



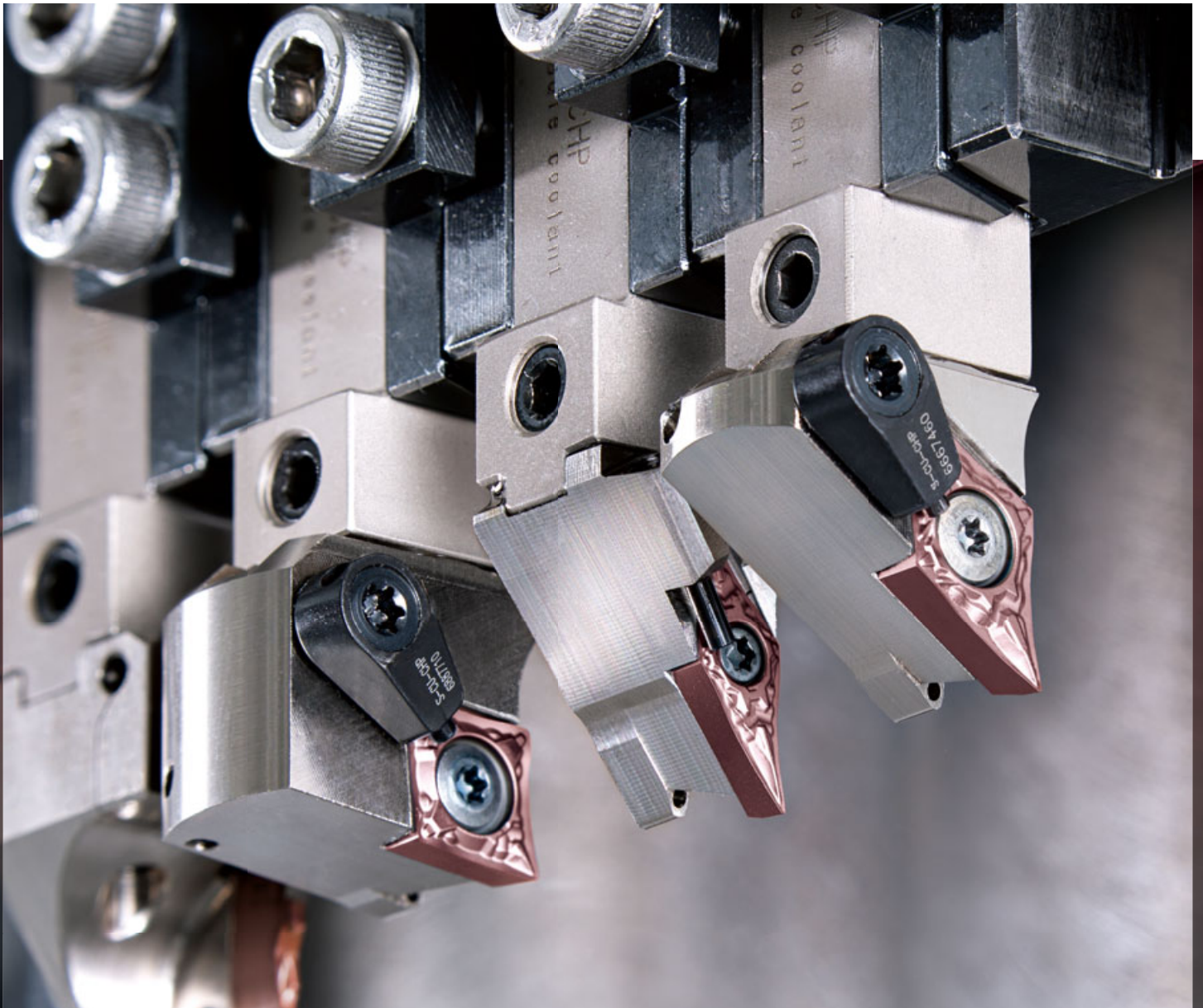
For more information

Grades for stainless steel

AH6200 SERIES

Tungaloy Report No. 547S1-G

Expansion of JS chipbreaker inserts for stainless steel machining



AH6200 SERIES

High precision G-class 3D chipbreaker

Provides excellent chip control and superior surface finishing quality in stainless steel

