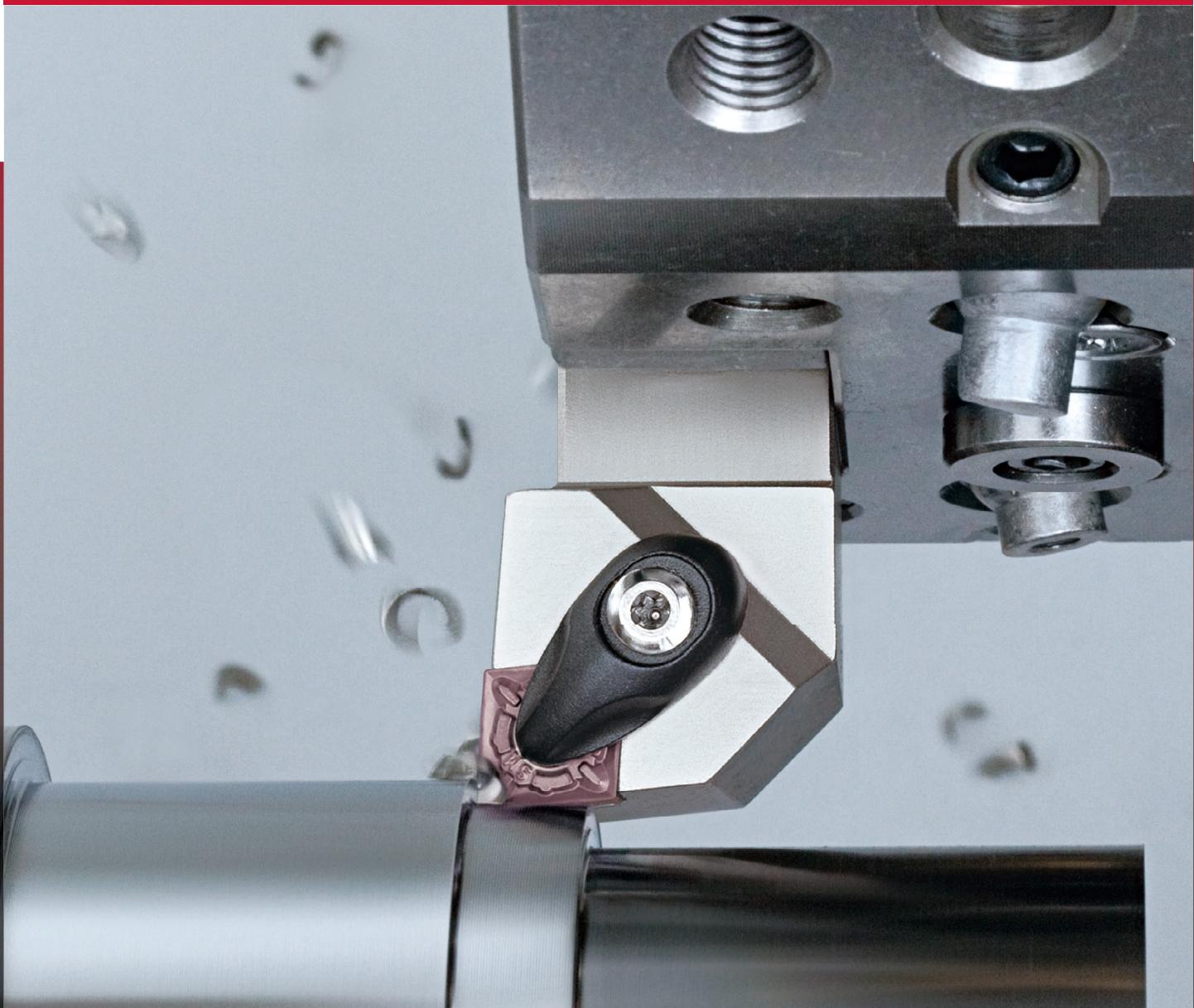


AH6225

Tungaloy Report No. 540-US

A new generation of PVD grade for stainless steel turning!





INDUSTRY 4.0
FEED the SPEED!

