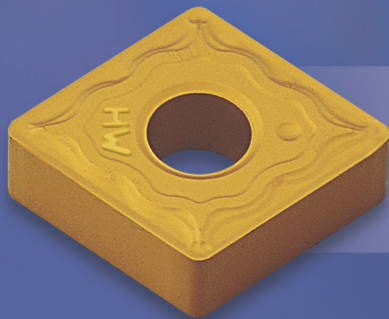


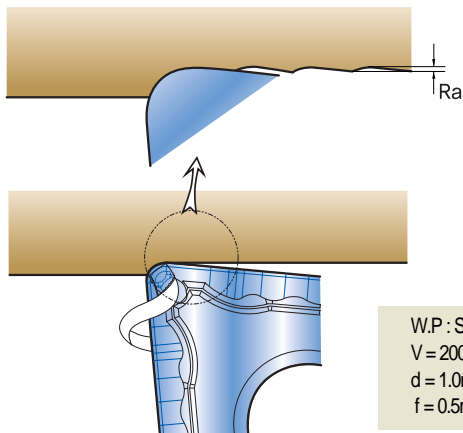
H-Series Chip-Breaker for high efficiency in finishing

Wiper Insert HW



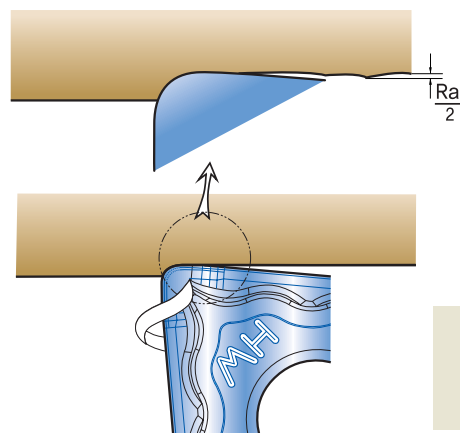
1. Upgraded toughness in a general feed rate.
2. High productivity and excellent toughness in high speed of cut and high feed rate.
3. Specially developed Recess cutting edge and Wiper cutting edge reduce cutting resistance.

General Insert



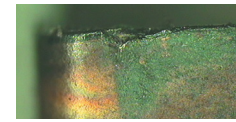
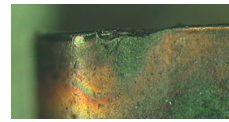
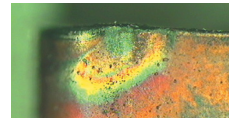
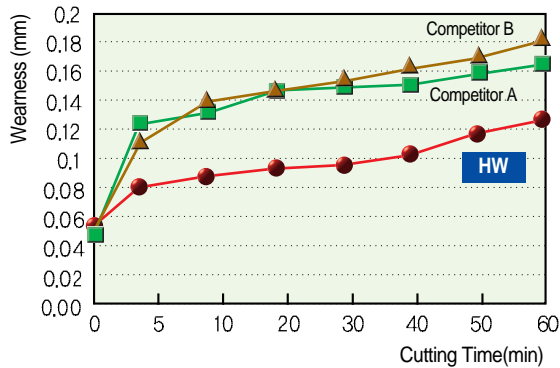
W.P : SCM440
V = 200m/min
d = 1.0mm
f = 0.5mm/rev

Wiper Insert HW



W.P : SCM440
V = 200m/min
d = 1.0mm
f = 0.5mm/rev

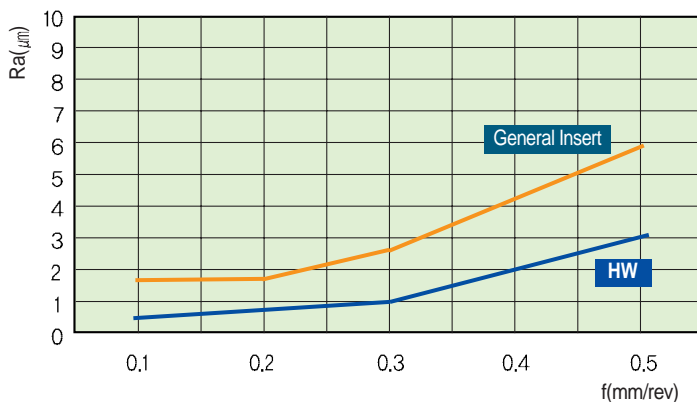
HW Wear-resistance



Wear-resistance

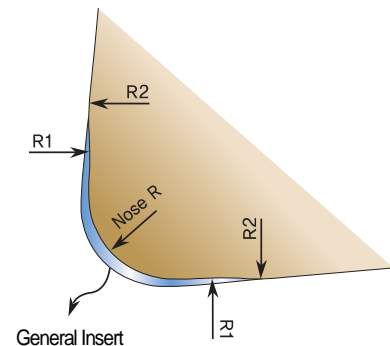
1. Work-piece : SCM440(DIN 42CrMo 4)
2. Condition : V=200m/min, f=0.5mm/rev, d=0.5mm
3. Description : CNMG120408-HW(K15 Grade)

HW Surface-finishing



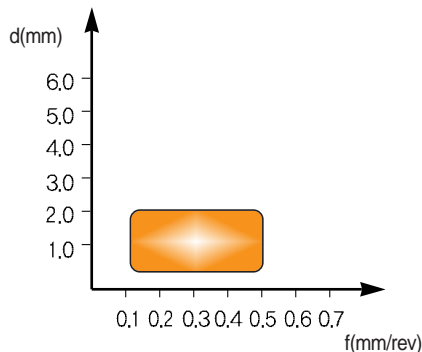
Description : CNMG120408-HW, Grade : NC320
V=200m/min d=1.0mm

Feature of Cutting Edge



- ◆ R1(Recess Cutting edge) → Reduce Cutting resistance
- ◆ R2(Wiper Cutting edge) → Upgrade Surface finish

HW Application & Recommendation



Description	Cutting Speed			feed	D.O.C
	P10	P20	K15		
	NC310	NC320	NC315K	f (mm/rev)	d (mm)
CNMG120404-HW	200~350	180~300	150~270	0.1~0.5	0.3~1.5
CNMG120408-HW	200~350	180~300	150~270	0.1~0.5	0.5~2.0
CNMG120412-HW	200~350	180~300	150~270	0.1~0.5	0.8~2.0