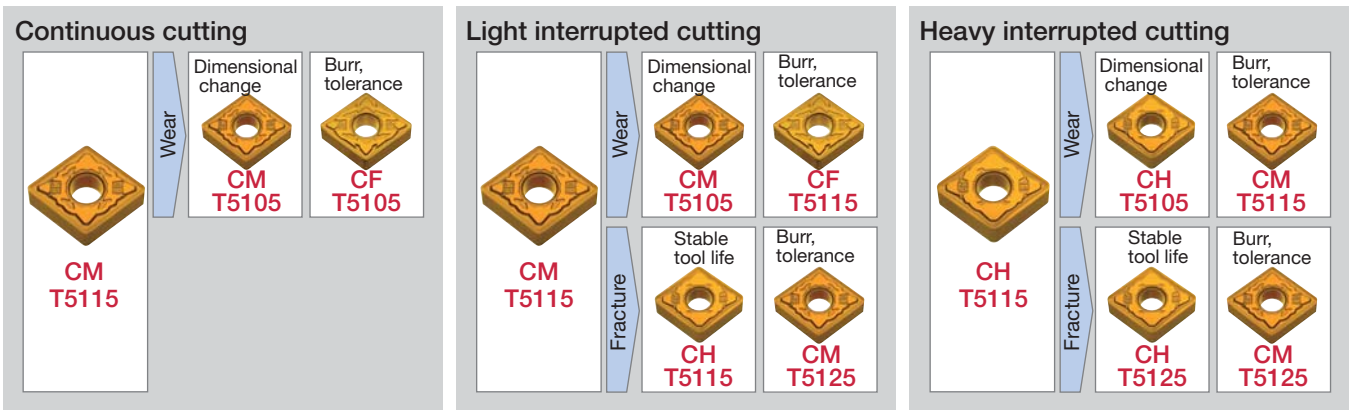
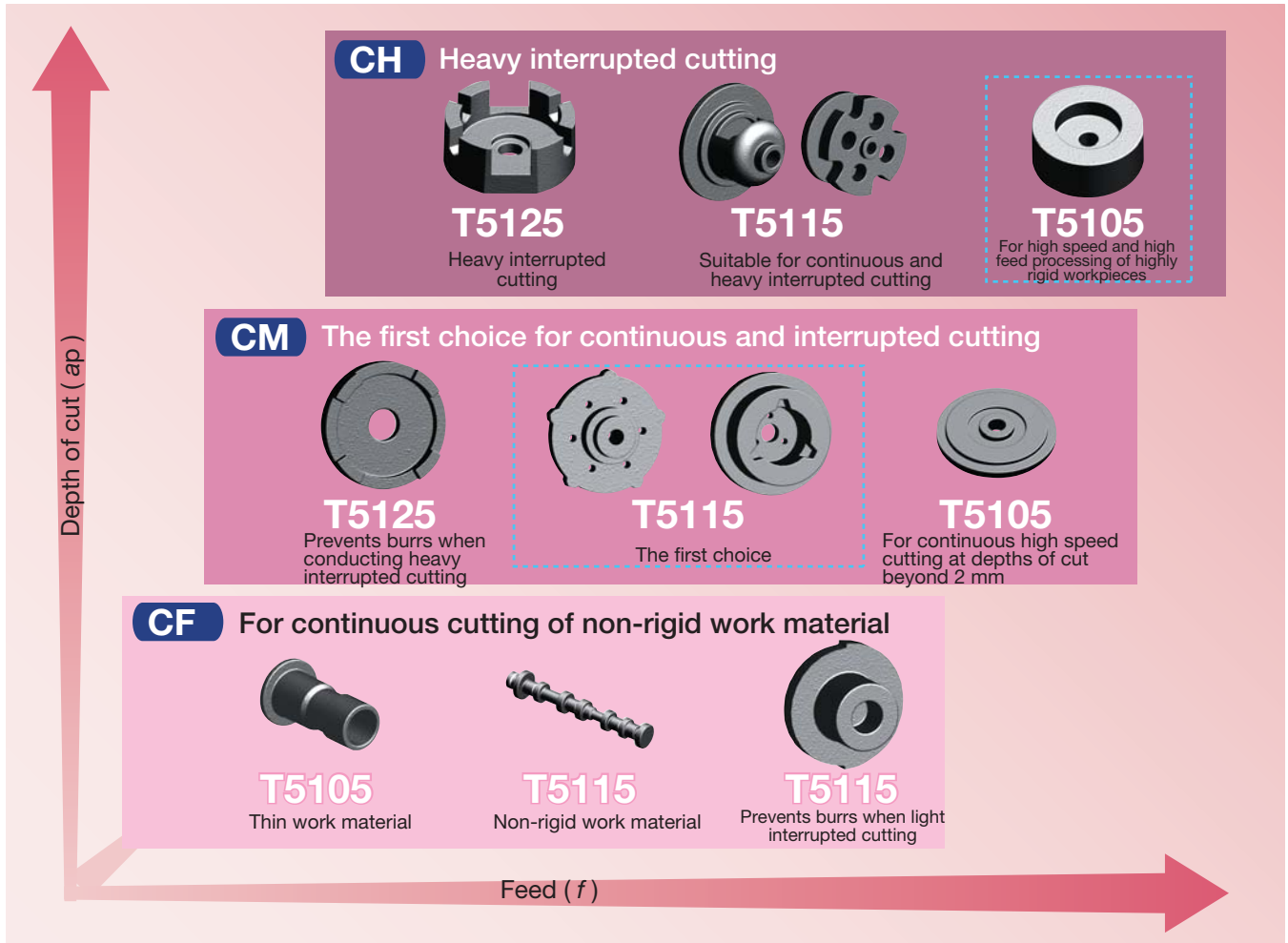


