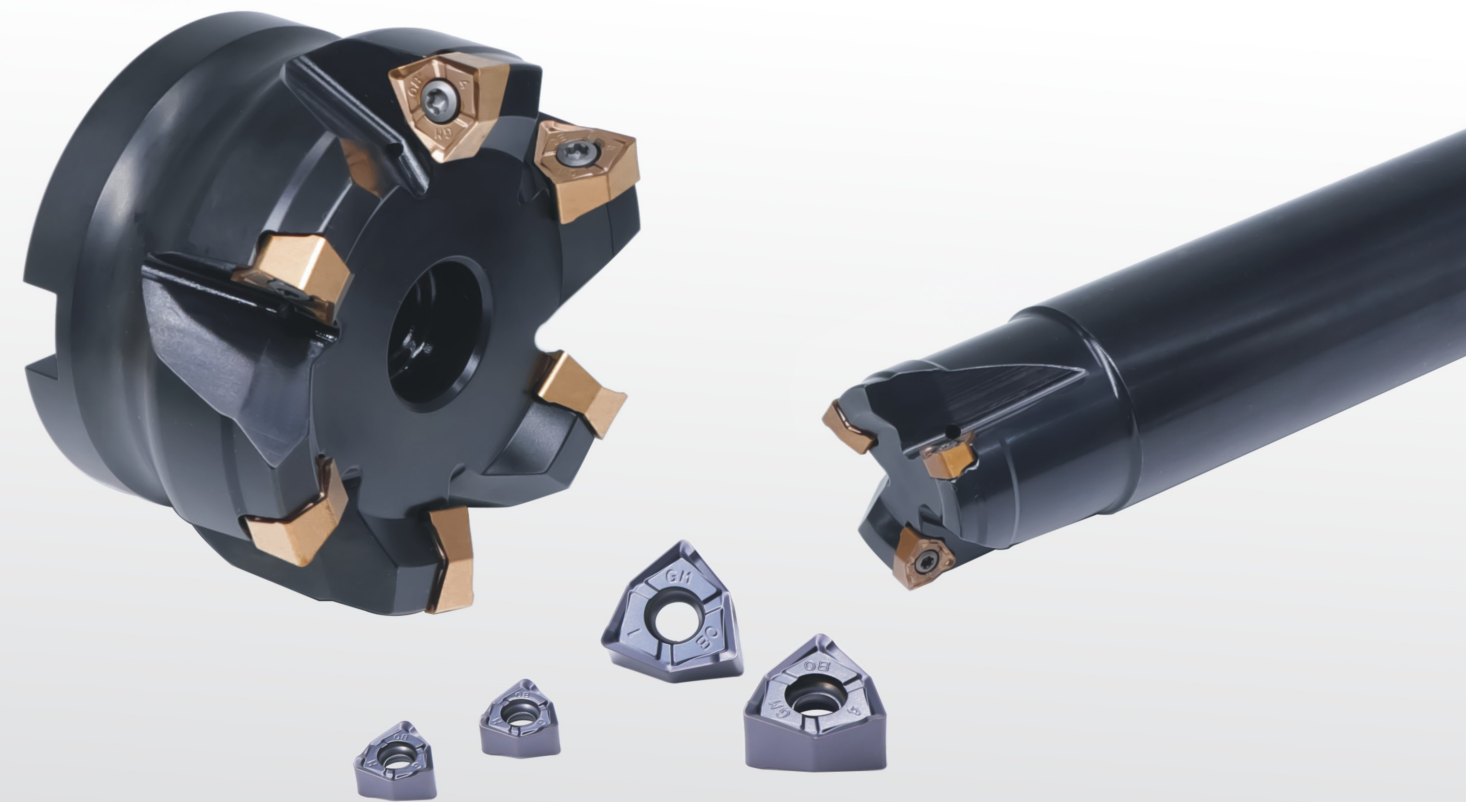


**2021-2022
PRODUCT CATALOGUE**



ZHUZHOU HUARUI PRECISION CUTTING TOOLS CO., LTD.





COMPANY PROFILE

Zhuzhou Huarui Precision Cutting tools Co. , Ltd. (Stock Code: 688059) was established in March 2007 with a registered capital of 44, 008, 000 CNY. As an advanced cutting tool manufacturer in China, HUARUI upholding the development strategy of "Independent Research & Development, Continuous Innovation", focus on the R&D, manufacture, sales and application of cemented carbide CNC cutting insert, constantly pursuing the improvement in overall performance and optimization in fabrication technology.

Relying on the multi-year technological accumulation and skilled talents, together with the intergration, assimilation and absorbtion of advanced equipment, HUARUI has formed their own independent core technology in the fields of "Substrate material", "Chip-breaker geometry", "Precision forming" and "Surface coating", and developed "Turning series", "Milling series" and "Drilling series" as the three major product range.

HUARUI is proud of their core product being the domestic leading level for their efficiency, long service life and cutting accuracy, successfully entered the high end markets which long time dominated by Europe, USA, Japan and Korea companies, Especially the milling series, it has formed a significant competitive advantage.

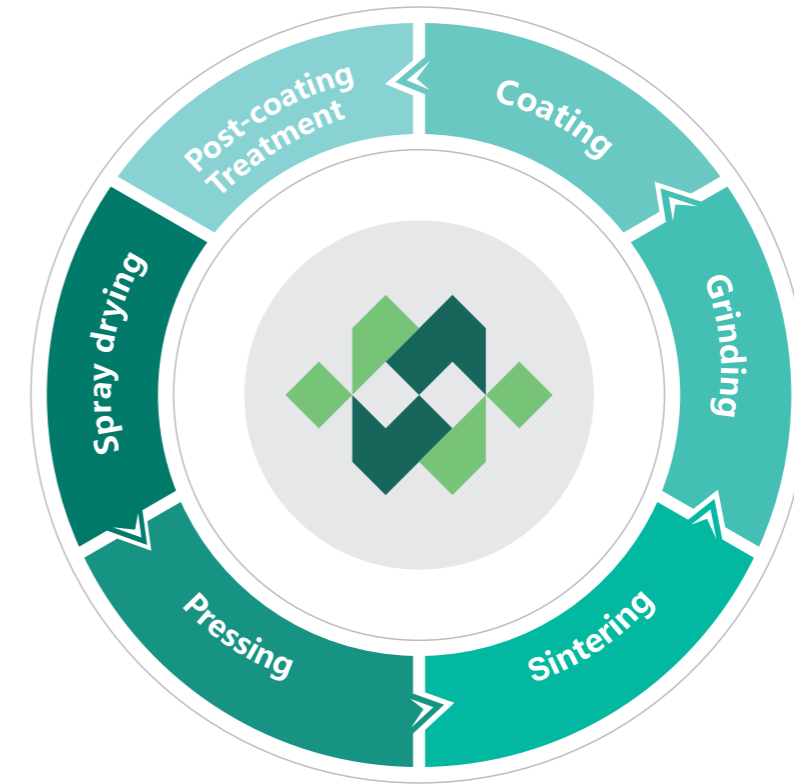
HUARUI has been awarded as the "National High-tech Enterprise", "National Small Giant Enterprise", "Hunan Province Recognized Enterprise Technology Center" and "100 Major Scientific and Technological Innovation Project 2020 Implementation Plan enterprise". Their "HARDSTONE" brand has been selected as the "Customer Satisfaction Brand" in the 4th Cutting Tool User Survey. And the independently developed FM series milling inserts has been awarded the "Golden Edge Awards" and "Ringier Technology Innovation Awards".

HONOR



TECHNOLOGY

HUARUI has a full set of process equipments and complete production line for CNC cutting insert manufacturing from powder material preparation, mould making, compression forming, pressure sintering, grinding, coating, post coating treatment to automatic packing. At the meantime, HUARUI adopt the R&D strategy of "Concentrate advantages to breakthrough each single product", focusing on the research and innovation of cemented carbide CNC cutting insert at the areas of substrate materials, chip breaker geometry, precision mould machining and surface coating, continuously improve the machining accuracy, efficiency and extend the service life. After more than ten years scientific research innovation, HUARUI has mastered lots of independent core technologies, possess strong independent R&D and design capabilities, and the overall technical strength has achieved the national advanced level.



CATALOGUE

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- ◆ Threading insert..... C3-01-03

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- ◆ Grooving insert..... B2-01
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D Drilling

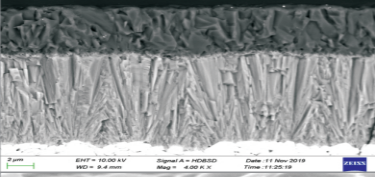
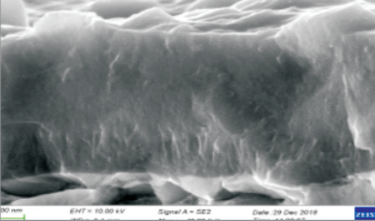
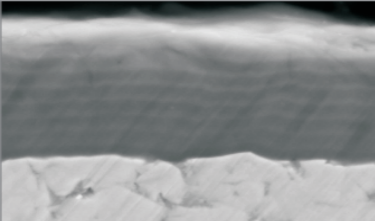
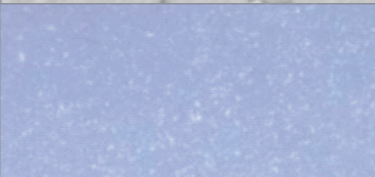
- ◆ Drilling insert..... D4-01

E Milling

- ◆ The introduction of grade..... E5-01-02
- ◆ Insert identification system..... E5-03-04
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- ◆ Milling tool..... E5-16-23
- ◆ Cases..... E5-24-28



The introduction of grade

Grade	Coating				Characteristics	Application	ISO	Wear Resistance ← Toughness															
	Type	Color	Metallographic Structure	Composition				01	05	10	15	20	25	30	35	40	45						
WS6115	CVD	Black		TiN+MT -TiCN+Al ₂ O ₃	The thickened CVD black diamond coating with special coating post-treatment, provide excellent wear resistance and toughness. Combined with the corresponding substrate, it has better universality and widely used in all kinds of cast iron machining.	It is a preferred grade for the turning of gray iron and ductile cast iron, with excellent comprehensive performance, it is also suitable for general interrupted machining, It can be used for low speed roughing of quenched steel and high strength steel.	K10-K20																
WS5225	PVD	bronze		TiAlSiN	The special proportion of ingredients, with rare metals added, actively improves bending strength and heat-cack resistance of the substrate, together with the highest level cutting nose and cutting edge treatment technology, and the latest nano coating containing Si+ elements, greatly ensured the cutting insert with high hardness, wear resistance and sharpness.	It is an exclusive grade for threading of various materials.	P10-P25 M10-M25 K10-K25																
WS5231	PVD	purple bronze		AlCrN+ TiSiN	The ultra-fine grainsize substrate material and special ingredient ratio actively improves the bending strength and wear resistance of the substrate, greatly reduced the crack risk of cutting edge. The PVD nano composite multi-layer coating effectively prevent the formation of longitudinal cracks. and the meantime, the small friction coefficient coating surface provide strong sticking resistance.	It is an exclusive grade for the drill machining of various materials.	P20-P35 M20-M35 K20-K35																
WSK10	Un-coated	Silver grey		(K10)	Uniform and fine grain substrate material present high bending strength and good wear resistance; The fine treatment of cutting nose and cutting edge greatly ensured the sharpness and provide stable comprehensive performance.	It is used for turning, milling of graphite, cast iron and other non-ferrous metal materials like aluminum, copper, etc. It can also used for low speed turning of titanium alloy and high temperature alloy.	K05-K10																

A

Turning

Grooving

Threading

Drilling

Milling

Insert identification system

Insert Shape			Chip-breaker and Clamping system							
			B	With	Without		N	Without	Without	
			H	With	Single-Side		R	Without	Single-Side	
			C	With	Without		F	Without	Double-Side	
			J	With	Double-side		A	With	Without	
			W	With	Without		M	With	Single-Side	
		Others	T	With	Single-Side		G	With	Double-Side	
			Q	With	Without		X	-	---	
			U	With	Double-side					
			Code	Hole	Chip-breaker	Section Plane	Code	Hole	Chip-breaker	Section Plane

C N M G

Clearance angle of main cutting edge

Code	Clearance angle	Code	Clearance angle
A		B	
C		D	
E		F	
G		N	
P		O	Others

Tolerance (mm)										
Code	Nose height Tolerance(m)	Inscribed circle(ΦD)	Thickness Tolerance(s)	◆ M-level tolerance(Identified by shape)						
				◆ Tolerance of tool tip height (mm)						
Code	Inscribed circle	Regular triangle	Square	Rhombus with 80°	Rhombus with 55°	Rhombus with 35°	Round			
A	±0.005	±0.025	±0.025	6.35	±0.08	±0.08	±0.08	±0.11	±0.16	---
F	±0.005	±0.013	±0.025	9.525	±0.08	±0.08	±0.08	±0.11	±0.16	---
C	±0.013	±0.025	±0.025	12.7	±0.13	±0.13	±0.13	±0.15	---	---
H	±0.013	±0.013	±0.025	15.875	±0.15	±0.15	±0.15	±0.18	---	---
E	±0.025	±0.025	±0.025	19.05	±0.15	±0.15	±0.15	±0.18	---	---
G	±0.025	±0.025	±0.13	25.4	---	±0.18	---	---	---	---
J	±0.005	±0.05±0.13	±0.025	◆ Inscribed circle(ΦD)Tolerance						
Code	Inscribed circle	Regular triangle	Square	Rhombus with 80°	Rhombus with 55°	Rhombus with 35°	Round			
K	±0.013	±0.05±0.13	±0.025	6.35	±0.05	±0.05	±0.05	±0.05	±0.05	---
L	±0.025	±0.05±0.13	±0.025	9.525	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05
M	±0.08±0.18	±0.05±0.13	±0.13	12.7	±0.08	±0.08	±0.08	±0.08	---	±0.08
N	±0.08±0.18	±0.05±0.13	±0.025	15.875	±0.10	±0.10	±0.10	±0.10	---	±0.10
U	±0.13±0.38	±0.08±0.25	±0.13	19.05	±0.10	±0.10	±0.10	±0.10	---	±0.10
				25.4	---	±0.13	---	---	---	±0.13

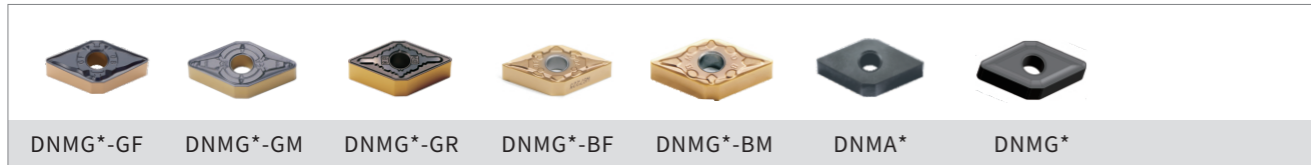
Diameter of IC(mm)	Length of Cutting Edge								Insert Thickness			
	C	D	R	S	T	V	W	K	Code	Thickness(mm)		
32.00					32					12	12.70	
31.75					31					10	11.11	
25.40					25	25				T9	9.72	
25.00	25	25			25					09	9.52	
20.00					20					07	7.94	
19.05	19				19	19	33			T6	6.75	
16.00		19			16					06	6.35	
15.875	16				15	16	27			T5	5.95	
12.70	12	15			12	12	22	22	08	05	5.56	
12.00					12					T4	4.96	
10.00					10					04	4.76	
9.525	09	11			09	09	16	16	06	16	T3	3.97
8.00					08					03	3.18	
6.35	06	07			06		11	11		T2	2.58	
6.00					06					02	2.38	
5.56							09			T1	1.98	
5.50										01	1.59	
3.97							06			T0	0.99	
										00	0.79	

