

Positive M-Class Chipbreaker for General Turning

NGU_{Type} Chipbreaker

Highly Recommended Versatile Chipbreaker for Positive Inserts

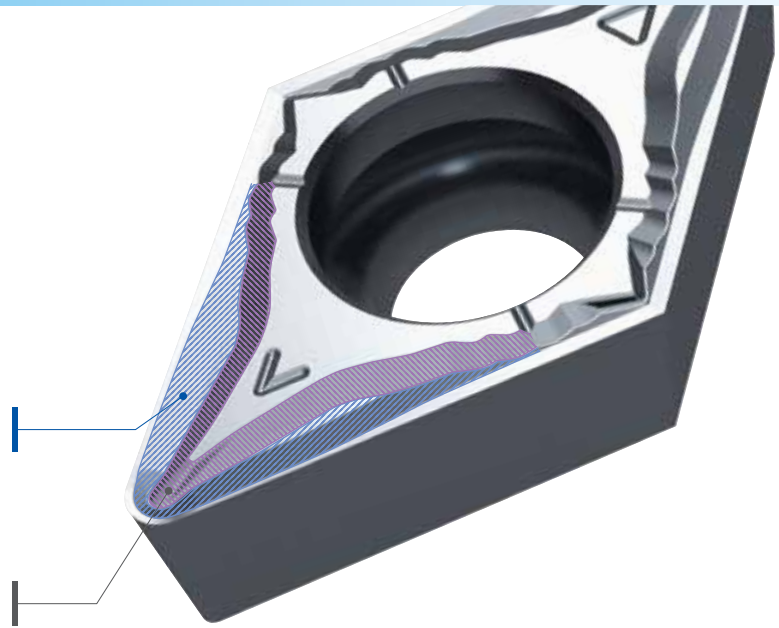


Chipbreaker for General Turning

NGU Type

NGU^{Positive} type Chipbreaker

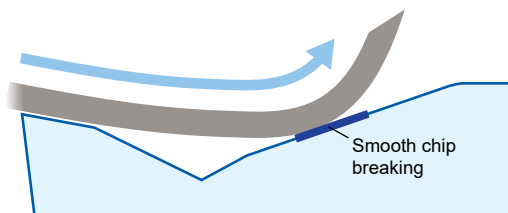
- Excellent chip control performance
- Wide chip pocket for various cutting conditions
- Less Vibration
- Improved chip control in a wide application field



- Suppresses chip jamming at high feed rates for ideal chip control



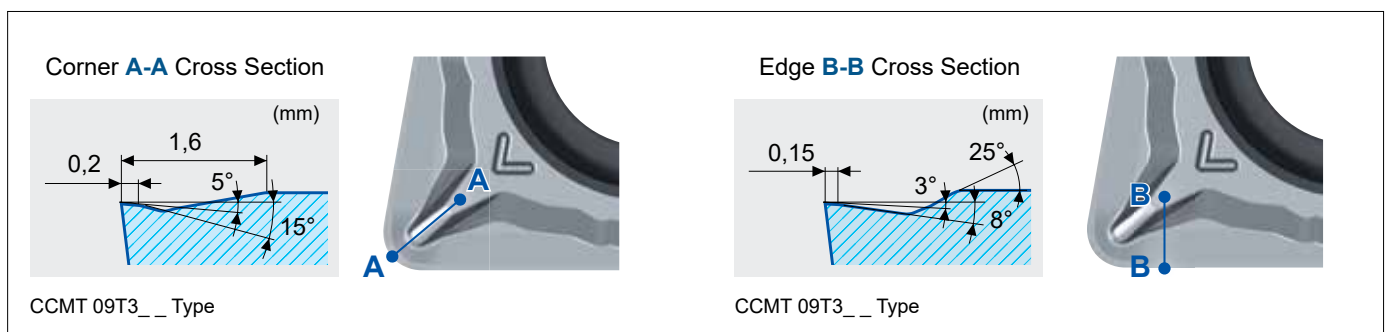
- Wide restraining face enables consistent chip control for light to medium cutting.
- Discharges chips well under high feed conditions and suppresses build-up



- Achieves stable machining with both versatility and low resistance

Improved Fracture Resistance

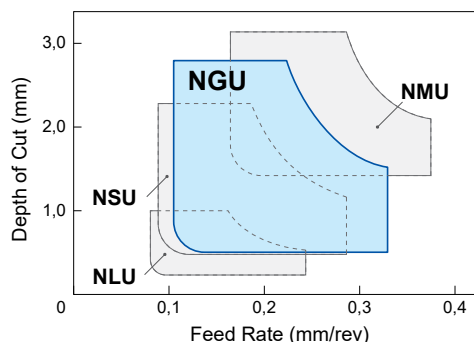
The two step rake angle geometry ensures outstanding sharpness and hardness.