JS First choice chipbreaker for finish cutting



Chipbreaker geometry that allows light cutting action and excellent chip breaking

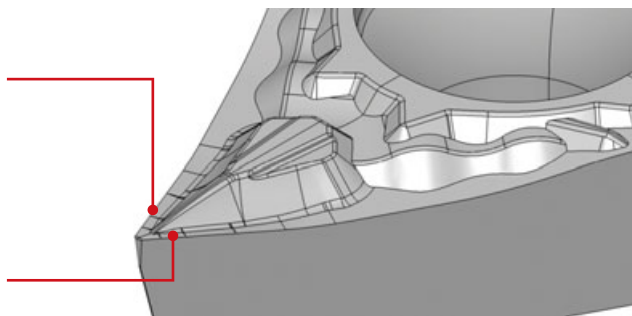
- A steep cutting edge inclination angle for better chip control and reduced cutting load
- A unique protrusion that extends towards the radius effectively controls chip flow from small to large cutting depths

Cutting edge with a steep inclination angle

Provides good chip evacuation and reduced cutting loads

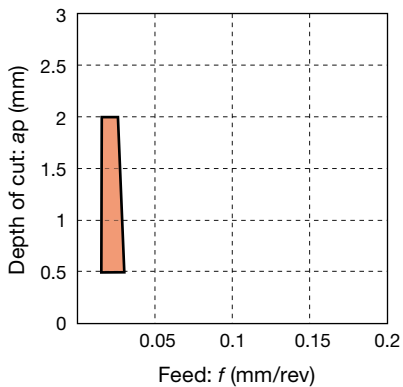
Rake with variable angles and steep protrusion

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

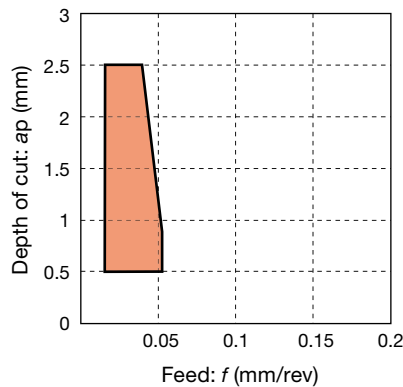


Chip control range

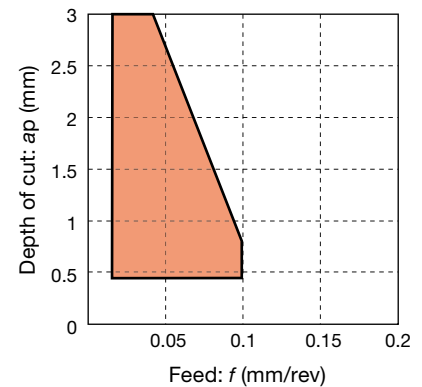
RE < 0.05 mm



RE < 0.1 mm



RE < 0.2 mm



Chip control



M Insert : DCGT11T302M-JS
AH6225
Workpiece material : SUS316L /
X5CrNiMo17-12-3
Cutting speed : $V_c = 80$ m/min
Feed : $f = 0.025$ mm/rev
Depth of cut : $a_p = 1$ mm
Coolant : Wet

M Insert : DCGT11T302M-JS
AH6225
Workpiece material : SUS316L /
X5CrNiMo17-12-3
Cutting speed : $V_c = 80$ m/min
Feed : $f = 0.05$ mm/rev
Depth of cut : $a_p = 0.5$ mm
Coolant : Wet

M Insert : DCGT11T302M-JS
AH6225
Workpiece material : SUS316L /
X5CrNiMo17-12-3
Cutting speed : $V_c = 80$ m/min
Feed : $f = 0.1$ mm/rev
Depth of cut : $a_p = 0.1$ mm
Coolant : Wet