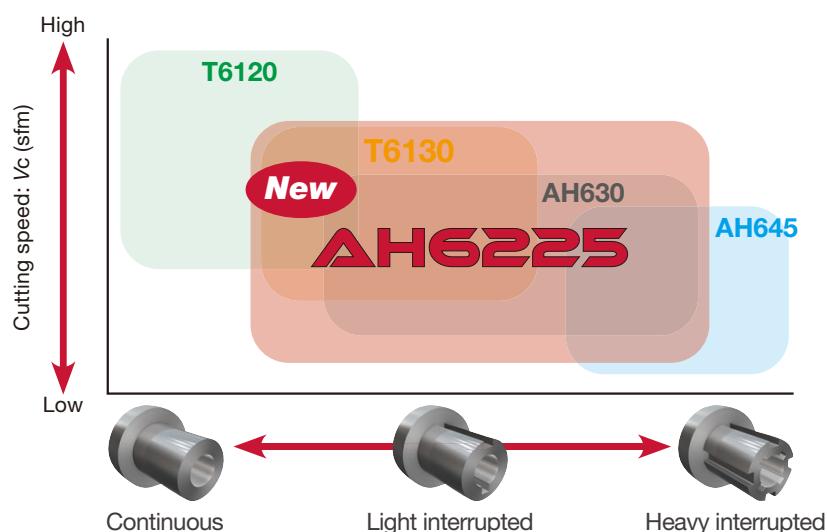


AH6225



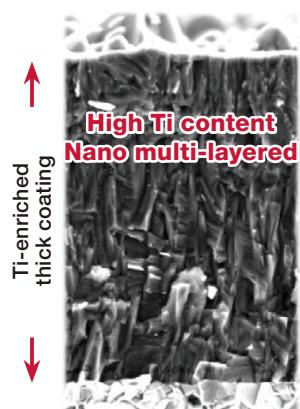
New grade for reliability in stainless steel turning!

AH6225 is our new versatile solution for all your challenges in stainless steel machining!



New

AH6225



Versatile PVD-coated grade

Ti-enriched coating

- Thick Ti-enriched PVD coating for enhanced thermal shock resistance
- Reduced crater wear

High Ti-content nano-structured multilayer coating

The outer layer consists of a high Ti-content nano-structured multilayer made possible by Tungaloy's latest coating technology. Its high hardness and nano structure provides the grade with a good balance of wear and fracture resistance, enhancing tool life and predictability.

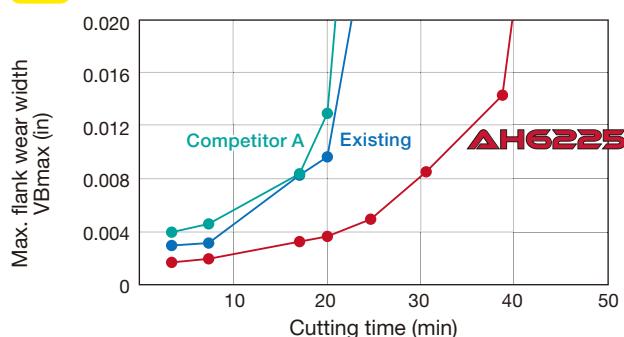
Dedicated carbide substrate

Thanks to high thermal conductivity of the substrate, heat generated during machining is dissipated, efficiently reducing temperature on the cutting edge. This provides edge toughness, while reducing plastic deformation of the cutting edge. Ideal for continuous cuts.

ISO	Grade	Substrate			Coating layer	
		Specific gravity	Hardness (HRA)	T.R.S. (GPa)	Main composition	Thickness (µm)
M	AH6225	14.9	91.8	3.1	(TiAl)N - Ti(CN)	5.5

CUTTING PERFORMANCE

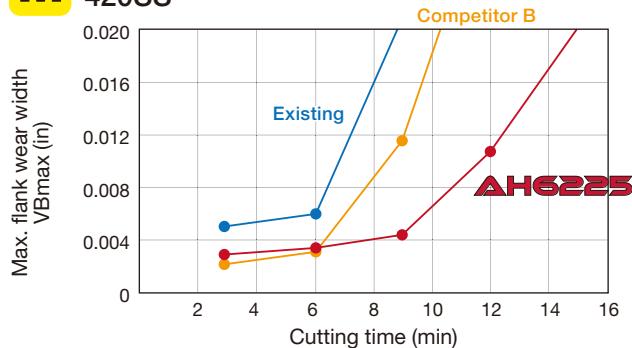
M Austenitic stainless steel 316SS



Cutting speed : $V_c = 490$ sfm
 Feed : $f = 0.012$ ipr
 Depth of cut : $ap = 0.079"$
 Machining : Continuous cutting
 Coolant : Wet

AH6225 showed excellent wear resistance in austenitic stainless steel machining.