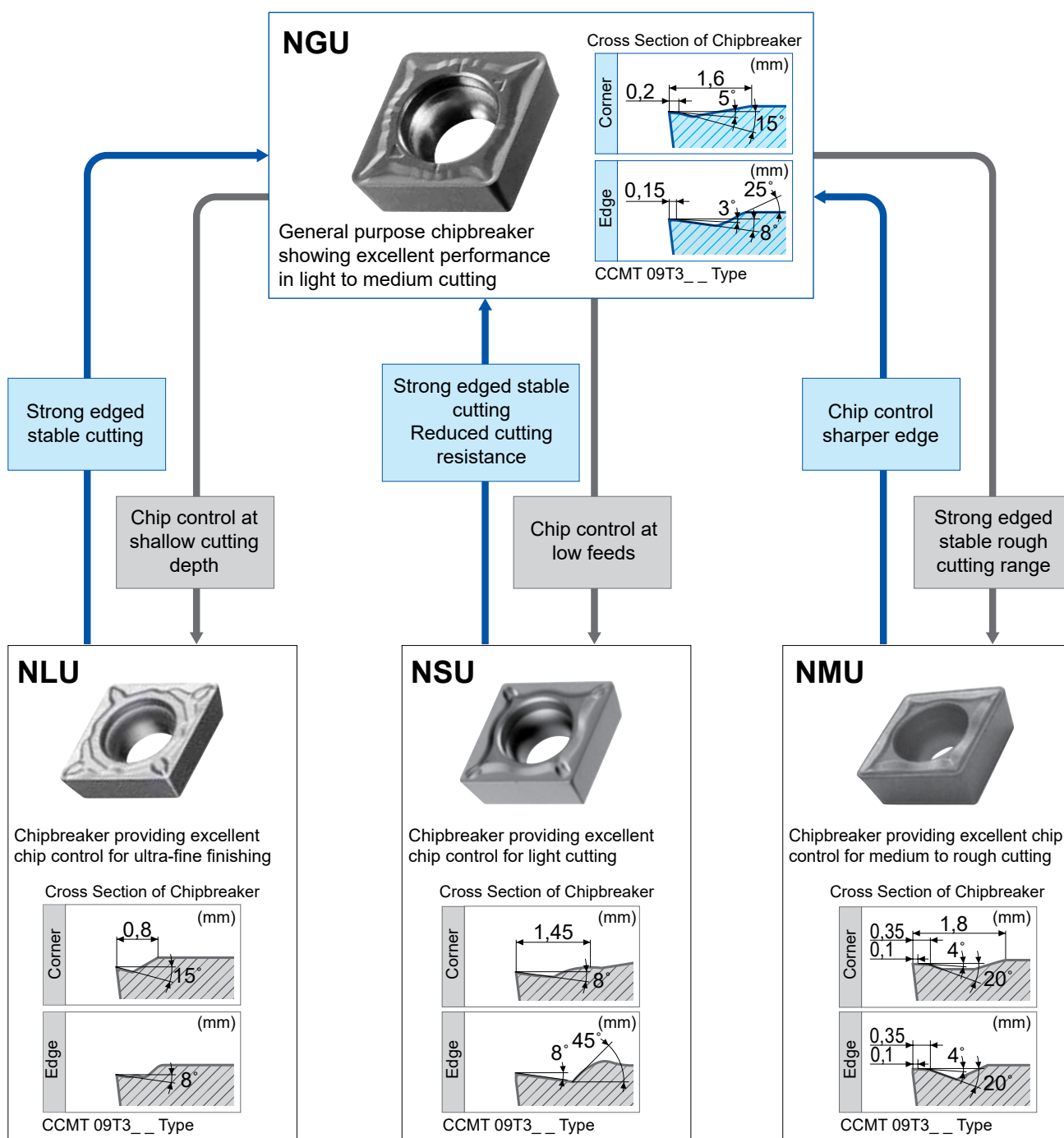
Chipbreaker for General Turning NGU Type

Application Range

Enhanced application range over conventional products.



