

NEW PRODUCT NEWS

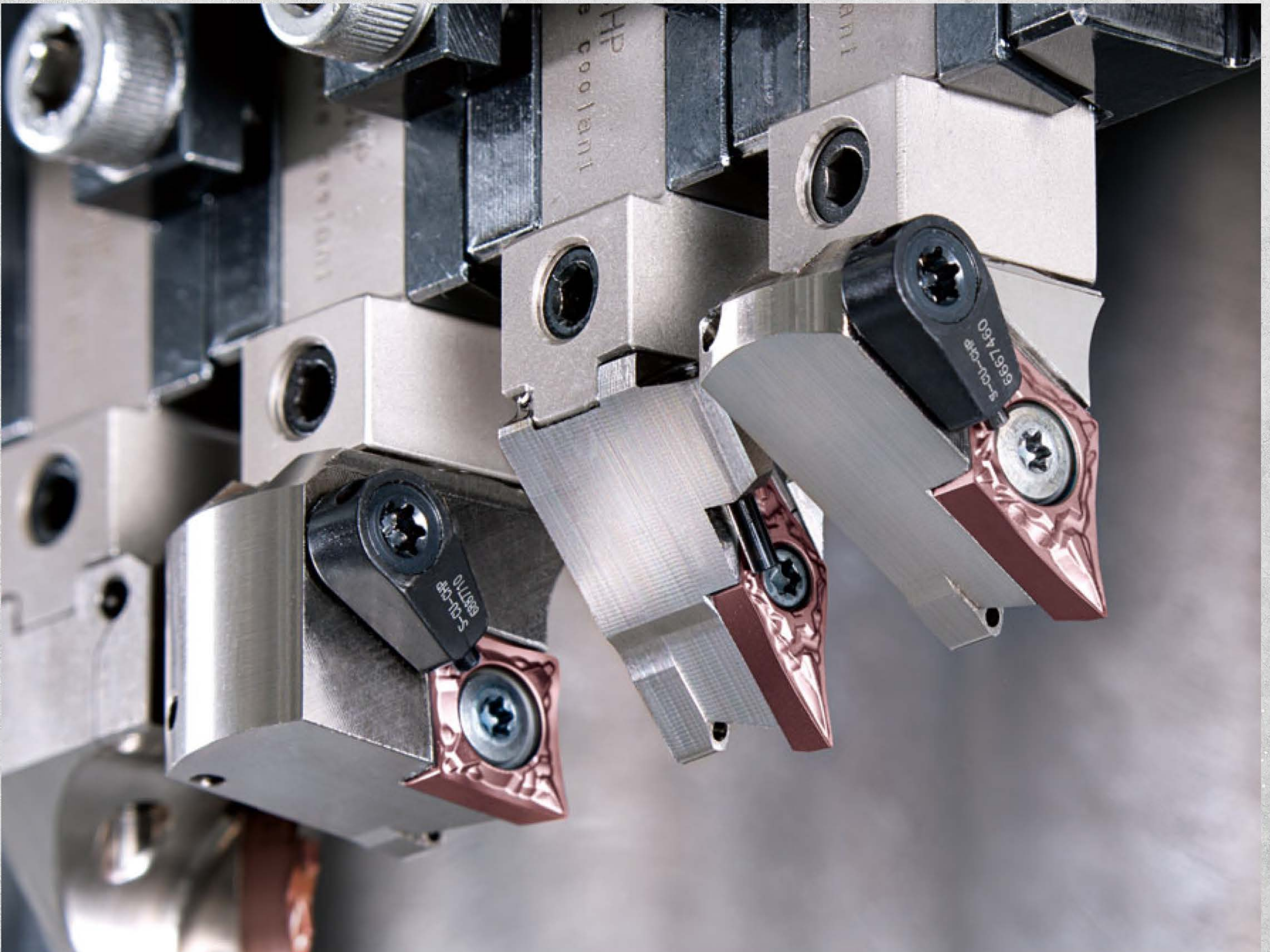


Tungaloy Report No. 547SI-G

Grades for stainless steel

AH6200 SERIES

Expansion of JS chipbreaker inserts for stainless steel machining



AH6200 SERIES

High precision G-class 3D chipbreaker

Provides excellent chip control and superior surface finishing quality in stainless steel

JS First choice chipbreaker for finish cutting



Chipbreaker geometry that allows light cutting action and excellent chip breaking

