

Strictly Confidential

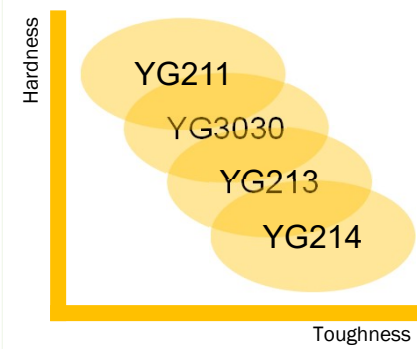
CNMG432 (120408) YG213

SS304 Chip chart



Turning Stainless Steel

Stainless Steel Grades



HARD ↑

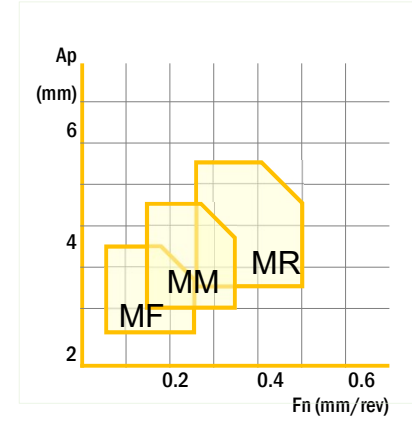
TOUGH ↓

NEW  **YG211** PVD M05-M20 S05-S25
Hard grade for Continuous Cut

 **YG3030** CVD P20-P35 M10-M30
CVD grade for High cutting speed

NEW  **YG213** PVD M25-M40 S25-S40
Tough grade for Roughing

NEW  **YG214** PVD M30-M50 S30-S50
Extremely Tough grade for Interrupted Cut



Chipbreakers



|| Hands-on in Charlotte Tech Center

- Develop a deep understand the relationships between our stainless geometries and how the chip area impacts chip control
- Show difference in chip breaking at same cutting data for MF, MM, MR
- Material: SS304
- Same speed for all passes
 - V_c 600/183m
- CNMG432/120408 for all geometries
- Same grade, YG213, for all geometries
- Same holder, MCLNL164D



Hands-on

- Material: 304
- Grade: YG213
- Vc: 600SFM/183m

	Ap	Fn	Fn	Fn
CNMG432-MF	0.010"	0.002"	0.004"	0.008"
	0.020"	0.002"	0.004"	0.008"
	0.050"	0.002"	0.004"	0.008"
CNMG432-MM	0.020"	0.004"	0.008"	0.012"
	0.050"	0.004"	0.008"	0.012"
	0.100"	0.004"	0.008"	0.012"
CNMG432-MR	0.050"	0.008"	0.012"	0.016"
	0.100"	0.008"	0.012"	0.016"
	0.150"	0.008"	0.012"	0.016"

	Ap	Fn	Fn	Fn
CNMG120408-MF	0.25mm	0.05mm	0.1mm	0.2mm
	0.5mm	0.05mm	0.1mm	0.2mm
	1.25mm	0.05mm	0.1mm	0.2mm
CNMG120408-MM	0.5mm	0.1mm	0.2mm	0.3mm
	1.25mm	0.1mm	0.2mm	0.3mm
	2.5mm	0.1mm	0.2mm	0.3mm
CNMG120408-MR	0.5mm	0.2mm	0.3mm	0.4mm
	1.25mm	0.2mm	0.3mm	0.4mm
	2.5mm	0.2mm	0.3mm	0.4mm



