



For more information

Cermet grades for steel finishing turning

NS/AT9530

Tungaloy Report No. 425S1-US

New series of JS, JP chipbreaker is now available with cermet turning inserts

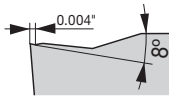
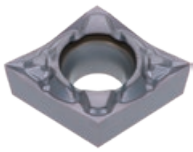


Pressed 3D chipbreaker series for small parts machining

Provides superior chip control and high parts quality in combination with cermet grades

New

I JP First choice chipbreaker for high precision finishing



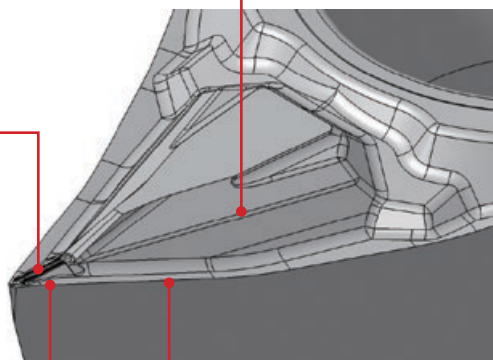
Eliminates chip nesting and other chip-associated issues that impede the shop's productivity and provides stable chip breaking over a wide range of feed rates and D.O.C.

- Effective chip breaking for high parts quality
- Versatile geometry designed for a broad application range
- Eliminates burr generation and controls vibration during aggressive D.O.C.

Secondary rake with multiple facets

Guides and redirects chips generated during machining at great cutting depths

A protrusion extending towards the nose radius
Provides excellent chip control in finish to super-finish cutting



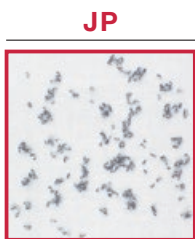
Cutting edge with a steep inclination angle

- For better chip evacuation
- For reduced cutting loads

Primary rake with variable angles

Controls the generation of burrs and vibration when machining at a maximum cutting depth capability

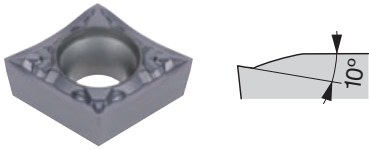
■ Chip control comparison



P Insert : DCGT 32.50 FN-JP NS9530
 Workpiece material : S45C / C45
 Cutting speed : $V_c = 262$ sfm
 Feed : $f = 0.0008$ ipr
 Depth of cut : $a_p = 0.19$ "
 Coolant : Wet

P Insert : DCGT 32.50 FN-JP NS9530
 Workpiece material : S45C / C45
 Cutting speed : $V_c = 262$ sfm
 Feed : $f = 0.0012$ ipr
 Depth of cut : $a_p = 0.002$ "
 Coolant : Wet

JS First choice chipbreaker for finish cutting



Chipbreaker geometry that allows light cutting action and excellent chip breaking

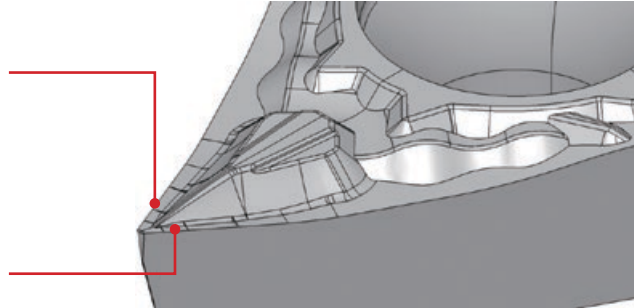
- A steep cutting edge inclination angle for better chip control and reduced cutting load
- A unique protrusion that extends towards the radius effectively controls chip flow from small to large cutting depths

Cutting edge with a steep inclination angle

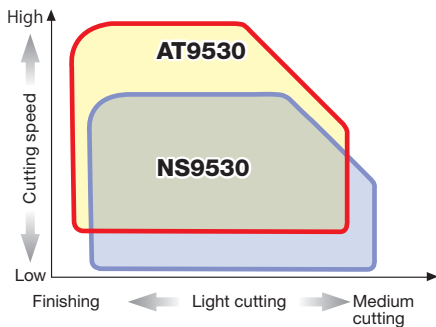
Provides good chip evacuation and reduced cutting loads

Rake with variable angles and steep protrusion

Provides stable chip control in the small to large cutting depth range and also maintains cutting edge integrity and sharpness over extended period of time



