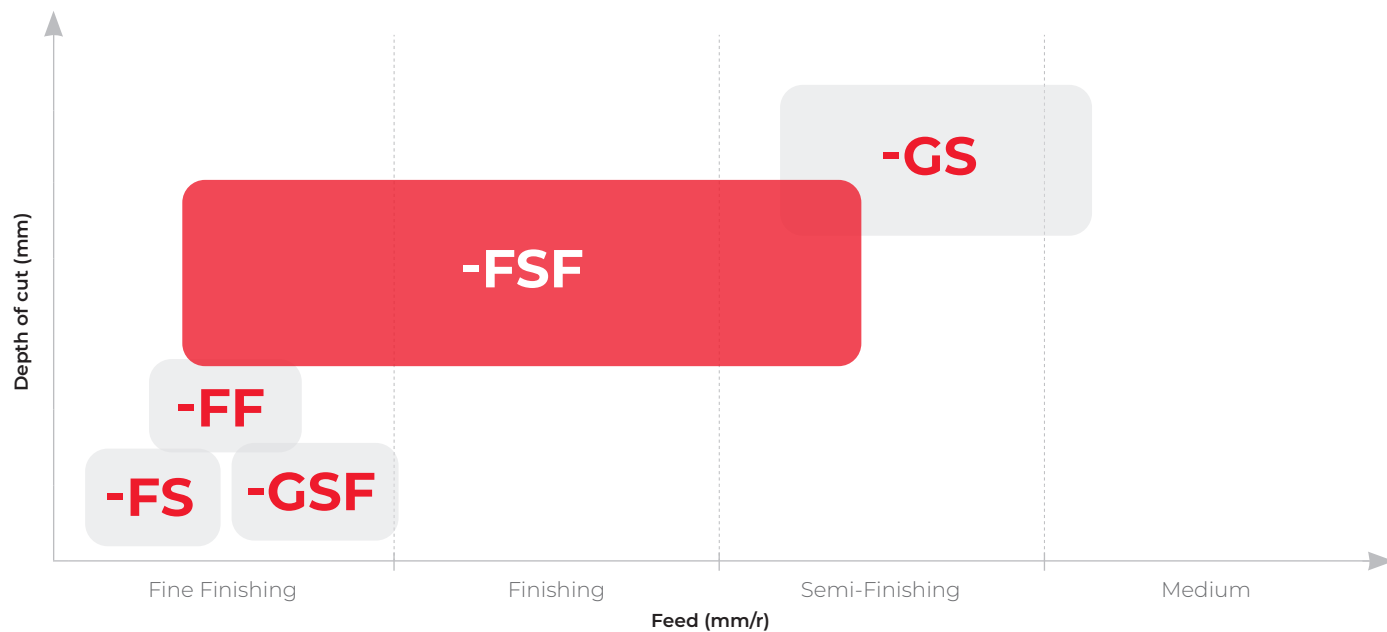
Smooth and continuous cutting action of small and delicate components.

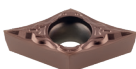


Feed vs Depth of Cut Chipbreaker family

ISO M & S - STAINLESS STEEL & HRSA

M **S**



		(2) Grade code		M		S	
				PVD		PVD	
				X6	Y3	X6	Y3
Inserts Pastilhas Plaquitas	(1) Geometry code	ISO Reference	ANSI Reference	PHH910	PHH920	PHH910	PHH920
 Finishing to Fine Finishing	1125158	CCGT 060201-FSF	CCGT 21.50.2-FSF				
	1125159	CCGT 060202-FSF	CCGT 21.50.5-FSF				
	1125160	CCGT 060204-FSF	CCGT 21.51-FSF				
	1125161	CCGT 09T301-FSF	CCGT 32.50.2-FSF				
	1125162	CCGT 09T302-FSF	CCGT 32.50.5-FSF				
	1125163	CCGT 09T304-FSF	CCGT 32.51-FSF				
 Fine Finishing	1125164	DCGT 070201-FSF	DCGT 21.50.2-FSF				
	1125165	DCGT 070202-FSF	DCGT 21.50.5-FSF				
	1125166	DCGT 070204-FSF	DCGT 21.51-FSF				
	1125167	DCGT 11T301-FSF	DCGT 32.50.5-FSF				
	1125039	DCGT 11T302-FSF	DCGT 32.50.5-FSF				
	1125038	DCGT 11T304-FSF	DCGT 32.51-FSF				
 Fine Finishing	1125168	DCGT 11T308-FSF	DCGT 32.52-FSF				
	1125169	VCGT 110301-FSF	VCGT 220.2-FSF				
	1125170	VCGT 110302-FSF	VCGT 220.5-FSF				
	1125171	VCGT 110304-FSF	VCGT 221-FSF				
	1125172	VCGT 160402-FSF	VCGT 330.5-FSF				
	1125173	VCGT 160404-FSF	VCGT 331-FSF				
	1125174	VCGT 160408-FSF	VCGT 332-FSF				