12 04 08 - GF (ISO)
4 3 2 (inch)

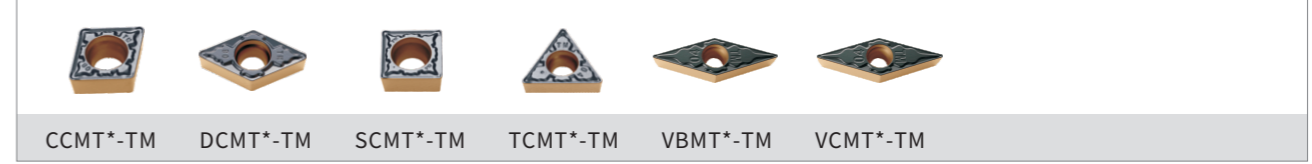
Inscribed Circle		Thickness		Nose Radius		Nose Radius Code		Chip-Breaker Code		
Code	Diameter of IC(mm)	Code	Thickness (mm)	Code	Nose Radius (mm)	Code	Nose Radius (mm)	GF	GM	TM
2	6.35	2	3.18	0	0.2	00	No Radius			
3	9.525	3	4.76	1	0.4	02	0.2			
4	12.7	4	6.35	2	0.8	04	0.4			
5	15.875	5	7.94	3	1.2	08	0.8			
6	19.05	6	9.52	4	1.6	12	1.2			
8	25.4			5	2.0	16	1.6			
				6	2.4	20	2.0			
						24	2.4			
						32	3.2			
						X	Others			
							Diameter of Inserts (Metric)			
							Round Inserts			

Overview

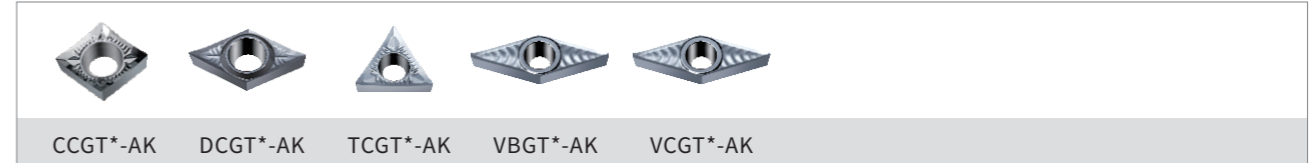
● Negative insert



● Positive Insert

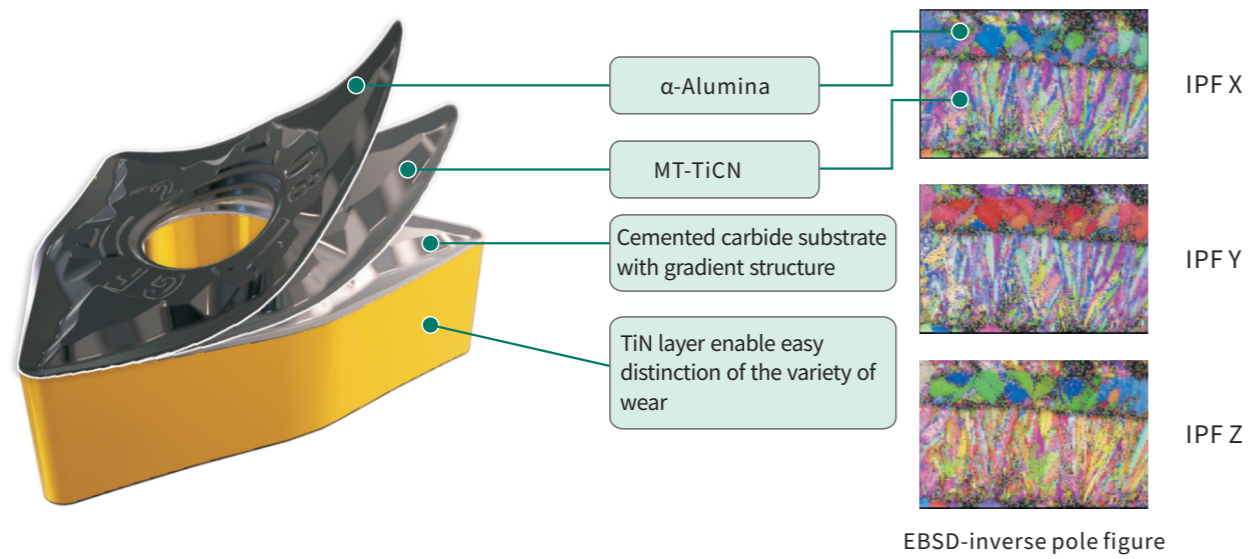


● Aluminium insert

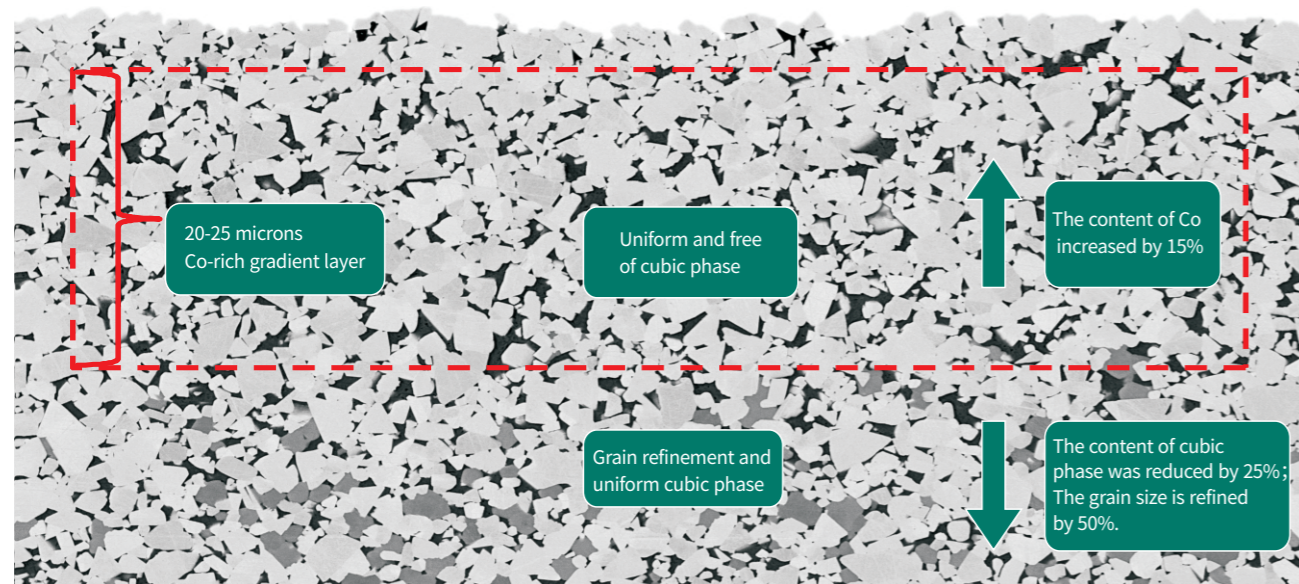


New Grade

WS8215\WS8135

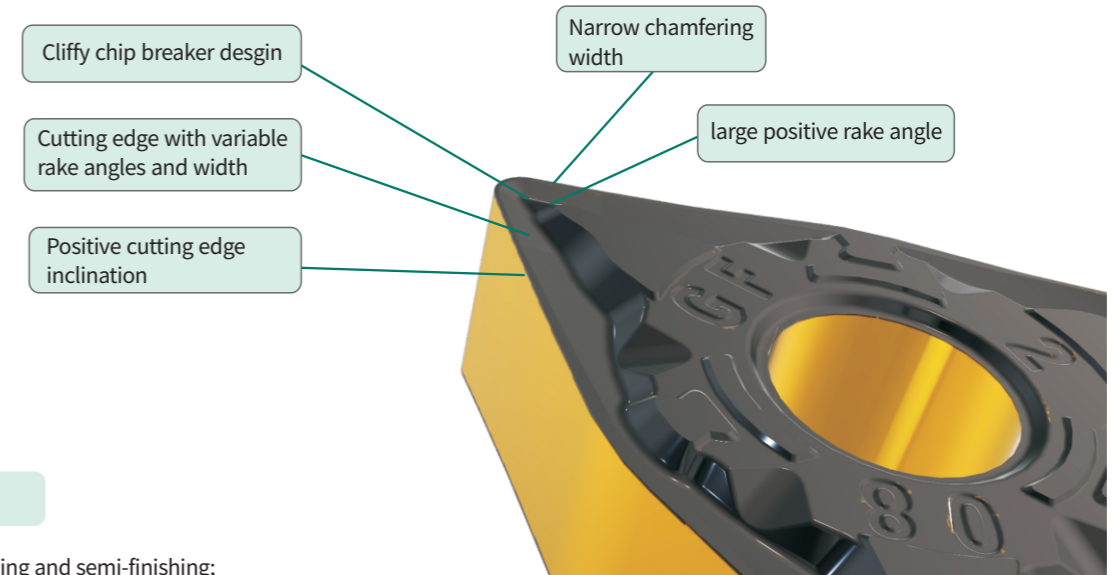


WS8215\WS8135



Introduction of chip-breaker

Steel machining

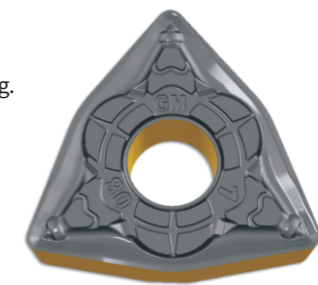


GF

- ◆ Used for finishing and semi-finishing;
- ◆ Large positive rake angle for smaller cutting resistance
- ◆ Positive cutting edge inclination effectively controls the cutting flow direction
- ◆ Two-section chip-breaker design ensures good chip breaking performance at small depth of cut.

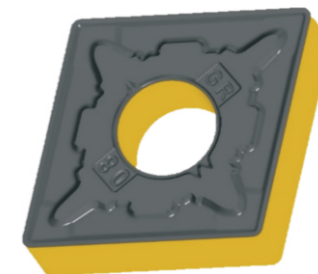
GM

- ◆ Used for semi-finishing and realizes high-efficiency and high-stability machining.
- ◆ Specially designed cutting edge perfectly combines sharpness and strength; Curved rake face consists of cutting edge with variable rake angles and width that makes controlling the chipping flow direction valid.
- ◆ Good versatility with a wide range of cutting.



GR

- ◆ Used for light-load roughing, semi-finishing.
- ◆ The cutting edge of chip-breaker makes controlling the chipping flow direction valid at small depth of cut.
- ◆ Specially designed large rake angle with wide land combine sharpness and strength.
- ◆ Good chip breaking performance and versatility with economical double-face chipbreaker.



Stainless steel machining

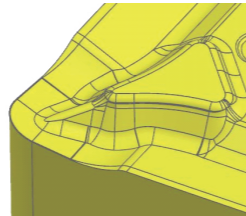
Features

- ◆ Specially designed chip-breaker is excellent in roughing , semi-finishing and finishing of stainless steel.
- ◆ BF chip-breaker used for finishing, semi-finishing and achieve good surface quality. Specially designed chip-breaker effectively eliminat the phenomena of burr.
- ◆ BM chip-breaker used for semi-finishing ,roughing and combine sharpness and strength. It is first choice for machining of stainless steel.
- ◆ Effectively cut off stainless steel and avoid adhering and surface hardening, achieving high surface quality.
- ◆ Specially designed chip-breaker makes controlling the chipping flow direction valid, which enables it to cut lightly and easily and reduce the occurrence of built-up edges.
- ◆ Different designs of cutting edge for roughing, semi-finishing and finishing.
- ◆ Inserts for finishing and semi-finishing focus on the sharpness of the cutting edge and inserts for roughing focus on optimal design of cutting edge, which achieves balance between edge security and sharpness and improve the efficiency of the insert.

Features of chip-breaker

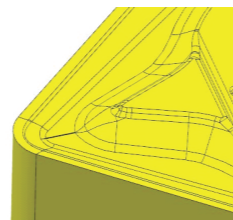
BF

- ◆ Used for finishing and semi-finishing.
- ◆ Sharp cutting edge, small cutting resistance.
- ◆ Good chip breaking performance at small depth of cut.
- ◆ Special edge treatment reduce the occurrence of built-up edges.



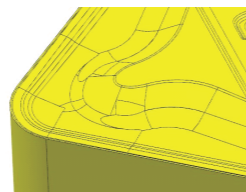
BM

- ◆ Used for semi-finishing and roughing
- ◆ Cutting edge is designed to combine sharpness and strength with a wide range of cutting.
- ◆ Good chip breaking performance, small cutting resistance.



BR

- ◆ Sturdy cutting land, used for interrupted machining and roughing.
- ◆ Well-proportioned cutting edge passivation.
- ◆ Optimized chipbreaker.
- ◆ Large space of chip-breaker is suited to roughing at high feed rate.



Cast iron machining

Features of chip-breaker

All round

- ◆ Double-sided chip-breaker with good versatility for K-type materials.
- ◆ Recommended cutting parameters: $a_p: 0.20-8.00$ $f_n: 0.15-0.60$



Without Chip-breaker

- ◆ Brittle and high hardness materials with high cutting edge strength ensure a perfect fit of holder. It is suitable for machining cast iron under unstable working conditions.



Positive chip-breaker

TM

- ◆ Used for semi-finishing with good versatility.
- ◆ With M-level tolerance, it is suitable for internal and external machining of steel, stainless steel, cast iron, etc.



Parting and grooving

Features

- ◆ QCMB can be used for grooving and turning with good versatility.
- ◆ Optimized 3D chip-breaker makes controlling the chipping flow direction valid, which reduce the cutting resistance and the vibration in machining.
- ◆ The parting and grooving insert combines specially developed cemented carbide substrate and coating that achieves the balance between wear resistance and toughness, also improves the tool life and reliability.

Parting and grooving

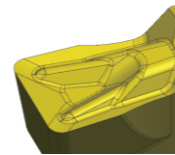
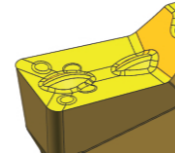
Features of chip-breaker

M

- Used for parting, grooving and turning etc. Enables it to cut lightly and easily, unobstructed chip flow and improve the surface quality.

T

- With specially designed flank, the cutting resistance can reduce by 20% and also reduces the vibration in machining and improve the surface quality. Specially designed cutting edge provides excellent chip breaking performance and can be transverse cutting feed.