M Martensitic stainless steel 420SS

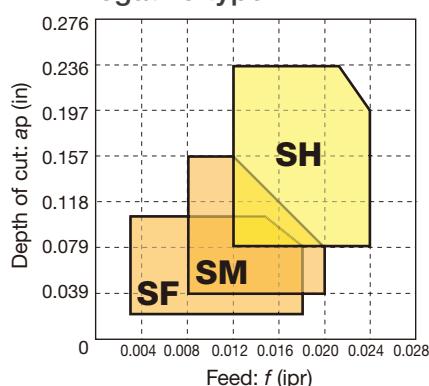


Cutting speed : $V_c = 660$ sfm
 Feed : $f = 0.012$ ipr
 Depth of cut : $ap = 0.079"$
 Machining : Continuous cutting
 Coolant : Wet

AH6225 showed excellent wear resistance in martensitic stainless steel machining.

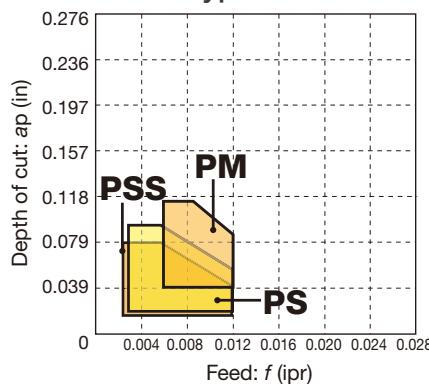
STANDARD CUTTING CONDITIONS

Negative type



Workpiece material	Grade	Chipbreaker	Cutting speed V_c (sfm)	Depth of cut ap (in)	Feed f (ipr)
Austenitic stainless steel	AH6225	SF	300 - 660	0.020 - 0.098	0.003 - 0.018
	AH6225	SM	300 - 660	0.039 - 0.157	0.008 - 0.020
	AH6225	SH	300 - 660	0.079 - 0.236	0.012 - 0.024
Ferritic / martensite stainless steel	AH6225	SF	360 - 790	0.020 - 0.098	0.003 - 0.018
	AH6225	SM	360 - 790	0.039 - 0.157	0.008 - 0.020
	AH6225	SH	360 - 790	0.079 - 0.236	0.012 - 0.024
Precipitation hardened stainless steel	AH6225	SF	200 - 360	0.020 - 0.098	0.003 - 0.018
	AH6225	SM	200 - 360	0.039 - 0.157	0.008 - 0.020
	AH6225	SH	200 - 360	0.079 - 0.236	0.012 - 0.024

Positive type



Workpiece material	Grade	Chipbreaker	Cutting speed V_c (sfm)	Depth of cut ap (in)	Feed f (ipr)
Austenitic stainless steel	AH6225	PSS	300 - 660	0.012 - 0.079	0.003 - 0.012
	AH6225	PS	300 - 660	0.020 - 0.098	0.003 - 0.012
	AH6225	PM	300 - 660	0.039 - 0.118	0.006 - 0.012
Ferritic / martensite stainless steel	AH6225	PSS	360 - 790	0.012 - 0.079	0.003 - 0.012
	AH6225	PS	360 - 790	0.020 - 0.098	0.003 - 0.012
	AH6225	PM	360 - 790	0.039 - 0.118	0.006 - 0.012
Precipitation hardened stainless steel	AH6225	PSS	200 - 360	0.012 - 0.079	0.003 - 0.012
	AH6225	PS	200 - 360	0.020 - 0.098	0.003 - 0.012
	AH6225	PM	200 - 360	0.039 - 0.118	0.006 - 0.012