 First choice | Primeira opção | 1ª opción

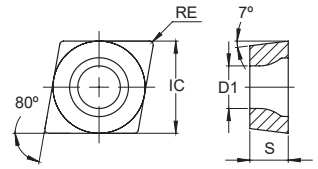
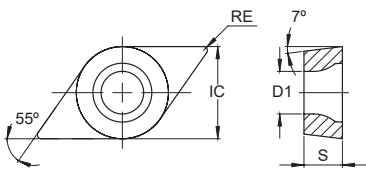
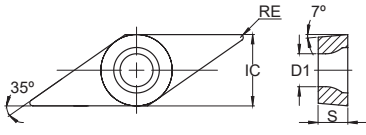
 Stock item | Produto de stock | Itens de stock

 Stock available soon | Stock disponível em breve | Existencias disponibles pronto

RECOMMENDED CUTTING CONDITIONS

Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	Vc (m/min) HB (Brinell)	PVD Coating	
				PHH910	PHH920
M	1	SS - Ferritic / Martensitic	200-330	30-220	30-200
	2	SS - Austenitic	180-330		
	3	SS - Austenitic-ferritic (Duplex)	230-260		
S	4	Heat Resistant Super Alloys (Iron Base)	220-280	30-110	30-100
	5	Heat Resistant Super Alloys (Nickel Base)	250-320		
	6	Heat Resistant Super Alloys (Cobalt Base)	200-320		
	7	Titanium Alloys	-		

Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting conditions Condições de corte Condiciones de corte						Technical drawing Desenho técnico Dibujo técnico
IC	S	RE	D1	AP (mm)	MIN	MAX	FN (mm/r)	MIN	MAX	
6,35	2,38	0,10	2,80	1,30	0,08	2,50	0,03	0,02	0,05	
6,35	2,38	0,20	2,80	1,55	0,10	3,00	0,06	0,02	0,10	
6,35	2,38	0,40	2,80	1,55	0,10	3,00	0,13	0,05	0,20	
9,53	3,97	0,10	4,40	1,30	0,08	2,50	0,03	0,02	0,05	
9,53	3,97	0,20	4,40	1,55	0,10	3,00	0,06	0,02	0,10	
9,53	3,97	0,40	4,40	1,55	0,10	3,00	0,13	0,05	0,20	
6,35	2,38	0,10	2,80	1,30	0,08	2,50	0,03	0,01	0,05	
6,35	2,38	0,20	2,80	1,55	0,10	3,00	0,06	0,02	0,10	
6,35	2,38	0,40	2,80	1,55	0,10	3,00	0,13	0,05	0,20	
9,53	3,97	0,10	4,40	1,30	0,08	2,50	0,03	0,01	0,05	
9,53	3,97	0,20	4,40	1,55	0,10	3,00	0,06	0,02	0,10	
9,53	3,97	0,40	4,40	1,55	0,10	3,00	0,13	0,05	0,20	
9,53	3,97	0,80	4,40	1,55	0,10	3,00	0,18	0,08	0,25	
6,35	3,18	0,10	2,80	1,30	0,08	2,50	0,03	0,01	0,05	
6,35	3,18	0,20	2,80	1,55	0,10	3,00	0,06	0,02	0,10	
6,35	3,18	0,40	2,80	1,55	0,10	3,00	0,13	0,05	0,20	
9,53	4,76	0,20	3,81	1,55	0,10	3,00	0,06	0,02	0,10	
9,53	4,76	0,40	3,81	1,55	0,10	3,00	0,13	0,05	0,20	
9,53	4,76	0,80	3,81	1,55	0,10	3,00	0,18	0,08	0,25	

Insert order code = (1) Geometry Code + (2) Grade Code

A patented double-sided negative insert, the DOMX with GS chipbreaker concept is designed to push the boundaries of stainless steel and HRSA turning, delivering consistent performance across a wide range of cutting conditions.

First choice for semi-finishing to semi-roughing operations. The DOMX-GS geometry combines a reduced contact surface with efficient heat dissipation, lowering cutting forces without compromising surface finish



REDUCED 45° ENTERING ANGLE



REDUCED CONTACT, LESS HEAT



SHARP CUTTING EDGE

01.

Machines at 45° with a 93° toolholder, combining high feed potential with superior workpiece access in a single setup.

02.

Smaller cutting contact surface with less heat generation and lower cutting forces than normal DNMG inserts.

03.

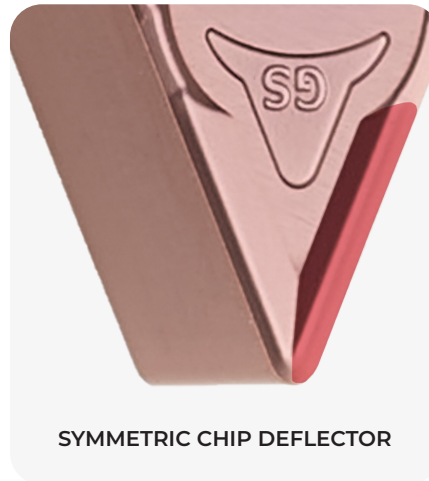
Sharp cutting edge slices through stainless steels and HRSA with minimal resistance, protecting the workpiece surface and maximising tool life.

DOMX & GS CHIPBREAKER

Negative Inserts

Designed for ISO negative insert geometries and especially suited for HRSA, the GS delivers reliable chip control across a broad machining range in stainless steels and heat-resistant superalloys.

Delivers reliable chip control at the highest APs and feeds within semi-finishing to semi-roughing operations.



