

GS Chip-breaker

The revolution on HRSA Turning



GS
CHIP-BREAKER

NEW

PHH

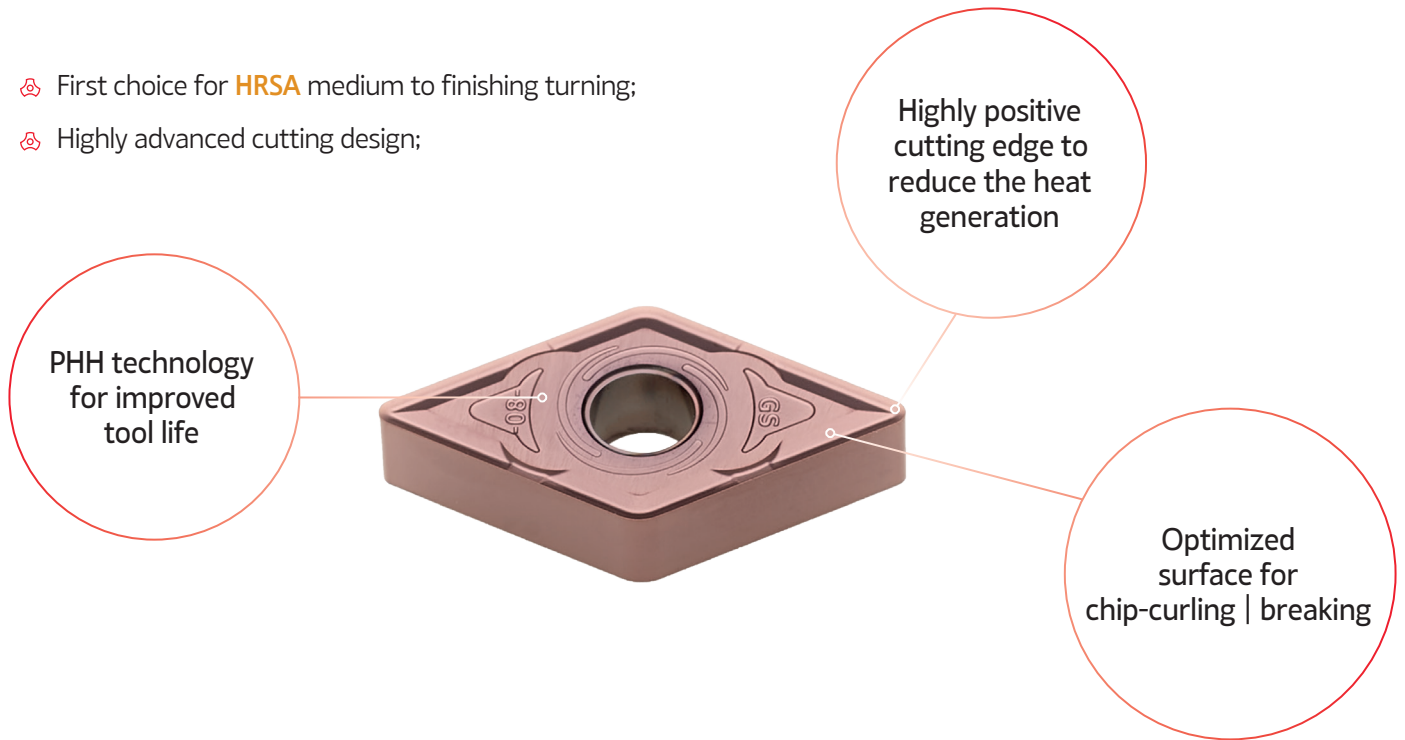
NEW
GRADE



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.

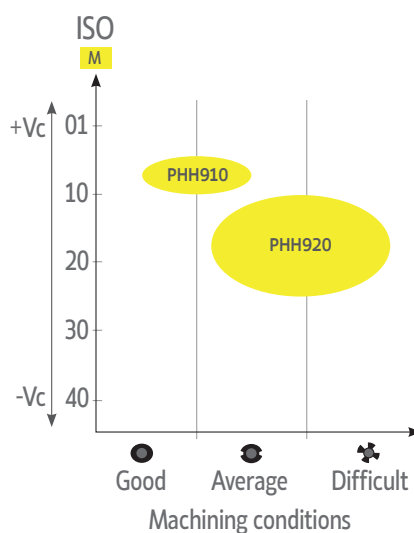


First choice for HRSA.

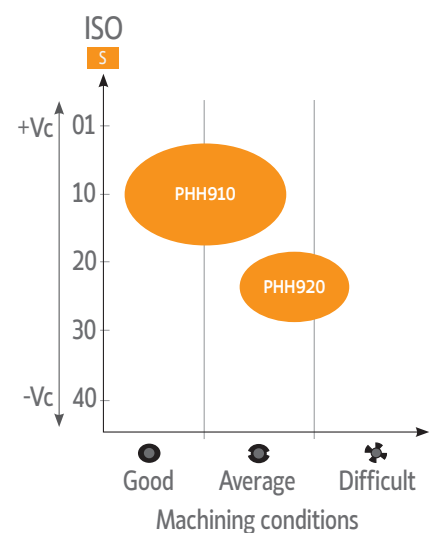


Solution for general turning of stainless steels and HRSA.

