

Tungaloy

Member IMC Group

Keeping the Customer First

Tungaloy Report No.009-USA

January 2009

JS Chipbreaker for Swiss Turning & Small Lathes

JS Chipbreaker

New 3 dimensional chipbreaker with excellent chip control for stainless steel and titanium



JS Chipbreaker

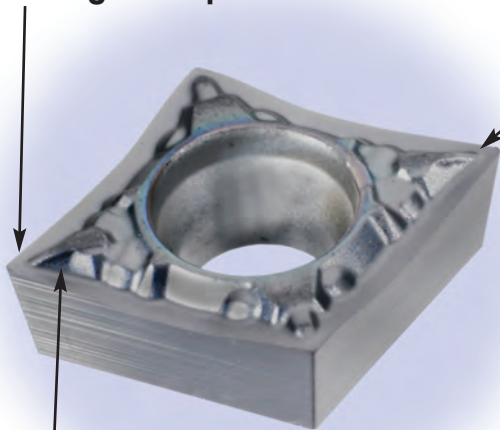


Tungaloy America, Inc.

JS Chipbreaker - Positive G Class Insert

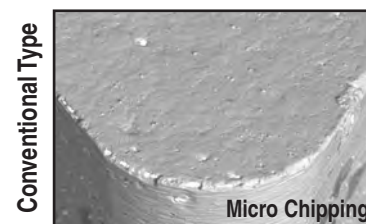
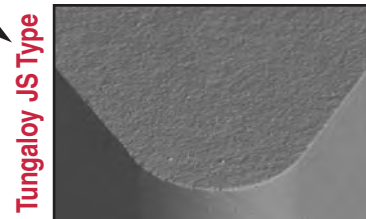
Dynamic Inclination

- Improved chip control
- Low cutting force prevents dimensional changes



JS Chipbreaker Super Fine Cutting Edge

- Improves surface finish



Steep Protrusion

- Improved chip coiling for profile turning

Applicable Inserts

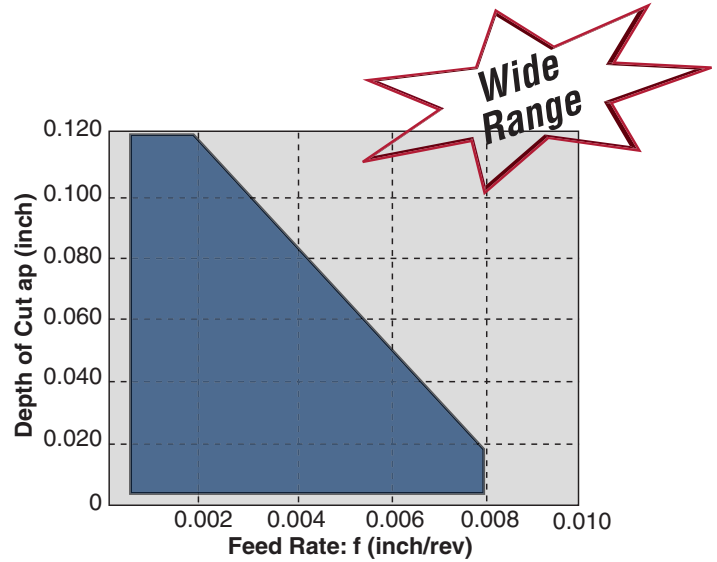
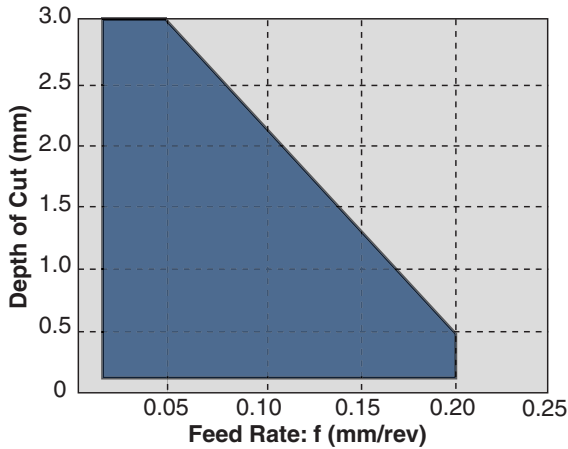
Inch Description	Metric Description	Stocked Grades
		SH730
CCGT21.5VFN-JS	CCGT060200FN-JS	●
CCGT21.50FN-JS	CCGT060201FN-JS	●
CCGT21.50.5FN-JS	CCGT060202FN-JS	●
CCGT21.51FN-JS	CCGT060204FN-JS	●
CCGT32.5VFN-JS	CCGT09T300FN-JS	●
CCGT32.50FN-JS	CCGT09T301FN-JS	●
CCGT32.50.5FN-JS	CCGT09T302FN-JS	●
CCGT32.51FN-JS	CCGT09T304FN-JS	●
DCGT21.5VFN-JS	DCGT070200FN-JS	●
DCGT21.50FN-JS	DCGT070201FN-JS	●
DCGT21.50.5FN-JS	DCGT070202FN-JS	●