01.

Suited for standard negative insert geometries, performing at higher feeds and depths of cut, covering a range from semi-roughing through to semi-finishing operations.

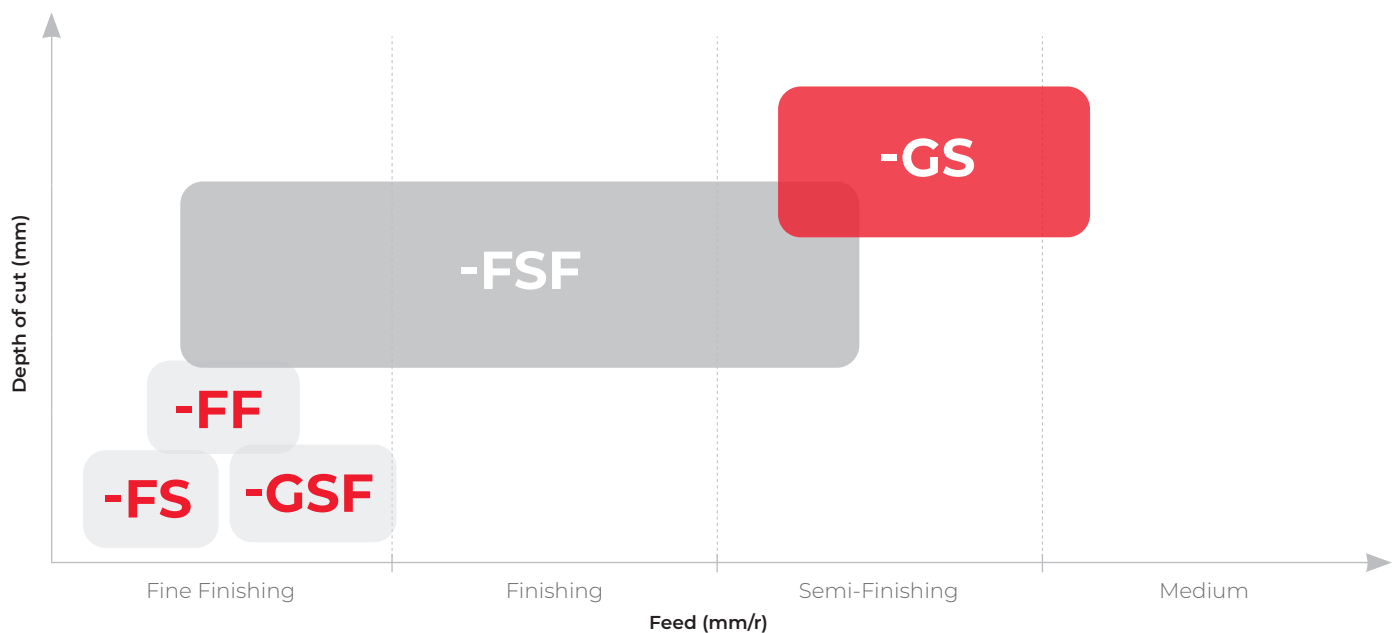
02.

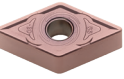
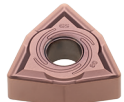
Dual ramp-style chip formers guide and break the chip progressively, ensuring consistent chip control across finishing and semi-finishing operations.

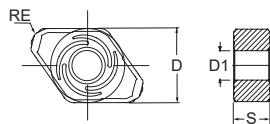
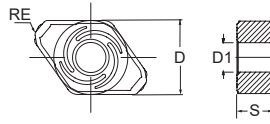
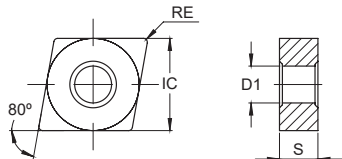
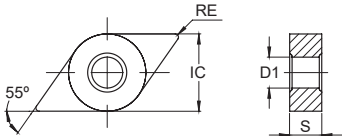
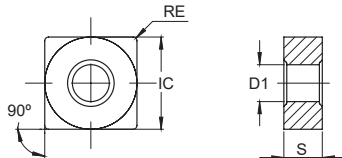
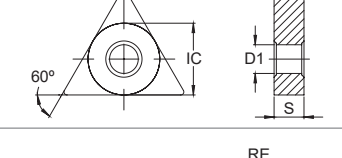
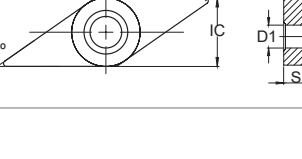
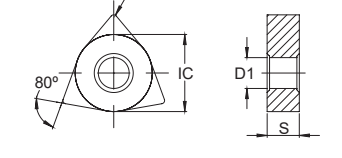
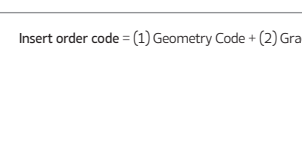
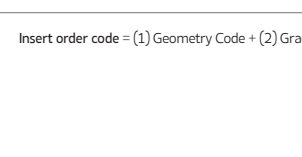
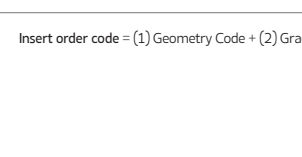
Feed vs Depth of Cut Chipbreaker family

