

FINE FINISHING FOR TURNING OPERATIONS Acabamento premium em operações de torneamento | Acabado premium en operaciones de torneado

Discover the GSF and FF chipbreakers in the world of fine finishing turning operations.

The negative chipbreaker GSF and positive chipbreaker FF are engineered with precision to provide superior chip control and surface finish.

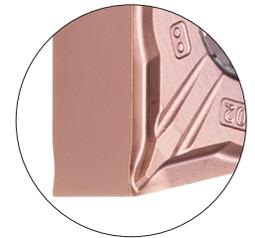
Along with the existing MS chipbreaker with a newly added 0,2mm radius option, these inserts are coated with PHH, our PVD coating designed specifically for efficient machining of HRSA.

Benefits:

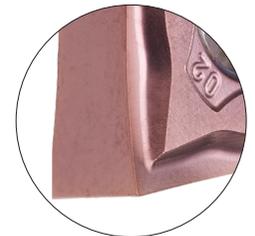
- Higher rake angle and special cutting edge shape;
- New chipbreakers (GSF & FF);
- 0,2 mm corner radius;
- Double sided negative inserts (GSF and MS);
- PHH coating;



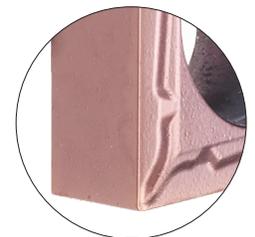
-GSF



-MS



-FF



PHH GRADE - THE CUTTING EDGE TECHNOLOGY FOR SUPERALLOYS TURNING

Grau PHH - A tecnologia de ponta para super-ligas em torneamento | Calidad PHH - La tecnología de vanguardia para superaleaciones en torneado

NEW

PHH905
M01-M05
S01-S05

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.

PHH910
M05-M10
S05-S15

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.

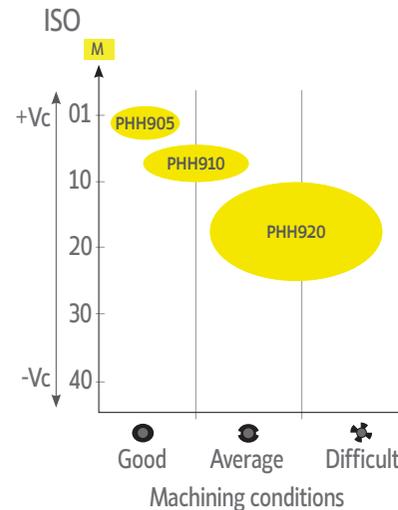
PHH920
M10-M25
S15-S30

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

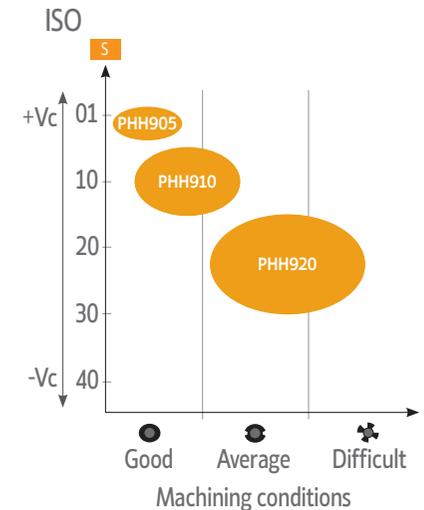
Solution for general turning of stainless steels and HRSA.



