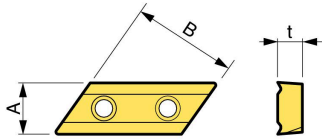


## Indexable Inserts



A=Non-coated AZX=TiCN+TiAlN multilayer coating

Insert Model	A	B	t	P30	P20
				A	AZX
CW1206	6.35	12.7	2.7	○	○
CW1909	9.525	19.05	4.5	○	○
CW3115	15.875	31.75	7.0	○	○

1. Insert is available from 1 pce.
2. Insert set is available in packs of 10 pcs. Please add "S" before each model number when ordering.  
Example:SCW1206A

## Recommended cutting conditions

Cutter Type	Max. Chamfer	Chamfering	General steel Alloy steel		Stainless steel		Cast iron		Aluminum	
			V (m/min)	f (mm/rev)	V (m/min)	f (mm/rev)	V (m/min)	f (mm/rev)	V (m/min)	f (mm/rev)
ST20-C5/85A-40	※2mm	Plunge Cutting	50	0.1	30	0.08	40	0.1	80	0.1
		Side Cutting	80	0.15	60	0.1	50	0.15	100	0.2
C0525C	C2	Plunge Cutting	50	0.1	30	0.08	40	0.1	80	0.1
		Side Cutting	80	0.15	60	0.1	50	0.15	100	0.15
C1040C	C3	Plunge Cutting	90	0.15	40	0.12	60	0.15	100	0.2
C1434C-60	※3mm	Side Cutting	120	0.3	60	0.2	90	0.3	150	0.3
C1652C-30		Plunge Cutting	120	0.3	60	0.18	90	0.25	150	0.3
C3060C/C3060	C4	Plunge Cutting	120	0.3	60	0.18	90	0.25	150	0.3
C3050C-60	※4mm	Side Cutting	150	0.45	60	0.3	120	0.6	200	0.6
C4565C-60		Plunge Cutting	150	0.4	80	0.25	120	0.35	180	0.4
C5085C-30	C4	Side Cutting	150	0.45	60	0.36	120	0.6	240	0.6
C50100C		Plunge Cutting	150	0.4	80	0.25	120	0.35	180	0.4

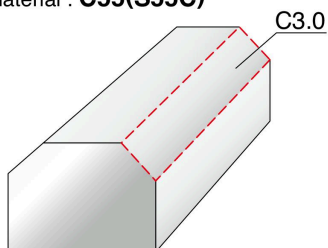
V : Cutting speed (m/min.) f: Feed per revolution (mm/rev.)

1. Cutting condition is the same for both non-coated and coated inserts. Coated inserts will achieve better surface finish and extended insert life.
2. Peck feed is necessary in case cutting chips are too long.
3. Reduce cutting speed if a larger chamfer than the max. amount shown in the table is required.
4. A high rigidity toolholder is recommended, such as BIG HMC or MEGA-D Chuck.
5. Max. chamfering amount with ※ in 30, 60 degree type and Universal type indicates the chamfering length of the longer side.

## Application example

### C3 traverse chamfering

Workmaterial : C55(S55C)



High cutting parameter was achieved without chattering.

C-CUTTER	ST25-C1040
Insert Model	CW1909A
Spindle speed	3,000 min <sup>-1</sup>
Feed	1,800mm/min