Chipbreaker Selection Guide

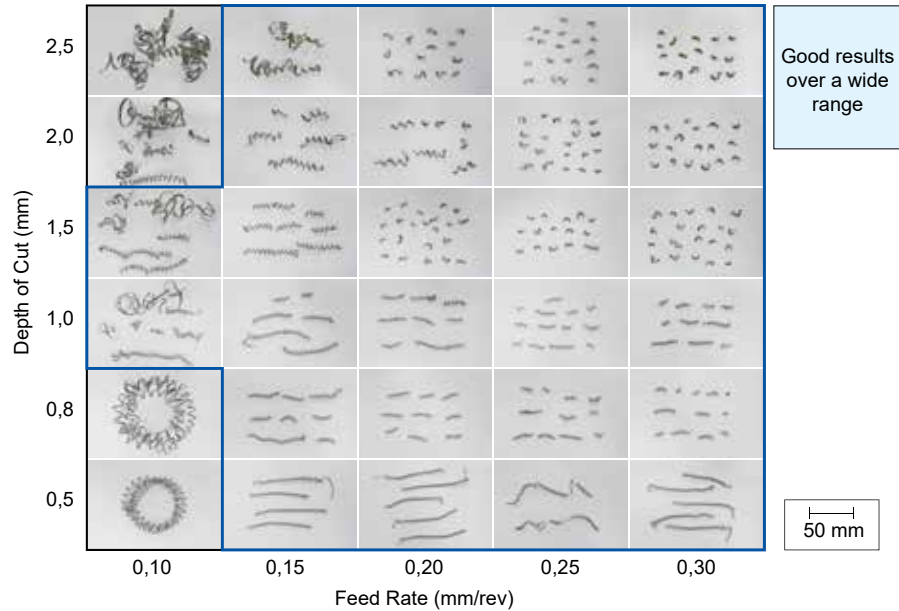
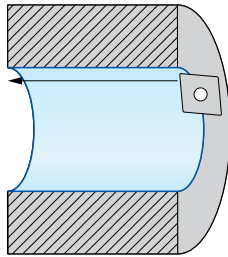


Chipbreaker for General Turning NGU Type

■ Cutting Performance

Chip Control

Wide ranging compatibility from light to medium cutting. Suppresses chip entanglement under high feed conditions to realize stable machining.



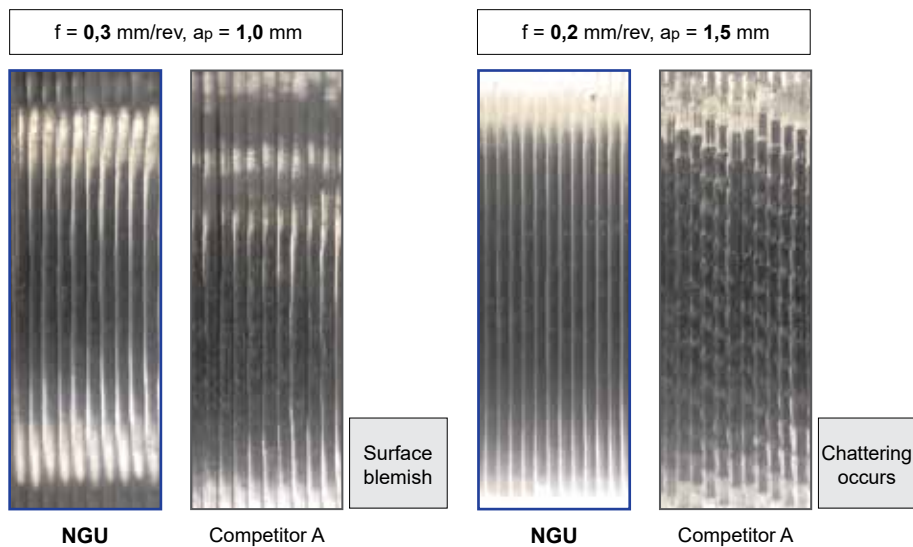
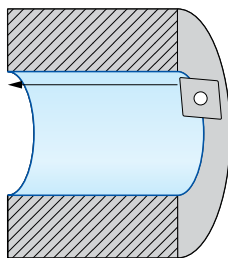
Good results over a wide range

50 mm

Work Material: STKM13A, pipe material (Ø30 mm, internal boring)
 Insert: CCMT 09T308 NGU (AC8025P)
 Cutting Conditions: $v_c = 200$ m/min, wet

Chatter Resistance

Protrusion design with a smooth incline that suppresses chatter.