Processing methods

External parting	External grooving
Face grooving	Internal grooving

Negative Insert

80° CN** With Hole



● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Diagram						Coatings										Cutting Parameters						
		L	IC	S	ød	Re	CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)					
							WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225				WS5231	WS7125	WS7225	WS7130	WSK10
	CNMG120404-GF	12.9	12.7	4.76	5.16	0.4	●	●													0.15-2.0	0.08-0.18		
	CNMG120408-GF	12.9	12.7	4.76	5.16	0.8	●	●														0.25-2.0	0.08-0.25	
	CNMG120404-GM	12.9	12.7	4.76	5.16	0.4	●	●														0.6-5.0	0.2-0.25	
	CNMG120408-GM	12.9	12.7	4.76	5.16	0.8	●	●														0.8-5.0	0.2-0.40	
	CNMG120412-GM	12.9	12.7	4.76	5.16	1.2	●	●														1.0-5.0	0.20-0.50	
	CNMG160608-GM	16.1	15.875	6.35	6.35	0.8	●	●														1.5-6.0	0.15-0.40	
	CNMG160612-GM	16.1	15.875	6.35	6.35	1.2	●	●														1.5-6.0	0.20-0.60	
	CNMG120408-GR	12.9	12.7	4.76	5.16	0.8		●														2.0-6.5	0.28-0.50	
	CNMG120412-GR	12.9	12.7	4.76	5.16	1.2		●														2.0-6.5	0.28-0.63	
	CNMG190608-GR	19.3	19.05	6.35	7.94	0.8		●														2.0-8.0	0.30-0.60	
	CNMG190612-GR	19.3	19.05	6.35	7.94	1.2		●														2.0-8.0	0.40-0.80	
	CNMG120404-BF	12.9	12.7	4.76	5.16	0.4															●	0.1-2.0	0.08-0.18	
	CNMG120408-BF	12.9	12.7	4.76	5.16	0.8															●	0.1-2.0	0.08-0.18	
	CNMG120404-BM	12.9	12.7	4.76	5.16	0.4															●	0.4-5.5	0.10-0.25	
	CNMG120408-BM	12.9	12.7	4.76	5.16	0.8															●	0.5-5.5	0.10-0.40	
	CNMG120412-BM	12.9	12.7	4.76	5.16	1.2															●	0.8-5.5	0.10-0.55	
	CNMG120408-BR	12.9	12.7	4.76	5.16	0.8															●	●	1.5-6.0	0.25-0.40
	CNMG120412-BR	12.9	12.7	4.76	5.16	1.2															●	●	1.5-6.0	0.25-0.55
	CNMG190616-BR	19.3	19.05	6.35	7.94	1.6															●	●	3.0-8.0	0.25-0.80

Negative Insert

80° CN** With Hole






● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Geometric Parameters					Coatings										Cutting Parameters											
		L	IC	S	ød	Re	CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)									
							WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225				WS5231	WS7125	WS7225	WS7130	WSK10				
	CNMA120404	12.9	12.7	4.76	5.16	0.4	●																	1.0-4.5	0.15-0.25			
	CNMA120408	12.9	12.7	4.76	5.16	0.8	●																		1.0-4.5	0.15-0.40		
	CNMA120412	12.9	12.7	4.76	5.16	1.2	●																			1.0-4.5	0.15-0.55	
	CNMA120416	12.9	12.7	4.76	5.16	1.6	●																				1.0-4.5	0.15-0.60
	CNMA160608	16.1	15.875	6.35	6.35	0.8	●																				2.0-6.0	0.15-0.40
	CNMA160612	16.1	15.875	6.35	6.35	1.2	●																				2.0-6.0	0.15-0.55
	CNMA160616	16.1	15.875	6.35	6.35	1.6	●																				2.0-6.0	0.15-0.70
	CNMA190612	19.3	19.05	6.35	7.94	1.2	●																				3.0-8.0	0.15-0.55
	CNMA190616	19.3	19.05	6.35	7.94	1.6	●																				3.0-8.0	0.15-0.80
	CNMG120404	12.9	12.7	4.76	5.16	0.4	●																			1.0-4.5	0.15-0.25	
	CNMG120408	12.9	12.7	4.76	5.16	0.8	●																				1.0-4.5	0.15-0.40
	CNMG120412	12.9	12.7	4.76	5.16	1.2	●																				1.0-4.5	0.15-0.55
	CNMG120416	12.9	12.7	4.76	5.16	1.6	●																				1.0-4.5	0.15-0.60
	CNMG160608	16.1	15.875	6.35	6.35	0.8	●																				2.0-6.0	0.15-0.40
	CNMG160612	16.1	15.875	6.35	6.35	1.2	●																				2.0-6.0	0.15-0.55
	CNMG160616	16.1	15.875	6.35	6.35	1.6	●																				2.0-6.0	0.15-0.70
	CNMG190612	19.3	19.05	6.35	7.94	1.2	●																				3.0-8.0	0.15-0.55
	CNMG190616	19.3	19.05	6.35	7.94	1.6	●																				3.0-8.0	0.15-0.80

Negative Insert

55° DN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Geometric Parameters					Coatings										Cutting Parameters												
		L	IC	S	ød	Re	CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)										
							WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225				WS5231	WS7125	WS7225	WS7130	WSK10					
	DNMG150404-GF	15.5	12.7	4.76	5.16	0.4	●	●																			0.15-2.0	0.08-0.18	
	DNMG150408-GF	15.5	12.7	4.76	5.16	0.8	●	●																				0.25-2.0	0.08-0.25
	DNMG150604-GF	15.5	12.7	6.35	5.16	0.4	●	●																				0.15-2.0	0.08-0.18
	DNMG150608-GF	15.5	12.7	6.35	5.16	0.8	●	●																				0.25-2.0	0.08-0.25
	DNMG150404-GM	15.5	12.7	4.76	5.16	0.4	●	●																				0.6-4.0	0.20-0.25
	DNMG150408-GM	15.5	12.7	4.76	5.16	0.8	●	●																				0.8-4.0	0.20-0.40
	DNMG150412-GM	15.5	12.7	4.76	5.16	1.2	●	●																				1.0-4.0	0.20-0.50
	DNMG150604-GM	15.5	12.7	6.35	5.16	0.4	●	●																				0.6-4.0	0.20-0.25
	DNMG150608-GM	15.5	12.7	6.35	5.16	0.8	●	●																				0.8-4.0	0.20-0.40
	DNMG150612-GM	15.5	12.7	6.35	5.16	1.2	●	●																				1.0-4.0	0.20-0.50
	DNMG150608-GR	15.5	12.7	6.35	5.16	0.8	●	●																				2.0-6.5	0.28-0.50
	DNMG150612-GR	15.5	12.7	6.35	5.16	1.2	●	●																				2.0-6.5	0.28-0.63
	DNMG150404-BF	15.5	12.7	4.76	5.16	0.4																		●			0.1-2.0	0.08-0.18	
	DNMG150408-BF	15.5	12.7	4.76	5.16	0.8																		●			0.1-2.0	0.08-0.18	
	DNMG150404-BM	15.5	12.7	4.76	5.16	0.4																		●			0.4-4.5	0.10-0.25	
	DNMG150408-BM	15.5	12.7	4.76	5.16	0.8																		●			0.5-4.5	0.10-0.40	
	DNMG150412-BM	15.5	12.7	4.76	5.16	1.2																		●			0.8-4.5	0.10-0.55	
	DNMG150604-BM	15.5	12.7	6.35	5.16	0.4																		●			0.4-4.5	0.10-0.25	
	DNMG150608-BM	15.5	12.7	6.35	5.16	0.8																		●			0.5-4.5	0.10-0.40	
	DNMG150612-BM	15.5	12.7	6.35	5.16	1.2																		●			0.8-4.5	0.10-0.55	

Negative Insert

55° DN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Diagram					Coatings										Cutting Parameters					
		L	IC	S	ød	Re	CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)			
							WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225				WS5231	WS7125	WS7225
	DNMA150404	15.5	12.7	4.76	5.16	0.4				●											1.0-4.5	0.15-0.25
	DNMA150408	15.5	12.7	4.76	5.16	0.8				●											1.0-4.5	0.15-0.40
	DNMA150412	15.5	12.7	4.76	5.16	1.2				●											1.0-4.5	0.15-0.55
	DNMA150604	15.5	12.7	6.35	5.16	0.4				●											1.0-4.5	0.15-0.25
	DNMA150608	15.5	12.7	6.35	5.16	0.8				●											1.0-4.5	0.15-0.40
	DNMA150612	15.5	12.7	6.35	5.16	1.2				●											1.0-4.5	0.15-0.55
	DNMG150404	15.5	12.7	4.76	5.16	0.4				●											1.0-4.5	0.15-0.25
	DNMG150408	15.5	12.7	4.76	5.16	0.8				●											1.0-4.5	0.15-0.40
	DNMG150412	15.5	12.7	4.76	5.16	1.2				●											1.0-4.5	0.15-0.55
	DNMG150604	15.5	12.7	6.35	5.16	0.4				●											1.0-4.5	0.15-0.25
	DNMG150608	15.5	12.7	6.35	5.16	0.8				●											1.0-4.5	0.15-0.40
	DNMG150612	15.5	12.7	6.35	5.16	1.2				●											1.0-4.5	0.15-0.55

Negative Insert

90° SN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Diagram					Coatings										Cutting Parameters						
		L	IC	S	ød	Re	CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)				
							WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225				WS5231	WS7125	WS7225	WS7130
	SNMG120404-GF	12.7	12.7	4.76	5.16	0.4	●	●														0.15-2.0	0.08-0.18
	SNMG120408-GF	12.7	12.7	4.76	5.16	0.8	●	●														0.25-2.0	0.08-0.25
	SNMG120404-GM	12.7	12.7	4.76	5.16	0.4	●	●														0.4-5.5	0.10-0.25
	SNMG120408-GM	12.7	12.7	4.76	5.16	0.8	●	●														0.5-5.5	0.10-0.40
	SNMG120412-GM	12.7	12.7	4.76	5.16	1.2	●	●														0.8-5.5	0.10-0.55
	SNMG120412-GR	12.7	12.7	4.76	5.16	1.2	●															2.0-6.5	0.28-0.50
	SNMG120408-GR	12.7	12.7	4.76	5.16	0.8	●															2.0-6.5	0.28-0.63
	SNMG190608-GR	19.05	19.05	6.35	7.94	0.8	●															2.0-8.0	0.30-0.60
	SNMG190612-GR	19.05	19.05	6.35	7.94	1.2	●															2.0-8.0	0.40-0.80
	SNMG190616-GR	19.05	19.05	6.35	7.94	1.6	●															2.0-8.0	0.50-1.00
	SNMM190612-GZ	19.05	19.05	6.35	7.94	1.2	●	●														3.0-10.0	0.50-0.80
	SNMM190624-GZ	19.05	19.05	6.35	7.94	2.4	●	●														3.0-10.0	0.50-1.20
	SNMM250724-CR	25.4	25.4	7.94	9.12	2.4	●	●														5.0-15.0	0.60-1.40
	SNMM250924-CR	25.4	25.4	9.52	9.12	2.4	●	●														5.0-15.0	0.60-1.40
	SNMG120404-HAF	12.7	12.7	4.76	5.16	0.4																	
	SNMG120404-HSF	12.7	12.7	4.76	5.16	0.4																	
	SNMG120404-BF	12.7	12.7	4.76	5.16	0.4													●			0.1-2.0	0.08-0.18
	SNMG120408-BF	12.7	12.7	4.76	5.16	0.8													●			0.1-2.0	0.08-0.18
	SNMG120404-BM	12.7	12.7	4.76	5.16	0.4														●		0.4-5.5	0.10-0.25
	SNMG120408-BM	12.7	12.7	4.76	5.16	0.8														●		0.5-5.5	0.10-0.40
	SNMG120412-BM	12.7	12.7	4.76	5.16	1.2														●		0.8-5.5	0.10-0.55
	SNMG120408-BR	12.7	12.7	4.76	5.16	0.8			●											●		1.5-6.0	0.25-0.40
	SNMG120412-BR	12.7	12.7	4.76	5.16	1.2			●											●		1.5-6.0	0.25-0.55

Negative Insert

90° SN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Diagram					Coatings										Cutting Parameters						
		L	IC	S	ød	Re	CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)				
							WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225				WS5231	WS7125	WS7225	WS7130
	SNMA120404	12.7	12.7	4.76	5.16	0.4	●														1.0-4.5	0.15-0.25	
	SNMA120408	12.7	12.7	4.76	5.16	0.8	●														1.0-4.5	0.15-0.40	
	SNMA120412	12.7	12.7	4.76	5.16	1.2	●														1.0-4.5	0.15-0.55	
	SNMA150608	15.875	15.875	6.35	6.35	0.8	●															2.0-6.0	0.15-0.40
	SNMA150612	15.875	15.875	6.35	6.35	1.2	●															2.0-6.0	0.15-0.55
	SNMA150616	15.875	15.875	6.35	6.35	1.6	●															2.0-6.0	0.15-0.70
	SNMA190612	19.05	19.05	6.35	7.94	1.2	●															3.0-8.0	0.15-0.55
	SNMA190616	19.05	19.05	6.35	7.94	1.6	●															3.0-8.0	0.15-0.80
	SNMG120404	12.7	12.7	4.76	5.16	0.4	●														1.0-4.5	0.15-0.25	
	SNMG120408	12.7	12.7	4.76	5.16	0.8	●														1.0-4.5	0.15-0.40	
	SNMG120412	12.7	12.7	4.76	5.16	1.2	●														1.0-4.5	0.15-0.55	
	SNMG150608	15.875	15.875	6.35	6.35	0.8	●															2.0-6.0	0.15-0.40
	SNMG150612	15.875	15.875	6.35	6.35	1.2	●															2.0-6.0	0.15-0.55
	SNMG150616	15.875	15.875	6.35	6.35	1.6	●															2.0-6.0	0.15-0.70
	SNMG190612	19.05	19.05	6.35	7.94	1.2	●															3.0-8.0	0.15-0.55
	SNMG190616	19.05	19.05	6.35	7.94	1.6	●															3.0-8.0	0.15-0.80

Negative Insert

60° TN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Diagram					Coatings										Cutting Parameters							
		L	IC	S	ød	Re	CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)					
							WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225				WS5231	WS7125	WS7225	WS7130	WSK10
	TNMG160404-GF	16.5	9.525	4.76	3.81	0.4	●	●														0.15-2.0	0.08-0.18	
	TNMG160408-GF	16.5	9.525	4.76	3.81	0.8	●	●															0.25-2.0	0.08-0.25
	TNMG160404-GM	16.5	9.525	4.76	3.81	0.4	●	●															0.4-4.5	0.10-0.25
	TNMG160408-GM	16.5	9.525	4.76	3.81	0.8	●	●															0.5-4.5	0.10-0.40
	TNMG160412-GM	16.5	9.525	4.76	3.81	1.2	●	●															0.8-4.5	0.10-0.55
	TNMG220412-GM	22	12.7	4.76	5.16	1.2	●	●															2.0-6.5	0.28-0.50
	TNMG160408-GR	16.5	9.525	4.76	3.81	0.8	●																2.0-6.5	0.28-0.50
	TNMG160412-GR	16.5	9.525	4.76	3.81	1.2	●																2.0-6.5	0.28-0.63
	TNMG160404-BF	16.5	9.525	4.76	3.81	0.4																●	0.1-2.0	0.08-0.18
	TNMG160408-BF	16.5	9.525	4.76	3.81	0.8																●	0.1-2.0	0.08-0.18
	TNMG160404-BM	16.5	9.525	4.76	3.81	0.4																●	0.4-4.5	0.10-0.25
	TNMG160408-BM	16.5	9.525	4.76	3.81	0.8																●	0.5-4.5	0.10-0.40
	TNMG160412-BM	16.5	9.525	4.76	3.81	1.2																●	0.8-4.5	0.10-0.55
	TNMG160408-BR	16.5	9.525	4.76	3.81	0.8				●												●	1.5-5.0	0.25-0.40
	TNMG160412-BR	16.5	9.525	4.76	3.81	1.2				●												●	1.5-5.0	0.25-0.55
	TNMA160404	16.5	9.525	4.76	3.81	0.4																●	1.0-4.5	0.15-0.25
	TNMA160408	16.5	9.525	4.76	3.81	0.8																●	1.0-4.5	0.15-0.40
	TNMA160412	16.5	9.525	4.76	3.81	1.2																●	1.0-4.5	0.15-0.55
	TNMA220408	22	12.7	4.76	5.16	0.8																●	2.0-6.0	0.15-0.40
	TNMA220412	22	12.7	4.76	5.16	1.2																●	2.0-6.0	0.15-0.55
	TNMA220416	22	12.7	4.76	5.16	1.6																●	2.0-6.0	0.15-0.70