Selection guide



Standard cutting conditions For negative insert

Chipbreaker	Corner radius (mm)	Depth of cut a_p (mm)	Feed f (mm/rev)
CF	0.4	1.0 (0.5 - 2.0)	0.15 (0.05 - 0.2)
	0.8		0.25 (0.1 - 0.35)
	1.2		0.3 (0.1 - 0.4)
	1.6		0.4 (0.2 - 0.6)
CM	0.4	2.0 (1.0 - 5.0)	0.15 (0.05 - 0.2)
	0.8		0.3 (0.15 - 0.4)
	1.2		0.35 (0.15 - 0.5)
CH	0.4	3.0 (2.0 - 6.0)	0.2 (0.1 - 0.3)
	0.8		0.35 (0.2 - 0.45)
	1.2		0.4 (0.2 - 0.6)
	1.6		0.45 (0.3 - 0.8)

Chipbreaker	Corner radius (mm)	Depth of cut a_p (mm)	Feed f (mm/rev)
without chipbreaker	0.4	1.0 (0.05 - 2.0)	0.2 (0.1 - 0.3)
	0.8		0.35 (0.2 - 0.45)
	1.2		0.45 (0.3 - 0.8)
	1.6		0.45 (0.3 - 0.8)
All-round	0.4	3.0 (1.0 - 6.0)	0.25 (0.2 - 0.3)
	0.8		0.3 (0.2 - 0.5)
	1.2		0.3 (0.2 - 0.5)

Grades	Cutting Speed V_c (m/min)	
	Grey cast iron	Ductile cast iron
T5105	330 (180 - 480)	290 (180 - 400)
T5115	270 (140 - 400)	255 (140 - 370)
T5125	210 (120 - 300)	180 (120 - 250)

Chipbreaker (For positive inserts)

CM type



For multi-purpose machining

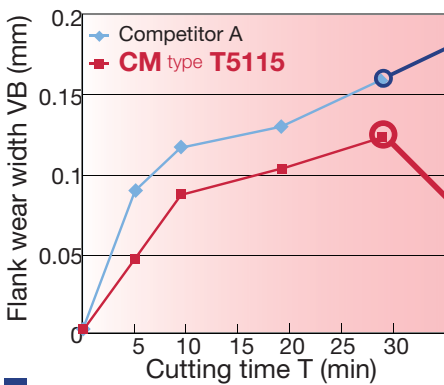
Without chipbreaker



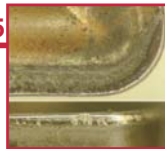
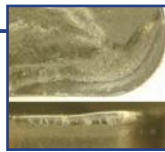
For interrupted cutting

Cutting performance

Excellent performance on cast irons



Flank Wear: after 30 min



Insert : **CCMT09T308-CM T5115**
 Toolholder : A20R-SCLCR09-D220
 Work material : FCD600 (GGG60)
 Cutting speed : $V_c = 150$ m/min
 Depth of cut : $a_p = 2.0$ mm
 Feed : $f = 0.25$ mm/rev
 Coolant : Water soluble

Standard cutting conditions For positive insert

Work material	Chip-breaker	Grade	Cutting speed V_c (m/min)	Depth of cut a_p (mm)	Feed f (mm/rev)		
					Corner R 0.4 (mm)	Corner R 0.8 (mm)	Corner R 1.2 (mm)
Grey cast irons, (FC250 etc.) (GG25 etc.)	CM without	T5115	270 (140 - 400)	1.0 (0.05 - 2.0)	0.15 (0.05 - 0.2)	0.2 (0.05 - 0.3)	0.2 (0.05 - 0.3)
Ductile cast irons (FCD450 etc.) (GG45 etc.)			255 (140 - 370)				

Inserts Positive type

80° Rhombic, 7° positive

Application	Chipbreaker Appearance (Cross section)	$f - a_p$	Insert Cat. No. (Metric)	Dimensions (mm)				Grade	
				I.C.dia ϕd	Thick-ness s	Hole dia ϕd_1	Corner R $r \epsilon$	Coated	
Finishing to medium cutting	CM 		CCMT060204-CM	6.35	2.38	2.8	0.4	●	
			CCMT060208-CM				0.8	●	
			CCMT09T304-CM	9.525	3.97	4.4	0.4	●	
			CCMT09T308-CM*				0.8	●	
			CCMT09T312-CM				1.2	●	
			CCMT120404-CM	12.7	4.76	5.5	0.4	●	
	CCMT120408-CM	0.8	●						
	Without Chipbreaker			CCMW060204	6.35	2.38	2.8	0.4	●
				CCMW060208				0.8	●
				CCMW09T304	9.525	3.97	4.4	0.4	●
CCMW09T308				0.8				●	

Note: The chipbreaker cross-section marked * is shown under the photographs of inserts.

● : Stocked items