M - STAINLESS STEEL

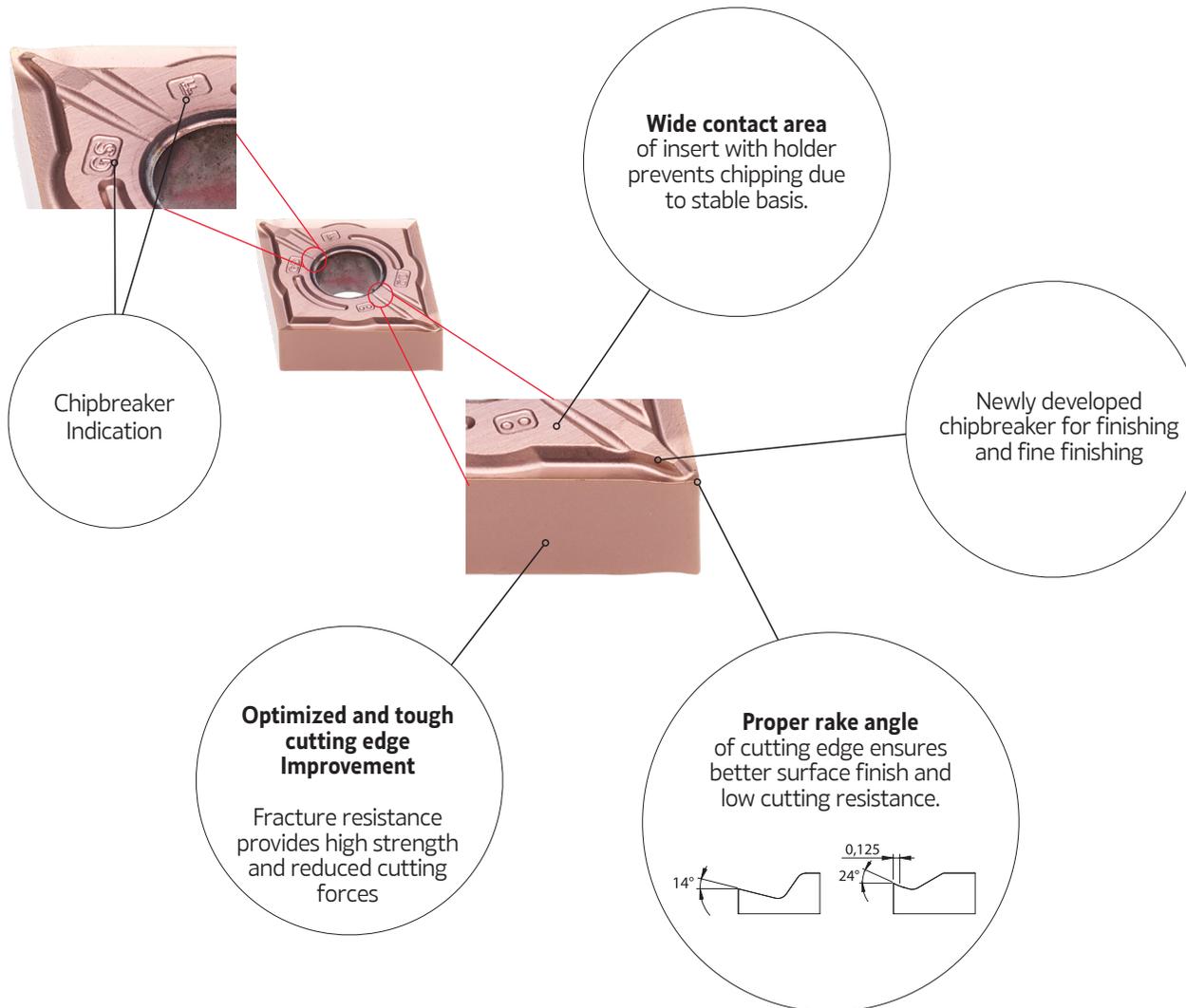


S - HEAT RESISTANT / TITANIUM ALLOYS



Heat resistant PVD coating with TiAlSiN.
Suitable for turning Stainless Steels and HRSA's.

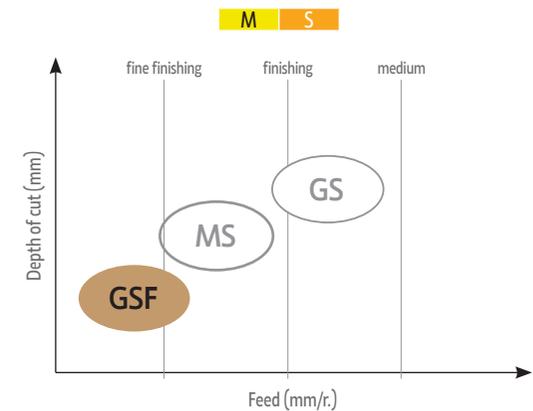
First choice for finishing and fine finishing operations.

