

For deep hole grooving/parting off

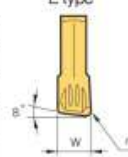
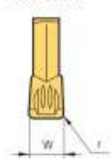
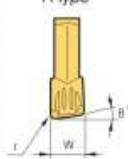
Saw Man

Features of parting insert

- Possible to machine a wide range of workpieces such as steel, cast iron, stainless steel, etc.
- Extended tool life due to low resistance rake angle
- Minimized burr due to minimal Nose R
- Various lead angle available
- Narrow chip curl due to dots on rake surface of insert

Workpiece	Cutting Speed (vc = m/min)									Feed (fn = mm/rev)				
	CVD				PVD				Uncoated	Cutting width (mm)				
	NC3120	NC3030	NCM325	NC5330	PC230	PC8110	PC5300	PC6510		2	3	4	5	6
SM□□C	80~180			80~180	80~180					0.02~0.15	0.03~0.20	0.08~0.30	0.10~0.4	0.12~0.50
SCM	70~150	70~150	70~150	70~150	70~150					0.02~0.15	0.03~0.20	0.08~0.30	0.10~0.4	0.12~0.50
GC/GCD				50~100				50~100	50~100	0.05~0.12	0.10~0.25	0.10~0.30	0.10~0.35	0.10~0.40
STS			50~120	50~120		50~120	60~140			0.02~0.10	0.03~0.15	0.08~0.25	0.10~0.35	0.12~0.40
Non-ferrous metal (Al, Copper)									200~450	0.05~0.10	0.05~0.20	0.05~0.25	0.05~0.30	0.05~0.35

Insert

Application	Picture	Designation	Coated								Uncoated	Dimensions (mm)			Configuration		
			NC3120	NC3225	NC3030	NCM325	NC5330	PC3035	PC8105	PC8110	PC5300	PC9030	ST30A	W		l	r
Parting tools		SP 160												1.6	7.8	0.16	R type Standard L type 
		180												1.8	9.3	0.16	
		200		●	●	●	●			●	●	●		2.2	9.3	0.2	
		200R			●							●		2.2	9.3	0.2	
		200L										●		2.2	9.3	0.2	
		300	●	●	●	●	●			●	●	●	●	3.1	11.3	0.2	
		300R		●	●	●				●				3.1	11.3	0.2	
		300L			●									3.1	11.3	0.2	
		400	●	●	●	●	●			●	●	●		4.1	11.3	0.25	
		400R			●					●				4.1	11.3	0.25	
		400L			●									4.1	11.3	0.25	
		500			●	●	●			●	●			5.1	11.4	0.3	
		500R												5.1	11.4	0.3	
		500L												5.1	11.4	0.3	
		600			●		●				●			6.4	11.4	0.35	
		600R												6.4	11.4	0.35	
		600L												6.4	11.4	0.35	
		800												8.0	14.06	0.4	
		900												9.6	14.06	0.45	

● : Stock item