AH6225

Insert

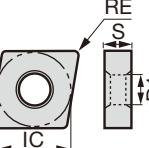
NEGATIVE TYPE

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

CN



**Rhombic, 80°
with hole**

CN		P	Steel	+														
		M	Stainless	●														
		K	Cast iron		+													
		N	Non-ferrous			+												
		S	Superalloy				+											
		H	Hard material					+										
 Rhombic, 80° with hole																		
Application	Designation		Coated												Dimension (in)			
Chipbreaker				AH6225														
		Inch		Metric											RE	IC	S	D1
 SF		CNMG 431 SF	CNMG120404-SF	●											0.016	0.500	0.188	0.203
 Finishing		CNMG 432 SF	CNMG120408-SF	●											0.031	0.500	0.188	0.203
 CNMG 433 SF		CNMG120412-SF	CNMG120412-SF	●											0.047	0.500	0.188	0.203
 SS		CNMG 431 SS	CNMG120404-SS	●											0.016	0.500	0.188	0.203
 CNMG 432 SS		CNMG120408-SS	CNMG120408-SS	●											0.031	0.500	0.188	0.203
 CNMG 433 SS		CNMG120412-SS	CNMG120412-SS	●											0.047	0.500	0.188	0.203
 SM		CNMG 431 SM	CNMG120404-SM	●											0.016	0.500	0.188	0.203
 CNMG 432 SM		CNMG120408-SM	CNMG120408-SM	●											0.031	0.500	0.188	0.203
 CNMG 433 SM		CNMG120412-SM	CNMG120412-SM	●											0.047	0.500	0.188	0.203
 SA		CNMG 431 SA	CNMG120404-SA	●											0.016	0.500	0.188	0.203
 CNMG 432 SA		CNMG120408-SA	CNMG120408-SA	●											0.031	0.500	0.188	0.203
 CNMG 433 SA		CNMG120412-SA	CNMG120412-SA	●											0.047	0.500	0.188	0.203
 S		CNMG 431 R-S	CNMG120404R-S	●											0.016	0.500	0.188	0.203
 CNMG 431 L-S		CNMG120404L-S	CNMG120404L-S	●											0.016	0.500	0.188	0.203
 CNMG 432 R-S		CNMG120408R-S	CNMG120408R-S	●											0.031	0.500	0.188	0.203
CNMG 432 L-S		CNMG120408L-S	CNMG120408L-S	●											0.031	0.500	0.188	0.203
SH		CNMG 432 SH	CNMG120408-SH	●											0.031	0.500	0.188	0.203
CNMG 433 SH		CNMG120412-SH	CNMG120412-SH	●											0.047	0.500	0.188	0.203
CNMG 434 SH		CNMG120416-SH	CNMG120416-SH	●											0.063	0.500	0.188	0.203

● : New product

Insert

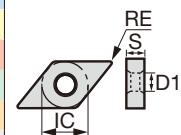
NEGATIVE TYPE

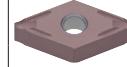
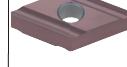
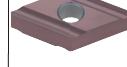
- : Continuous cutting
- : Light interrupted cutting
- : Heavy interrupted cutting

DN

 Rhombic, 55° with hole

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



Application	Chipbreaker	Designation	Coated	Dimension (in)					
				Inch	Metric	RE	IC	S	D1
Finishing	 SF	DNMG 431 SF	DNMG150404-SF	●					
		DNMG 432 SF	DNMG150408-SF	●					
		DNMG 441 SF	DNMG150604-SF	●					
		DNMG 442 SF	DNMG150608-SF	●					
Medium cutting	 SS	DNMG 431 SS	DNMG150404-SS	●					
		DNMG 432 SS	DNMG150408-SS	●					
		DNMG 433 SS	DNMG150412-SS	●					
		DNMG 441 SS	DNMG150604-SS	●					
Medium to heavy cutting	 SM	DNMG 431 SM	DNMG150404-SM	●					
		DNMG 432 SM	DNMG150408-SM	●					
		DNMG 433 SM	DNMG150412-SM	●					
		DNMG 441 SM	DNMG150604-SM	●					
 S	 S	DNMG 431 R-S	DNMG150404R-S	●					
		DNMG 431 L-S	DNMG150404L-S	●					
		DNMG 432 R-S	DNMG150408R-S	●					
		DNMG 432 L-S	DNMG150408L-S	●					
 SH	 SH	DNMG 441 R-S	DNMG150604R-S	●					
		DNMG 441 L-S	DNMG150604L-S	●					
		DNMG 442 R-S	DNMG150608R-S	●					
		DNMG 442 L-S	DNMG150608L-S	●					

