



## TOOLHOLDER KITS WITH INSERTS


- **CHIPBREAKER GUIDE**
- **GRADE GUIDE**
- **CUTTING DATA**



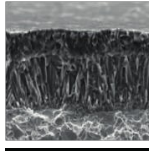
**BG Chipbreaker**  
For medium turning of steels under stable conditions



**MM Chipbreaker**  
For medium turning of stainless steels under stable conditions



**SM Chipbreaker**  
For medium turning of clean HRSA materials



**ET32C**  
CVD Coated. Versatile grade for a wide variety of steels.  
**P15 - P30**



**ET23P**  
PVD Coated. For mid range turning of stainless steel.  
**M20 - M35**



**ET41P**  
PVD Coated. For mid range turning of clean HRSA material.  
**S05 - S15**

### CUTTING DATA

INSERT	RE (mm)	f <sub>n</sub> (mm/rev)	a <sub>p</sub> (mm)	P	M	S
				ET32C	ET23P	ET41P
				CVD	PVD	
<b>CNMG 120408-BG</b>	0.8	0.20 - 0.40	1.0 - 3.0	● 00465		
<b>CNMG 120408-MM</b>	0.8	0.20 - 0.35	1.0 - 3.5		● 00646	
<b>CNMG 120408-SM</b>	0.8	0.15 - 0.30	1.0 - 3.0			● 01034
<b>DNMG 150608-BG</b>	0.8	0.20 - 0.40	1.0 - 3.0	● 00491		
<b>DNMG 150608-MM</b>	0.8	0.20 - 0.35	1.0 - 3.5		● 00649	
<b>DNMG 150608-SM</b>	0.8	0.15 - 0.30	1.0 - 3.0			● 01046

► EDP Code TI..... Example: CNMG 120408-BG ET32C = TI00465. Pk. qty 10

ISO		P			M		S
MATERIAL	Non-alloy steel	Low alloy steel	High alloy steel	Ferritic / Martensitic Stainless steel	Austenitic Stainless steel	Heat Resistant and Super Alloys	
	VDI GROUP	1-5	6-9	10-11	12-13	14	31-37
V <sub>c</sub> (m/min)	ET32C	180 - 380	110 - 350	60 - 300	-	-	-
	ET23P	-	-	-	110 - 180	40 - 130	-
	ET41P	-	-	-	-	-	20 - 55