ISO M & S - STAINLESS STEEL & HRSA

M S



				M			S		
				PVD			PVD		
				W8	X6	Y3	W8	X6	Y3
Inserts Pastilhas Plaquitas	(1) Geometry code	ISO Reference	ANSI Reference	PHH905	PHH910	PHH920	PHH905	PHH910	PHH920
 DOMX-GS	1124595	DOMX 1506R1-GS	DOMX 44R1-GS						
 DOMX-GS	1124493	DOMX 1506L1-GS	DOMX 44L1-GS						
 CNMG-GS Medium to Finishing	1124514	CNMG 120404-GS	CNMG 431-GS						
	1124502	CNMG 120408-GS	CNMG 432-GS						
	1124515	CNMG 120412-GS	CNMG 433-GS						
 DNMG-GS Medium to Finishing	1124688	DNMG 110404-GS	DNMG 331-GS						
	1124689	DNMG 110408-GS	DNMG 332-GS						
	1124511	DNMG 150404-GS	DNMG 431-GS						
	1124512	DNMG 150408-GS	DNMG 432-GS						
	1124513	DNMG 150412-GS	DNMG 433-GS						
	1124682	DNMG 150604-GS	DNMG 441-GS						
	1124683	DNMG 150608-GS	DNMG 442-GS						
	1124684	DNMG 150612-GS	DNMG 443-GS						
 SNMG-GS Medium to Finishing	1124556	SNMG 120408-GS	SNMG 432-GS						
	1124557	SNMG 120412-GS	SNMG 433-GS						
	1124558	SNMG 120416-GS	SNMG 434-GS						
 TNMG-GS Medium to Finishing	1124508	TNMG 160404-GS	TNMG 331-GS						
	1124509	TNMG 160408-GS	TNMG 332-GS						
	1124510	TNMG 160412-GS	TNMG 333-GS						
 VNMG-GS Medium to Finishing	1124562	VNMG 160404-GS	VNMG 331-GS						
	1124563	VNMG 160408-GS	VNMG 332-GS						
	1124564	VNMG 160412-GS	VNMG 333-GS						
 WNMG-GS Medium to Finishing	1124690	WNMG 060404-GS	WNMG 331-GS						
	1124691	WNMG 060408-GS	WNMG 332-GS						
	1124559	WNMG 080404-GS	WNMG 431-GS						
	1124560	WNMG 080408-GS	WNMG 432-GS						
	1124561	WNMG 080412-GS	WNMG 433-GS						

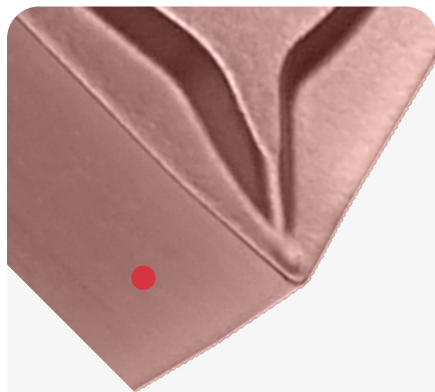
Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting conditions Condições de corte Condiciones de corte						Technical drawing Desenho técnico Dibujo técnico
IC	S	RE	D1	AP (mm)	MIN	MAX	FN (mm/r)	MIN	MAX	
12,70	6,35	0,80	5,16	1,50	0,30	1,50	0,30	0,20	0,50	
12,70	6,35	0,80	5,16	1,50	0,30	1,50	0,30	0,20	0,50	
12,70	4,76	0,40	5,16	1,50	0,15	2,50	0,20	0,10	0,30	
12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,10	0,35	
12,70	4,76	1,20	5,16	2,00	0,30	4,00	0,30	0,10	0,45	
9,53	4,76	0,40	3,81	1,50	0,15	2,00	0,20	0,10	0,25	
9,53	4,76	0,80	3,81	2,00	0,20	2,50	0,25	0,10	0,30	
12,70	4,76	0,40	5,16	1,50	0,15	2,00	0,20	0,10	0,25	
12,70	4,76	0,80	5,16	2,00	0,20	2,50	0,25	0,10	0,30	
12,70	4,76	1,20	5,16	2,00	0,30	3,00	0,25	0,10	0,35	
12,70	6,35	0,40	5,16	1,50	0,15	2,00	0,20	0,10	0,25	
12,70	6,35	0,80	5,16	2,00	0,20	2,50	0,25	0,10	0,30	
12,70	6,35	1,20	5,16	0,30	0,30	3,00	0,30	0,10	0,35	
12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,15	0,40	
12,70	4,76	1,20	5,16	2,50	0,50	5,00	0,30	0,20	0,50	
12,70	4,76	1,60	5,16	2,50	0,50	5,00	0,40	0,20	0,50	
9,53	4,76	0,40	3,81	1,50	0,15	3,00	0,15	0,10	0,30	
9,53	4,76	0,80	3,81	2,00	0,20	3,00	0,25	0,10	0,30	
9,53	4,76	1,20	3,81	2,00	0,30	3,00	0,30	0,15	0,35	
9,53	4,76	0,40	3,81	1,00	0,15	2,00	0,15	0,05	0,20	
9,53	4,76	0,80	3,81	1,50	0,20	2,50	0,20	0,07	0,25	
9,53	4,76	1,20	3,81	1,50	0,30	3,00	0,20	0,10	0,25	
9,53	4,76	0,40	3,81	1,50	0,15	2,50	0,20	0,10	0,30	
9,53	4,76	0,80	3,81	2,00	0,20	3,00	0,25	0,10	0,35	
12,70	4,76	0,40	5,16	1,50	0,15	2,50	0,20	0,10	0,30	
12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,10	0,35	
12,70	4,76	1,20	5,16	2,00	0,30	3,50	0,30	0,10	0,40	