f_n 0.002"/0.05mm

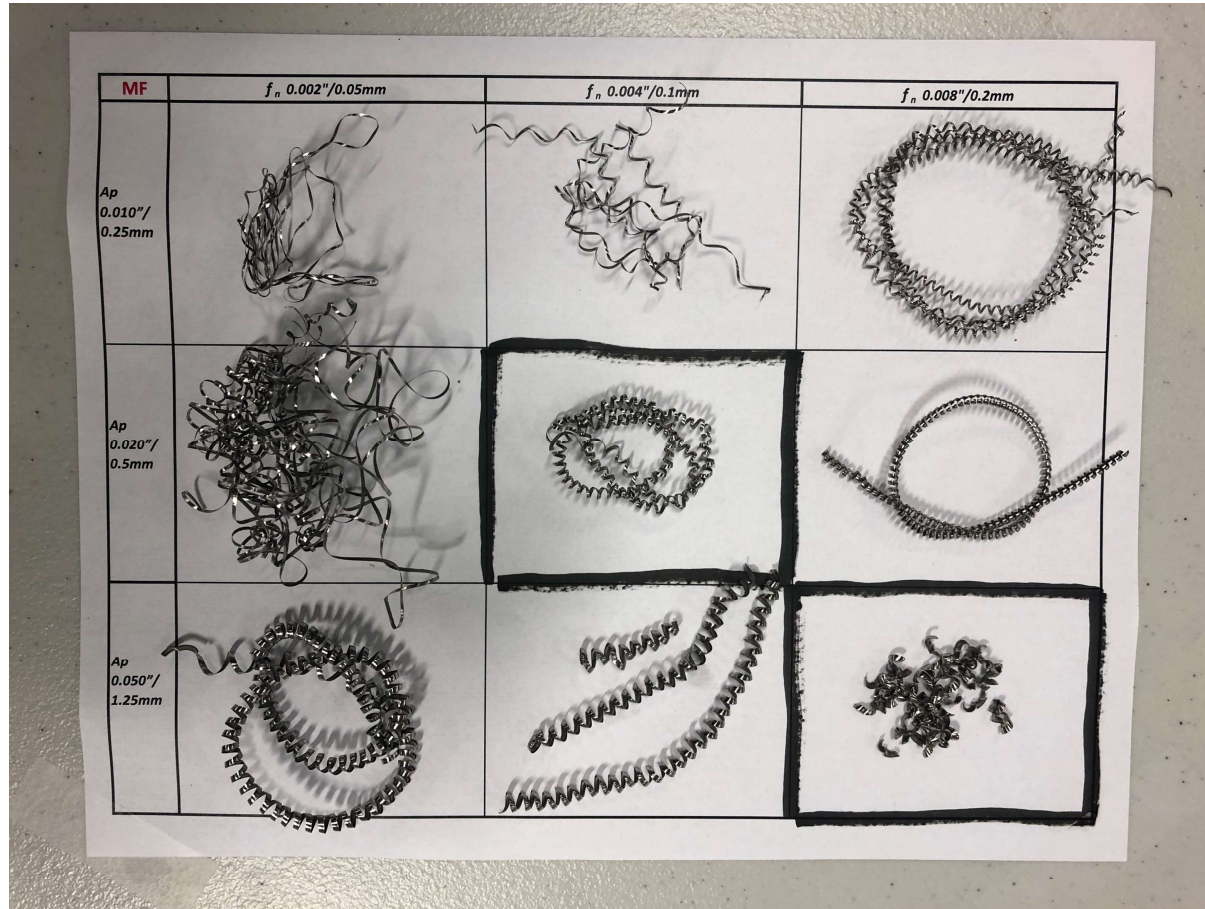
f_n 0.004"/0.1mm

f_n 0.008"/0.2mm

A_p
0.010"/
0.25mm

A_p
0.020"/
0.5mm

A_p
0.050"/
1.25mm





f_n 0.004"/0.1mm

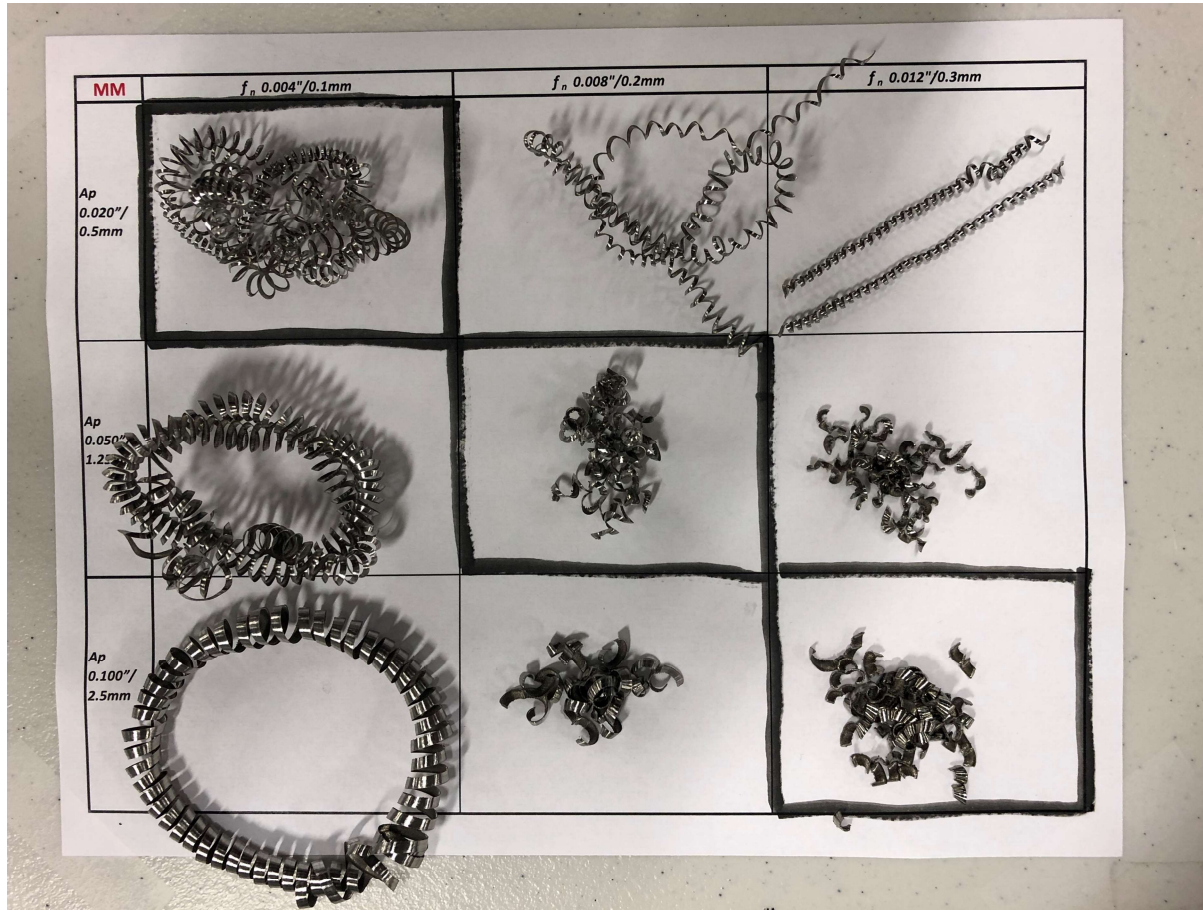
f_n 0.008"/0.2mm

f_n 0.012"/0.3mm

A_p
0.020"/