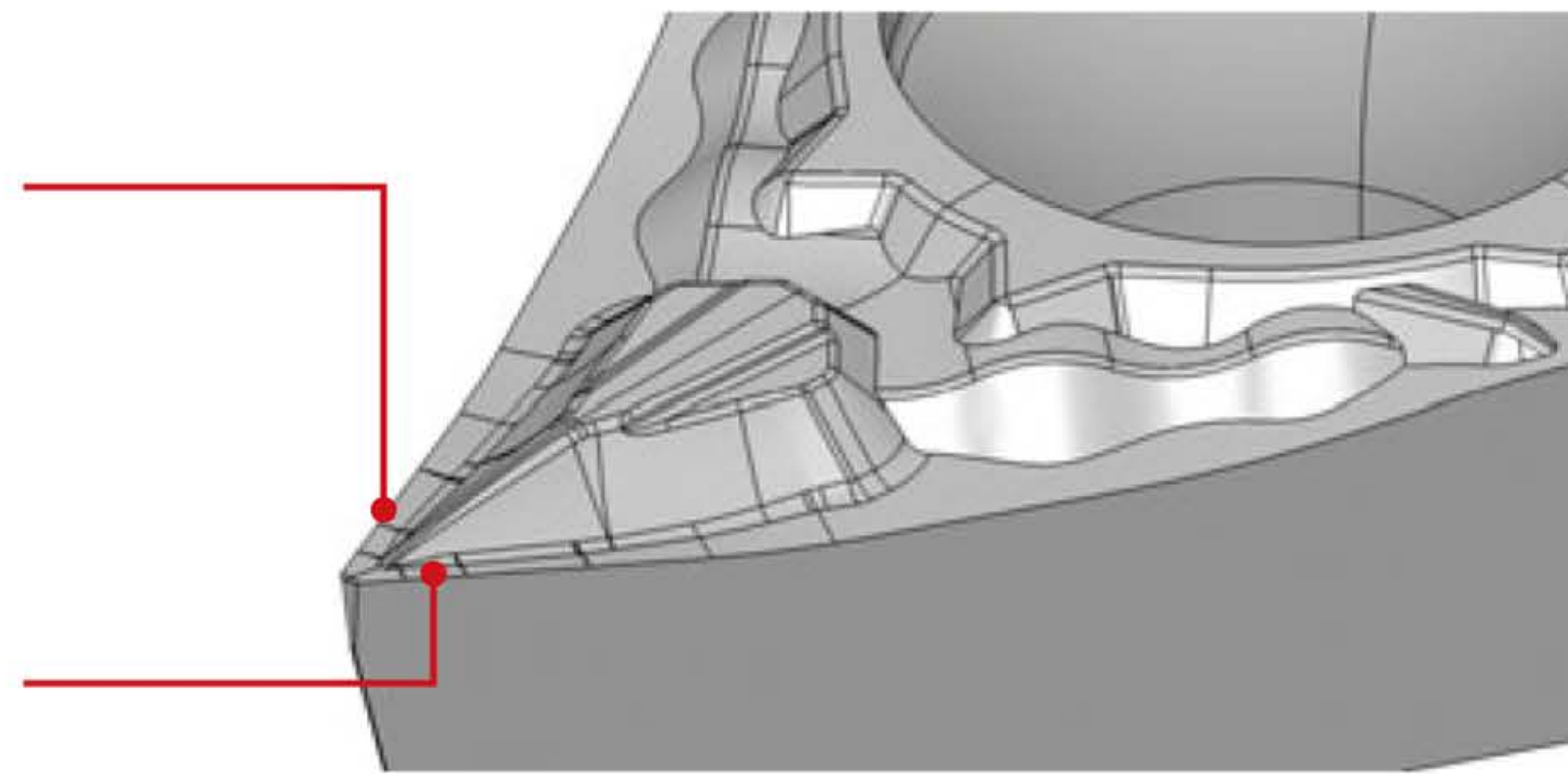
- A steep cutting edge inclination angle for better chip control and reduced cutting load
- A unique protrusion that extends towards the radius effectively controls chip flow from small to large cutting depths