Insert order code = (1) Geometry Code + (2) Grade Code

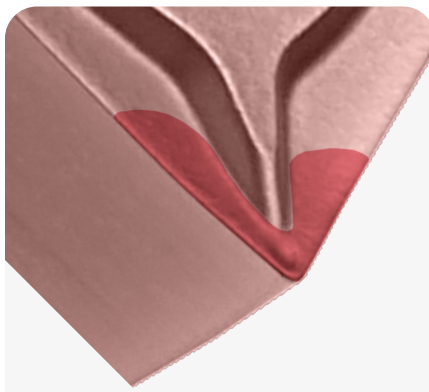
FS CHIPBREAKER

Positive Inserts

A sharp, positive rake geometry engineered for finishing operations. Delivering low cutting forces and precise chip control on positive inserts, particularly effective at small depths of cut.



PRECISION GROUND GEOMETRY



LIGHT-CUTTING ACTION

01.

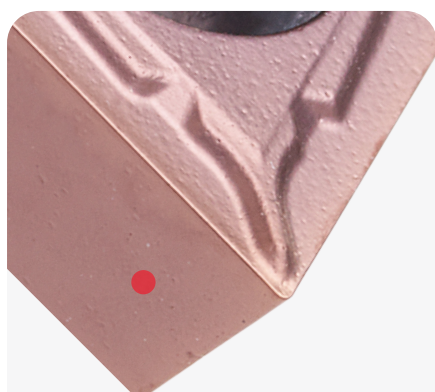
A precision-ground geometry promotes smoother cutting action and enhanced edge stability, helping achieve superior surface finishes and consistent machining performance.

02.

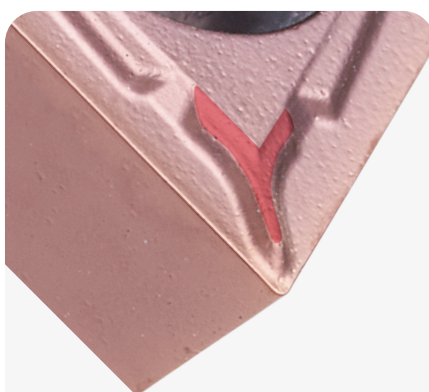
A sharp, free-cutting edge is optimised for low depths of cut and light feed rates, delivering reduced cutting forces, excellent surface finishes, and consistent dimensional accuracy in finishing applications.

FF CHIPBREAKER

Direct-pressed for full edge integrity, its wave profile breaker guides chip flow smoothly and reduces cutting forces without material sticking.



DIRECT-PRESSED



"WAVE" PROFILE BREAKER

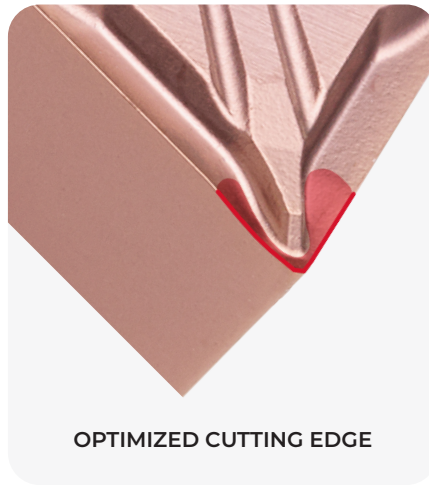
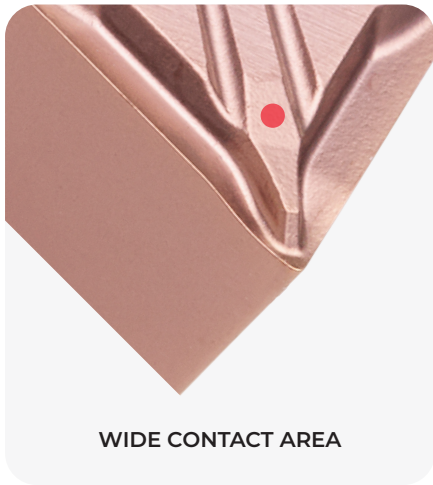
01.

Manufactured without secondary grinding, reducing costs while maintaining full performance and edge integrity.

02.

Guides chip flow smoothly, reduces cutting forces, and prevents material sticking for consistent quality finish.

Designed for negative insert geometries, GSF has a wide contact area that ensures stability against chipping, while the optimized cutting edge reduces cutting forces without compromising surface finish.



01.

Inserts with holder prevents chipping due to stable basis.