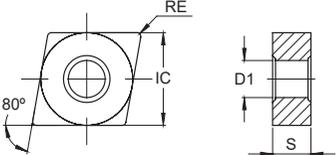
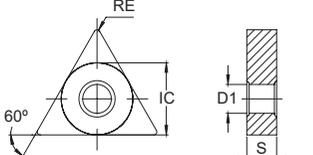
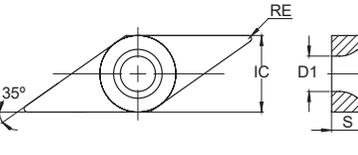
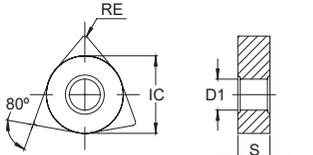


Chip control range



GSF for Fine Turning



Inserts Pastilhas Plaquitas	(1) Geometry code	(2) Grade code		M			S			Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting Conditions Condições de Corte Condiciones de Corte					Technical drawing Desenho técnico Dibujo técnico	
				PVD			PVD													
				W8	X6	Y3	W8	X6	Y3	IC	S	RE	D1	AP (mm)	MIN	MAX	FN (mm/rev)	MIN		
	1124855	CNMG 120402-GSF	CNMG 430.5-GSF	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	12,700	4,76	0,20	5,16	1,30	0,10	2,50	0,12	0,08	0,15	
Fine Finishing																				
	1124857	TNMG 160402-GSF	TNMG 330.5-GSF	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	9,525	4,76	0,20	3,81	1,55	0,10	3,00	0,19	0,08	0,30	
Fine Finishing																				
	1124861	VNMG 160402-GSF	VNMG 330.5-GSF	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	9,525	4,76	0,20	3,81	1,10	0,20	2,00	0,15	0,05	0,25	
Fine Finishing																				
	1124859	WNMG 080402-GSF	WNMG 430.5-GSF	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	12,700	4,76	0,20	5,16	1,30	0,10	2,50	0,17	0,08	0,25	
Fine Finishing																				

 First choice | Primeira opção | 1ª opción

 Stock item | Produto de stock | Itens de stock

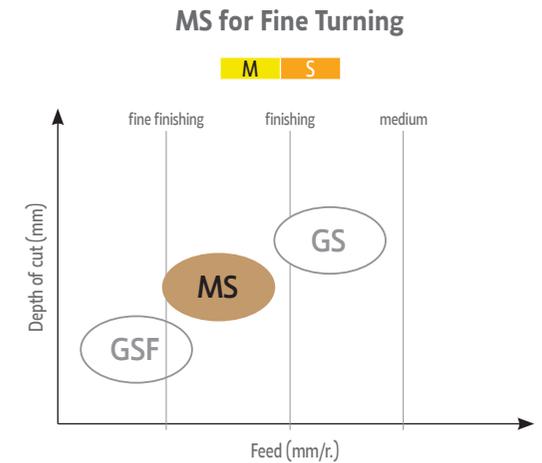
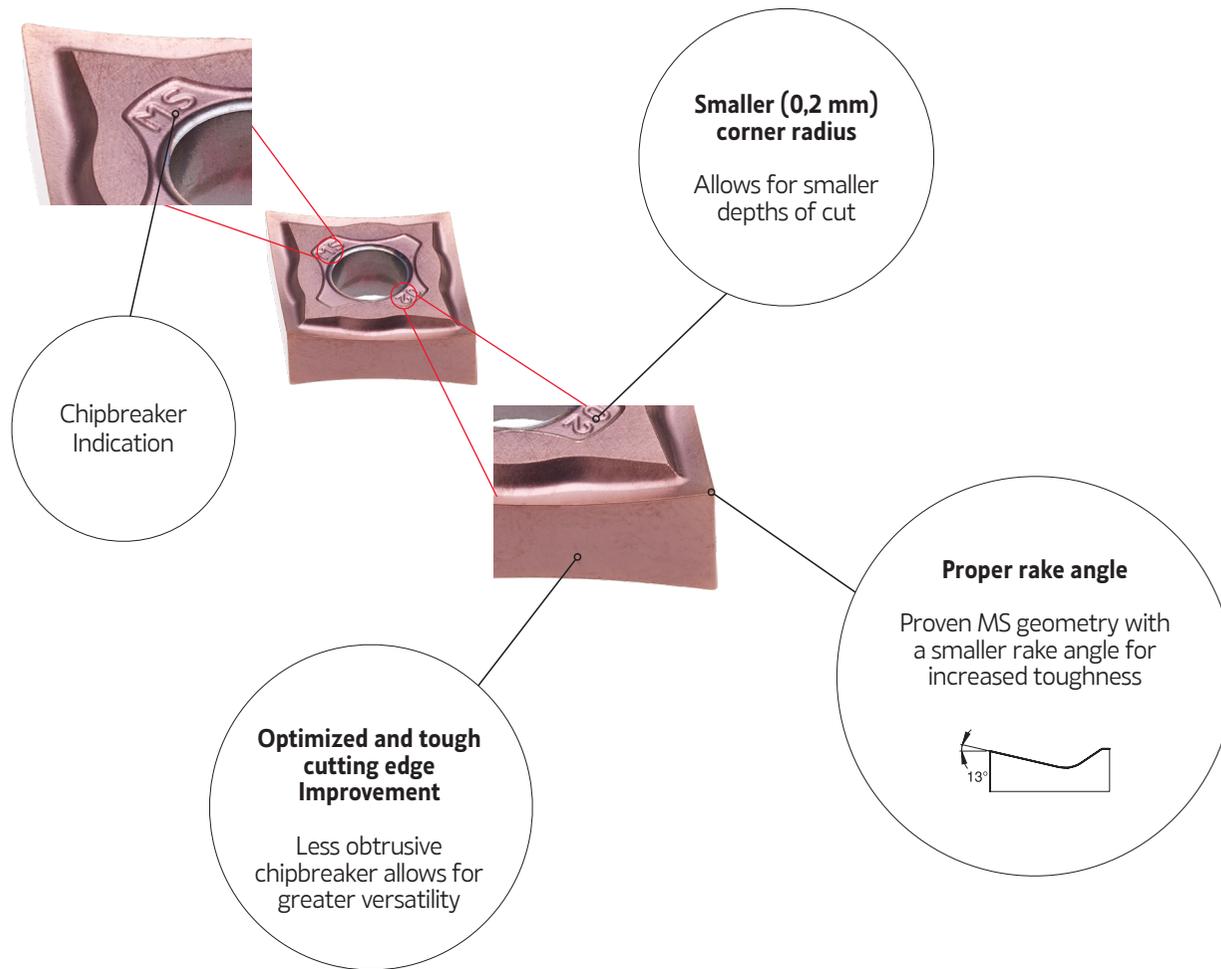
Available under request | Disponível sobre consulta | Disponible bajo consulta

