

GS Chip-breaker

The revolution on HRSA Turning



NEW
GS
CHIP-BREAKER

PHH

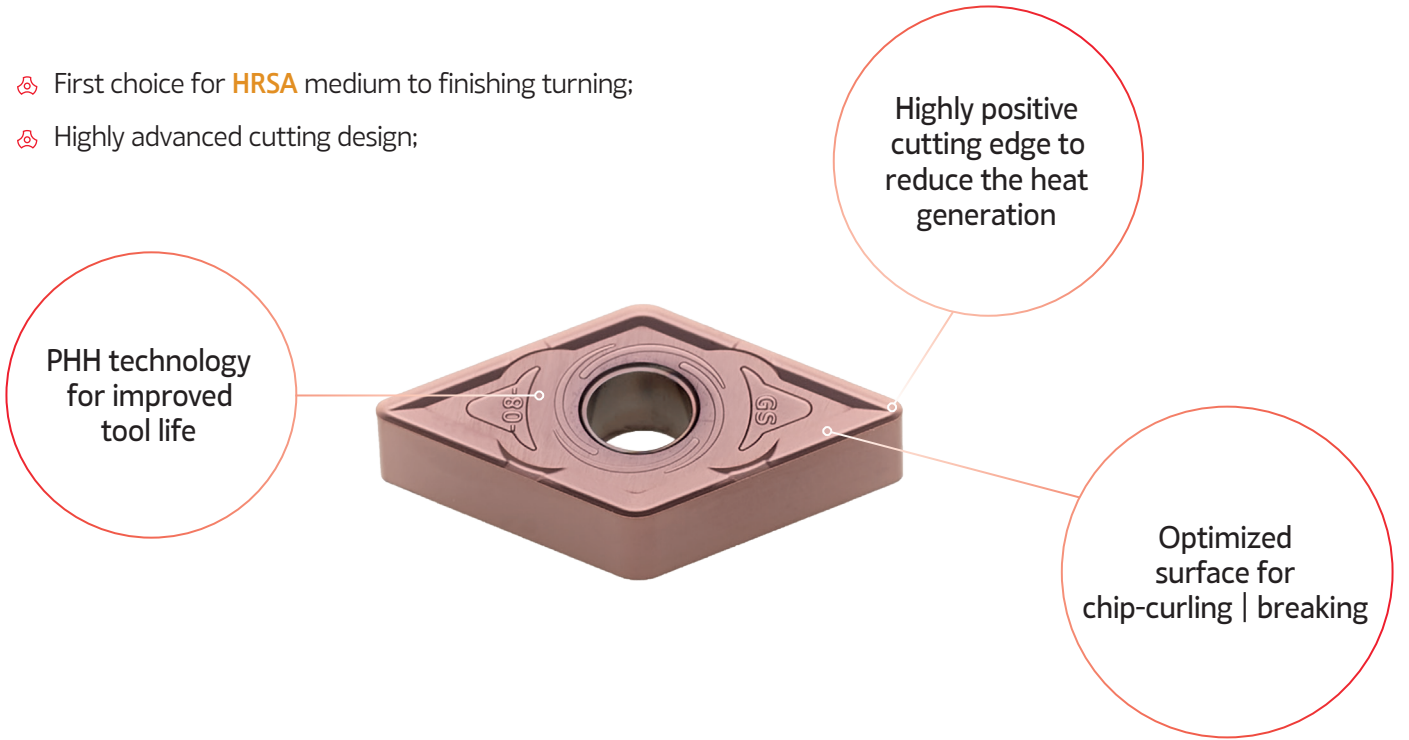
NEW
GRADE



SINCE 1916

Designed especially for HRSA, the new chip-breaker **GS** combined with the latest PHH technology, offers exceptional performance in the exotic materials machining.

- ⊗ First choice for **HRSA** medium to finishing turning;
- ⊗ Highly advanced cutting design;



PHH GRADE | Grau PHH | Grado PHH

Product of the latest coating technology, the new PHH coating comes to revolutionize the turning of HRSA and stainless steel. PHH is a stable PVD coating that merges both high hardness and unmatched heat resistance.



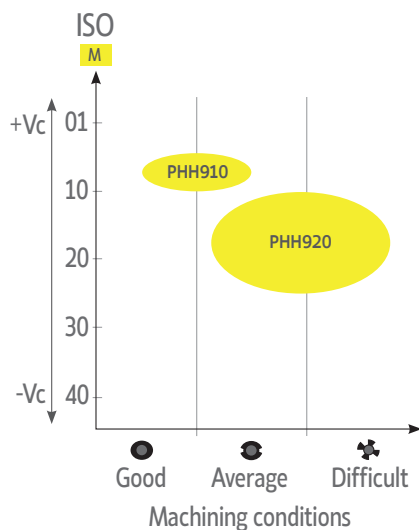
PHH910 NEW
M05-M10
S05-S15

First choice for HRSA.