0.5mm

A_p
0.050"/
1.25mm

A_p
0.100"/
2.5mm





f_n 0.008"/0.2mm

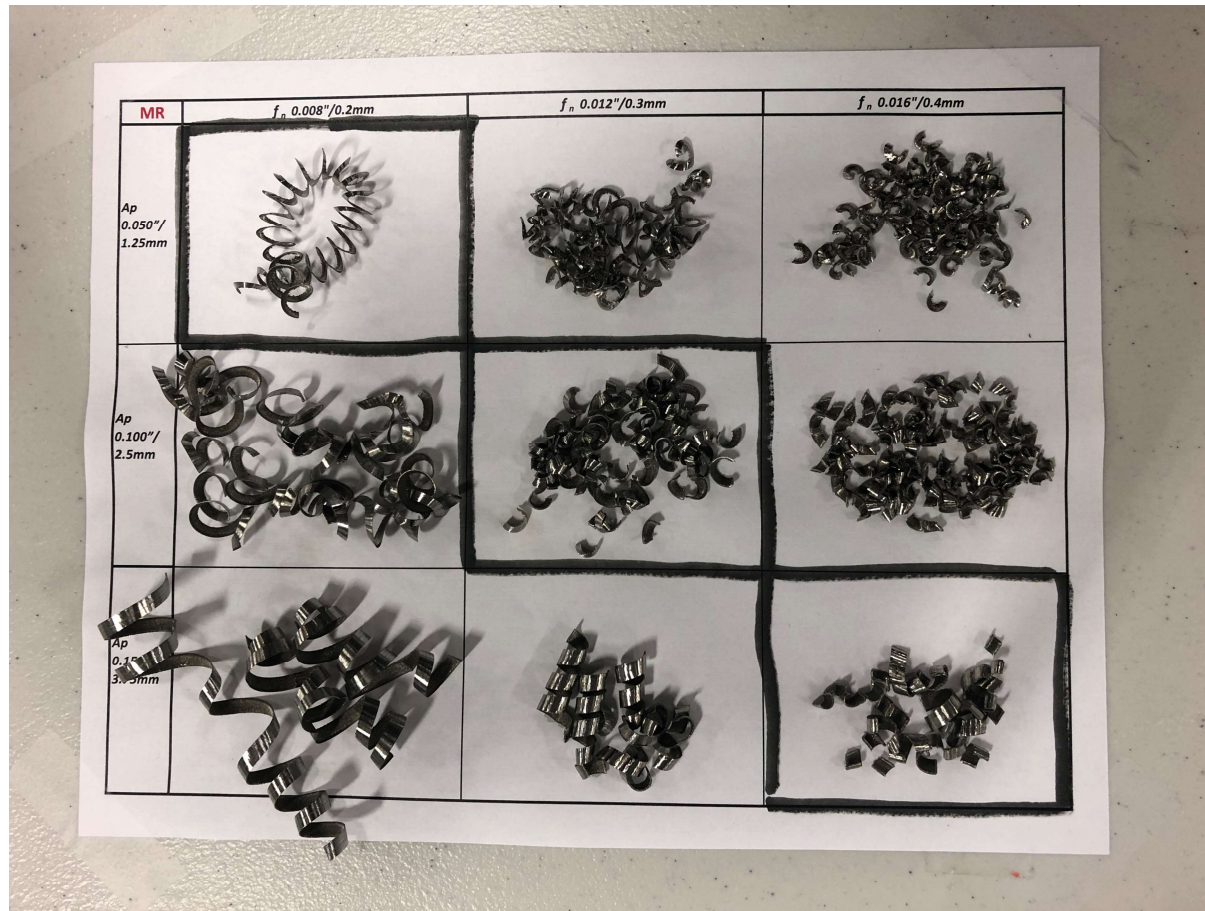
f_n 0.012"/0.3mm

f_n 0.016"/0.4mm

A_p
0.050"/
1.25mm

A_p
0.100"/
2.5mm

A_p
0.150"/
3.75mm





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