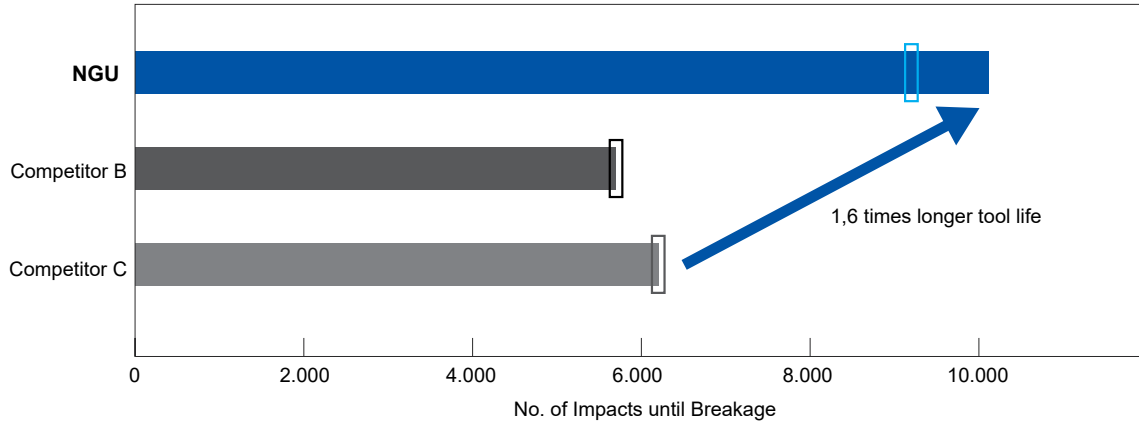


Work Material: 15CrMo5, (Ø15 mm, internal boring)
 Holder: S10K-STUP R1103-12 (steel holder L/D=3)
 Insert: TPMT 110308 NGU (AC8025P)
 Cutting Conditions: $v_c = 100$ m/min, wet

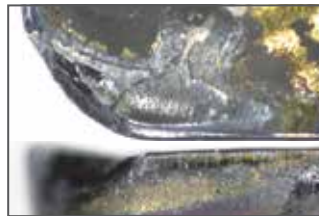
Cutting Performance

Fracture Resistance

Strengthened cutting edge design improves fracture resistance.



NGU
(9.200 impacts)



Competitor B
(5.700 impacts)



Competitor C
(6.200 impacts)

Work Material: 34CrMo4, groove material (light interrupted cut, external turning)
 Insert: CCMT 09T308 NGU (AC8025P)
 Cutting Conditions: $v_c = 300$ m/min, $f = 0,2$ mm/rev, $a_p = 1,5$ mm, wet

Recommended Cutting Conditions

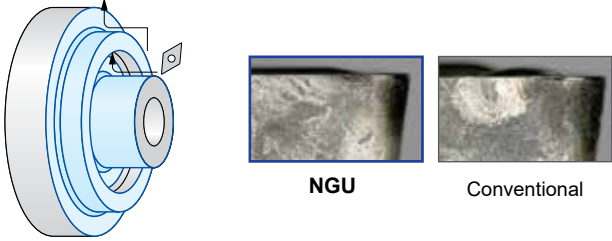
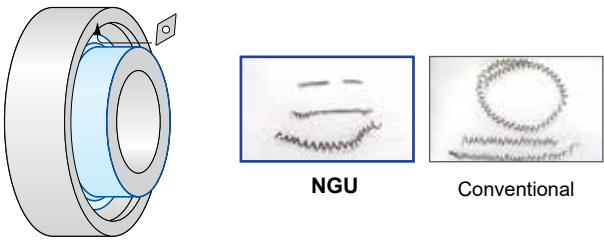
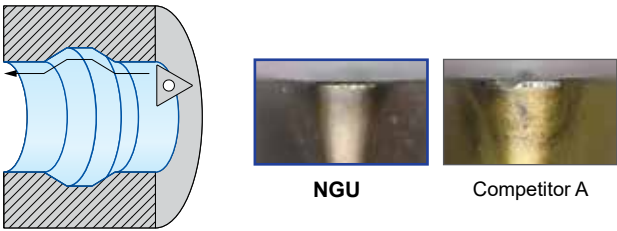
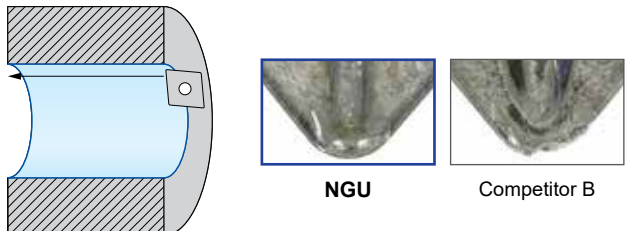
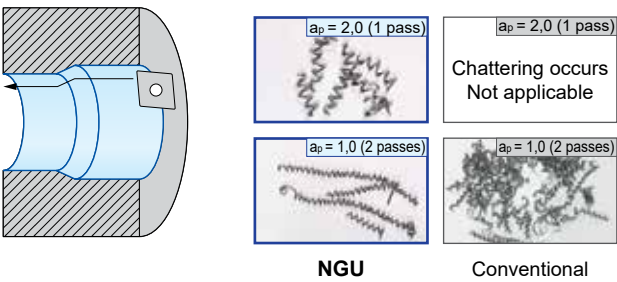
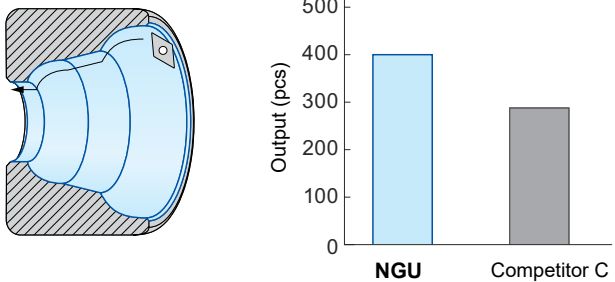
Min. - Optimum - Max.

