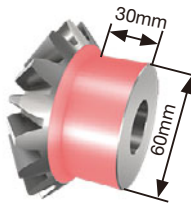
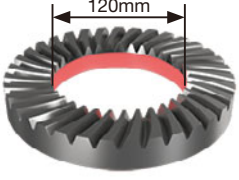
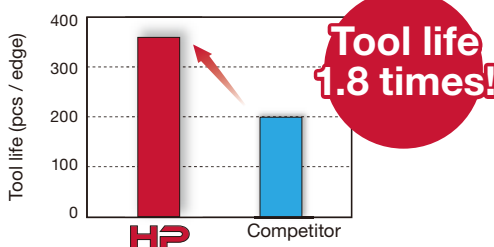
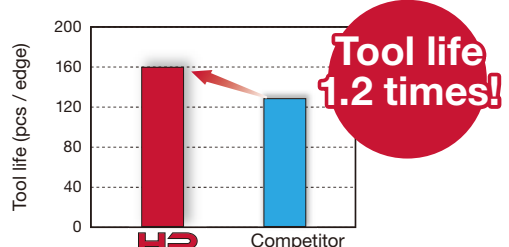


## STANDARD CUTTING CONDITIONS

ISO	Grade	Work condition	Cutting speed Vc(m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
<b>H</b>	BXM10	Continuous	120 - 350	0.05 - 0.20	0.05 - 0.20
	BXA20	Continuous	70 - 180	0.05 - 0.20	0.05 - 0.20
		Light interrupted	70 - 180	0.05 - 0.20	0.05 - 0.20

## PRACTICAL EXAMPLES

Workpiece type		Bevel gear	Gear Wheel	
Insert		2QP-CNGM120408-HP	2QP-CNGM120408WL-HP	
Grade		BXA20	BXA20	
Workpiece material		JIS SCM420 (HRC58)	JIS SCM420 (HRC58)	
				
Cutting conditions	Cutting speed: Vc (m/min)	160	150	
	Feed : f (mm/rev)	0.10	0.12	
	Depth of cut : ap (mm)	0.15	0.18	
	Coolant	Wet	Dry	
Results	 <p>Competitor's inserts had a short tool life because of chip re-cutting. The -HP chipbreaker insert solved chip entanglement issues, prolonging tool life and achieving excellent surface finish quality.</p>		 <p>The -HP chipbreaker insert with wiper provided good chip flow and machined surface.</p>	