Negative Insert

60° TN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description						Coating										Cutting Parameters					
							CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)			
		L	IC	S	ød	Re	WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231			WS7125	WS7225	WS7130
	TNMG160404	16.5	9.525	4.76	3.81	0.4	●	●													1.0-4.5	0.15-0.25
	TNMG160408	16.5	9.525	4.76	3.81	0.8	●	●													1.0-4.5	0.15-0.40
	TNMG160412	16.5	9.525	4.76	3.81	1.2	●	●													1.0-4.5	0.15-0.55
	TNMG220408	22	12.7	4.76	5.16	0.8	●	●													2.0-6.0	0.15-0.40
	TNMG220412	22	12.7	4.76	5.16	1.2	●	●													2.0-6.0	0.15-0.55
	TNMG220416	22	12.7	4.76	5.16	1.6	●	●													2.0-6.0	0.15-0.70

35° VN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description						Coating										Cutting Parameters					
							CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)			
		L	IC	S	ød	Re	WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231			WS7125	WS7225	WS7130
	VNMG160404-GF	16.6	9.525	4.76	3.81	0.4	●	●													0.15-2.0	0.08-0.18
	VNMG160408-GF	16.6	9.525	4.76	3.81	0.8	●	●													0.25-2.0	0.08-0.25
	VNMG160404-GM	16.6	9.525	4.76	3.81	0.4	●	●													0.4-4.0	0.10-0.25
	VNMG160408-GM	16.6	9.525	4.76	3.81	0.8	●	●													0.5-4.0	0.10-0.40
	VNMG160412-GM	16.6	9.525	4.76	3.81	1.2	●	●													0.8-4.0	0.10-0.55
	VNMG160404-BF	16.6	9.525	4.76	3.81	0.4													●		0.1-2.0	0.08-0.18
	VNMG160408-BF	16.6	9.525	4.76	3.81	0.8													●		0.1-2.0	0.08-0.18
	VNMG160404-BM	16.6	9.525	4.76	3.81	0.4													●		0.4-4.5	0.10-0.25
	VNMG160408-BM	16.6	9.525	4.76	3.81	0.8													●		0.5-4.5	0.10-0.40
	VNMG160412-BM	16.6	9.525	4.76	3.81	1.2													●		0.8-4.5	0.10-0.55
	VNMA160404	16.6	9.525	4.76	3.81	0.4													●		1.0-4.5	0.15-0.25
	VNMA160408	16.6	9.525	4.76	3.81	0.8													●		1.0-4.5	0.15-0.40
	VNMG160404	16.6	9.525	4.76	3.81	0.4													●		1.0-4.5	0.15-0.25
	VNMG160408	16.6	9.525	4.76	3.81	0.8													●		1.0-4.5	0.15-0.40

Negative Insert

80° WN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description						Coating										Cutting Parameters					
							CVD Coating					PVD Coating					un-coated	Ap (mm)	Fn (mm/r)			
		L	IC	S	ød	Re	WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231			WS7125	WS7225	WS7130
	WNMG080404-GF	8.7	12.7	4.76	5.16	0.4	●	●													0.15-2.0	0.08-0.18
	WNMG080408-GF	8.7	12.7	4.76	5.16	0.8	●	●													0.25-2.0	0.08-0.25
	WNMG080404-GM	8.7	12.7	4.76	5.16	0.4	●	●													0.4-5.5	0.10-0.25
	WNMG080408-GM	8.7	12.7	4.76	5.16	0.8	●	●													0.5-5.5	0.10-0.40
	WNMG080412-GM	8.7	12.7	4.76	5.16	1.2	●	●													0.8-5.5	0.10-0.55
	WNMG080408-GR	8.7	12.7	4.76	5.16	0.8	●	●													2.0-6.5	0.28-0.50
	WNMG080412-GR	8.7	12.7	4.76	5.16	1.2	●	●													2.0-6.5	0.28-0.63
	WNMG080404-BF	8.7	12.7	4.76	5.16	0.4														●	0.1-2.0	0.08-0.18
	WNMG080408-BF	8.7	12.7	4.76	5.16	0.8														●	0.1-2.0	0.08-0.18
	WNMG06T312-BM	6.6	9.525	3.97	3.81	0.8														●	0.8-3.0	0.10-0.55
	WNMG060412-BM	6.6	9.525	4.76	3.81	0.8														●	0.8-3.0	0.10-0.55
	WNMG080404-BM	8.7	12.7	4.76	5.16	0.4														●	0.4-5.5	0.10-0.25
	WNMG080408-BM	8.7	12.7	4.76	5.16	0.8														●	0.5-5.5	0.10-0.40
	WNMG080412-BM	8.7	12.7	4.76	5.16	1.2														●	0.8-5.5	0.10-0.55
	WNMG080408-BR	8.7	12.7	4.76	5.16	0.8													●	●	1.5-6.0	0.25-0.40
	WNMG080412-BR	8.7	12.7	4.76	5.16	1.2													●	●	1.5-6.0	0.25-0.55
	WNMA060404	6.6	9.525	4.76	3.81	0.4														●	0.5-3.0	0.15-0.25
	WNMA060408	6.6	9.525	4.76	3.81	0.8														●	0.5-3.0	0.15-0.40
	WNMA080404	8.7	12.7	4.76	5.16	0.4														●	1.0-4.5	0.15-0.25
	WNMA080408	8.7	12.7	4.76	5.16	0.8														●	1.0-4.5	0.15-0.40
	WNMA080412	8.7	12.7	4.76	5.16	1.2														●	1.0-4.5	0.15-0.55
	WNMA080416	8.7	12.7	4.76	5.16	1.6														●	1.0-4.5	0.15-0.60

Negative Insert

80° WN** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description						CVD Coating		PVD Coating		un-coated	Cutting Parameters						
							WS8215	WS8135	WS8133	WS6115		WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231
		L	IC	S	ød	Re	(mm)	(mm/r)										
	WNMG060404	6.6	9.525	4.76	3.81	0.4	●	●									0.5-3	0.15-0.40
	WNMG060408	6.6	9.525	4.76	3.81	0.8	●	●									1.0-4.5	0.15-0.25
	WNMG080404	8.7	12.7	4.76	5.16	0.4	●	●									1.0-4.5	0.15-0.40
	WNMG080408	8.7	12.7	4.76	5.16	0.8	●	●									1.0-4.5	0.15-0.55
	WNMG080412	8.7	12.7	4.76	5.16	1.2	●	●									1.0-4.5	0.15-0.60

Positive Insert

80° CC** With Hole

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description						CVD Coating		PVD Coating		un-coated	Cutting Parameters						
							WS8215	WS8135	WS8133	WS6115		WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231
		L	IC	S	ød	Re	(mm)	(mm/r)										
	CCMT060204-TM	6.4	6.35	2.38	2.8	0.4	●	●	●								0.2-2.0	0.06-0.20
	CCMT060208-TM	6.4	6.35	2.38	2.8	0.8	●	●	●								0.2-2.0	0.08-0.30
	CCMT09T304-TM	9.7	9.525	3.97	4.4	0.4	●	●	●								0.3-3.0	0.08-0.25
	CCMT09T308-TM	9.7	9.525	3.97	4.4	0.8	●	●	●								0.3-3.0	0.10-0.30
	CCMT120404-TM	12.9	12.7	4.76	5.56	0.4	●	●	●								0.3-3.5	0.10-0.25
	CCMT120408-TM	12.9	12.7	4.76	5.56	0.8	●	●	●								0.3-3.5	0.20-0.40
	CCMT120412-TM	12.9	12.7	4.76	5.56	1.2	●	●	●								0.3-3.5	0.20-0.50
	CCGT060202-AK	6.4	6.35	2.38	2.8	0.2										●	0.05-3.0	0.01-0.12
	CCGT060204-AK	6.4	6.35	2.38	2.8	0.4										●	0.1-3.0	0.02-0.20
	CCGT09T302-AK	9.7	9.525	3.97	4.4	0.2										●	0.1-5.0	0.02-0.15
	CCGT09T304-AK	9.7	9.525	3.97	4.4	0.4										●	0.1-5.0	0.02-0.25
	CCGT120404-AK	12.9	12.7	4.76	5.56	0.4										●	0.1-5.0	0.02-0.40
	CCGT120408-AK	12.9	12.7	4.76	5.56	0.8										●	0.1-5.0	0.02-0.60

55° DC** With Hole

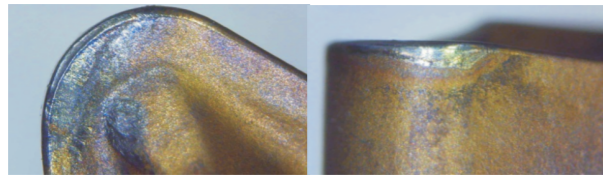
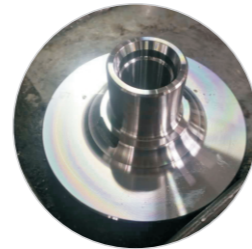
● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description						CVD Coating		PVD Coating		un-coated	Cutting Parameters						
							WS8215	WS8135	WS8133	WS6115		WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231
		L	IC	S	ød	Re	(mm)	(mm/r)										
	DCMT070204-TM	7.8	6.35	2.38	2.8	0.4	●	●	●								0.2-2.0	0.06-0.20
	DCMT070208-TM	7.8	6.35	2.38	2.8	0.8	●	●	●								0.2-2.0	0.08-0.30
	DCMT11T304-TM	11.6	9.525	3.97	4.4	0.4	●	●	●								0.3-3.0	0.08-0.25
	DCMT11T308-TM	11.6	9.525	3.97	4.4	0.8	●	●	●								0.3-3.0	0.10-0.30
	DCMT11T312-TM	11.6	9.525	3.97	4.4	1.2	●	●	●								0.3-3.0	0.10-0.40
	DCGT070202-AK	7.8	6.35	2.38	2.8	0.2										●	0.05-3.0	0.01-0.12
	DCGT070204-AK	7.8	6.35	2.38	2.8	0.4										●	0.1-3.0	0.02-0.20
	DCGT11T302-AK	11.6	9.525	3.97	4.4	0.2										●	0.05-4.0	0.02-0.20
	DCGT11T304-AK	11.6	9.525	3.97	4.4	0.4										●	0.1-4.0	0.02-0.25

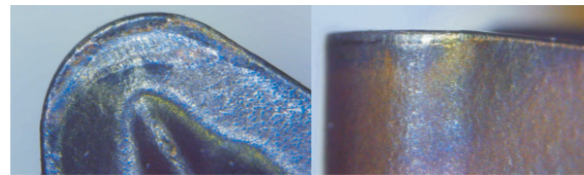
Cases

Continuous finish turning - Flange

- **Workpiece** Flange 40Cr
- **Machining Methods** Wet-type continuous finish turning of external & end face
- **Insert** DNMG150408-GF WS8215
- **Cutting Conditions** $V_c=338.5\text{m/min}$, $f=0.14\sim0.32\text{mm/r}$, $a_p=0.2\text{mm}$
- **Result of cutting** Compare with Brand A after 200 pcs/cutting edge, WS8215 shows better surface quality and abrasion resistance.



Brand A



HARDSTONE

High speed continuous turning - Automobile Hub Unit

- **Workpiece** Automobile Hub unit steel 65Mn
- **Machining Methods** Wet-type continuous finish turning of external & end face
- **Insert** WNMG080408-GF WS8215
- **Cutting Conditions** $V_c=330\text{m/min}$, $f=0.3\text{mm/r}$, $a_p=0.8\text{mm}$

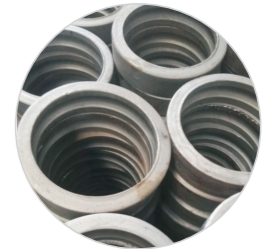


WS8215 with GF chip-breaker provide excellent chip breaking effect, high surface quality and good wear resistance for high speed continuous turning of steel.

Cutting life	
Hardstone	23~30pcs/edge
Brand A	13~21pcs/edge

Continuous turning - Bearing

- **Workpiece** Bearing GCr15
- **Machining Methods** Wet-type continuous internal roughing and semi-finishing
- **Insert** VNMG160408-GM WS8215
- **Cutting Conditions** $V_c=200\text{m/min}$, $f=0.30\text{mm/r}$, $a_p=0.30\sim1.0\text{mm}$

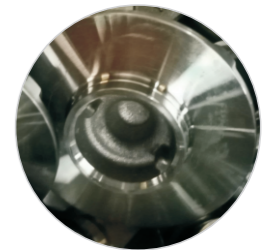


GM type chip-breaker, with smooth chip evacuation and safty cutting edge for continuous roughing, and sharp edge for finishing

Cutting life	
Hardstone	138pcs/edge
Brand A	130~140pcs/edge

Continuous turning - Flange

- **Workpiece** 65Mn
- **Machining Methods** Wet-type continuous rough turning of external & end face
- **Insert** WNMG080412-GM WS8135
- **Cutting Conditions** $V_c=260\text{m/min}$, $f=0.32\text{mm/r}$, $a_p=1.0\text{mm}$



WS8135 with GM chip-breaker, not only applicable for interrupted medium speed roughing, but also with strong versatility.

Cutting life	
Hardstone	100pcs/edge
Brand A	80pcs/edge

Cases

Strong interrupted turning - Flange

- **Workpiece** Flange steel 45#
- **Machining Methods** Wet-type rough & finish turning of heavy interrupted end face
- **Insert** WNMG080408-GM WS8135
- **Cutting Conditions** $V_c=180\sim358\text{m/min}$, $f=0.275\text{mm/r}$, $a_p=1.3/3\text{mm}$



WS8135 matching GM chip-breaker has a strong adaptability to constant speed and variable speed rough turning and fine turning of strongly discontinuous parts.

Cutting life	
Hardstone	33pcs/edge
Brand A	15~25pcs/edge

Interrupted turning- Flange

- **Workpiece** Quenched and tempered steel 55#
- **Machining Methods** Wet-type finish turning of continuous external and interrupted end face
- **Insert** WNMG080408-GM WS8135
- **Cutting Conditions** $V_c=285.7\text{m/min}$, $f=0.27\text{mm/r}$, $a_p=0.6\text{mm}$

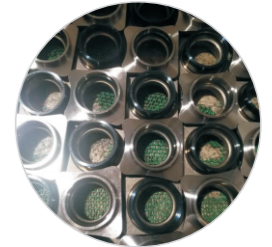


WS8135 with GM chip-breaker, provide high performance and strong stability for medium and high speed semi-finish turning of workpiece with both continuous and interrupted machining requirements.