Cutting edge with a steep inclination angle

Provides good chip evacuation and reduced cutting loads

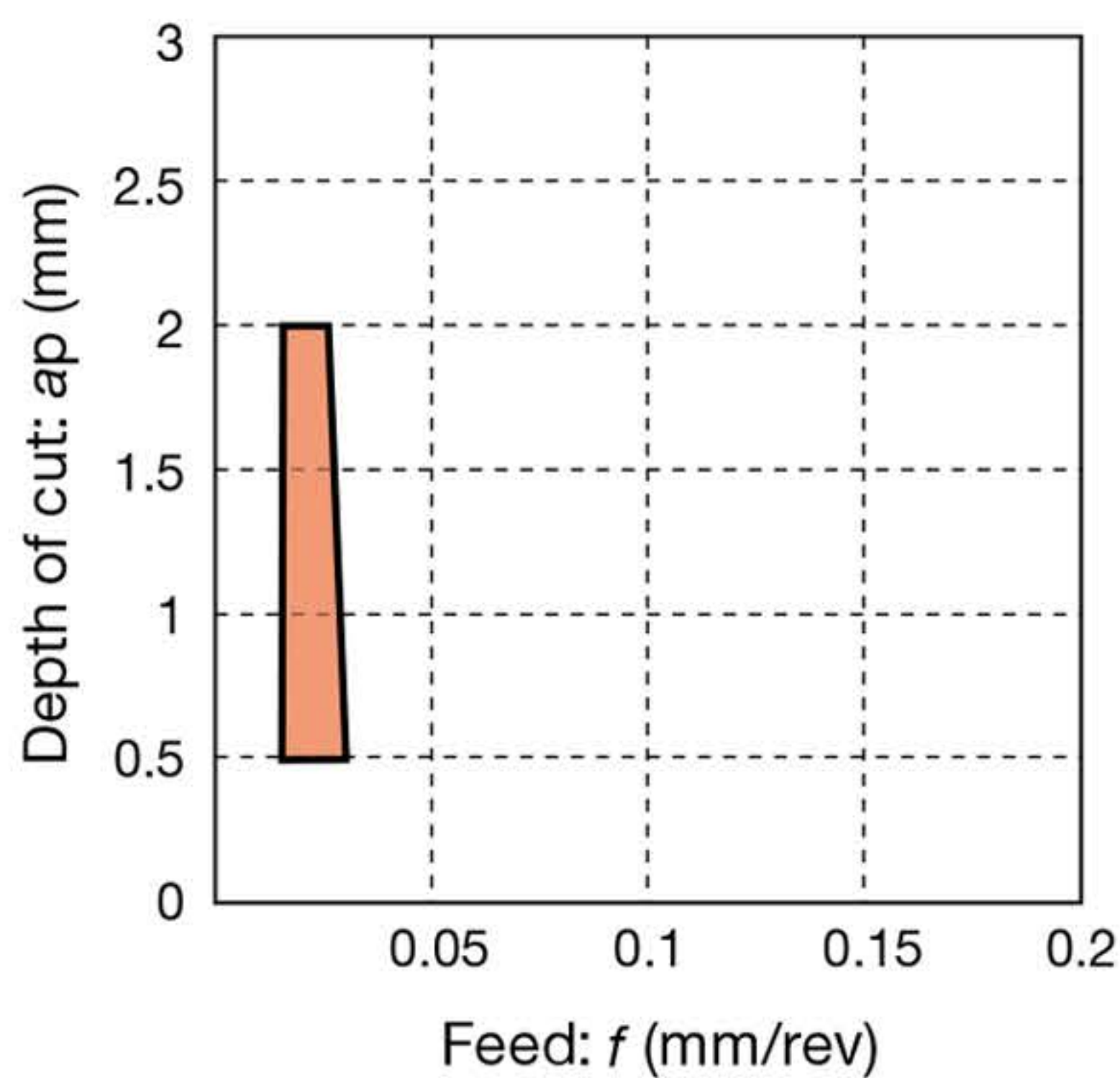
Rake with variable angles and steep protrusion

Provides stable chip control in the small to large cutting depth range and also maintains cutting edge integrity and sharpness over extended period of time