M - STAINLESS STEEL

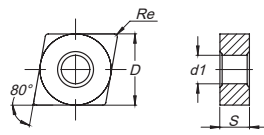
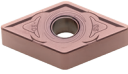
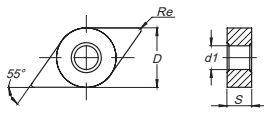
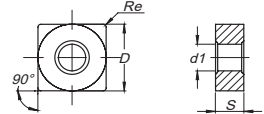
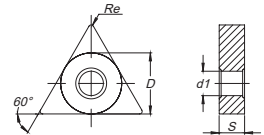
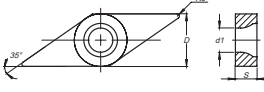
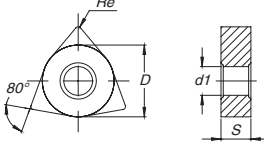


S - HEAT RESISTANT / TITANIUM ALLOYS

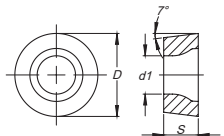


			M		S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting Conditions Condições de Corte Condiciones de Corte						Technical drawing Desenho técnico Dibujo técnico
			PVD		PVD												
			(2) Grade code		X6	Y3	X6	Y3									
Inserts Pastilhas Plaquetas	(1) Geometry code	ISO Reference	PHH910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

NEGATIVE INSERTS

	CNMG-GS	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	
	DNMG-GS	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	
	SNMG-GS	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	
	TNMG-GS	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	
	VNMG-GS	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	
	WNMG-GS	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

	RCMT-GS	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	

 First choice | 1ª Escolha | 1ª Opción  Stock Items | Itens de stock  Available under request | Disponível sob consulta | Disponible bajo consulta

Insert Order Code: (1) Geometry code + (2) Grade code

GS Chip-breaker

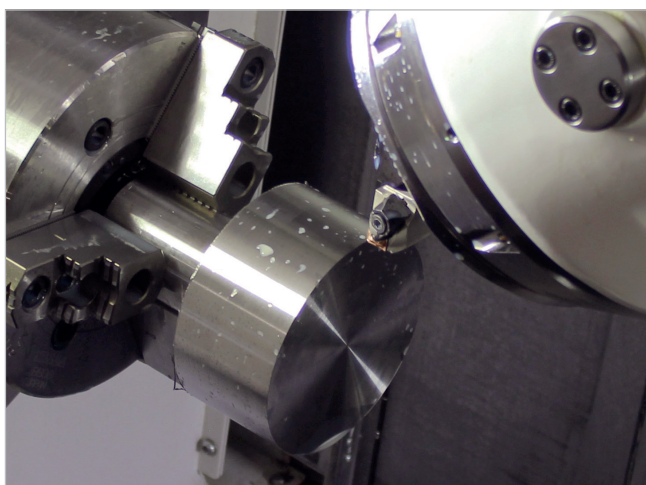
The revolution on HRSA Turning

NEW

TEST REPORT || Relatório de teste | Informes de prueba

Toolholder: DCLN L 2525 M12 060 13

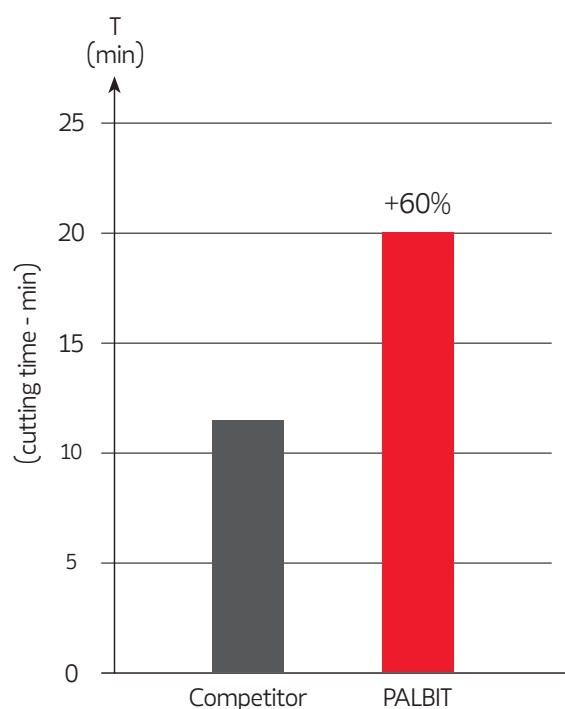
Insert: CNMG 120408-GS PHH910 vs Competitor Equivalent



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

T - V_{bmax} (0,4 mm)



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