Cutting life	
Hardstone	74pcs/edge
Brand A	60~70pcs/edge

Interrupted turning - Bearing Block

- **Workpiece** Quenched and tempered steel 55#
- **Machining Methods** Wet-type finish turning of continuous external and interrupted end face
- **Insert** WNMG080408-GM WS8135
- **Cutting Conditions** $V_c=282.6\text{m/min}$, $f=0.225\text{mm/r}$, $a_p=0.5\text{mm}$

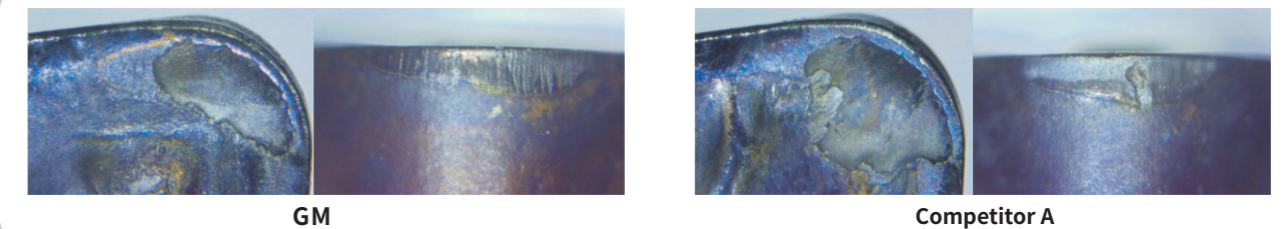


WS8135 with GM chip-breaker, provide high performance and strong stability for medium and high speed semi-finish turning of workpiece with both continuous and interrupted machining requirements.

Cutting life	
Hardstone	70pcs/edge
Brand A	37~48pcs/edge

Interrupted & continuous turning - Housing

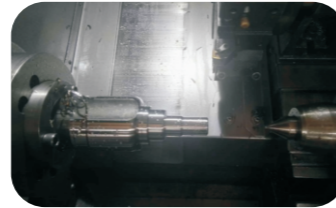
- **Workpiece** Quenched and tempered steel 55#
- **Machining Methods** Wet-type finish turning of continuous external and interrupted end face
- **Insert** WNMG080408-GM WS8135
- **Cutting Conditions** $V_c=285.7\text{m/min}$, $f=0.27\text{mm/r}$, $a_p=0.6\text{mm}$
- **Result of cutting** Compare with Brand A after testing 21 pcs/cutting edge, all samples shows minor abrasion in rake/flank face, and are of the same life span.



Cases

Interrupted / continuous roughing turning - Housing

- **Workpiece** CF53
- **Machining Methods** Wet-type semi-finish turning of continuous & interrupted external
- **Insert** DNMG150408-GM WS8135
- **Cutting Conditions** $V_c=354\text{m/min}$, $f=0.345\text{mm/r}$, $a_p=0.5\text{mm}$



WS8135 with GM chip-breaker, provide strong versatility for ultra-high speed finish turning of workpiece with both continuous and interrupted machining requirements.

Cutting life	
Hardstone	48pcs/edge
Brand A	40~50pcs/edge

Interrupted and continuous rough turning - Housing

- **Workpiece** CF53
- **Machining Methods** Wet-type rough turning of interrupted shaft journal and continuous small shaft
- **Insert** WNMG080412-GR WS8135
- **Cutting Conditions** $V_c=351\text{m/min}$, $f=0.45\text{mm/r}$, $a_p=2.0\text{mm}$



WS8135 with GR chip-breaker, provide superior advantages for ultra-high speed, large cutting depth, high feeding rate rough turning of workpiece with both continuous and interrupted machining requirements.

Cutting life	
Hardstone	15pcs/edge
Brand A	9~10pcs/edge

Interrupted and continuous rough turning - Housing

- **Workpiece** CF53
- **Machining Methods** Wet-type finish turning of interrupted shaft journal and continuous small shaft
- **Insert** DNMG150408-GM WS8135
- **Cutting Conditions** $V_c=369\text{m/min}$, $f=0.3\text{mm/r}$, $a_p=0.5\text{mm}$

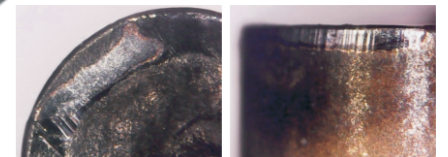


WS8135 with GM chip-breaker, provide strong applicability for ultra-high speed finish turning of workpiece with both continuous and interrupted machining requirements.

Cutting life	
Hardstone	108pcs/edge
Brand A	100pcs/edge

Continuous rough turning - Slender shaft

- **Workpiece** 45#
- **Machining Methods** Wet-type rough turning of continuous external
- **Insert** DNMG150408-GM WS8135
- **Cutting Conditions** $V_c=354\text{m/min}$, $f=0.26\text{mm/r}$, $a_p=0.25\text{mm}$



WS8135 with GR chip-breaker, provide very good chip evacuation, excellent surface finish and long lifespan for shaft type workpiece.

Cutting life	
Hardstone	104~110pcs/edge
Brand A	100pcs/edge

Cases

Finish turning - Flange

- **Workpiece** Stainless steel SUS304
- **Machining Methods** Wet-type finish turning of continuous external & end face
- **Insert** VNMG160408-BF WS7225
- **Cutting Conditions** $V_c=171\sim180\text{m/min}$, $f=0.08\text{mm/r}$, $a_p=0.10\text{mm}(Ra\leq 0.8)$



BF chip-breaker, with sharp edge, landless design, big and wide rake angle, provide small chip deformation and small cutting vibration, suitable for finish machining environment with high surface quality requirement only. WS7225 is preferable for the machining of viscous materials.

Cutting life	
Hardstone	160~180pcs/edge
Brand A	120pcs/edge

Finish turning - Flange

- **Workpiece** Stainless steel SUS304
- **Machining Methods** Finish turning of continuous external & end face
- **Insert** WNMG080408-BF WS7225
- **Cutting Conditions** $V_c=259\text{m/min}$, $f=0.10\text{mm/r}$, $a_p=0.10\text{mm}(Ra\leq 0.8)$



BF chip-breaker, with sharp edge, landless design, big and wide rake angle, provide small chip deformation and small cutting vibration, suitable for finish machining environment with high surface quality requirement only. WS7225 is preferable for high speed machining of viscous materials.

Cutting life	
Hardstone	47~48pcs/edge
Brand A	36~55pcs/edge

Rough Turning - Compressor Cylinder

- **Workpiece** Stainless steel SUS304
- **Machining Methods** Wet-type semi-finish turning of continuous conical surface & end face
- **Insert** WNMG080408-BM WS7225
- **Cutting Conditions** $V_c=150\sim243\text{m/min}$, $f=0.2\text{mm/r}$, $a_p=0.8\text{mm}$

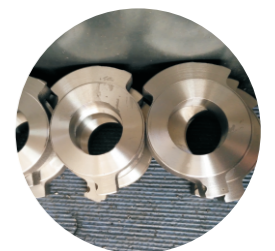


BM chip-breaker, with sharp cutting edge and large rake angle, provide small chip deformation and small built up edge, together with the high anti-adhesion property new grade, significantly improved the lifespan.

Cutting life	
Hardstone	125pcs/edge
Brand A	73pcs/edge

Rough turning

- **Workpiece** HT250
- **Machining Methods** Rough turning of external and end face
- **Insert** WNMG080412 WS6115
- **Cutting Conditions** $V_c=415\text{m/min}$, $f=0.15\text{mm/r}$, $a_p=0.4\text{mm}$



For sub high speed turning of cast iron workpiece, its lifespan and stability reached the imported top brand level

Cutting life	
Hardstone	60~70pcs/edge
Brand A	60~70pcs/edge

Cases

Continuous and interrupted rough turning - Compressor Flange

- **Workpiece** Flange
- **Machining Methods** Dry-type rough turning of continuous external and interrupted end face
- **Insert** WNMG080408 WS6115
- **Cutting Conditions** Vc=563m/min, f=0.25mm/r, ap=1mm

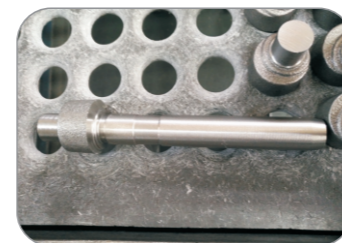


For high speed turning of slight interrupted cast iron workpiece, it's lifespan and stability reached the imported top brand level.

Cutting life	
Hardstone	70~80pcs/edge
Brand A	70~80pcs/edge

Continuous rough turning - Compressor Crankshaft

- **Workpiece** Crankshaft QT550
- **Machining Methods** Continuous rough turning
- **Insert** WNMG080408 WS6115
- **Cutting Conditions** Vc=190m/min, f=0.4mm/r, ap=1mm



For medium and low speed turning of cast iron workpiece, it's lifespan and stability much more better than domestic brands.

Cutting life	
Hardstone	170~176pcs/edge
Brand A	120~140pcs/edge

Parting and Grooving

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	CVD Coating				PVD Coating				un-coated	Cutting Parameters												
		L	W	S	R	WS8215	WS8135	WS8133	WS6115		WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231	WS7125	WS7225	WS7130	WSK10	Ap	Fn
						(mm)	(mm/r)																
	QCMB2002-T	16	2	3.55	0.2	●	●															~14.0	0.05-0.12
	QCMB2502-T	18.5	2.5	4.5	0.2	●	●															~16.0	0.05-0.15
	QCMB3004-T	21	3	4.86	0.4	●	●															~18.0	0.07-0.15
	QCMB4004-T	21	4	4.86	0.4	●	●															~18.0	0.07-0.18
	QCMB5008-T	26	5	5.8	0.8	●	●															~23.0	0.10-0.18
	QPMB2010-M	16	2	3.5	1	●	●															~14.0	0.05-0.12
	QPMB3015-M	21	3	4.8	1.5	●	●															~18.0	0.07-0.12
	QPMB4020-M	21	4	4.8	2	●	●															~23.0	0.07-0.15
	QPMB5025-M	26	5	5.8	2.5	●	●															~23.0	0.08-0.15
	QPMB6030-M	26	6	5.9	3	●	●															~23.0	0.08-0.15
	TDC20	20	2	3.9	0.2																	~22.0	0.05-0.18
	TDC30	20	3	4.2	0.2																	~22.0	0.07-0.25
	TDC40	20	4	4.2	0.3																	~22.0	0.08-0.30
	TDC50	25	5	5	0.3																	~25.0	0.09-0.35

Cases

Parting and Grooving

- **Workpiece** Steel 45#
- **Machining way** Continuous external grooving
- **Inserts** QCMB3004-T WS7125
- **Cutting Conditions** Vc=82m/min, f=0.2mm/r

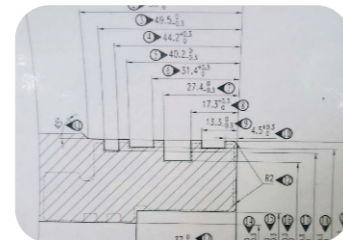


T type chip breaker, provide smooth cutting and excellent chip evacuation performance.

Cutting life	
Hardstone	60~70pcs/edge
Brand A	60pcs/edge

Grooving

- **Workpiece** piston 45#
- **Machining way** Wet-type continuous grooving
- **Inserts** QCMB4004-T WS8133
- **Cutting Conditions** Vc=325m/min, f=0.12mm/r



T type chip-breaker, smooth and light cutting, effectively reduced the vibration. special designed groove cutter grade WS8133, provide good vibration resistance,excellent wear resistance and stability.

Cutting life	
Hardstone	55~60pcs/edge
Brand A	25~30pcs/edge

Grooving

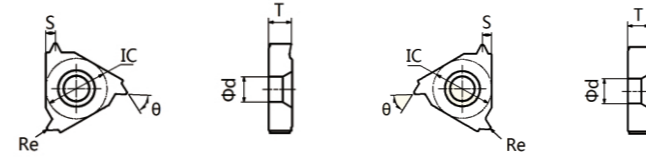
- **Workpiece** Qt600
- **Machining way** Wet-type continuous/interrupted grooving
- **Inserts** QCMB5008-T WS8133
- **Cutting Conditions** Vc=150m/min, f=0.12~0.18mm/r



T type chip breaker, smooth and light cutting, effectively reduced the vibration. special designed grade WS8133 provide good vibration resistance, excellent wear resistance and stability.

Cutting life	
Hardstone	130~140pcs/edge
Brand A	100~120pcs/edge

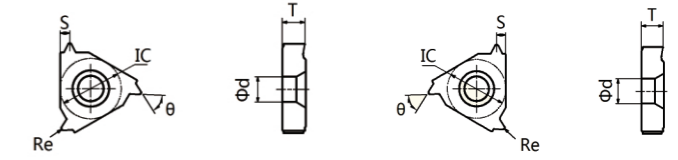
60° ISO metric thread



● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Thread pitch	Specification (mm)						Grade
			IC	S	T	Re	ød	θ	
	16ER100ISO	1.00	9.53	0.70	3.52	0.13	4.00	60°	WS5225
	16ER125ISO	1.25	9.53	0.90	3.52	0.16	4.00	60°	WS5225
	16ER150ISO	1.50	9.53	1.00	3.52	0.10	4.00	60°	WS5225
	16ER175ISO	1.75	9.53	1.20	3.52	0.22	4.00	60°	WS5225
	16ER200ISO	2.00	9.53	1.30	3.52	0.26	4.00	60°	WS5225
	16ER250ISO	2.50	9.53	1.50	3.52	0.33	4.00	60°	WS5225
	16ER300ISO	3.00	9.53	1.60	3.52	0.44	4.00	60°	WS5225
		11IR100ISO	1.00	6.35	0.70	3.05	0.06	3.20	60°
11IR125ISO		1.25	6.35	0.90	3.05	0.08	3.20	60°	WS5225
11IR150ISO		1.50	6.35	1.00	3.05	0.10	3.20	60°	WS5225
11IR250ISO		2.50	6.35	1.50	3.05	0.08	3.20	60°	WS5225
16IR100ISO		1.00	9.53	0.70	3.52	0.06	4.00	60°	WS5225
16IR125ISO		1.25	9.53	0.90	3.52	0.08	4.00	60°	WS5225
16IR150ISO		1.50	9.53	1.00	3.52	0.10	4.00	60°	WS5225
16IR175ISO		1.75	9.53	1.20	3.52	0.11	4.00	60°	WS5225
16IR200ISO		2.00	9.53	1.30	3.52	0.13	4.00	60°	WS5225
16IR250ISO		2.50	9.53	1.50	3.52	0.17	4.00	60°	WS5225
16IR300ISO	3.00	9.53	1.50	3.52	0.22	4.00	60°	WS5225	