● : New product

AH6225

Insert NEGATIVE TYPE

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

SN



**Square, 90°
with hole**

Application	Designation	Coated					Dimension (in)	
			AH6225				RE	IC
Finishing	SF 	SNMG 431 SF	SNMG120404-SF	●				0.016 0.500 0.187 0.203
		SNMG 432 SF	SNMG120408-SF	●				0.031 0.500 0.187 0.203
	SS 	SNMG 431 SS	SNMG120404-SS	●				0.016 0.500 0.187 0.203
		SNMG 432 SS	SNMG120408-SS	●				0.031 0.500 0.187 0.203
Medium cutting	SM 	SNMG 432 SM	SNMG120408-SM	●				0.031 0.500 0.187 0.203
		SNMG 433 SM	SNMG120412-SM	●				0.047 0.500 0.187 0.203
	SA 	SNMG 431 SA	SNMG120404-SA	●				0.016 0.500 0.187 0.203
		SNMG 432 SA	SNMG120408-SA	●				0.031 0.500 0.187 0.203
Medium to heavy cutting	S 	SNMG 431 R-S	SNMG120404R-S	●				0.016 0.500 0.187 0.203
		SNMG 431 L-S	SNMG120404L-S	●				0.016 0.500 0.187 0.203
	SH 	SNMG 432 R-S	SNMG120408R-S	●				0.031 0.500 0.187 0.203
		SNMG 432 L-S	SNMG120408L-S	●				0.031 0.500 0.187 0.203

● : New product

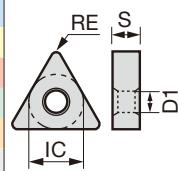
Insert NEGATIVE TYPE

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

TN



Triangular, 60° with hole



● : New product

AH6225

Insert NEGATIVE TYPE

- : Continuous cutting
- : Light interrupted cutting
- : Heavy interrupted cutting

VN



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

Application	Chipbreaker	Designation	Inch	Metric	Coated	AH6225	Dimension (in)							
							RE	IC	S	D1				
SF	VNMG 331 SF	VNMG160404-SF	●								0.016	0.375	0.187	0.150
	VNMG 332 SF	VNMG160408-SF	●								0.031	0.375	0.187	0.150
Finishing	VNMG 331 SS	VNMG160404-SS	●								0.016	0.375	0.187	0.150
	VNMG 332 SS	VNMG160408-SS	●								0.031	0.375	0.187	0.150
SS	VNMG 333 SS	VNMG160412-SS	●								0.047	0.375	0.187	0.150
SM	VNMG 331 SM	VNMG160404-SM	●								0.016	0.375	0.187	0.150
	VNMG 332 SM	VNMG160408-SM	●								0.031	0.375	0.187	0.150
Medium cutting	VNMG 333 SM	VNMG160412-SM	●								0.047	0.375	0.187	0.150

● : New product

Insert

NEGATIVE TYPE

- : Continuous cutting
- c : Light interrupted cutting
- x : Heavy interrupted cutting

WN



	P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material	RE	S	ID1
--	---------	-------------	-------------	---------------	--------------	-----------------	----	---	-----

Application	Chipbreaker	Designation		Coated	AH6225	Dimension (in)			
		Inch	Metric			RE	IC	S	D1
Finishing	SF	WNMG 431 SF	WNMG080404-SF	●					0.016 0.500 0.187 0.203
		WNMG 432 SF	WNMG080408-SF	●					0.031 0.500 0.187 0.203
Medium cutting	SS	WNMG 431 SS	WNMG080404-SS	●					0.016 0.500 0.187 0.203
		WNMG 432 SS	WNMG080408-SS	●					0.031 0.500 0.187 0.203
Medium to heavy cutting	SM	WNMG 431 SM	WNMG080404-SM	●					0.016 0.500 0.187 0.203
		WNMG 432 SM	WNMG080408-SM	●					0.031 0.500 0.187 0.203
	SA	WNMG 431 SA	WNMG080404-SA	●					0.047 0.500 0.187 0.203
		WNMG 432 SA	WNMG080408-SA	●					0.031 0.500 0.187 0.203
	SH	WNMG 432 SH	WNMG080408-SH	●					0.047 0.500 0.187 0.203
		WNMG 433 SH	WNMG080412-SH	●					0.031 0.500 0.187 0.203