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

MS CHIPBREAKER - RADIUS 0,2mm Quebra aparas MS com raio 0,2 mm | Rompe virutas MS con radio 0,2 mm

Extension of existing MS chipbreaker, now includes inserts with smaller corner radius
Suitable for turning Stainless Steels and HRSA's.

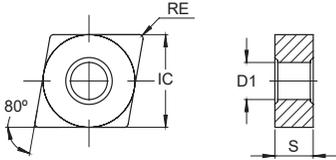
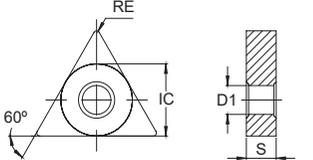
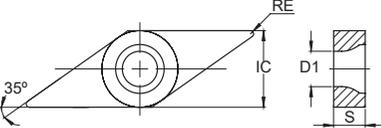
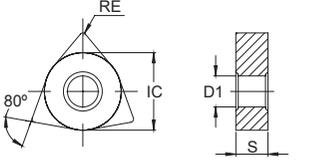
The smaller corner radius allows for improved performance in finishing and fine finishing operations.



MS CHIPBREAKER - RADIUS 0,2mm

Quebra aparas MS com raio 0,2 mm | Rompe virutas MS con radio 0,2 mm

Negative Inserts

Inserts Pastilhas Plaquitas	(1) Geometry code	(2) Grade code		M			S			Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting Conditions Condições de Corte Condiciones de Corte				Technical drawing Desenho técnico Dibujo técnico		
				PVD			PVD													
				W8	X6	Y3	W8	X6	Y3	IC	S	RE	D1	AP (mm)	MIN	MAX	FN (mm/rev)			MIN
 CNMG-MS Fine Finishing	1124854	CNMG 120402-MS	CNMG 430.5-MS	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	12,700	4,76	0,20	5,16	1,85	0,10	3,60	0,12	0,08	0,15	
 TNMG-MS Fine Finishing	1124856	TNMG 160402-MS	TNMG 330.5-MS	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	9,525	4,76	0,20	3,81	1,85	0,20	3,50	0,12	0,08	0,15	
 VNMG-MS Fine Finishing	1124860	VNMG 160402-MS	VNMG 330.5-MS	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	9,525	4,76	0,20	3,81	2,10	0,20	4,00	0,12	0,08	0,15	
 WNMG-MS Fine Finishing	1124858	WNMG 080402-MS	WNMG 430.5-MS	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	12,700	4,76	0,20	5,16	2,25	0,50	4,00	0,25	0,15	0,35	