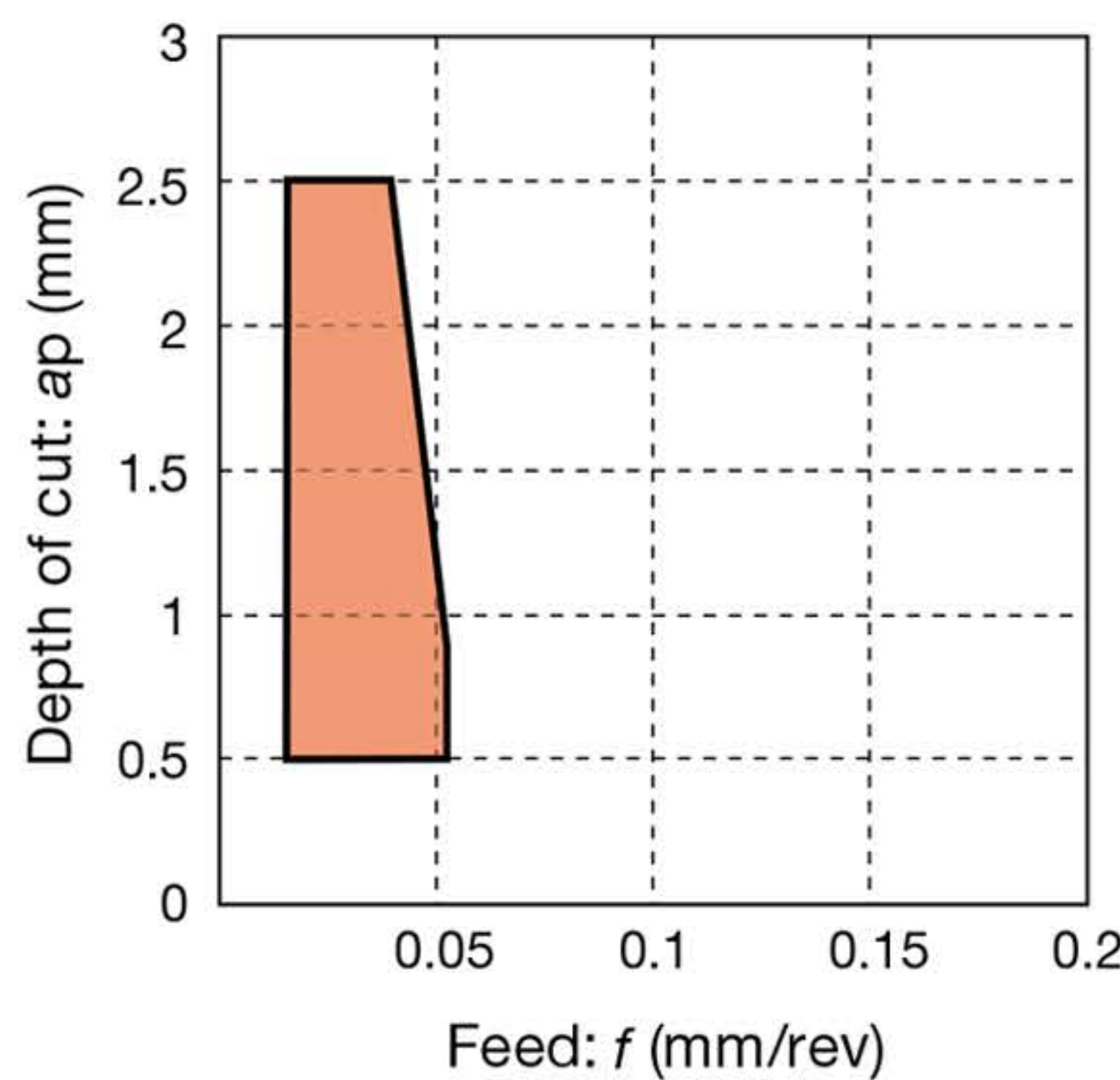


Chip control range

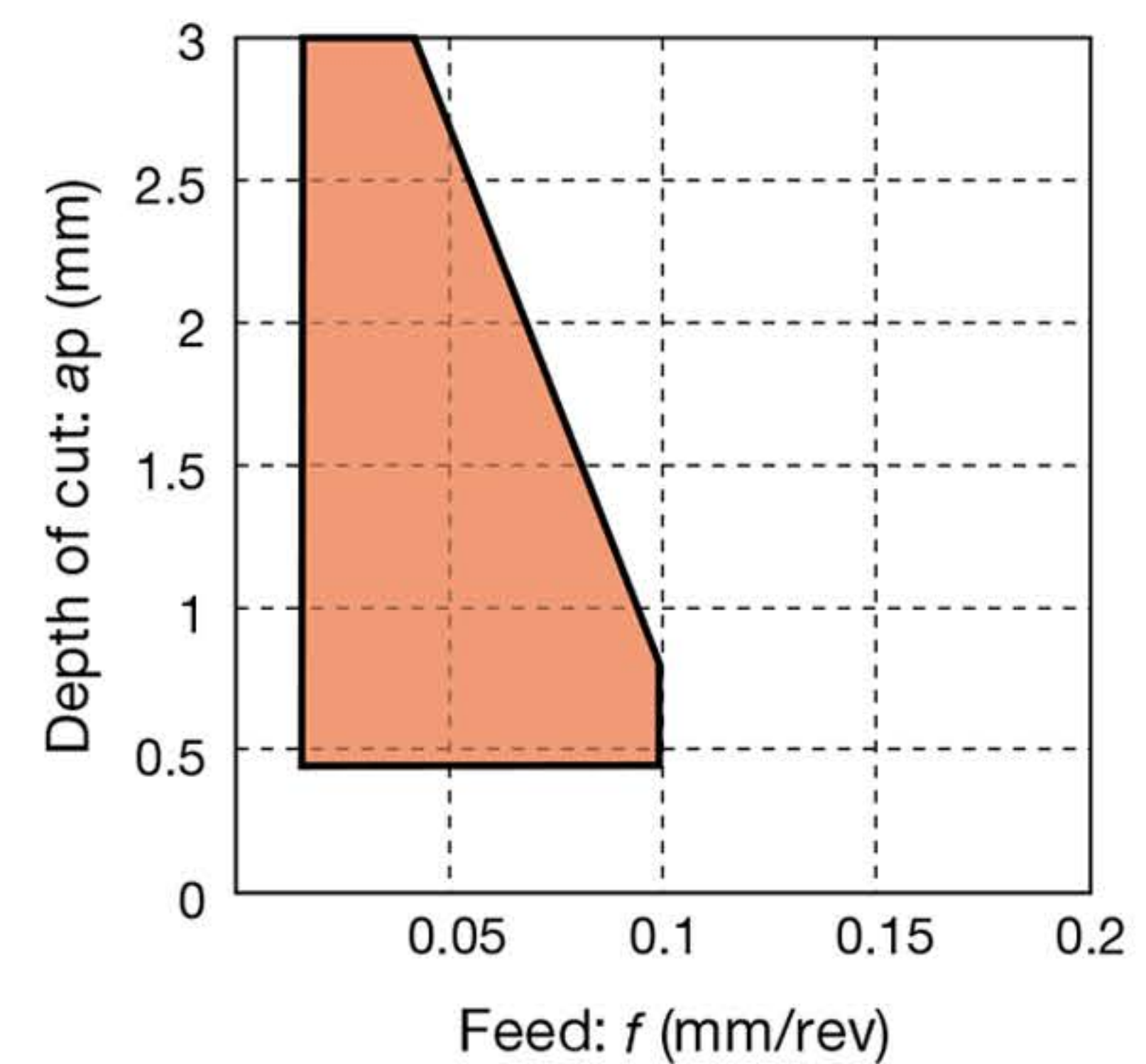
RE < 0.05 mm



RE < 0.1 mm



RE < 0.2 mm



Chip control



M Insert : DCGT11T302M-JS
AH6225
Workpiece material : SUS316L /
X5CrNiMo17-12-3
Cutting speed : $V_c = 80$ m/min
Feed : $f = 0.025$ mm/rev
Depth of cut : $a_p = 1$ mm
Coolant : Wet

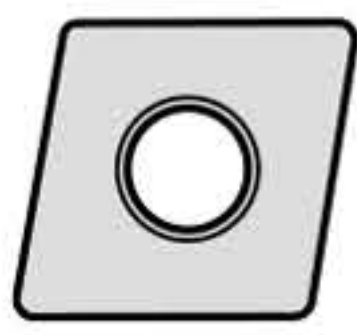
M Insert : DCGT11T302M-JS
AH6225
Workpiece material : SUS316L /
X5CrNiMo17-12-3
Cutting speed : $V_c = 80$ m/min
Feed : $f = 0.05$ mm/rev
Depth of cut : $a_p = 0.5$ mm
Coolant : Wet

M Insert : DCGT11T302M-JS
AH6225
Workpiece material : SUS316L /
X5CrNiMo17-12-3
Cutting speed : $V_c = 80$ m/min
Feed : $f = 0.1$ mm/rev
Depth of cut : $a_p = 0.1$ mm
Coolant : Wet

