

TURNING	<h1>CC</h1> <p>2 edges</p>		CARBIDE Positive					ISO513	HC-CVD						HC-PVD		HW		HT							
			Size	IC	S	D1	AN		P	JC7010	JC7020	JC8005	JC8015	JC8025	JC9010	JC9025	JPS015	JPS025	JPS010	JU6010	JU6020	JU4015	JP4020			
			MICRO CC	3.50	1.40	1.90	7°		M			200 380	180 360	140 300			80 220	60 180					200 380	200 400		
						K	180 380	150 300				150 280	120 240	80 160	60 120					160 280	160 300					
						N										600 2200	600 2000	500 1500								
						S								40 80												
						H																				
THREADING	GRADE APPLICATION AREA		Stable machining, continuous cut																							
	main application		General machining, light interruption																							
	applicable		Unstable machining, interrupted cut																							
FINISHING	<p>MICROBORING, ground chipbreaker</p>	GB P M N	MICRO	CC.R01-GBL	RE 0.1	a _p 0.05 f _n 0.02	0.20 0.04	0.35 0.06																		
				CC.R02-GBL	RE 0.2	a _p 0.05 f _n 0.03	0.20 0.05	0.35 0.07																		
				CC.R04-GBL	RE 0.4	a _p 0.05 f _n 0.04	0.20 0.06	0.35 0.08																		
	<p>ground chipbreaker, picture: right-hand</p>	PPF P M	CCET	060202%-PPF	RE 0.2	a _p 0.10 f _n 0.04	0.40 0.07	0.70 0.10																		
				060204%-PPF	RE 0.4	a _p 0.10 f _n 0.04	0.40 0.08	0.70 0.12																		
				09T302%-PPF	RE 0.2	a _p 0.10 f _n 0.04	0.50 0.08	0.90 0.12																		
				09T304%-PPF	RE 0.4	a _p 0.10 f _n 0.04	0.50 0.09	0.90 0.14																		
	<p>sharp edge</p>	PFU P M S	CCMT	060202-PFU	RE 0.2	a _p 0.20 f _n 0.04	0.80 0.08	1.40 0.12																		
				060204-PFU	RE 0.4	a _p 0.20 f _n 0.05	0.80 0.11	1.40 0.17																		
				09T302-PFU	RE 0.2	a _p 0.30 f _n 0.05	1.00 0.10	1.70 0.15																		
			09T304-PFU	RE 0.4	a _p 0.30 f _n 0.06	1.00 0.14	1.70 0.22																			
			09T308-PFU	RE 0.8	a _p 0.30 f _n 0.08	1.00 0.16	1.70 0.24																			
MEDIUM	<p>ground chipbreaker, picture: right-hand</p>	PPM P M	CCET	09T304%-PPM	RE 0.4	a _p 0.50 f _n 0.04	1.50 0.07	2.50 0.10																		
	<p>general purpose</p>	PMU P M K	CCMT	060202-PMU	RE 0.2	a _p 0.50 f _n 0.05	1.50 0.10	2.50 0.15																		
				060204-PMU	RE 0.4	a _p 0.50 f _n 0.06	1.50 0.13	2.50 0.20																		
				060208-PMU	RE 0.8	a _p 0.50 f _n 0.08	1.50 0.16	2.50 0.24																		
				09T302-PMU	RE 0.2	a _p 0.60 f _n 0.06	1.80 0.13	3.00 0.20																		
				09T304-PMU	RE 0.4	a _p 0.60 f _n 0.07	1.80 0.16	3.00 0.25																		
				09T308-PMU	RE 0.8	a _p 0.60 f _n 0.08	1.80 0.19	3.00 0.30																		
				120404-PMU	RE 0.4	a _p 0.80 f _n 0.08	2.20 0.17	3.60 0.26																		
				120408-PMU	RE 0.8	a _p 0.80 f _n 0.10	2.20 0.22	3.60 0.32																		
		120412-PMU	RE 1.2	a _p 0.80 f _n 0.12	2.20 0.24	3.60 0.36																				

● stock standard, ○ non-standard stock



CC	CARBIDE Positive					ISO513	HC-CVD						HC-PVD		HW		HT				
	Size	IC	S	D1	AN		JC7010	JC7020	JC8005	JC8015	JC8025	JC9010	JC9025	JPS015	JPS025	JPS010	JU6010	JU6020	JU4015	JP4020	
	MICRO CC	3.50	1.40	1.90	7°	P			200 380	180 360	140 300		80 220	60 180				200 380	200 400		
	0602□□	6.35	2.38	2.80	7°	M					150 280	120 240	80 160	60 120				160 280	160 300		
	0602□□	6.35	2.38	2.80	7°	K	180 380	150 300						80 170				200 400	200 420		
	09T3□□	9.525	3.97	4.40	7°	N									600 2200	600 2000	500 1500				
	1204□□	12.70	4.76	5.50	7°	S							40 80								
						H															
GRADE APPLICATION AREA	Stable machining, continuous cut																				
main application	General machining, light interruption																				
applicable	Unstable machining, interrupted cut																				
MEDIUM polished surface	CCGX	060202-PMN	RE 0.2	a _p 0.30 f _n 0.05	1.50 0.10	2.70 0.15															
		060204-PMN	RE 0.4	a _p 0.30 f _n 0.06	1.50 0.13	2.70 0.20															
		060208-PMN	RE 0.8	a _p 0.30 f _n 0.08	1.50 0.16	2.70 0.24										○	○	●			
	CCGX	09T302-PMN	RE 0.2	a _p 0.50 f _n 0.06	2.00 0.11	3.50 0.16									○	●					
		09T304-PMN	RE 0.4	a _p 0.50 f _n 0.08	2.00 0.16	3.50 0.24										●	●	●			
		09T308-PMN	RE 0.8	a _p 0.50 f _n 0.10	2.00 0.20	3.50 0.30										○	○	●			
	CCGX	120402-PMN	RE 0.2	a _p 0.50 f _n 0.08	3.00 0.14	5.50 0.20										○	●				
		120404-PMN	RE 0.4	a _p 0.50 f _n 0.10	3.00 0.20	5.50 0.30										○	●	●			
		120408-PMN	RE 0.8	a _p 0.50 f _n 0.15	3.00 0.25	5.50 0.35										○	●	●			
	ROUGHING reinforced edge	CCMT	09T304-PRU	RE 0.4	a _p 1.50 f _n 0.10	2.50 0.19	3.50 0.28	●			●										
09T308-PRU			RE 0.8	a _p 1.50 f _n 0.12	2.50 0.22	3.50 0.32	●			●											
CCMT		120408-PRU	RE 0.8	a _p 1.50 f _n 0.14	3.00 0.26	4.50 0.38	●			●											
		120412-PRU	RE 1.2	a _p 1.50 f _n 0.16	3.00 0.28	4.50 0.40	●			●											

● stock standard, ○ non-standard stock

TURNING

THREADING

GROOVING

MILLING

DRILLING

ACCESSORIES