 First choice | Primeira opção | 1ª opción

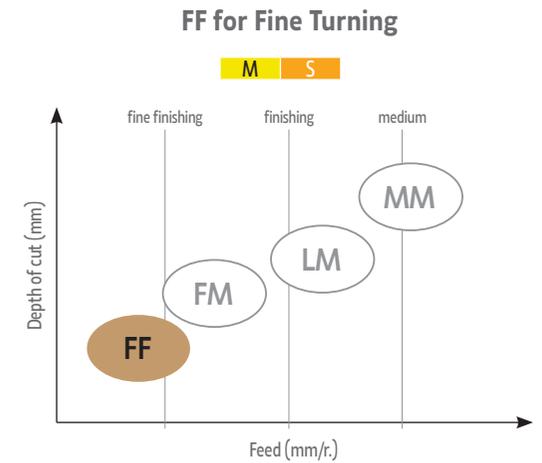
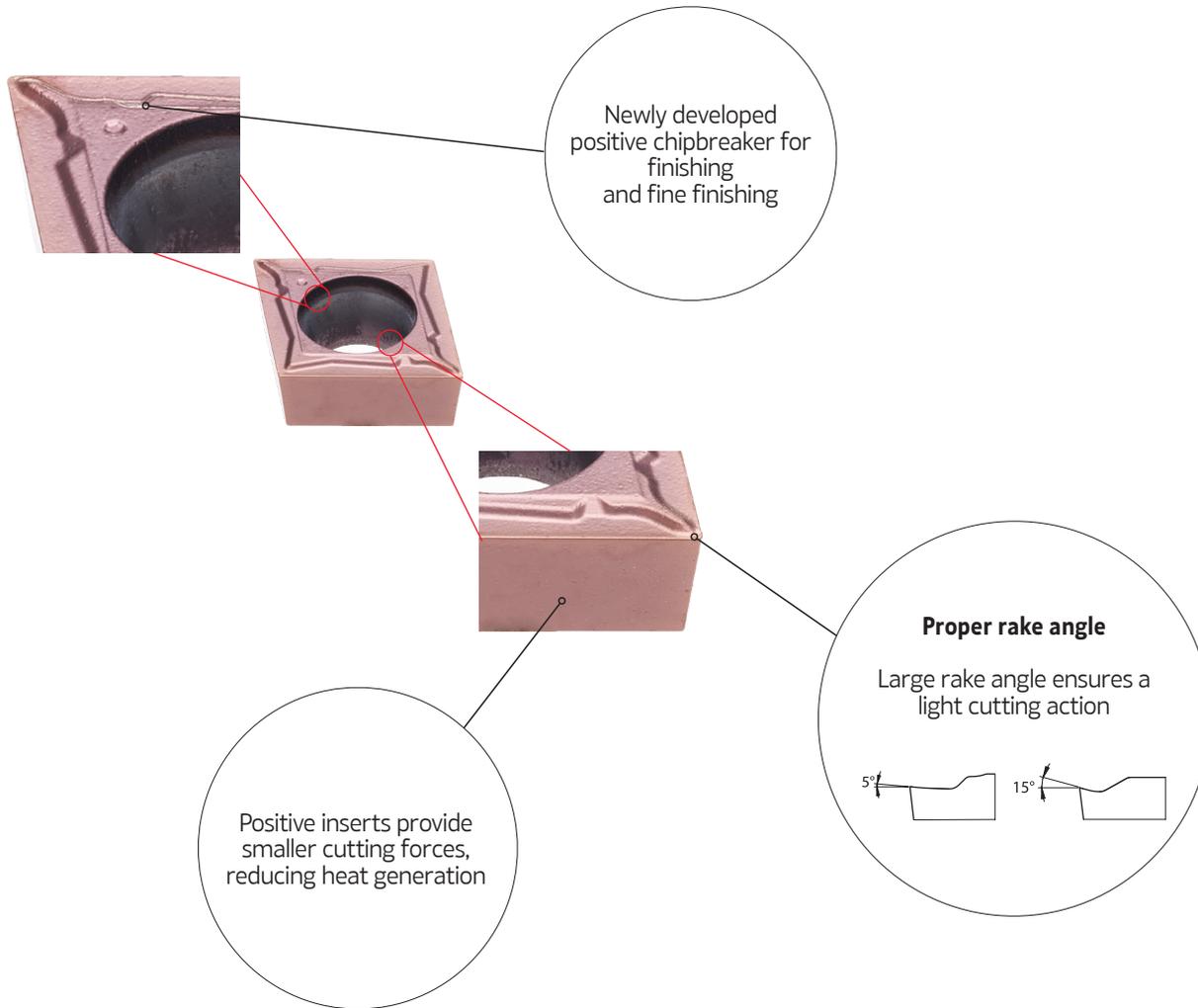
 Stock item | Produto de stock | Itens de stock