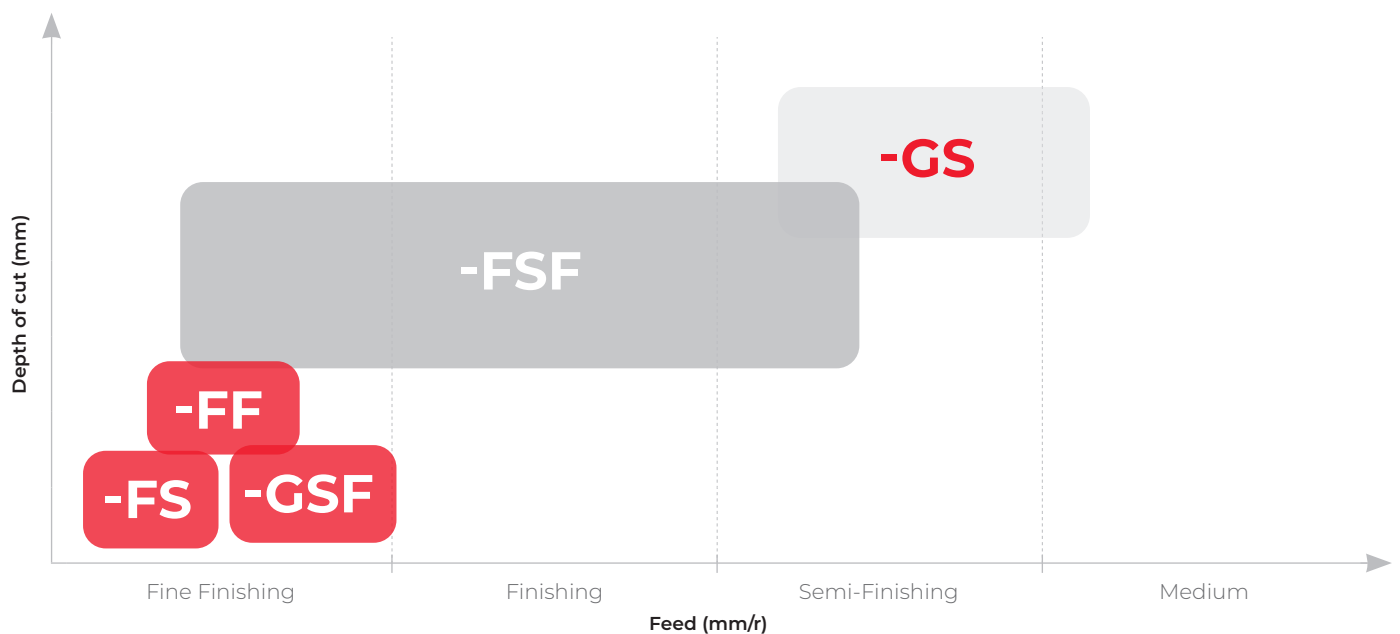
02.

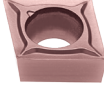
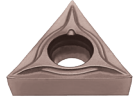
Fracture resistance provides high strength and reduced cutting forces.

Feed vs Depth of Cut Chipbreaker family

ISO M & S - STAINLESS STEEL & HRSA

M S

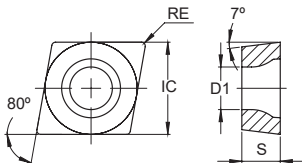
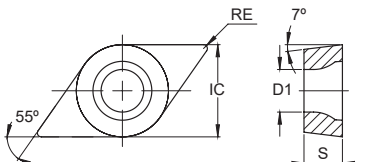
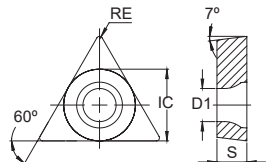
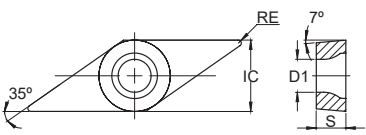


