THE NEW VALUE FRONTIER

KYOCERA

CERATIP®
KYOCERA Cutting Tools
CP174-E

GBA-MY Type

3-corners Use Grooving Tool with 3-D Chipbreaker

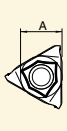
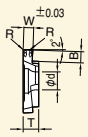
Product Expansion

Super Micro Grain Cermet TN6020 is coming!!

Stable Machining with ImprovedChip Control Performance

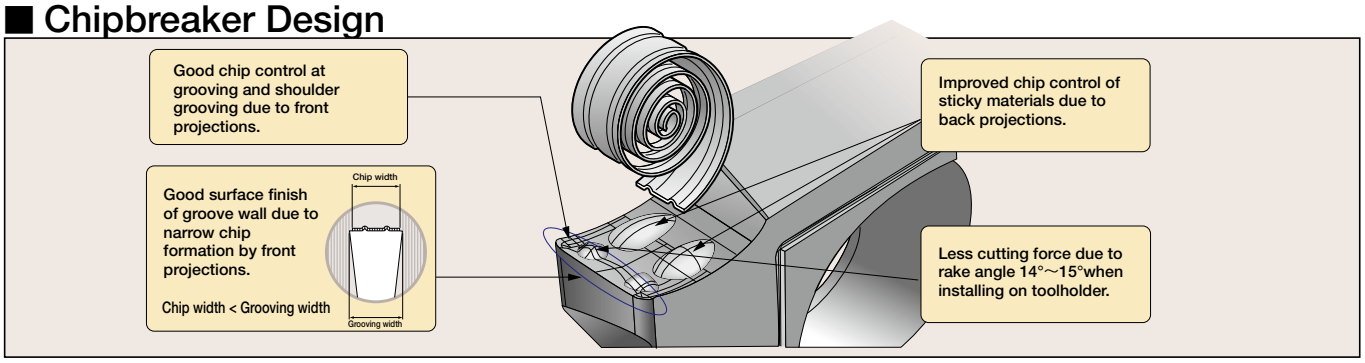
Improved Chip Control and Machining Stability by 3-D Chipbreaker Line up for Micro Grain Cermet TN6020

■ Standard Stock Items

Insert (Handed Insert Shows Right-hand)	Description	Previous Description	W	B	R	A	T	φd	Stock: Cermet TN6020 (NEW)	Stock: PVD Coated PR930 (NEW)	Stock: PVD Coated PR1115
  	GBA43R/L 175-020MY	GBA43R/L 175MY	1.75	3.5	R0.2	12.70	4.76	5.5	●	●	▲
	185-020MY	185MY	1.85						●	●	▲
	200-020MY	200MY	2.00						●	●	▲
	230-020MY	230MY	2.30						●	●	▲
	250-030MY	GBA43R/L 250MY	2.50	4.0	R0.3				●	●	
	250-030MY	-	2.50	5.0							▲
	265-030MY	GBA43R/L 265MY	2.65	4.0					●	●	
	265-030MY	-	2.65	5.0							▲
	300-030MY	GBA43R/L 300MY	3.00	4.0					●	●	
	300-030MY	-	3.00	5.0							▲
	330-030MY	GBA43R/L 330MY	3.30	4.0					R	R	
	330-030MY	-	3.30	5.0							▲
	350-030MY	GBA43R/L 350MY	3.50	5.0					●	●	▲
	400-040MY	400MY	4.00		R0.4				●	●	▲

● : Standard Stock R : Right Hand Only ▲ : Scheduled to be Stock in January 2007

■ Chipbreaker Design



■ Chip Control Comparison

Grooving

Feed Rate (mm/rev)	0.08	0.1	0.15
GBA-MY			
Conventional Ground Chipbreaker A			

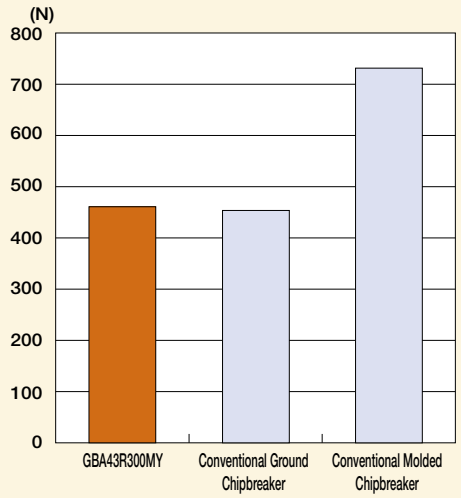
<Cutting Conditions>
SCM440 (4140)
V=150m/min (500SFM)
Wet

Shoulder Grooving

Feed Rate (mm/rev)	0.08	0.1	0.15
D.O.C 0.5mm			
D.O.C1.0mm			

<Cutting Conditions>
SCM415 (CrMo)
V=150m/min (500SFM)Wet
GBA43R400MY PR930

■ Cutting Force Comparison



<Cutting Conditions>
SCM435 (4135)
V=120m/min (400SFM)
f=0.1mm/rev
Width: 3.0mm

Cutting force of GBA-MY is as low as that of the conventional ground chipbreaker and much lower than that of the conventional molded chipbreaker.