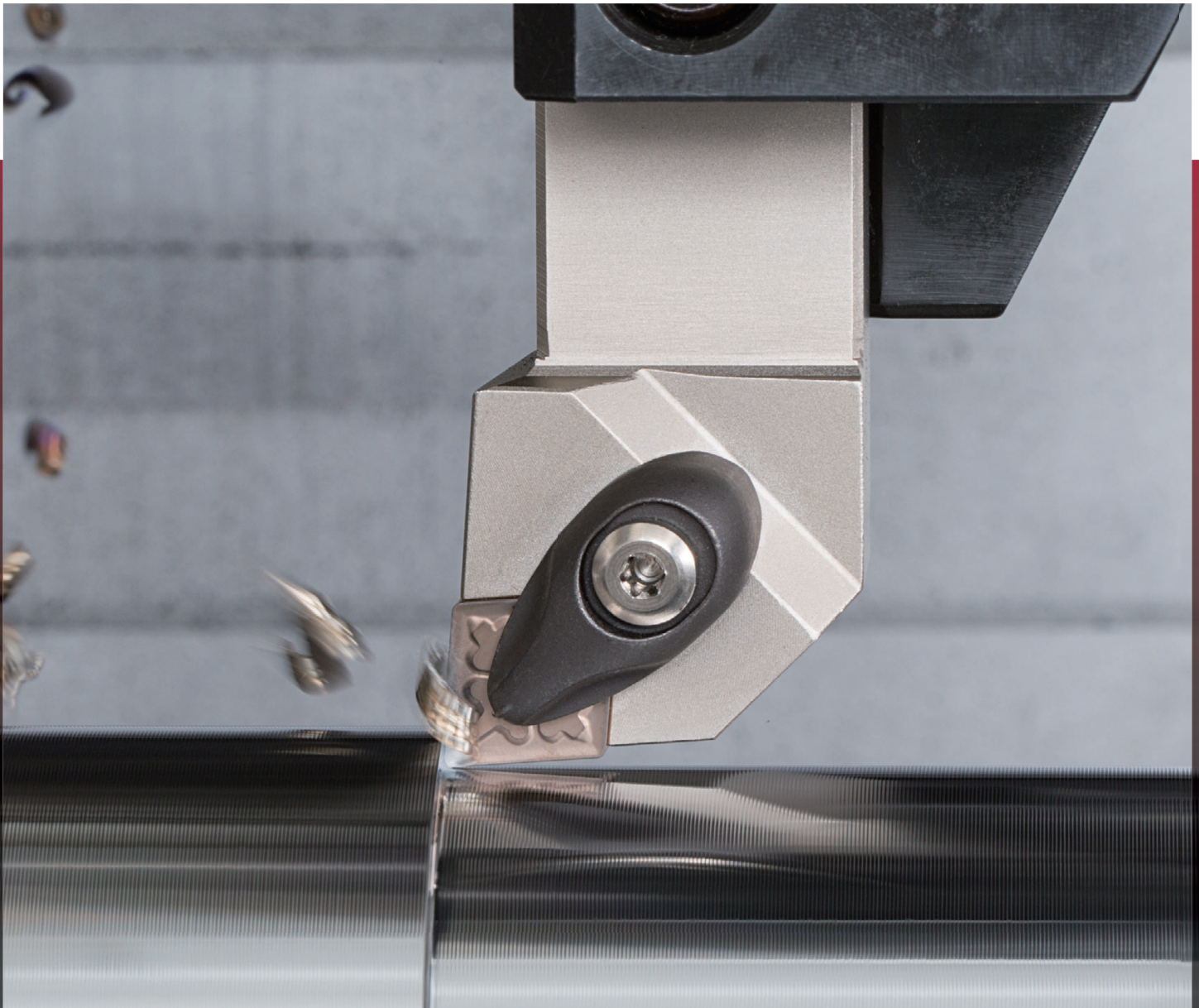


T9200 SERIES

Tungaloy Report No. 513S1-US

PS and PM chipbreakers are now available on negative inserts for steel turning





The T9200 series now offers new chipbreaker geometries **PS and PM** for steel turning