				M			S		
				PVD			PVD		
				W8	X6	Y3	W8	X6	Y3
Inserts Pastilhas Plaquetas	(1) Geometry code	ISO Reference	ANSI Reference	PHH905	PHH910	PHH920	PHH905	PHH910	PHH920
 Finishing to Fine Finishing	1121725	CCGT 060201-FS	CCGT 21.50.2-FS	○	⊗	⊗	○	⊗	⊗
	1121726	CCGT 060202-FS	CCGT 21.50.5-FS	○	⊗	⊗	○	⊗	⊗
	1121727	CCGT 060204-FS	CCGT 21.51-FS	○	⊗	⊗	○	⊗	⊗
	1121455	CCGT 09T301-FS	CCGT 32.50.2-FS	○	⊗	⊗	○	⊗	⊗
	1121456	CCGT 09T302-FS	CCGT 32.50.5-FS	○	⊗	⊗	○	⊗	⊗
	1121457	CCGT 09T304-FS	CCGT 32.51-FS	○	⊗	⊗	○	⊗	⊗
 Finishing to Fine Finishing	1121747	DCGT 070201-FS	DCGT 21.50.2-FS		⊗	⊗	○	⊗	⊗
	1121748	DCGT 070202-FS	DCGT 21.50.5-FS		⊗	⊗	○	⊗	⊗
	1121872	DCGT 070204-FS	DCGT 21.51-FS		⊗	⊗	○	⊗	⊗
	1121873	DCGT 11T301-FS	DCGT 32.50.2-FS		⊗	⊗	○	⊗	⊗
	1121874	DCGT 11T302-FS	DCGT 32.50.5-FS		⊗	⊗	○	⊗	⊗
	1121875	DCGT 11T304-FS	DCGT 32.51-FS		⊗	⊗	○	⊗	⊗
	1124101	DCGT 11T308-FS	DCGT 32.52-FS		⊗	⊗		⊗	⊗
 Finishing to Fine Finishing	1123865	TCGT 090202-FS	TCGT 1.81.50.5-FS		⊗	⊗		⊗	⊗
	1123866	TCGT 090204-FS	TCGT 1.81.51-FS		⊗	⊗		⊗	⊗
	1123867	TCGT 110201-FS	TCGT 21.50.2-FS		⊗	⊗		⊗	⊗
	1123868	TCGT 110202-FS	TCGT 21.50.5-FS		⊗	⊗		⊗	⊗
	1123869	TCGT 110204-FS	TCGT 21.51-FS		⊗	⊗		⊗	⊗
	1123870	TCGT 110301-FS	TCGT 220.2-FS		⊗	⊗		⊗	⊗
	1123871	TCGT 110302-FS	TCGT 220.5-FS		⊗	⊗		⊗	⊗
 Finishing to Fine Finishing	1123861	VCGT 110301-FS	VCGT 110304-FS	○	⊗	⊗	○	⊗	⊗
	1123862	VCGT 110302-FS	VCGT 220.5-FS	○	⊗	⊗	○	⊗	⊗
	1123863	VCGT 110304-FS	VCGT 221-FS	○	⊗	⊗	○	⊗	⊗

⊗ First choice | Primeira opção | 1ª opción

⊗ Stock item | Produto de stock | Itens de stock

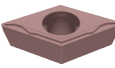
○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting conditions Condições de corte Condiciones de corte						Technical drawing Desenho técnico Dibujo técnico
IC	S	RE	D1	AP (mm)	MIN	MAX	FN (mm/r)	MIN	MAX	
6,350	2,38	0,10	2,80	0,30	0,10	1,00	0,03	0,01	0,06	
6,350	2,38	0,20	2,80	0,50	0,10	1,50	0,07	0,02	0,12	
6,350	2,38	0,40	2,80	0,80	0,15	1,50	0,20	0,08	0,25	
9,525	3,97	0,10	4,40	0,50	0,10	1,50	0,03	0,01	0,06	
9,525	3,97	0,20	4,40	1,00	0,10	2,00	0,07	0,02	0,12	
9,525	3,97	0,40	4,40	1,25	0,15	2,50	0,15	0,08	0,25	
6,350	2,38	0,10	2,80	0,30	0,10	1,00	0,03	0,01	0,06	
6,350	2,38	0,20	2,80	0,50	0,10	1,50	0,07	0,02	0,12	
6,350	2,38	0,40	2,80	0,80	0,15	1,50	0,15	0,08	0,25	
9,525	3,97	0,10	4,40	0,50	0,10	1,50	0,03	0,01	0,06	
9,525	3,97	0,20	4,40	1,00	0,10	2,00	0,07	0,02	0,12	
9,525	3,97	0,40	4,40	1,50	0,15	3,00	0,15	0,08	0,25	
9,525	3,97	0,80	4,40	2,00	0,20	3,50	0,18	0,10	0,30	
5,560	2,38	0,20	2,50	0,50	0,10	1,50	0,07	0,02	0,12	
5,560	2,38	0,40	2,50	1,00	0,50	2,00	0,15	0,08	0,25	
6,350	2,38	0,10	2,80	0,30	0,10	1,00	0,03	0,01	0,08	
6,350	2,38	0,20	2,80	0,50	0,10	1,50	0,07	0,02	0,12	
6,350	2,38	0,40	2,80	1,30	0,30	2,50	0,15	0,08	0,25	
9,525	3,18	0,10	2,80	0,30	0,10	1,00	0,03	0,01	0,08	
9,525	3,18	0,20	2,80	0,50	0,10	1,50	0,07	0,02	0,12	
9,525	3,18	0,40	2,80	1,30	0,50	2,50	0,15	0,08	0,25	
6,350	3,18	0,10	2,80	0,30	0,10	1,00	0,03	0,01	0,08	
6,350	3,18	0,20	2,80	0,50	0,10	1,50	0,07	0,02	0,12	
6,350	3,18	0,40	2,80	1,00	0,30	2,50	0,15	0,08	0,25	

Insert order code = (1) Geometry Code + (2) Grade Code

FF CHIPBREAKER

Positive Inserts

				M			S		
				PVD			PVD		
				W8	X6	Y3	W8	X6	Y3
Inserts Pastilhas Plaquitas	(1) Geometry code	ISO Reference	ANSI Reference	PHH905	PHH910	PHH920	PHH905	PHH910	PHH920
 CCMT-FF Fine Finishing	1124850	CCMT 09T302-FF	CCMT 32.50.5-FF	○	⊗		○	⊗	
	1124669	CCMT 09T304-FF	CCMT 32.51-FF	○	⊗		○	⊗	
	1124851	CCMT 09T308-FF	CCMT 32.52-FF	○	⊗		○	⊗	
 DCMT-FF Fine Finishing	1121389	DCMT 11T302-FF	DCMT 32.50.5-FF		⊗	⊗		⊗	⊗
	1121390	DCMT 11T304-FF	DCMT 32.51-FF		⊗	⊗		⊗	⊗
	1121391	DCMT 11T308-FF	DCMT 32.52-FF		⊗	⊗		⊗	⊗
 VBMT-FF Fine Finishing	1124852	VBMT 160402-FF	VBMT 330.5-FF	○	⊗		○	⊗	
	1124672	VBMT 160404-FF	VBMT 331-FF	○	⊗		○	⊗	
	1124853	VBMT 160408-FF	VBMT 332-FF	○	⊗		○	⊗	