Application range



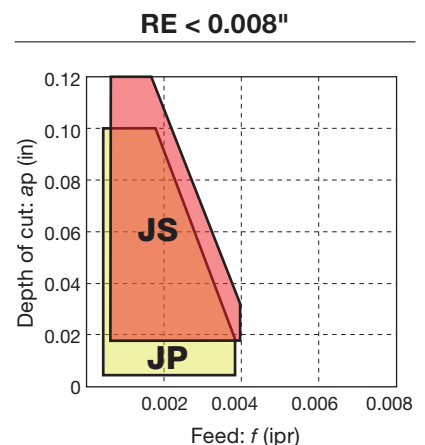
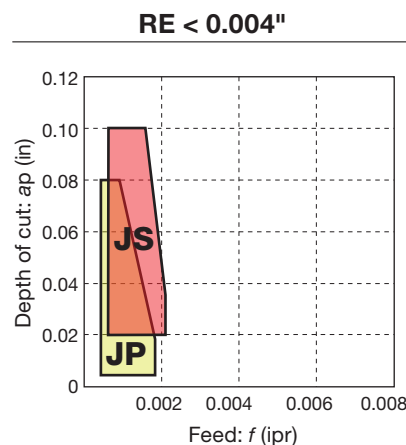
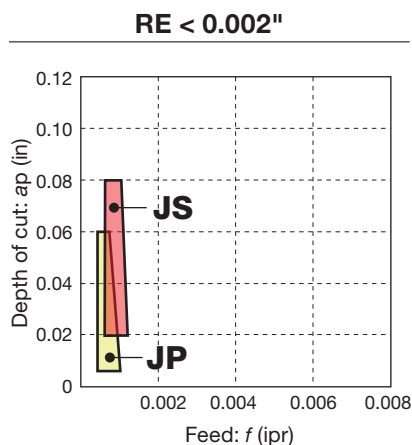
AT9530

- Coated cermet grade with excellent wear resistance in high-speed finishing
- The 1st recommendation for machining alloy steel due to its outstanding wear resistance.

NS9530

- Versatile cermet grade with incredible fracture and wear resistance.
- Provides long tool life and excellent surface appearance in finishing to medium cutting of steels.

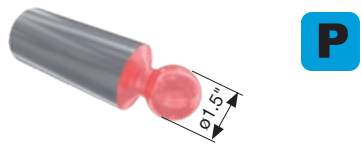


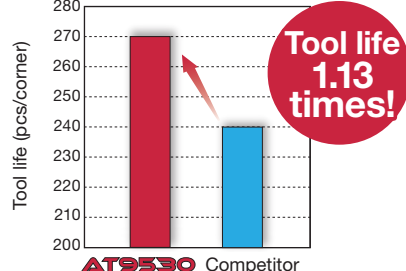
Chip control range



STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Chipbreaker	Grade	Cutting speed Vc (sfm)	Depth of cut ap (in)	Feed: f (ipr)			
						RE < 0.002"	RE < 0.004"	RE < 0.008"	RE < 0.016"
P	Carbon steel Alloy steel	JP	NS9530	492 - 820	0.002 - 0.098	0.0008 - 0.0012	0.0008 - 0.0020	0.0008 - 0.0039	-
			AT9530	492 - 984	0.002 - 0.098	0.0008 - 0.0012	0.0008 - 0.0020	0.0008 - 0.0039	-
		JS	NS9530	492 - 820	0.020 - 0.118	0.0008 - 0.0012	0.0008 - 0.0020	0.0008 - 0.0039	0.0020 - 0.0079
			AT9530	492 - 984	0.020 - 0.118	0.0008 - 0.0012	0.0008 - 0.0020	0.0008 - 0.0039	0.0020 - 0.0079

PRACTICAL EXAMPLES

Workpiece type	Piston shoe	Automotive part
Insert	VBGT 221 N-JS	DCGT 32.50.5 FN-JP
Grade	AT9530	NS9530
Workpiece material	SCM440 / 42CrMo4	SCM435 / 34CrMo4
		
Cutting conditions	Cutting speed: V_c (sfm)	656
	Feed : f (ipr)	0.002 - 0.004
	Depth of cut : a_p (in)	0.020
	Coolant	Wet
Results	 <p>Improved chip control</p> <p>Chips formed by JS chipbreaker</p> <p>JS chipbreaker significantly reduced bird nesting of chips, while improving part surface quality.</p>	 <p>Tool life (pcs/corner)</p> <p>280 270 260 250 240 230 220 210 200</p> <p>270 240</p> <p>AT9530 Competitor</p> <p>Tool life 1.13 times!</p> <p>Provided 1.13 times tool life increase over the competitor.</p>

Tungaloy-NTK America Inc.

United States

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.

Inside Sales: +1-888-554-8394

Technical Support: +1-888-554-8391

Fax: +1-888-554-8392

www.tungaloy.com/us

Canada

432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada

Phone: +1-519-758-5779 Fax: +1-519-758-5791

www.tungaloy.com/ca

Mexico

C Los Arellano 113, Parque Industrial Siglo XXI

Aguascalientes, AGS, Mexico 20290

Phone: +52-449-929-5410 Fax: +52-449-929-5411

www.tungaloy.com/mx



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