

GRADES

Application	Grade Application code	Substrate			Coating layer	
		Specific gravity	Hardness (HRA)	T.R.S. (GPa)	Main composition	Thickness (μm)
S	AH8005	15.0	93.0	2.2	(Al,Ti)N	3.5
	S01 - S10					
	AH8015	14.9	91.8	3.1	(Al,Ti)N	3.5
	S10 - S20					

STANDARD CUTTING CONDITIONS

Chipbreakers for negative inserts

Chipbreaker	Corner radius RE	Depth of cut ap (mm)	Feed f (mm/rev)	Cutting speed: Vc (m/min)	
				AH8005	AH8015
HRF	0.4	0.2 - 1.5	0.05 - 0.23	40 - 100	20 - 80
	0.8	0.2 - 1.5	0.05 - 0.25	40 - 100	20 - 80
	1.2	0.2 - 1.5	0.07 - 0.27	40 - 100	20 - 80
HRM	0.4	0.5 - 4.0	0.05 - 0.30	40 - 100	20 - 80
	0.8	0.5 - 4.0	0.07 - 0.33	40 - 100	20 - 80
	1.2	0.5 - 4.0	0.10 - 0.35	40 - 100	20 - 80
	1.6	0.5 - 4.0	0.15 - 0.40	40 - 100	20 - 80
28	0.4	0.5 - 3.0	0.08 - 0.20	40 - 100	20 - 80
	0.8	0.5 - 3.0	0.10 - 0.30	40 - 100	20 - 80
	1.2	0.5 - 3.0	0.10 - 0.30	40 - 100	20 - 80

* Values for the inserts with 12.7 mm I.C. dia.

Chipbreakers for positive inserts

Chipbreaker	Corner radius RE	Depth of cut ap (mm)	Feed f (mm/rev)	Cutting speed: Vc (m/min)	
				AH8005	AH8015
PSF	0.4	0.05 - 0.5	0.02 - 0.20	40 - 100	20 - 80
	0.8	0.05 - 0.5	0.02 - 0.30	40 - 100	20 - 80
PSS	0.4	0.3 - 2.0	0.02 - 0.20	40 - 100	20 - 80
	0.8	0.3 - 2.0	0.03 - 0.30	40 - 100	20 - 80
	1.2	0.3 - 2.0	0.05 - 0.30	40 - 100	20 - 80
PS	0.4	0.5 - 2.5	0.02 - 0.20	40 - 100	20 - 80
	0.8	0.5 - 2.5	0.03 - 0.30	40 - 100	20 - 80
	1.2	0.5 - 2.5	0.05 - 0.30	40 - 100	20 - 80
All-round	0.4	0.5 - 3.0	0.08 - 0.20	40 - 100	20 - 80
	0.8	0.5 - 3.0	0.08 - 0.30	40 - 100	20 - 80
	1.2	0.5 - 3.0	0.08 - 0.30	40 - 100	20 - 80
RS		0.5 - 1.5	0.03 - 0.30	40 - 100	20 - 80
61		0.5 - 2.0	0.20 - 0.60	40 - 100	20 - 80

* Values for the inserts with 9.525 mm I.C. dia.