● : New product

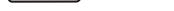
AH6225

Insert POSITIVE TYPE

- : Continuous cutting
- : Light interrupted cutting
- : Heavy interrupted cutting

CC

Rhombic, 80°
with hole
Positive 7°



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

Application	Designation	Coated	Dimension (in)					
			Inch	Metric	RE	IC		
Chipbreaker	CCMT 21.51 PSS	AH6225						
	CCMT 21.52 PSS	CCMT060208-PSS	●		0.016	0.250	0.094	0.110
	CCMT 32.51 PSS	CCMT09T304-PSS	●		0.031	0.250	0.094	0.110
	CCMT 32.52 PSS	CCMT09T308-PSS	●		0.016	0.375	0.156	0.173
Finishing to light cutting	CCMT 21.50.5 PS	CCMT060202-PS	●		0.008	0.250	0.094	0.110
	CCMT 21.51 PS	CCMT060204-PS	●		0.016	0.250	0.094	0.110
	CCMT 21.52 PS	CCMT060208-PS	●		0.031	0.250	0.094	0.110
	CCMT 32.50.5 PS	CCMT09T302-PS	●		0.008	0.375	0.156	0.173
	CCMT 32.51 PS	CCMT09T304-PS	●		0.016	0.375	0.156	0.173
	CCMT 32.52 PS	CCMT09T308-PS	●		0.031	0.375	0.156	0.173
Finishing to medium cutting	CCMT 21.51 PM	CCMT060204-PM	●		0.016	0.250	0.094	0.110
	CCMT 21.52 PM	CCMT060208-PM	●		0.031	0.250	0.094	0.110
	CCMT 32.51 PM	CCMT09T304-PM	●		0.016	0.375	0.156	0.173
	CCMT 32.52 PM	CCMT09T308-PM	●		0.031	0.375	0.156	0.173
Medium cutting	CCMT 21.51 PSS	CCMT060208-PSS			0.016	0.250	0.094	0.110
	CCMT 21.52 PSS	CCMT060208-PSS			0.031	0.250	0.094	0.110
	CCMT 32.51 PSS	CCMT09T304-PSS			0.016	0.375	0.156	0.173
	CCMT 32.52 PSS	CCMT09T308-PSS			0.031	0.375	0.156	0.173

● : New product

Insert POSITIVE TYPE

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

CP

**Rhombic, 80°
with hole
Positive 11°**



Application	Designation	Coated									Dimension (in)			
			AH6225								RE	IC	S	D1
Finishing to light cutting	Inch	Metric									0.016	0.375	0.125	0.173
	PSS	CPMT 321 PSS	CPMT090304-PSS	●							0.031	0.375	0.125	0.173
Finishing to medium cutting											0.016	0.375	0.125	0.173
Medium cutting	PS	CPMT 321 PS	CPMT090304-PS	●							0.016	0.375	0.125	0.173
											0.031	0.375	0.125	0.173
Medium cutting	PM	CPMT 321 PM	CPMT090304-PM	●							0.016	0.375	0.125	0.173
											0.031	0.375	0.125	0.173

● : New product

AH6225

Insert POSITIVE TYPE

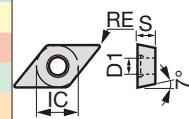
- : Continuous cutting
- : Light interrupted cutting
- : Heavy interrupted cutting