Inch Description	Metric Description	Stocked Grades
		SH730
DCGT32.5VFN-JS	DCGT11T300FN-JS	●
DCGT32.50FN-JS	DCGT11T301FN-JS	●
DCGT32.50.5FN-JS	DCGT11T302FN-JS	●
DCGT32.51FN-JS	DCGT11T304FN-JS	●
TCGT21.5VFN-JS	TCGT110200FN-JS	●
TCGT21.50FN-JS	TCGT110201FN-JS	●
TCGT21.50.5FN-JS	TCGT110202FN-JS	●
TCGT21.51FN-JS	TCGT110204FN-JS	●
VBGT22VFN-JS	VBGT110300FN-JS	●
VBGT220FN-JS	VBGT110301FN-JS	●
VBGT220.5FN-JS	VBGT110302FN-JS	●
VBGT221FN-JS	VBGT110301FN-JS	●

General Cutting Conditions

Work Materials	Cutting Speed (SFM)	Feed (ipr)	Depth of Cut (in)
300 Series Stainless	150 - 480	0.0004 - 0.006	0.004 - 0.080
Ferritic/Martensitic & PH Type Stainless Steels	100 - 250	0.0004 - 0.006	0.004 - 0.080
Titanium	100 - 330	0.0004 - 0.008	0.004 - 0.120

Application



Tool Life - 316L Stainless Steel

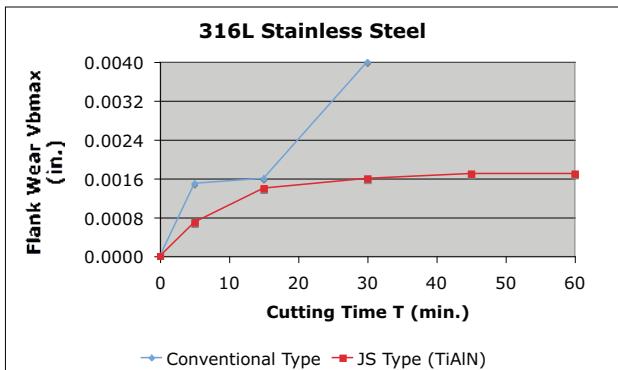
DCGT11T301-□□

 $f = 0.0006 \sim 0.001$ IPR

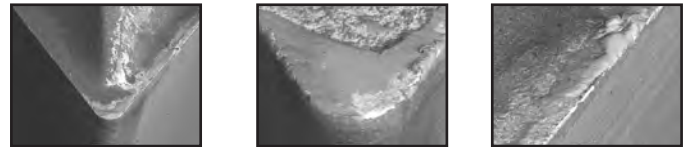
 $V_c = 600$ SFM

 $a_p = 0.020 \sim 0.080$ inch

Long Tool Life



Tungaloy JS Type - 60 min.



Conventional Type - 35 min.



Tool Life - Ti-6Al-4V Titanium

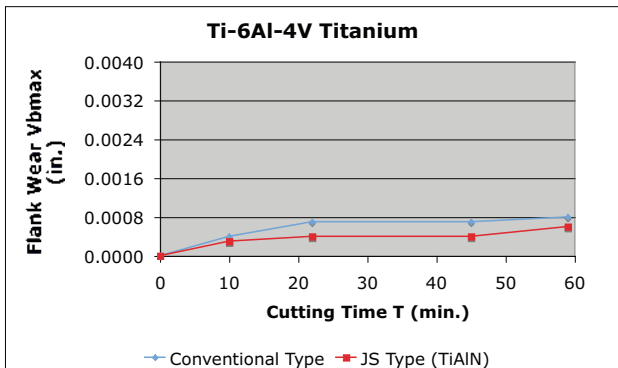
DCGT11T301-□□

 $f = 0.0006 \sim 0.001$ IPR

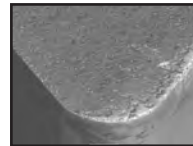
 $V_c = 600$ SFM

 $a_p = 0.020 \sim 0.080$ inch

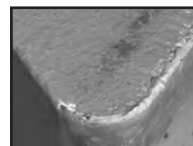
Excellent Surface Finish



Tungaloy JS Type - 60 min.



Conventional Type - 60 min.



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