PREMIUMTEC

A new surface treatment technology is applied, making T9200 series hard to break

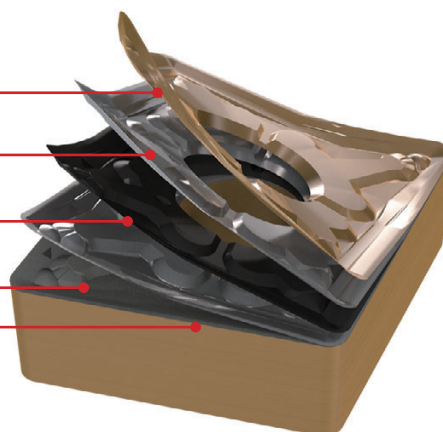
Outermost layer

Ti-layer

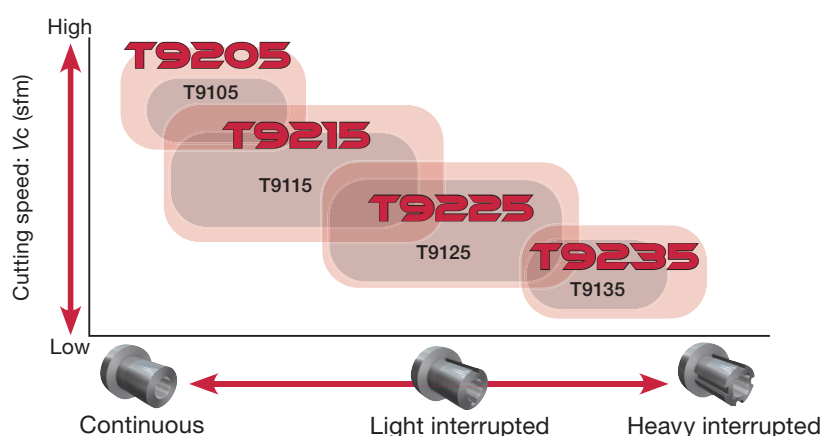
Al₂O₃

Ti compound

Specially designed substrate



APPLICATION AREA

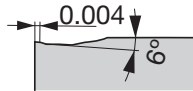


Application	Grade	Substrate			Coating layer	
		Specific gravity	Hardness (HRA)	T.R.S. (GPa)	Main composition	Thickness (μm)
P	T9205	14.2	91.5	2.4	Ti compound + Al ₂ O ₃	18
	T9215	14	90.5	2.6	Ti compound + Al ₂ O ₃	18
	T9225	13.8	89.8	2.7	Ti compound + Al ₂ O ₃	18
	T9235	13.6	89	2.7	Ti compound + Al ₂ O ₃	18

New chipbreaker geometries for steel turning

New

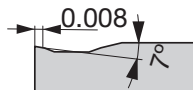
PS



Unique geometry to provide better crater wear resistance and chip control during turning at light cutting depths.

New

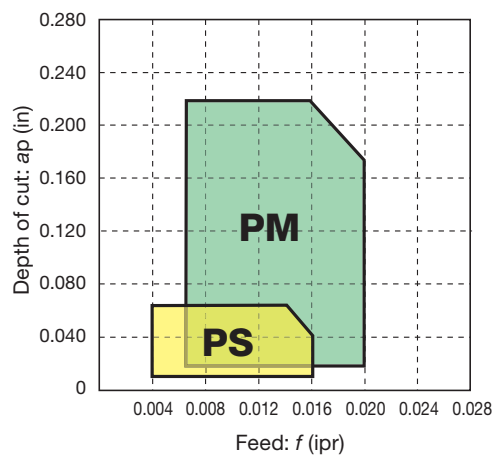
PM



Versatile geometry with optimized cutting edge design to provide superior chip control in wide range of applications.

New

Chipbreakers (complementary)

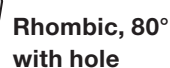
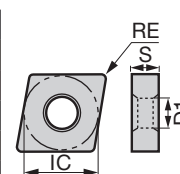


STANDARD CUTTING CONDITIONS

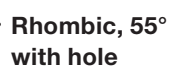
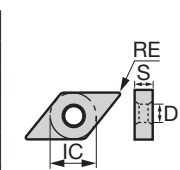
ISO	Operation	Chipbreaker	Grade	Depth of cut a_p (in)	Feed f (ipr)	Cutting speed: V_c (sfm)		
						Low carbon steels, alloy steels	Medium carbon steels, alloy steels	High carbon steels, alloy steels
P	Finishing	New PS	T9215	0.012 - 0.059	0.004 - 0.016	492 - 1312	492 - 1312	394 - 984
			T9225	0.012 - 0.059	0.004 - 0.016	394 - 984	394 - 984	328 - 820
	Medium cutting	New PM	T9215	0.020 - 0.217	0.006 - 0.020	492 - 1312	492 - 1312	394 - 984
			T9225	0.020 - 0.217	0.006 - 0.020	394 - 984	394 - 984	328 - 820

Insert **NEGATIVE TYPE**

CN

[illegible][illegible]

DN

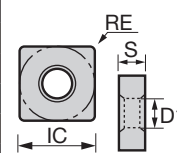
[illegible][illegible]

● : New

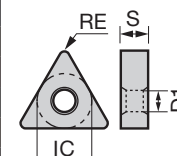
- : Continuous cutting
- ◐ : Light interrupted cutting
- ⊗ : Heavy interrupted cutting

**Square, 90°
with hole**

	P	M	K	N	S	H
Steel	● ● ☒					
Stainless	● ●					
Cast iron	● ●					
Non-ferrous						
Superalloy						
Hard material						

[illegible]

**Triangular, 60°
with hole**

[illegible][illegible]

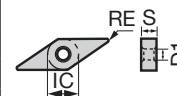
● : New

Insert **NEGATIVE TYPE**

VN



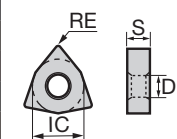
**Rhombic, 35°
with hole**

[illegible][illegible]

WN



**Trigon, 80°
with hole**

[illegible][illegible]

● : New

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