DC

Rhombic, 55°
with hole
Positive 7°



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



Application	Designation	Coated	Dimension (in)					
			Inch	Metric	RE	IC		
Finishing to light cutting	PSS	DCMT 21.51 PSS DCMT070204-PSS	●		0.016	0.250	0.094	0.110
		DCMT 32.51 PSS DCMT11T304-PSS	●		0.016	0.375	0.156	0.173
		DCMT 32.52 PSS DCMT11T308-PSS	●		0.031	0.375	0.156	0.173
Finishing to medium cutting	PS	DCMT 21.51 PS DCMT070204-PS	●		0.016	0.250	0.094	0.110
		DCMT 32.50.5 PS DCMT11T302-PS	●		0.008	0.375	0.156	0.173
		DCMT 32.51 PS DCMT11T304-PS	●		0.016	0.375	0.156	0.173
Medium cutting	PM	DCMT 21.51 PM DCMT070204-PM	●		0.016	0.250	0.094	0.110
		DCMT 32.51 PM DCMT11T304-PM	●		0.016	0.375	0.156	0.173
		DCMT 32.52 PM DCMT11T308-PM	●		0.031	0.375	0.156	0.173

● : New product

Insert POSITIVE TYPE

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



Application	Designation	Coated					Dimension (in)							
			AH6225								RE	IC	S	D1
Finishing to medium cutting	Inch	Metric									0.016	0.375	0.156	0.173
	PS	SCMT 32.51 PS	SCMT09T304-PS	●							0.031	0.375	0.156	0.173
Medium cutting		SCMT 32.52 PS	SCMT09T308-PS	●										
PM		SCMT 32.51 PM	SCMT09T304-PM	●							0.016	0.375	0.156	0.173
		SCMT 32.52 PM	SCMT09T308-PM	●							0.031	0.375	0.156	0.173

● : New product

AH6225

Insert POSITIVE TYPE

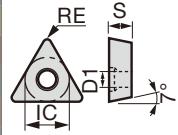
- : Continuous cutting
- : Light interrupted cutting
- : Heavy interrupted cutting

TC

Triangular, 60°
with hole
Positive 7°



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



Application	Designation	Coated	Dimension (in)			
			RE	IC	S	D1
Chipbreaker	Inch Metric	AH6225				
PS		TCMT 21.51 PS TCMT110204-PS	●			
		TCMT 21.52 PS TCMT110208-PS	●			
		TCMT 32.51 PS TCMT16T304-PS	●			
		TCMT 32.52 PS TCMT16T308-PS	●			
Finishing to medium cutting						
Medium cutting	PM		TCMT 21.51 PM TCMT110204-PM	●		
			TCMT 21.52 PM TCMT110208-PM	●		
			TCMT 32.51 PM TCMT16T304-PM	●		
			TCMT 32.52 PM TCMT16T308-PM	●		

● : New product

Insert POSITIVE TYPE

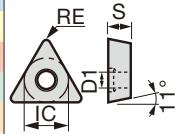
- : Continuous cutting
- : Light interrupted cutting
- : Heavy interrupted cutting

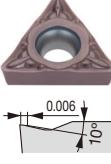
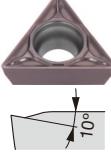
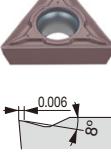
TP