	Work Material	Grades	Cutting Conditions		
			Cutting Speed (m/min)	Feed Rate (mm/rev)	Depth of Cut (mm)
P	Soft Steel (STKM13A, ST44-2, etc.)	AC8015P	240- 330 -420	0,12- 0,20 -0,30	0,50- 1,00 -2,50
		AC8025P	220- 300 -380		
		AC8035P	160- 200 -240		
		T1500A	100- 190 -280		
		T1500Z	110- 220 -310		
		T2500Z	80- 180 -280		
	Carbon Steel, Alloy Steel (C45, 34CrMo4, etc.)	AC8015P	220- 300 -380	0,10- 0,20 -0,30	0,40- 1,00 -2,50
		AC8025P	190- 250 -310		
		AC8035P	140- 180 -220		
		T1500A	90- 170 -250		
		T1500Z	100- 200 -300		
		T2500Z	70- 160 -250		
M	Stainless Steel (austenitic)	AC6020M	130- 170 -210	0,10- 0,20 -0,30	0,40- 1,00 -2,50
		AC6030M	100- 130 -160		
		AC6040M	90- 115 -140		
K	GG GGG	AC4010K	200- 400 -700	0,12- 0,20 -0,30	0,50- 1,00 -2,50
		AC4015K	180- 300 -450		
S	Heat Resistant Alloy (Ni, Fe, Co material)	AC5015S	30- 55 -80	0,08- 0,15 -0,25	0,40- 0,80 -2,00
		AC5025S	30- 55 -80		

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




NGU Type

Application Examples

<p>SPHC, Press Material Cylinder Parts</p> <p>Stable machining without cutting edge failure.</p>  <p>NGU Conventional</p> <p>Insert: DCMT 11T304 NGU (AC8025P) Cutting Conditions: $v_c = 220$ m/min, $f = 0,2$ mm/rev, $a_p = 0,5$ mm, wet, external profiling</p>	<p>15CrMo5, Automotive Drive Parts</p> <p>Improves chip entanglement for improved machining efficiency.</p>  <p>NGU Conventional</p> <p>Insert: DCMT 11T308 NGU (AC8015P) Cutting Conditions: $v_c = 180$ m/min, $f = 0,3$ mm/rev, $a_p = 1,5$ mm, wet, external profiling</p>
<p>15CrMo5, Precision Mechanical Parts</p> <p>Suppresses cutting edge temperature rise, reducing wear and damage.</p>  <p>NGU Competitor A</p> <p>Insert: TPMT 110304 NGU (AC6040M) Cutting Conditions: $v_c = 130$ m/min, $f = 0,2$ mm/rev, $a_p = 0,5$ mm, wet, internal profiling</p>	<p>15CrMo5, Fastening Parts</p> <p>Strong cutting edge design realizes 1,5 times the tool life.</p>  <p>NGU Competitor B</p> <p>Insert: CCMT 09T308 NGU (AC8025P) Cutting Conditions: $v_c = 190$ m/min, $f = 0,25$ mm/rev, $a_p = 1,0$ mm, wet, internal boring</p>
<p>24CrMo5, Automotive Parts</p> <p>Improves chip entanglement for improved machining efficiency.</p>  <p>NGU Conventional</p> <p>Insert: CPMT 090308 NGU (AC8025P) Cutting Conditions: $v_c = 200$ m/min, $f = 0,2$ mm/rev, $a_p = 2,0$ mm, wet, internal taper boring</p>	<p>Bearing Steel, Bearing Parts</p> <p>Strong cutting edge design realizes 1,3 times the tool life.</p>  <p>NGU Competitor C</p> <p>Insert: DCMT 11T312 NGU (AC8025P) Cutting Conditions: $v_c = 220$ m/min, $f = 0,15-0,35$ mm/rev, $a_p = 0,8-3,8$ mm, wet, internal boring</p>