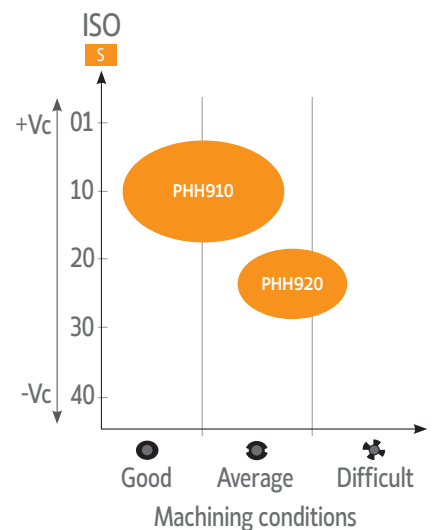
PHH920 NEW
M10-M25
S15-S30

Solution for general turning of stainless steels and HRSA.

M - STAINLESS STEEL


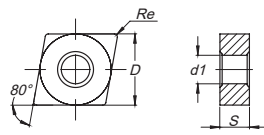
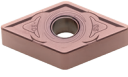
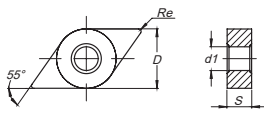

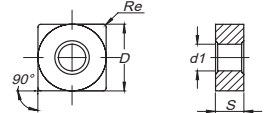

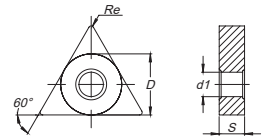

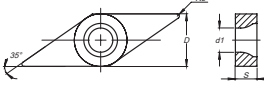

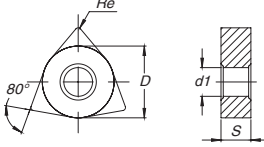


S - HEAT RESISTANT / TITANIUM ALLOYS


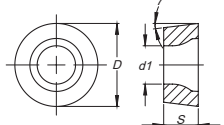


Inserts Pastilhas Plaquetas	(1) Geometry code	(2) Grade code	ISO Reference	M		S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting Conditions Condições de Corte Condiciones de Corte				Technical drawing Desenho técnico Dibujo técnico		
				PVD		PVD		D	S	Re	d1	ap (mm)	Min	Max	fn (mm/rev)		Min	Max
				X6	Y3	X6	Y3											
PHH910	PHH920	PHH910	PHH920															

NEGATIVE INSERTS

	1124514	CNMG 120404-GS	🔴	🔴	🔴	🔴	12,70	4,76	0,40	5,16	1,50	0,15	2,50	0,20	0,10	0,30	
	1124502	CNMG 120408-GS	🔴	🔴	🔴	🔴	12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,10	0,35	
	1124515	CNMG 120412-GS	🔴	🔴	🔴	🔴	12,70	4,76	1,20	5,16	2,00	0,30	4,00	0,30	0,10	0,45	
	1124688	DNMG 110404-GS	🔴	🔴	🔴	🔴	9,53	4,76	0,40	3,81	1,50	0,15	2,00	0,20	0,10	0,25	
	1124689	DNMG 110408-GS	🔴	🔴	🔴	🔴	9,53	4,76	0,80	3,81	2,00	0,20	2,50	0,25	0,10	0,30	
	1124511	DNMG 150404-GS	🔴	🔴	🔴	🔴	12,70	4,76	0,40	5,16	1,50	0,15	2,00	0,20	0,10	0,25	
	1124512	DNMG 150408-GS	🔴	🔴	🔴	🔴	12,70	4,76	0,80	5,16	2,00	0,20	2,50	0,25	0,10	0,30	
	1124513	DNMG 150412-GS	🔴	🔴	🔴	🔴	12,70	4,76	1,20	5,16	2,00	0,30	3,00	0,25	0,10	0,35	
	1124682	DNMG 150604-GS	🔴	🔴	🔴	🔴	12,70	6,35	0,40	5,16	1,50	0,15	2,00	0,20	0,10	0,25	
	1124683	DNMG 150608-GS	🔴	🔴	🔴	🔴	12,70	6,35	0,80	5,16	2,00	0,20	2,50	0,25	0,10	0,30	
	1124684	DNMG 150612-GS	🔴	🔴	🔴	🔴	12,70	6,35	1,20	5,16	0,30	0,30	3,00	0,30	0,10	0,35	
	1124556	SNMG 120408-GS	🔴	🔴	🔴	🔴	12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,15	0,40	
	1124557	SNMG 120412-GS	🔴	🔴	🔴	🔴	12,70	4,76	1,20	5,16	2,50	0,50	5,00	0,30	0,20	0,50	
	1124558	SNMG 120416-GS	🔴	🔴	🔴	🔴	12,70	4,76	1,60	5,16	2,50	0,50	5,00	0,40	0,20	0,50	
	1124508	TNMG 160404-GS	🔴	🔴	🔴	🔴	9,53	4,76	0,40	3,81	1,50	0,15	3,00	0,15	0,10	0,30	
	1124509	TNMG 160408-GS	🔴	🔴	🔴	🔴	9,53	4,76	0,80	3,81	2,00	0,20	3,00	0,25	0,10	0,30	
	1124510	TNMG 160412-GS	🔴	🔴	🔴	🔴	9,53	4,76	1,20	3,81	2,00	0,30	3,00	0,30	0,15	0,35	
	1124562	VNMG 160404-GS	🔴	🔴	🔴	🔴	9,53	4,76	0,40	3,81	1,00	0,15	2,00	0,15	0,05	0,20	
	1124563	VNMG 160408-GS	🔴	🔴	🔴	🔴	9,53	4,76	0,80	3,81	1,50	0,20	2,50	0,20	0,07	0,25	
	1124564	VNMG 160412-GS	🔴	🔴	🔴	🔴	9,53	4,76	1,20	3,81	1,50	0,30	3,00	0,20	0,10	0,25	
	1124690	WNMG 060404-GS	🔴	🔴	🔴	🔴	9,53	4,76	0,40	3,81	1,50	0,15	2,50	0,20	0,10	0,30	
	1124691	WNMG 060408-GS	🔴	🔴	🔴	🔴	9,53	4,76	0,80	3,81	2,00	0,20	3,00	0,25	0,10	0,35	
	1124559	WNMG 080404-GS	🔴	🔴	🔴	🔴	12,70	4,76	0,40	5,16	1,50	0,15	2,50	0,20	0,10	0,30	
	1124560	WNMG 080408-GS	🔴	🔴	🔴	🔴	12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,10	0,35	
	1124561	WNMG 080412-GS	🔴	🔴	🔴	🔴	12,70	4,76	1,20	5,16	2,00	0,30	3,50	0,30	0,10	0,40	