Triangular, 60°
with hole
Positive 11°



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



Application	Designation			Coated	Dimension (in)													
	Inch	Metric			RE	IC	S	D1										
Finishing to light cutting		TPMT 731 PSS	TPMT090204-PSS	●											0.016	0.219	0.094	0.098
		TPMT 732 PSS	TPMT090208-PSS	●											0.031	0.219	0.094	0.098
		TPMT 21.51 PSS	TPMT110204-PSS	●											0.016	0.250	0.094	0.110
		TPMT 221 PSS	TPMT110304-PSS	●											0.016	0.250	0.125	0.134
		TPMT 2.521 PSS	TPMT130304-PSS	●											0.016	0.313	0.125	0.134
		TPMT 2.522 PSS	TPMT130308-PSS	●											0.031	0.313	0.125	0.134
		TPMT 32.51 PSS	TPMT16T304-PSS	●											0.016	0.375	0.156	0.173
		TPMT 32.52 PSS	TPMT16T308-PSS	●											0.031	0.375	0.156	0.173
Finishing to medium cutting		TPMT 730.5 PS	TPMT090202-PS	●											0.008	0.219	0.094	0.098
		TPMT 731 PS	TPMT090204-PS	●											0.016	0.219	0.094	0.098
		TPMT 732 PS	TPMT090208-PS	●											0.031	0.219	0.094	0.098
		TPMT 21.51 PS	TPMT110204-PS	●											0.016	0.250	0.094	0.110
		TPMT 221 PS	TPMT110304-PS	●											0.016	0.250	0.125	0.134
		TPMT 2.521 PS	TPMT130304-PS	●											0.016	0.313	0.125	0.134
		TPMT 2.522 PS	TPMT130308-PS	●											0.031	0.313	0.125	0.134
		TPMT 32.51 PS	TPMT16T304-PS	●											0.016	0.375	0.156	0.173
Medium cutting		TPMT 32.52 PS	TPMT16T308-PS	●											0.031	0.375	0.156	0.173
		TPMT 731 PM	TPMT090204-PM	●											0.016	0.219	0.094	0.098
		TPMT 732 PM	TPMT090208-PM	●											0.031	0.219	0.094	0.098
		TPMT 21.51 PM	TPMT110204-PM	●											0.016	0.250	0.094	0.110
		TPMT 221 PM	TPMT110304-PM	●											0.016	0.250	0.125	0.134
		TPMT 2.521 PM	TPMT130304-PM	●											0.016	0.313	0.125	0.134
		TPMT 2.522 PM	TPMT130308-PM	●											0.031	0.313	0.125	0.134
		TPMT 32.51 PM	TPMT16T304-PM	●											0.016	0.375	0.156	0.173
		TPMT 32.52 PM	TPMT16T308-PM	●											0.031	0.375	0.156	0.173

● : New product

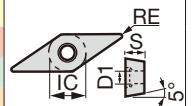
AH6225

Insert POSITIVE TYPE

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

VB

Rhombic, 35°
with hole
Positive 5°

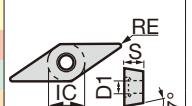


Application	Designation	Coated					Dimension (in)	
			AH6225				RE	IC
Finishing to light cutting	Inch	Metric						S D1
	PSS	VBMT 221 PSS	VBMT110304-PSS	●				0.016 0.250 0.125 0.110
		VBMT 222 PSS	VBMT110308-PSS	●				0.031 0.250 0.125 0.110
		VBMT 331 PSS	VBMT160404-PSS	●				0.016 0.375 0.187 0.173
		VBMT 332 PSS	VBMT160408-PSS	●				0.031 0.375 0.187 0.173
Finishing to medium cutting								
	PS	VBMT 221 PS	VBMT110304-PS	●				0.016 0.250 0.125 0.110
		VBMT 222 PS	VBMT110308-PS	●				0.031 0.250 0.125 0.110
		VBMT 331 PS	VBMT160404-PS	●				0.016 0.375 0.187 0.173
		VBMT 332 PS	VBMT160408-PS	●				0.031 0.375 0.187 0.173

● : New product

VC

Rhombic, 35°
with hole
Positive 7°



● : New product

PRACTICAL EXAMPLES

Workpiece type	Joint part	Ball valve part	
Insert	CNMG120404-SM	CNMG120408-SM	
Grade	AH6225	AH6225	
Workpiece material			
Cutting conditions	Cutting speed: V_c (sfm) Feed : f (ipr) Depth of cut : ap (in) Machining Coolant	260 0.004 0.039 External turning Wet	490 0.008 0.059 External turning Wet
Results	<p>AH6225 doubled tool life and significantly reduced premature insert failure, helping the customer gain productivity.</p>	<p>AH6225 eliminated tool life unpredictability such as premature insert failures, while satisfying the tool life requirement of 20 pcs per edge.</p>	
Workpiece type	Coupling part	Machine part	
Insert	TNMG160408-SM	VNMG160404-SF	
Grade	AH6225	AH6225	
Workpiece material			
Cutting conditions	Cutting speed: V_c (sfm) Feed : f (ipr) Depth of cut : ap (in) Machining Coolant	490 0.010 0.039 External turning Wet	330 0.004 0.020 External turning Wet
Results	<p>AH6225 significantly reduced notch wear, while increasing tool life to 100 pcs per edge surpassing the required tool life of 60 pcs per edge.</p>	<p>AH6225 doubled tool life, allowing the customer to gain productivity.</p>	

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