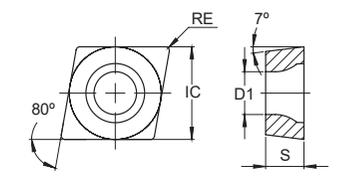
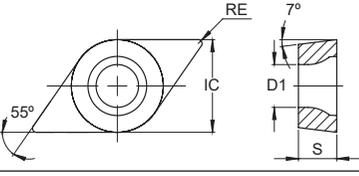
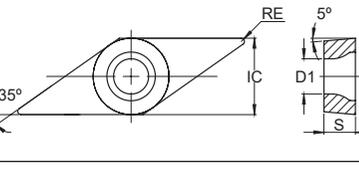
Available under request | Disponível sobre consulta | Disponible bajo consulta

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

New chipbreaker geometry for positive inserts.
Suitable for finishing and fine finishing of HRSA's & stainless steels.

First choice for internal turning or slender parts.



Inserts Pastilhas Plaquetas	(1) Geometry code	ISO Reference	ANSI Reference	M			S			Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting Conditions Condições de Corte Condiciones de Corte				Technical drawing Desenho técnico Dibujo técnico		
				PVD			PVD													
				(2) Grade code			W8	X6	Y3	W8	X6	Y3	IC	S	RE	D1	AP (mm)		MIN	MAX
	1124850	CCMT 09T302-FF	CCMT 32.50.5-FF	○	⊗		○	⊗		9,525	3,97	0,20	4,40	1,00	0,08	2,00	0,09	0,04	0,13	
	1124669	CCMT 09T304-FF	CCMT 32.51-FF	○	⊗		○	⊗		9,525	3,97	0,40	4,40	1,25	0,08	2,00	0,13	0,02	0,23	
	Fine Finishing	1124851	CCMT 09T308-FF	CCMT 32.52-FF	○	⊗		○	⊗		9,525	3,97	0,80	4,40	1,50	0,15	2,00	0,27	0,08	
	1121389	DCMT 11T302-FF	DCMT 32.50.5-FF		⊗	⊗		⊗	⊗	9,525	3,97	0,20	4,40	0,30	0,08	2,00	0,08	0,04	0,15	
	1121390	DCMT 11T304-FF	DCMT 32.51-FF		⊗	⊗		⊗	⊗	9,525	3,97	0,40	4,40	0,50	0,11	2,00	0,11	0,06	0,23	
	Fine Finishing	1121391	DCMT 11T308-FF	DCMT 32.52-FF		⊗	⊗		⊗	⊗	9,525	3,97	0,80	4,40	0,80	0,15	2,00	0,15	0,08	
	1124852	VBMT 160402-FF	VBMT 330.5-FF	○	⊗		○	⊗		9,525	4,76	0,20	4,40	1,00	0,07	1,80	0,09	0,04	0,14	
	1124672	VBMT 160404-FF	VBMT 331-FF	○	⊗		○	⊗		9,525	4,76	0,40	4,40	1,20	0,10	1,80	0,13	0,05	0,20	
	Fine Finishing	1124853	VBMT 160408-FF	VBMT 332-FF	○	⊗		○	⊗		9,525	4,76	0,80	4,40	1,60	0,14	1,80	0,17	0,07	

⊗ First choice | Primeira opção | 1ª opción

⊗ Stock item | Produto de stock | Itens de stock

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

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

FINE FINISHING

GSF, MF and FF Chipbreakers

The ultimate fine finishing for turning



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