POSITIVE INSERTS

	1124495	RCMT 0803M0-GS	🔴	🔴	🔴	🔴	8,00	3,18	-	3,40	1,00	0,20	2,00	0,25	0,15	0,40	
	1124496	RCMT 1003M0-GS	🔴	🔴	🔴	🔴	10,00	3,18	-	3,40	1,50	0,40	2,50	0,30	0,15	0,45	

GS Chip-breaker

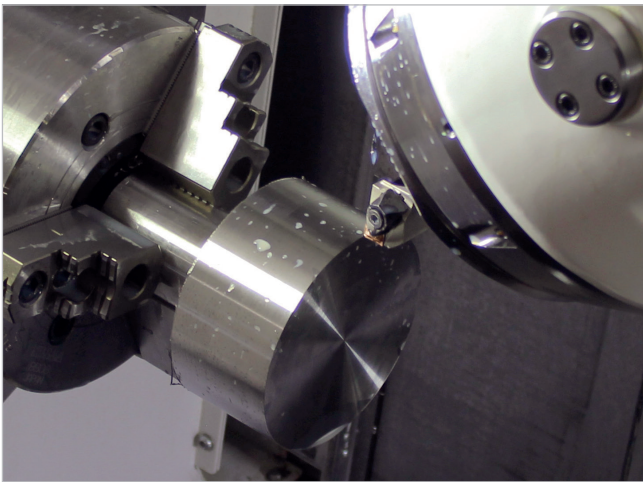
The revolution on HRSA Turning

NEW

TEST REPORT | Relatório de teste | Informes de prueba

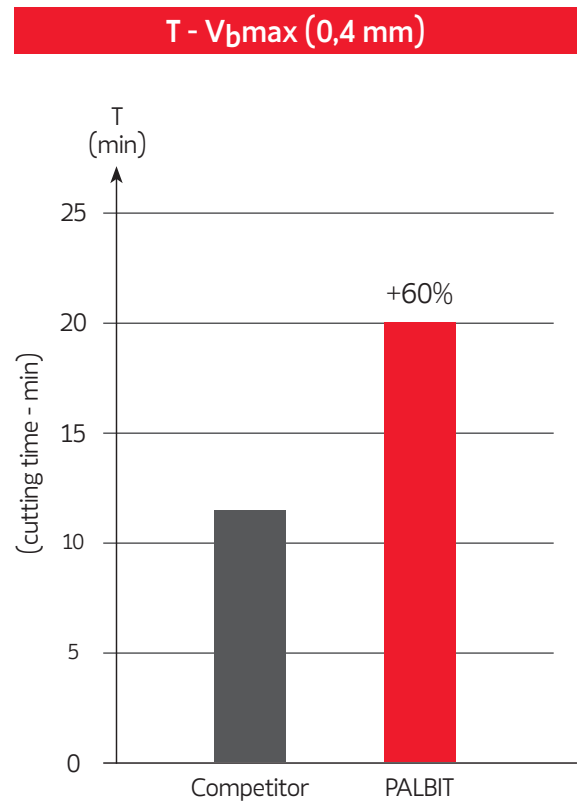
Toolholder: DCLN L 2525 M12 060 13

Insert: CNMG 120408-GS PHH910 vs Competitor Equivalent



Workpiece Material: Inconel 625 Alloy

Cutting speed: V_c	85 m/min
Feed per tooth: f_n	0,12 mm/rev
Depth of cut: a_p	0,5 mm
Operation	External turning
Coolant	Emulsion



ZIBTRPRO
tehnologija obdelave · vpenjalni sistemi