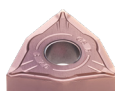
⊗ First choice | Primeira opção | 1ª opción

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

GSF CHIPBREAKER

Negative Inserts

				M			S		
				PVD			PVD		
				W8	X6	Y3	W8	X6	Y3
Inserts Pastilhas Plaquitas	(1) Geometry code	ISO Reference	ANSI Reference	PHH905	PHH910	PHH920	PHH905	PHH910	PHH920
 CNMG-GSF Fine Finishing	1124855	CNMG 120402-GSF	CNMG 430.5-GSF	○	⊗	⊗	○	⊗	⊗
	1124857	TNMG 160402-GSF	TNMG 330.5-GSF	○	⊗	⊗	○	⊗	⊗
	1124861	VNMG 160402-GSF	VNMG 330.5-GSF	○	⊗	⊗	○	⊗	⊗
 WNMG-GSF Fine Finishing	1124859	WNMG 080402-GSF	WNMG 430.5-GSF	○	⊗	⊗	○	⊗	⊗

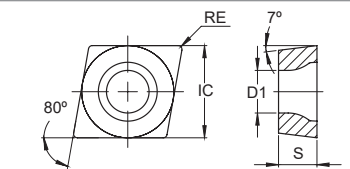
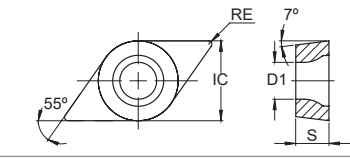
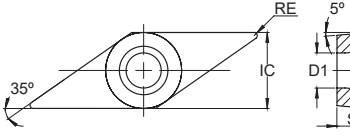
⊗ First choice | Primeira opção | 1ª opción

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

FF CHIPBREAKER

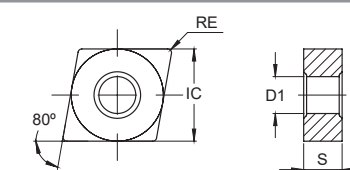
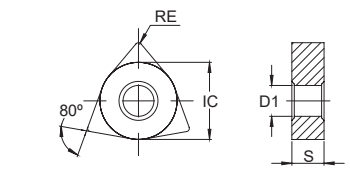
Positive Inserts

Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting conditions Condições de corte Condiciones de corte						Technical drawing Desenho técnico Dibujo técnico
IC	S	RE	D1	AP (mm)	MIN	MAX	FN (mm/r)	MIN	MAX	
9,525	3,97	0,20	4,40	1,00	0,08	2,00	0,09	0,04	0,13	
9,525	3,97	0,40	4,40	1,25	0,08	2,00	0,13	0,02	0,23	
9,525	3,97	0,80	4,40	1,50	0,15	2,00	0,27	0,08	0,45	
9,525	3,97	0,20	4,40	0,30	0,08	2,00	0,08	0,04	0,15	
9,525	3,97	0,40	4,40	0,50	0,11	2,00	0,11	0,06	0,23	
9,525	3,97	0,80	4,40	0,80	0,15	2,00	0,15	0,08	0,30	
9,525	4,76	0,20	4,40	1,00	0,07	1,80	0,09	0,04	0,14	
9,525	4,76	0,40	4,40	1,20	0,10	1,80	0,13	0,05	0,20	
9,525	4,76	0,80	4,40	1,60	0,14	1,80	0,17	0,07	0,27	

Insert order code = (1) Geometry Code + (2) Grade Code

GSF CHIPBREAKER

Negative Inserts

Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting conditions Condições de corte Condiciones de corte						Technical drawing Desenho técnico Dibujo técnico
IC	S	RE	D1	AP (mm)	MIN	MAX	FN (mm/r)	MIN	MAX	
12,700	4,76	0,20	5,16	1,30	0,10	2,50	0,12	0,08	0,15	
9,525	4,76	0,20	3,81	1,55	0,10	3,00	0,19	0,08	0,30	
9,525	4,76	0,20	3,81	1,10	0,20	2,00	0,15	0,05	0,25	
12,700	4,76	0,20	5,16	1,30	0,10	2,50	0,17	0,08	0,25	
9,525	4,76	0,20	3,81	1,10	0,20	2,00	0,15	0,05	0,25	
9,525	4,76	0,20	3,81	1,10	0,20	2,00	0,15	0,05	0,25	

Insert order code = (1) Geometry Code + (2) Grade Code

CHIPBREAKERS FOR

STAINLESS STEEL & HRSA MATERIALS

Advanced geometries delivering excellent
surface finish and stable material removal



Check the QrCode for more information



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