55° Whitworth thread



● Good working condition ● Normal working condition ■ Bad working condition

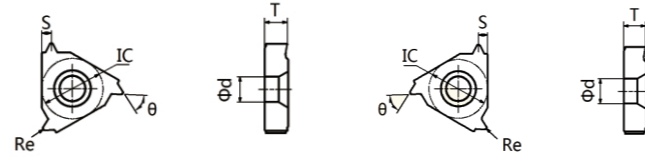
Shape	Description	Thread pitch	Specification (mm)						Grade
			IC	S	T	Re	ød	θ	
	16ER11W	11.00	9.53	1.50	3.52	0.30	4.00	55°	WS5225
	16ER14W	14.00	9.53	1.20	3.52	0.23	4.00	55°	WS5225
	16ER19W	19.00	9.53	1.00	3.52	0.17	4.00	55°	WS5225
	16IR11W	11.00	9.53	1.50	3.52	0.30	4.00	55°	WS5225
	16IR12W	12.00	9.53	1.40	3.52	0.30	4.00	55°	WS5225
	16IR14W	14.00	9.53	1.20	3.52	0.23	4.00	55°	WS5225
16IR19W	19.00	9.53	1.00	3.52	0.17	4.00	55°	WS5225	

General pitch thread

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Thread pitch	Specification (mm)						Grade
			IC	S	T	Re	ød	θ	
	16ERAG55	0.5-3.0	9.53	1.70	3.52	0.06	4.00	55°	WS5225
	16ERA55	0.5-1.5	9.53	0.90	3.52	0.05	4.00	55°	WS5225
	16ERAG55	1.75-3.0	9.53	1.70	3.52	0.23	4.00	55°	WS5225
	16ERAG60	0.5-3.0	9.53	1.70	3.52	0.07	4.00	60°	WS5225
	16ERA60	0.5-1.5	9.53	0.90	3.52	0.06	4.00	60°	WS5225
	16ERAG60	1.75-3.0	9.53	1.70	3.52	0.18	4.00	60°	WS5225
	16IRAG55	0.5-3.0	9.53	1.70	3.52	0.06	4.00	55°	WS5225
	16IRA55	0.5-1.5	9.53	0.90	3.52	0.05	4.00	55°	WS5225
	16IRAG55	1.75-3.0	9.53	1.70	3.52	0.21	4.00	55°	WS5225
	16IRAG60	0.5-3.0	9.53	1.70	3.52	0.08	4.00	60°	WS5225
	16IRA60	0.5-1.5	9.53	0.90	3.52	0.05	4.00	60°	WS5225
	16IRAG60	1.75-3.0	9.53	1.70	3.52	0.10	4.00	60°	WS5225

British standard taper pipe thread



● Good working condition ● Normal working condition ■ Bad working condition

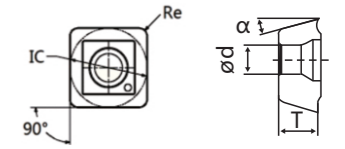
Shape	Description	Thread pitch	Specification (mm)						Grade
			IC	S	T	Re	ød	θ	
	16ER11BSPT	11.00	9.53	1.50	3.52	0.32	4.00	55°	WS5225
	16ER14BSPT	14.00	9.53	1.20	3.52	0.23	4.00	55°	WS5225
	16ER19BSPT	19.00	9.53	0.90	3.52	0.19	4.00	55°	WS5225
	16IR11BSPT	11.00	9.53	1.50	3.52	0.32	4.00	55°	WS5225
	16IR14BSPT	14.00	9.53	1.20	3.52	0.23	4.00	55°	WS5225
	16IR19BSPT	19.00	9.53	0.90	3.52	0.19	4.00	55°	WS5225

American standard taper pipe thread

● Good working condition ● Normal working condition ■ Bad working condition

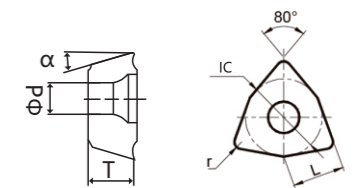
Shape	Description	Thread pitch	Specification (mm)						Grade
			IC	S	T	Re	ød	θ	
	16ER14NPT	14.00	9.53	1.20	3.52	0.07	4.00	60°	WS5225
	16ER115NPT	11.50	9.53	1.50	3.52	0.08	4.00	60°	WS5225
	16ER18NPT	18.00	9.53	1.00	3.52	0.06	4.00	60°	WS5225
	16IR14NPT	14.00	9.53	1.20	3.52	0.07	4.00	60°	WS5225
	16IR115NPT	11.50	9.53	1.50	3.52	0.08	4.00	60°	WS5225
	16IR18NPT	18.00	9.53	1.00	3.52	0.06	4.00	60°	WS5225

Drilling



● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Specification (mm)					CVD Coating			PVD Coating			un-coated	Cutting Parameters										
		IC	T	r	ød	α	WS8215	WS8135	WS8133	WS6115	WS7120	WS5115		WS5120	WS5130	WS5225	WS5231	WS7125	WS7225	WS7130	WSK10	Ap (mm)	Fn (mm/r)	
	SPMG050204DG	11.5	4.3	0.8	4.5	16.5°																		0.04-0.15
	SPMG060204DG	9.8	4.3	0.8	4.05	17.5°																		0.04-0.16
	SPMG07T308DG	7.94	3.97	0.8	2.85	15.5°																		0.04-0.20
	SPMG090408DG	6	2.38	0.4	2.61	14°																		0.06-0.25
	SPMG110408DG	5	2.38	0.4	2.25	14°																		0.06-0.28



● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description	Specification (mm)					CVD Coating			PVD Coating			un-coated	Cutting Parameters										
		IC	T	r	ød	α	WS8215	WS8135	WS8133	WS6115	WS7120	WS5115		WS5120	WS5130	WS5225	WS5231	WS7125	WS7225	WS7130	WSK10	Ap (mm)	Fn (mm/r)	
	WCMX030204	5.56	2.38	0.8	2.8	7																		0.04-0.15
	WCMX030208	5.56	2.38	0.8	2.8	7																		0.04-0.15
	WCMX040204	6.35	2.38	0.8	3	7																		0.04-0.16
	WCMX040208	6.35	2.38	0.8	3	7																		0.04-0.16
	WCMX050308	7.94	3.18	0.8	3.4	7																		0.04-0.20
	WCMX06T308	9.525	3.97	0.8	3.8	7																		0.06-0.25
	WCMX080412	12.7	4.76	1.2	4.4	7																		0.06-0.28

Overview

● Square shoulder milling



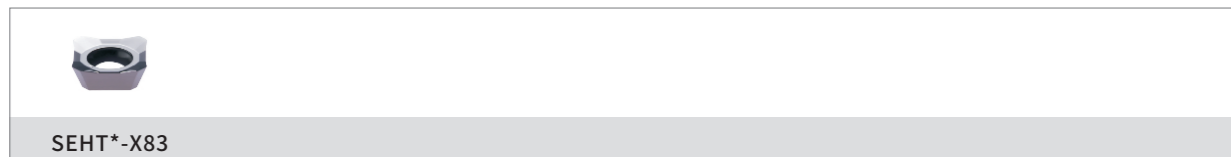
● Profile milling



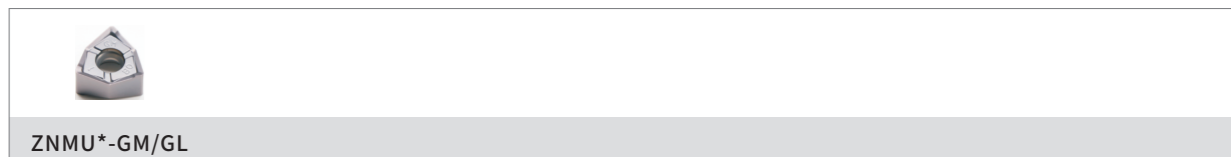
● Helical end milling



● Face milling



● Economical square shoulder milling



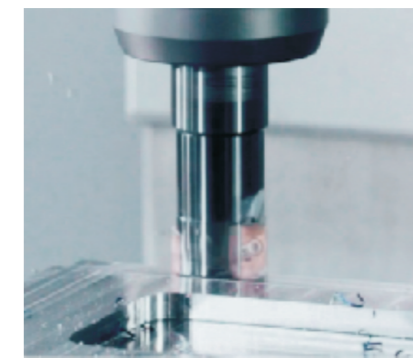
High Precision Square Shoulder Milling Insert S/CSM190

- New**
- ✓ Long service life
 - ✓ High cutting efficiency
 - ✓ High surface finish quality
 - ✓ High vertical sidewall accuracy



Features

90 degree shoulder square milling in the true sense

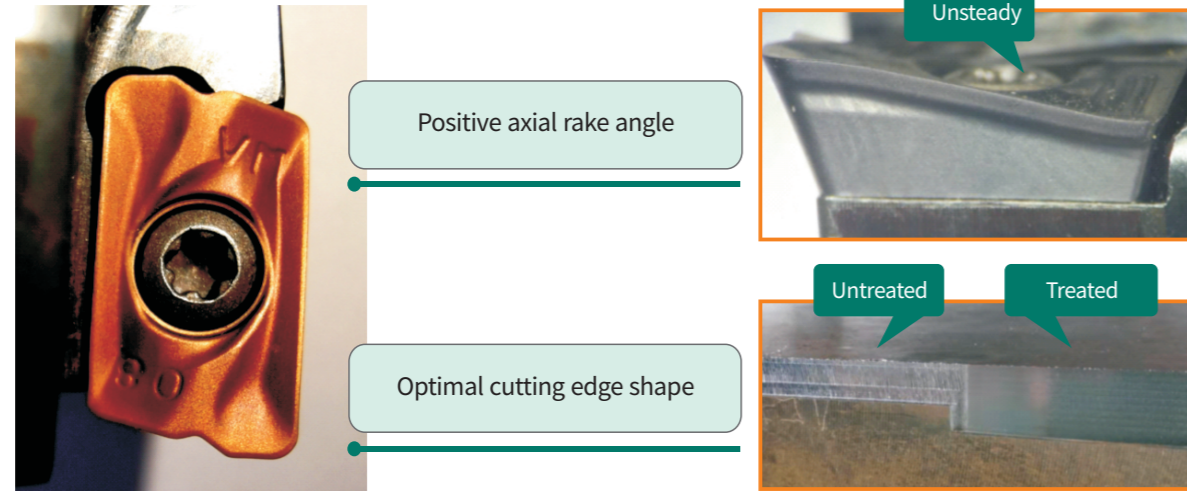


Excellent sidewall surface finish, runout < 0.005mm (depth: 20mm, φ16X2 edges,)

Features A

The unique inserts design of 3D chipbreaker and cutting edge structure to reduce cutting vibration.

The small cutting wedge angle enables the tool to smoothly cut into the workpiece, and under the control of the inserts edge structure, it can especially achieve high-precision sidewall surface quality. At the same time, with the help of the anti-vibration cutter body, the cutting vibration can be better reduced.



Features B

Latest independently-developed three PVD coating types for your choice, covering various materials and hardness range.



Machined material hardness
Under HRC30
<WS5130>



Machined material hardness
HRC30~HRC40
<WS5120>



Machined material hardness
HRC40~HRC50
<WS5115>

Suitable for general purpose machining of steel, stainless steel and cast iron workpiece, as well as high hardness materials like SKD61, hardened steel, etc.

Features C

Special pre- and post-coating technology and micro edge processing technologies. Fine and smooth surface, uniform cutting edge, greatly increased the cutting stability.

Features D

Apart from the high strength steel body, a new combination of exchangeable tool head and cemented carbide holder has been adopted, which enriched the tool style and enhanced the vibration resistance of sidewall machining.



Cutting performance

Sidewall precision comparison



	HARDSTONE	Brand M	Brand S
NO.1 (ap=2mm)	0.002mm	0.002mm	0.002mm
NO.2 (ap=4mm)	0.004mm	0.007mm	0.005mm

HARDSTONE sample`s average precision runout <0.005mm, better than other brand samples.

Workpiece materials: steel 45 # (28HRC)
 ■Cutting parameters:
 Vc=280m/min, fz=0.15mm/z, ap=20mm, ae=1mm
 ■Tool type:
 AOKT113508PEER-VM, WS5130, tooth φ16x2, overhang depth: 40mm

Plane precision comparison

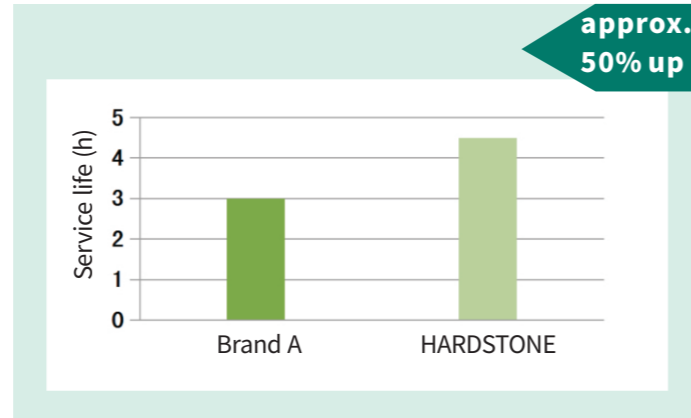
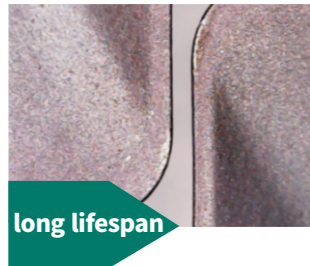


	HARDSTONE	Brand M	Brand S
Vertical toolpath	Ra=0.31μm	Ra=0.37μm	Ra=0.38μm
Parallel toolpath	Ra=0.26μm	Ra=0.32μm	Ra=0.37μm

For the vertical precision and parallel toolpath precision, HARDSTONE products are much higher than other samples.

