



VB			Chip Breaker: PS - Finishing to Medium		
PS	Chip Breaker		Cermets Grades	Coated Carbide Grades	
			AT530	T9025	
<---Speed/Toughness-->					
I.C.	T	Radius	Applications	Steel 600-1000	Steel
			Geometry	Stainless 500-800	
1/4 0.250	1/8 0.125	1/128 0.008	VBMT220PS VBMT110302PS	TO-3122	-
1/4 0.250	1/8 0.125	1/64 0.016	VBMT221PS VBMT110304PS	TO-3123	-
1/4 0.250	1/8 0.125	1/32 0.031	VBMT222PS VBMT110308PS	TO-3124	-
3/8 0.375	3/16 0.187	1/64 0.016	VBMT331PS VBMT160404PS	TO-3125	TO-3676
3/8 0.375	3/16 0.187	1/32 0.031	VBMT332PS VBMT160408PS	TO-3127	TO-3677
D.O.C. = .020~.080, Feed = .003 ~ .012					

VC			Chip Breaker: PP - General Purpose	
PP	Chip Breaker		Uncoated Carbide Grades	
			H10T	
I.C.	T	Radius	Applications	S.A.
			Geometry	Non Ferrous 700-1500
3/8 0.375	3/16 0.187	1/64 0.016	VCGT331PP VCGT160404PP	TO-3129
3/8 0.375	3/16 0.187	1/32 0.031	VCGT332PP VCGT160408PP	TO-3130
3/8 0.375	3/16 0.187	3/64 0.047	VCGT333PP VCGT160412PP	TO-3131
D.O.C. = .020~.140, Feed = .004 ~ .020				



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WN			Chip Breaker: TS - SEMI FINISHING				
TS	Chip Breaker		Cermets grades		Coated Carbide Grades		
			NS530	AT530	T9015	T9025	
<-----Speed/Toughness----->							
I.C.	T	Radius	Applications	Steel	Steel 700-1100	Steel 700-1000	Steel 400-800
			Geometry		Stainless 500-700		Stainless 300-600
1/2 0.500	3/16 0.187	1/64 0.016	WNMG431TS WNMG080404TS	TO-3296	TO-3294	TO-3702	TO-3703
1/2 0.500	3/16 0.187	1/32 0.031	WNMG432TS WNMG080408TS	TO-3358	TO-3356	TO-3712	TO-3713
D.O.C. = .020~.060, Feed = .003 ~ .008							

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WN			Chip Breaker: SS - SEMI-FINISH		
SS	Chip Breaker		Coated Carbide Grades		
			T6020	T6030	
<---Speed/Toughness-->					
I.C.	T	Radius	Applications	Stainless 350-600	Stainless 250-500
			Geometry		
1/2 0.500	3/16 0.187	1/64 0.016	WNMG431SS WNMG080404SS	TO-3266	TO-3267
1/2 0.500	3/16 0.187	1/32 0.031	WNMG432SS WNMG080408SS	TO-3318	TO-3319
1/2 0.500	3/16 0.187	3/64 0.047	WNMG433SS WNMG080412SS	-	TO-3376
D.O.C. = .020~.120, Feed = .003 ~ .008					

WN			Chip Breaker: SA - Light Cutting		
SA	Chip Breaker		Coated Carbide Grades		
			AH110	AH120	
<----Speed/Toughness---->					
I.C.	T	Radius	Applications	S.A. 200-250	S.A. 150-200
			Geometry	Stainless 500-800	Stainless 450-700
1/2 0.500	3/16 0.187	1/32 0.031	WNMG432SA WNMG080408SA	TO-3310	TO-3311
1/2 0.500	3/16 0.187	3/64 0.047	WNMG433SA WNMG080412SA	-	TO-3371
D.O.C. = .040~.100, Feed = .008 ~ .014					

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WN			Chip Breaker: SM - for Medium Cutting		
SM			Coated Carbide Grades		
			T6020	T6030	
<--Speed/Toughness-->					
I.C.	T	Radius	Applications	Stainless 400-650	Stainless 300-500
			Geometry		
1/2 0.500	3/16 0.187	1/64 0.016	WNMG431SM WNMG080404SM	TO-3262	TO-3263
1/2 0.500	3/16 0.187	1/32 0.031	WNMG432SM WNMG080408SM	TO-3314	TO-3315
1/2 0.500	3/16 0.187	3/64 0.047	WNMG433SM WNMG080412SM	TO-3374	TO-3375

D.O.C. = .040~.150, Feed = .006 ~ .014



WN			Chip Breaker: TM for Medium Cutting					
TM			Coated Carbide Grades					
			T9015	T9025	T9035	AH110	AH120	
<-----Speed/Toughness----->								
I.C.	T	Radius	Applications	Steel 500-1000	Steel 400-800	Steel	S.A. 125-200	S.A. 65-150
			Geometry					Stainless 400-600
3/8 0.375	3/16 0.187	1/64 0.016	WNMG331TM WNMG060404TM	TO-3694	TO-3695	-	-	-
3/8 0.375	3/16 0.187	1/32 0.031	WNMG332TM WNMG060408TM	TO-3697	TO-3698	-	-	-
1/2 0.500	3/16 0.187	1/64 0.016	WNMG431TM WNMG080404TM	TO-3699	TO-3700	TO-3701	TO-3276	TO-3277
1/2 0.500	3/16 0.187	1/32 0.031	WNMG432TM WNMG080408TM	TO-3709	TO-3710	TO-3711	TO-3337	TO-3338
1/2 0.500	3/16 0.187	3/64 0.047	WNMG433TM WNMG080412TM	TO-3718	TO-3719	TO-3720	TO-8550	TO-3391
1/2 0.500	3/16 0.187	1/16 0.062	WNMG434TM WNMG080416TM	TO-3722	TO-3723	-	-	-

D.O.C. = .040~.175, Feed = .008 ~ .020

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WN			Chip Breaker: TH - for Roughing					
TH			Coated Carbide Grades					
			T9005	T9025	T9035	T6030	AH120	
<-----Speed/Toughness----->								
I.C.	T	Radius	Applications	Steel 650-1050	Steel 300-700	Steel	Stainless 250-500	S.A. 65-150
			Geometry					
1/2 0.500	3/16 0.187	1/32 0.031	WNMG432TH WNMG080408TH	TO-3704	TO-3705	TO-3707	TO-3332	TO-3329
1/2 0.500	3/16 0.187	3/64 0.047	WNMG433TH WNMG080412TH	TO-3714	TO-3715	TO-3717	TO-3386	TO-3383
1/2 0.500	3/16 0.187	1/16 0.062	WNMG434TH WNMG080416TH	TO-3721	-	-	-	-

D.O.C. = .120~.250, Feed = .012 ~ .020

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