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Stock Items

Shape	Relief Angle	Cat. No.	Grade											Dimensions (mm)					
			Coated Carbide									Coated Cermet		Cermet	Inscribed Circle	Thick-ness	Screw Hole Ø	Nose Radius	
			AC8015P	AC8025P	AC8035P	AC6020M	AC6030M	AC6040M	AC4010K	AC4015K	AC5015S	AC5025S	T1500Z	T2500Z					T1500A
	7°	CCMT 060204 NGU	●	●	●	●	●	●		●	●	○	●	○	○	6,35	2,38	2,8	0,4
		060208 NGU	●	●	○	○	●	●					○	○	○	6,35	2,38	2,8	0,8
		CCMT 09T304 NGU	●	●	●	●	●	●			●	●	●	●	○	9,525	3,97	4,4	0,4
		09T308 NGU	●	●	●	●	●	●	●	●		●	●	○	○	9,525	3,97	4,4	0,8
		CCMT 120408 NGU	●	●	●	●	●		●	●						12,7	4,76	5,5	0,8
	11°	CPMT 090304 NGU	○	○	○	○	○	○					○	○	○	9,525	3,18	4,4	0,4
		090308 NGU	○	○	○	○	○	○					○	○	○	9,525	3,18	4,4	0,8
	7°	DCMT 070204 NGU	●	●	●	●	●	○					●	○	○	6,35	2,38	2,8	0,4
		070208 NGU	●	●	○	○	●	○					○	○	○	6,35	2,38	2,8	0,8
		DCMT 11T302 NGU	●	●	○	●	●	○					●	○	○	9,525	3,97	4,4	0,2
		11T304 NGU	●	●	●	●	●	●	●	●	●	●	●	●	●	9,525	3,97	4,4	0,4
		11T308 NGU	●	●	●	●	●	●	●	●	●	●	●	●	●	9,525	3,97	4,4	0,8
		11T312 NGU		○			○									9,525	3,97	4,4	1,2
	7°	SCMT 09T304 NGU	●	●	○	○	●	○			●				9,525	3,97	4,4	0,4	
		09T308 NGU	●	●	●	○	●	○		●	●	●			9,525	3,97	4,4	0,8	
		120408 NGU	○	●	○		●								12,7	4,76	5,5	0,8	
	11°	TPMT 110304 NGU	○	●	○	○	●	○					○	○	○	6,35	3,18	3,4	0,4
		110308 NGU	○	○	○	○	○	○					○	○	○	6,35	3,18	3,4	0,8
		160404 NGU	○	○	○	○	○	○					○	○	○	9,525	4,76	4,4	0,4
		160408 NGU	●	○	○	○	●	○					○	○	○	9,525	4,76	4,4	0,8
	5°	VBMT 110304 NGU	○	○	○	○	●	○					○	○	○	6,35	3,18	2,8	0,4
		110308 NGU	●	○	○	●	○	○					○	○	○	6,35	3,18	2,8	0,8
		VBMT 160404 NGU	●	●	○	●	●	○		●	●	●	●	●	○	9,525	4,76	4,4	0,4
		160408 NGU	●	●	●	●	●	○	●	●		●	●	○	○	9,525	4,76	4,4	0,8
	7°	VCMT 160404 NGU	●	●	○	○	●	○		●	●	○			9,525	4,76	4,4	0,4	
		160408 NGU	●	●	○	○	●	○				○			9,525	4,76	4,4	0,8	

Chipbreaker for General Turning

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