Workpiece materials: steel 45 # (28HRC)
 ■Cutting parameters:
 Vc=280m/min, fz=0.15mm/z, ap=20mm, ae=1mm
 ■Tool type:
 AOKT113508PEER-VM, WS5130, tooth φ16x2, overhang depth: 40mm

Service life comparison



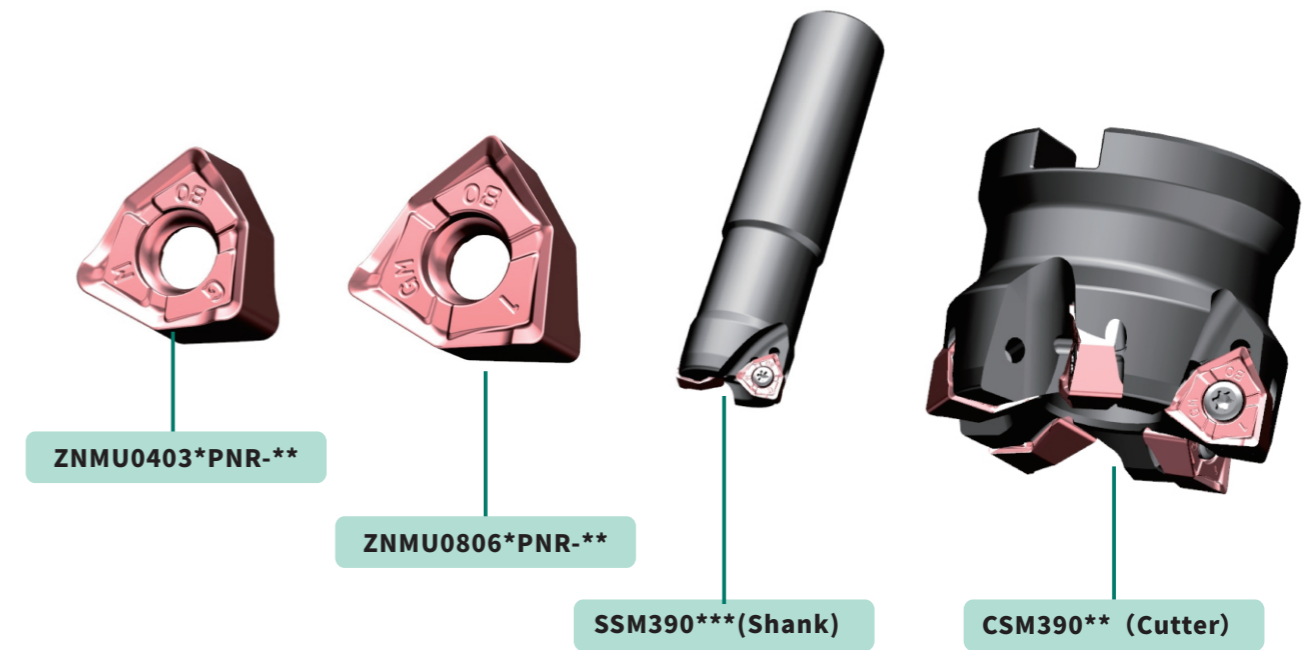
Processing



HARDSOTNE equivalent quality Brand A

Workpiece material: 718H (35HRC)
 Test location: Mould center, Xiamen City
 Workpiece: large-scale mould base cavity
 Cutting parameters:
 $V_c=326\text{m/min}$, $f_z=0.5\text{mm/z}$, $a_p=0.25\text{mm}$, $a_e=0.1\text{mm}$
 Tool: AOKT160408PEER-VM, WS5130,
 Tool $\phi 26 \times 2$, Overhang depth: 80mm

New generation economic square shoulder milling insert S/CSM390



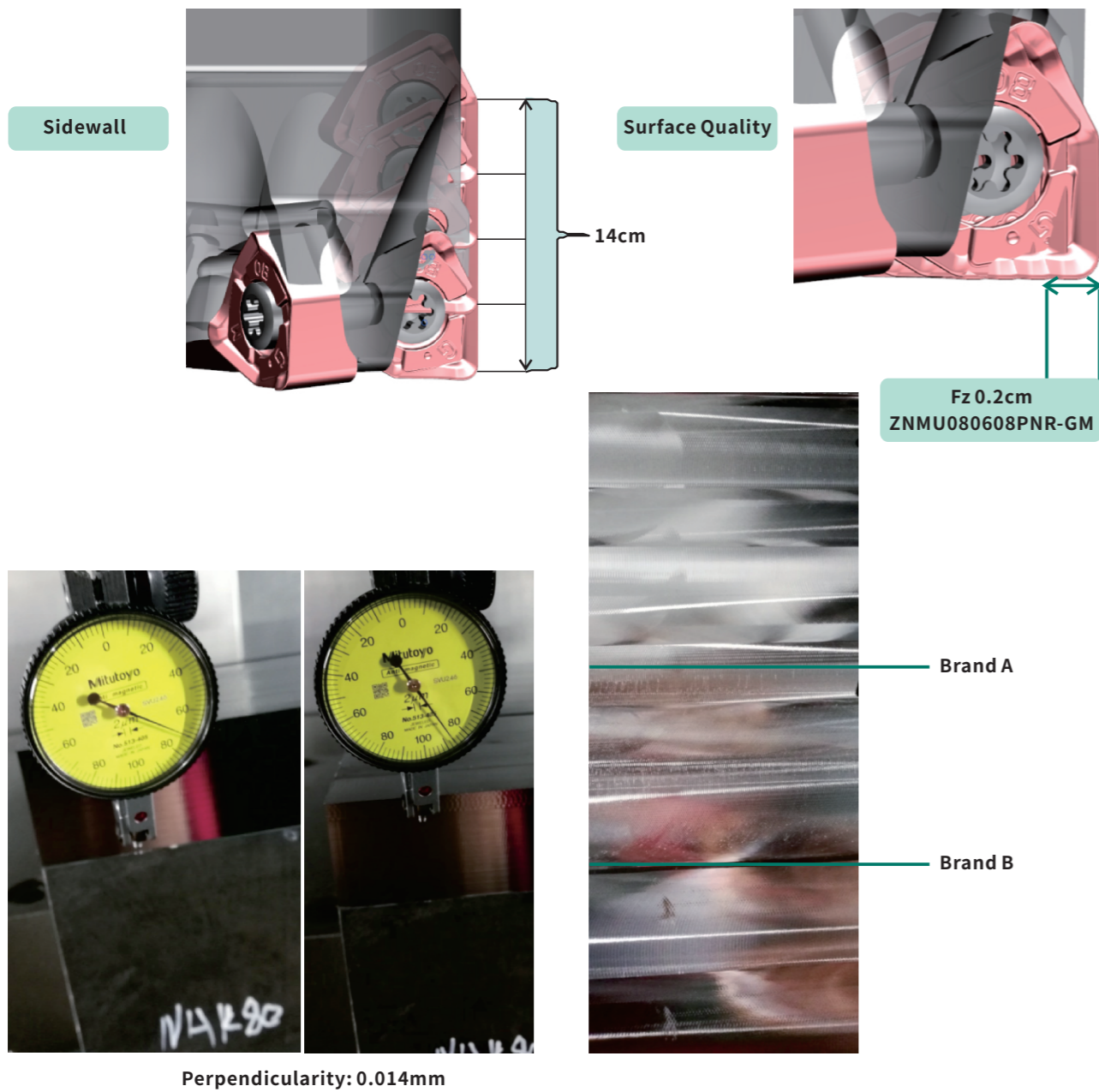
Features

- Optimized support surface structure provide good support and excellent chip-breaking capacity.
- Independent support, surface to avoid chip contamination
- Stable positioning desgin, suppressed the micro-vibration and improves the lifespan.
- Large rake angle, low resistance design, enhanced large cutting edge, excellent versatility.
- Hyperbolic edge desgin, compensate the errors of manufacturing and clamping process, take account of both square shoulder effect and surface quality.

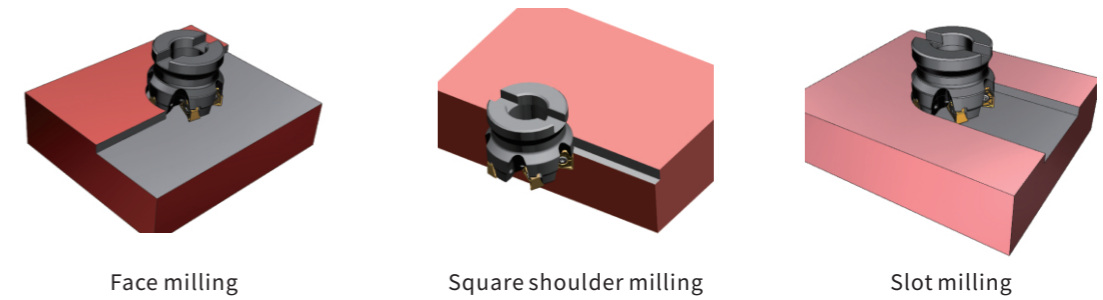
- E
- Turning
- Grooving
- Threading
- Drilling
- Milling

New generation economic square shoulder milling insert S/CSM390

Cutting effect



Application and parameters

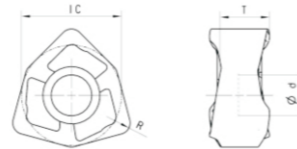


ISO	Material	Grade	Recommended cutting parameters	
			VC(m/min)	FZ(mm/z)
P	Mild steel	WS5130 WS5120	120~250	0.08~0.3
	Carbon steel alloy steel		120~200	0.08~0.3
	Pre hardened steel		120~200	0.08~0.3
M	Martensitic stainless steel		120~180	0.08~0.3
	Austenitic stainless steel		120~160	0.08~0.3
K	Grey cast iron		100~220	0.08~0.3
	Nodular cast iron	100~180	0.08~0.3	
S	Heat resistant alloy	50~100	0.08~0.3	

Face milling

● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description					CVD Coating		PVD Coating		un-coated	Cutting Parameters											
		L	φD	S	φd	WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231	WS7125	WS7225	WS7130	WSK10	Ap	Fn
		(mm)	(mm)	(mm)	(mm)																(mm)	(mm/r)
	SEHT1204AFFN-X83	12.70	12.70	4.76	5.50															●	~4.0	0.03~0.30



Economical square shoulder milling

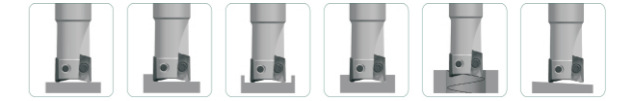
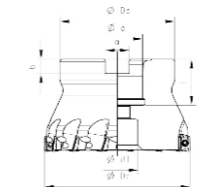
● Good working condition ● Normal working condition ■ Bad working condition

Shape	Description						CVD Coating		PVD Coating		un-coated	Cutting Parameters											
		IC	Apm	R	φd	T	WS8215	WS8135	WS8133	WS6115	WS7120	WS7140	WS5115	WS5120	WS5130	WS5225	WS5231	WS7125	WS7225	WS7130	WSK10	Ap	Fn
		(mm)	(mm)	(mm)	(mm)	(mm)																(mm)	(mm/r)
	ZNMU040308PNR-GM	7	4.2	0.8	2.8	3.65							●	●								~4.2	0.05~0.30
	ZNMU080608PNR-GM	12	7.2	0.8	4.6	6.35							●	●								~7.3	0.06~0.35
	ZNMU080608PNR-GL	12	7.2	0.8	4.6	6.35							●	●								~7.3	0.05~0.30

Milling Tools

Cutter

High strength tool body

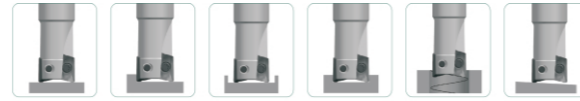




Type	Stock	Number of teeth	Basic dimensions								Applicable inserts	Spare parts	
			φDc	Lf	φDb	φd	φd1	a	b	l		Screw	Wrench
			(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
CSM190-040A1605-AO11	●	5	40	40	33	16	14	8.4	5.6	18	AOKT1135**		
CSM190-050A2206-AO11	●	6	50	40	47	22	18.2	10.4	6.3	22	PEER-VM	M2.5X5.5	T-8
CSM190-063A2207-AO11	●	7	63	40	47	22	18.2	10.4	6.3	22			
CSM190-050A2204-AO16	●	4	50	40	47	22	18.2	10.4	6.3	22	AOKT1604**		
CSM190-063A2205-AO16	●	5	63	40	47	22	18.2	10.4	6.3	22	PEER-VM	M4.0X10	T-15
CSM190-080A2706-AO16	●	6	80	50	52	27	18.2	12.4	7	24			

Milling Tools

Shank

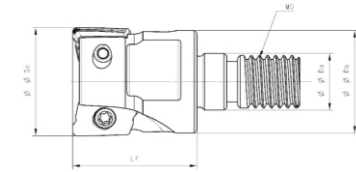
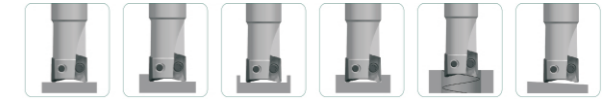
High strength tool body




Type	Stock	Number of teeth	Basic dimensions				Applicable inserts	Spare parts	
			φDc	l2	L	φDs		Screw	Wrench
									
SSM190-016G1602(L)-AO11	•	2	16	40	130(160)	16	AOKT1135** PEER-VM	M2.5X5.5	T-8
SSM190-017G1602(L)-AO11	•	2	17	40	160(200)	16			
SSM190-020G2002(L)-AO11	•	2	20	40	130(160)	20			
SSM190-021G2002(L)-AO11	•	2	21	50	160(200)	20			
SSM190-025G2503(L)-AO11	•	3	25	50	120(160)	25			
SSM190-025G2502(L)-AO16	•	2	25	50	160(200)	25	AOKT1604** PEER-VM	M4.0X10	T-15
SSM190-026G2502(L)-AO16	•	2	26	50	160(200)	25			
SSM190-032G3202(L)-AO16	•	2	32	80	160(200)	32			

Modular cutting head

High strength tool body

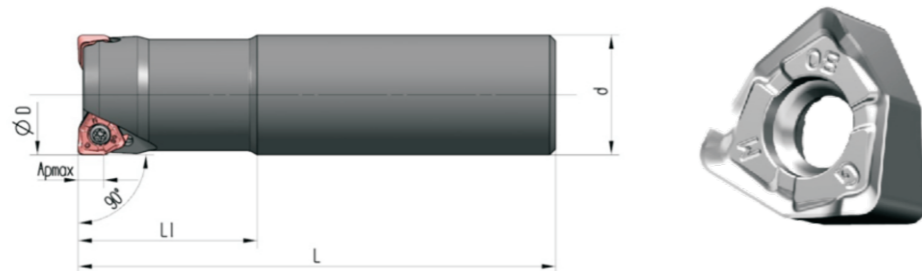


Type	Stock	Number of teeth	Basic dimensions					Applicable inserts	Spare parts	
			φDc	Lf	φDa	φDb	MD		Screw	Wrench
										
KH-1702-AOKT11-M08	•	2	17	25	8.5	15	M8	AOKT1135** PEER-VM	M2.5X5.5	T-8
KH-2102-AOKT11-M10	•	2	21	30	10.5	19	M10			
KH-2603-AOKT11-M12	•	3	26	35	12.5	24	M12			
KH-3304-AOKT11-M16	•	4	33	40	17	30	M16			

Milling Tools

Shank

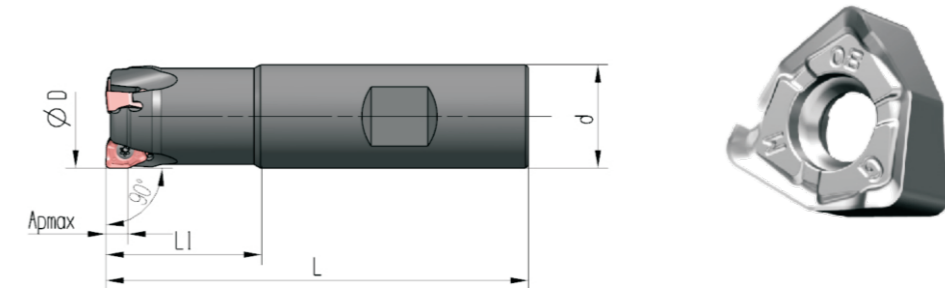
High strength tool body



Type	Stock	Number of teeth	Basic dimensions				Apmax	Applicable inserts	inner-cooling	Spare parts	
			D	d	L	L1				Screw	Wrench
SSM390-020G2002L-ZN04	•	2	20	20	150	30	4.2	ZNMU0403**	•	M2.5X6.5	T-8
SSM390-020G2003L-ZN04		3	20	20	150	30	4.2				
SSM390-021G2002L-ZN04	•	2	21	20	150	30	4.2				
SSM390-021G2003L-ZN04		3	21	20	150	30	4.2				
SSM390-025G2502L-ZN04	•	2	25	25	170	30	4.2				
SSM390-025G2503L-ZN04	•	3	25	25	170	30	4.2				
SSM390-025G2504L-ZN04		4	25	25	170	30	4.2				
SSM390-025G2505L-ZN04		5	25	25	170	30	4.2				
SSM390-026G2502L-ZN04	•	2	26	25	170	30	4.2				
SSM390-026G2503L-ZN04		3	26	25	170	30	4.2				
SSM390-032G3202L-ZN04	•	2	32	32	200	30	4.2				
SSM390-032G3203L-ZN04	•	3	32	32	200	30	4.2				
SSM390-032G3204L-ZN04		4	32	32	200	30	4.2				
SSM390-032G3205L-ZN04		5	32	32	200	30	4.2				
SSM390-032G3206L-ZN04		6	32	32	200	30	4.2				
SSM390-035G3202L-ZN04	•	2	35	32	200	30	4.2				
SSM390-035G3203L-ZN04	•	3	35	32	200	30	4.2				
SSM390-040G3204L-ZN04		4	40	32	200	30	4.2				
SSM390-040G3205L-ZN04		5	40	32	200	30	4.2				
SSM390-040G3206L-ZN04		6	40	32	200	30	4.2				

Shank

High strength tool

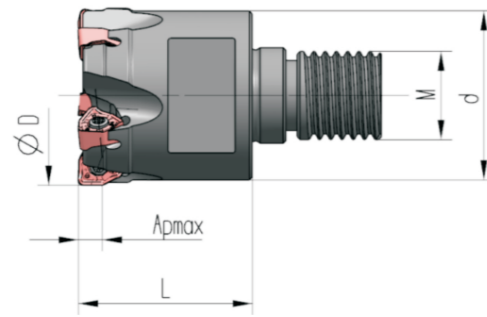


Type	Stock	Number of teeth	Basic dimensions				Apmax	Applicable inserts	inner-cooling	Spare parts	
			D	d	L	L1				Screw	Wrench
SSM390-020X2002-ZN04		2	20	20	90	30	4.2	ZNMU0403**	•	M2.5X6.5	T-8
SSM390-020X2003-ZN04		3	20	20	90	30	4.2				
SSM390-025X2502-ZN04		2	25	25	100	30	4.2				
SSM390-025X2503-ZN04		3	25	25	100	30	4.2				
SSM390-025X2504-ZN04		4	25	25	100	30	4.2				
SSM390-025X2505-ZN04		5	25	25	100	30	4.2				
SSM390-032X3202-ZN04		2	32	32	110	30	4.2				
SSM390-032X3203-ZN04		3	32	32	110	30	4.2				
SSM390-032X3204-ZN04		4	32	32	110	30	4.2				
SSM390-032X3205-ZN04		5	32	32	110	30	4.2				
SSM390-032X3206-ZN04		6	32	32	110	30	4.2				

Milling Tools

Modular cutting head

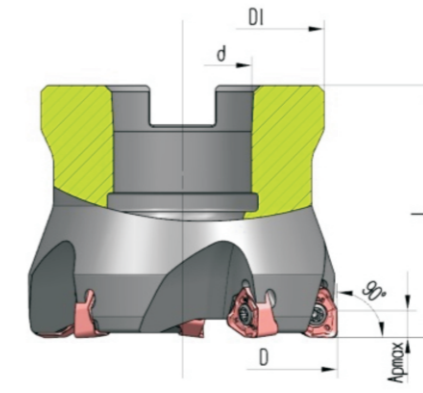
High strength tool body



Type	Stock	Number of teeth	Basic dimensions				Apmax	Applicable inserts	inner-cooling	Spare parts	
			D	d	L	M				Screw	Wrench
KH-2002-ZN04-M10		2	20	18	30	10	4.2	ZNMU0403**	M2.5X6.5	T-8	
KH-2003-ZN04-M10		3	20	18	30	10	4.2				
KH-2502-ZN04-M12		2	25	23	30	12	4.2				
KH-2503-ZN04-M12		3	25	23	30	12	4.2				
KH-2504-ZN04-M12		4	25	23	30	12	4.2				
KH-2505-ZN04-M12		5	25	23	30	12	4.2				
KH-3202-ZN04-M16		2	32	30	40	16	4.2				
KH-3203-ZN04-M16		3	32	30	40	16	4.2				
KH-3204-ZN04-M16		4	32	30	40	16	4.2				
KH-3205-ZN04-M16		5	32	30	40	16	4.2				
KH-3206-ZN04-M16		6	32	30	40	16	4.2				

Cutter

High strength tool body

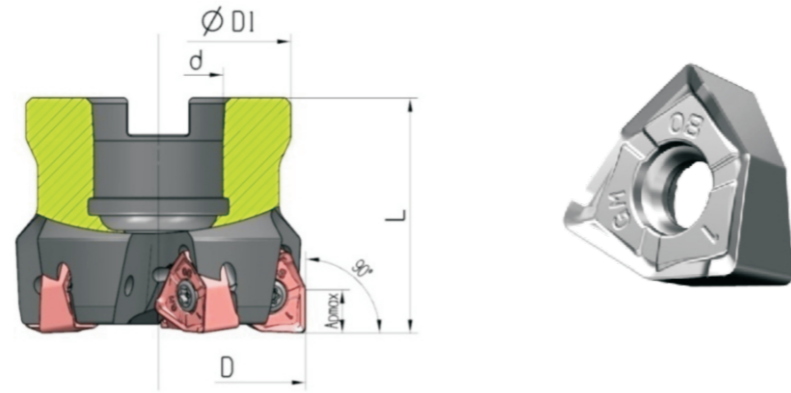


Type	Stock	Number of teeth	Basic dimensions				Apmax	Applicable inserts	inner-cooling	Spare parts	
			D	d	D1	L				Screw	Wrench
CSM390-040A1605-ZN04		5	40	16	35	40	4.2	ZNMU0403**	M2.5X6.5	T-8	
CSM390-040A1607-ZN04		7	40	16	35	40	4.2				
CSM390-050A2206-ZN04		6	50	22	45	40	4.2				
CSM390-050A2208-ZN04		8	50	22	45	40	4.2				
CSM390-063A2207-ZN04		7	63	22	50	40	4.2				
CSM390-063A2210-ZN04		9	63	22	50	40	4.2				

Milling Tools

Cutter

High strength tool body

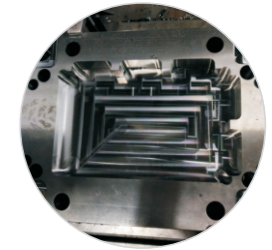


Type	Stock	Number of teeth	Basic dimensions				Apmax	Applicable inserts	inner-cooling	Spare parts	
			D	d	D1	L				Screw	Wrench
CSM390-040A1604-ZN08		4	40	16	35	40	7.3				
CSM390-050A2204-ZN08	•	4	50	22	45	40	7.3				
CSM390-050A2205-ZN08		5	50	22	45	40	7.3				
CSM390-063A2205-ZN08	•	5	63	22	50	40	7.3				
CSM390-063A2206-ZN08		6	63	22	50	40	7.3				
CSM390-080A2706-ZN08	•	6	80	27	60	50	7.3				
CSM390-080A2707-ZN08		7	80	27	60	50	7.3				
CSM390-080A2709-ZN08		9	80	27	60	50	7.3				
CSM390-100B3207-ZN08	•	7	100	32	80	50	7.3				
CSM390-100B3208-ZN08		8	100	32	80	50	7.3	ZNMU0806**	M4X10	T-15	
CSM390-100B3211-ZN08		11	100	32	80	50	7.3				
CSM390-125B4008-ZN08	•	8	125	40	100	63	7.3				
CSM390-125B4011-ZN08		11	125	40	100	63	7.3				
CSM390-125B4014-ZN08		14	125	40	100	63	7.3				
CSM390-160C4010-ZN08		10	160	40	115	63	7.3				
CSM390-160C4012-ZN08		12	160	40	115	63	7.3				
CSM390-160C4016-ZN08		16	160	40	115	63	7.3				
CSM390-200C6012-ZN08		12	200	60	150	63	7.3				
CSM390-200C6016-ZN08		16	200	60	150	63	7.3				

Cases

Milling

- Workpiece: Mould base, 45# steel
- Machining Methods: Finish milling of mould sidewall (aire cooling)
- Insert: AOKT113508PEER-VM WS5115
- Tool: SSM190-025G2503-AO11
- Cutting parameters: Vc=220m/min, ap=2mm, ae=0.2mm, fz=0.3mm/z
- Cutting performance: Process quality, dimation precision and lifespan close to top brand.



AOKT's cutting vibration is very small, significantly improved the sidewall machined trace, surface quality and surface accuracy. It's surface quality, dimension accuracy and wear resistance have reached the import level.

Finish milling - Mould Sidewall

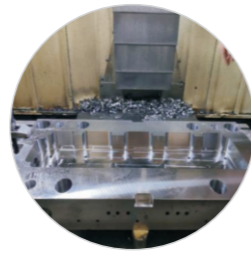
- Workpiece: Die materialP20
- Machining Methods: Finish milling of mould sidewall
- Insert: AOKT113508PEER-VM
- Tool: KH-2603-AOKT11-M12
- Cutting parameters: Vc=259m/min, ap=1mm, ae=0.12mm, fz=0.25mm/z
- Cutting performance: Surface roughness Ra:0.63、perpendicularity < 0.01, satisfy customers' requirement!



Cases

Finish milling - Mould Sidewall

- **Workpiece** Mold frame 45# steel
- **Machining Methods** Finish milling of mould sidewall
- **Insert** AOKT113508PEER-VM
- **Tool** Dc:SSM190-025G2503(L)-AO11
- **Cutting parameters** $V_c=220\text{m/min}$, $a_p=1.5\text{mm}$, $a_e=0.25\text{mm}$, $f_z=0.36\text{mm/z}$
- **Cutting performance** perpendicularity < 0.012 , satisfy customers' requirement. Successfully replace imported products!



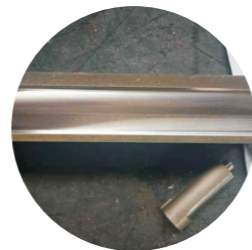
Side milling - Cylinder block

- **Workpiece** Cylinder block HT250
- **Machining Methods** Side milling of cylinder block
- **Insert** AOKT113508PEER-VM
- **Tool** KH-2603-AOKT11-M12
- **Cutting parameters** $V_c=285\text{m/min}$, $a_p=0.8\text{mm}$, $a_e=0.15\text{mm}$, $f_z=0.1\text{mm/z}$
- **Cutting performance** perpendicularity < 0.008 , Successfully replace imported products!



Side milling - Cylinder block

- **Workpiece** Cr15 Quenching(HRC48) Air cooling
- **Machining way** Groove milling
- **Insert** AOKT113508PEER-VM WS5115
- **Tool** SSM190-020G2002-AO11
- **Cutting parameters** $V_c=138\text{m/min}$, $a_p=0.12\text{mm}$, $a_e=5\text{mm}$, $f_z=0.25\text{mm/z}$
- **Cutting performance** Comparing with cermet insert from BRAND A, the surface quality (burr-free sidewall) and life are comparable.



HARDSTONE AOKT tool provide high dimensional precision, sharp edge, light and smooth cutting, excellent surface quality.

Roughing - Cast iron

- **Workpiece** Dry cut casting steel
- **Machining Methods** Rough milling of cast steel
- **Insert** ZNMU080608PNR-GM/WS5120
- **Tool** CSM390-200C6012-ZN08
- **Cutting parameters** $N=300/\text{min}$, $a_p=2\sim 5\text{mm}$, $F=700\text{mm/min}$
- **Cutting life** HARDSTONE: 3 hrs, Brand A: 2.5 hrs
- **Cutting performance** Good surface quality, long cutting life, high cost performance



Mounting surface - Milling plate spring

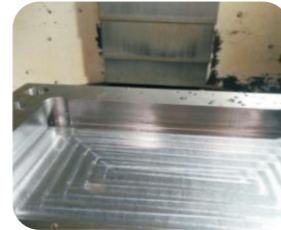
- **Workpiece** Dry cutting 40CrMo HB285-333 Back of plate spring
- **Machining Methods** Mounting surface of Milling plate spring
- **Insert** SSM390-063A2205-ZN08
- **Tool** ZNMU080608PNR-GM/WS5120
- **Cutting parameters** $N=720/\text{min}$, $a_p=1.5\sim 3\text{mm}$, $F=540\text{mm/min}$
- **Cutting life** HARDSTONE: 27pieces, Brand A:12pieces
- **Cutting performance** Good surface quality, long cutting life, high cost performance



Cases

Clean-up machining - Frame

- **Workpiece** Frame 45# steel
- **Machining Methods** Clean-up machining of mould frame
- **Insert** ZNMU040308PNR-GM/WS5130
- **Tool** SSM390-021G2002L-ZN04
- **Cutting parameters** N=2750/min, ap=0.3mm ae=0.5~21mm, F=2500mm/min
- **Original insert** APMT1135
- **Original cutting parameters** N=2750/min, F=2500mm/min, ap=0.3mm, ae=0.5~21mm
- **Cutting life** HARDSTONE:3hours(3pieces), Brand A:2hours(2pieces)
- **Cutting performance** Light cutting, cutting efficiency increased by 3 times, long lifespan, good surface quality, remarkable economic benefit.



Roughing - Internal Mould Insert

- **Workpiece** XF136BDHH
- **Machining Methods** Roughing of internal mold insert, dry cutting
- **Insert** ZNMU040308PNR-GM/WS5115
- **Tool** SSM390-021G2002L-ZN04
- **Cutting parameters** Vc=132m/min, N=2000/min, ap=0.4mm, ae=15mm, fz=3000mm/r
- **Original insert** APMT1135
- **Original cutting parameters** Vc=132m/min, N=2000/min, F=2000mm/r, ap=0.25mm, ae=15mm
- **Cutting life** HARDSTONE: 40 mins, No obvious wear; Brand A: 30 mins, Cutting edge burst crack
- **Cutting performance** Light cutting, cutting efficiency increased to 240%, good surface quality, long lifespan.



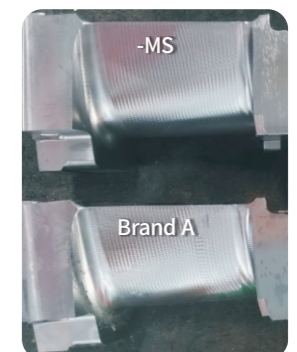
Forming - Front mold insert

- **Workpiece** JY136ADHH
- **Machining Methods** Contour machining of front mold insert Dry cutting
- **Insert** ZNMU040308PNR-GM/WS5115
- **Tool** SSM390-021G2002L-ZN04
- **Cutting parameters** Vc=132m/min, N=2000/min, ap=0.4mm, ae=15mm, F=3000mm/min
- **Original insert** APMT1135
- **Original cutting parameters** Vc=132m/min, N=2000/min, F=2000mm/min, ap=0.4mm, ae=15mm
- **Cutting life** HARDSTONE:37mins; Brand A:10mins+
- **Cutting performance** Light cutting, cutting efficiency increased to 168%, good surface quality, lifespan increased 3.7 times.



Finish milling - Stainless Steel Blade

- **Workpiece** Blade, 2Cr11Mo1VNbN
- **Machining Methods** Finish milling of stainless steel blade (air cooling)
- **Insert** RPKT10T3MO-MS WS7130
- **Cutting parameters** Vc=235.5m/min, ap=0.8mm, e=2mm, fz=0.42~0.74mm/r
- **Cutting performance** Performance comparison after two pieces machining for both HARDSTONE and Brand A



HARDSTONE quality and dimension precision are much better than Brand A

Hardstone Efficient Cutting tools