● : Continuous cutting
 ● : Light interrupted cutting
 ✱ : Heavy interrupted cutting

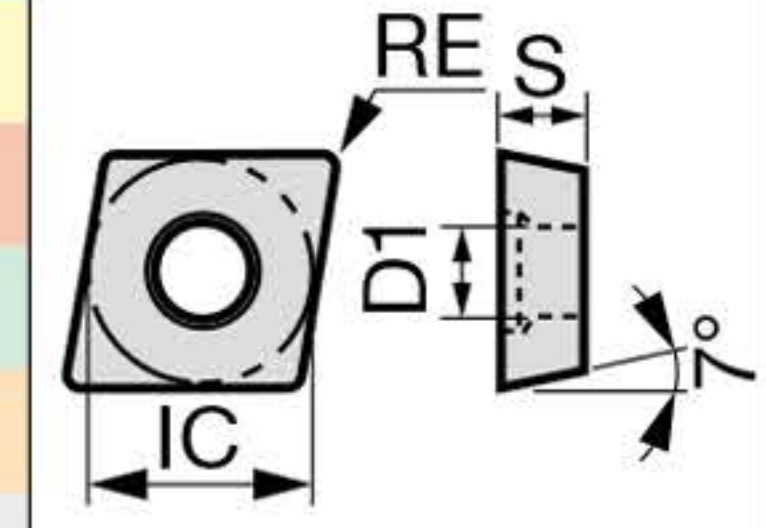
Insert POSITIVE TYPE

CC



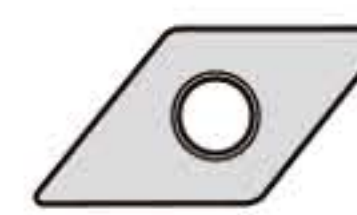
Rhombic, 80°
with hole
Positive 7°

P	Steel	● ✱
M	Stainless	● ●
K	Cast iron	
N	Non-ferrous	
S	Superalloy	
H	Hard material	



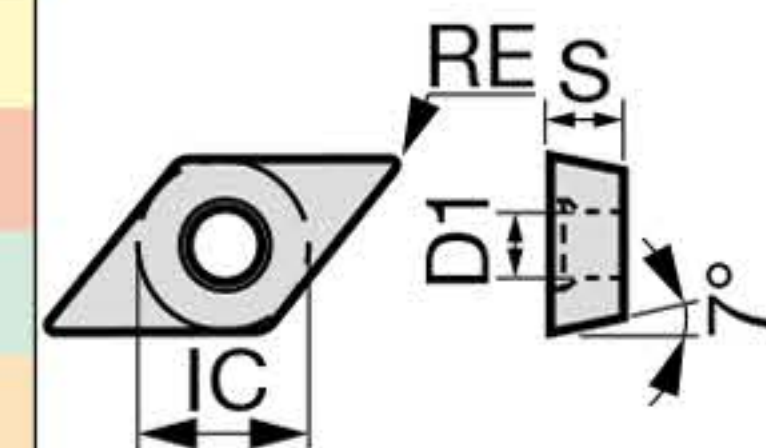
Application	Chipbreaker	Designation	Coated					Dimension (mm)			
			AH6225					RE	IC	S	D1
Finishing		JS CCGT060201M-JS	●					<0.1	6.35	2.38	2.8
		CCGT060202M-JS	●					<0.2	6.35	2.38	2.8
		CCGT060204M-JS	●					<0.4	6.35	2.38	2.8
		CCGT09T301M-JS	●					<0.1	9.525	3.97	4.4
		CCGT09T302M-JS	●					<0.2	9.525	3.97	4.4
		CCGT09T304M-JS	●					<0.4	9.525	3.97	4.4

DC



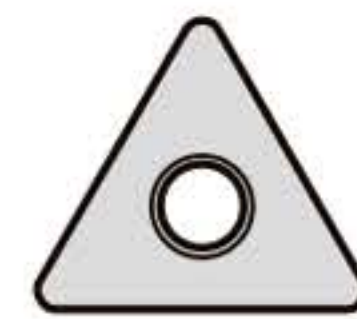
Rhombic, 55°
with hole
Positive 7°

P	Steel	● ✱
M	Stainless	● ●
K	Cast iron	
N	Non-ferrous	
S	Superalloy	
H	Hard material	



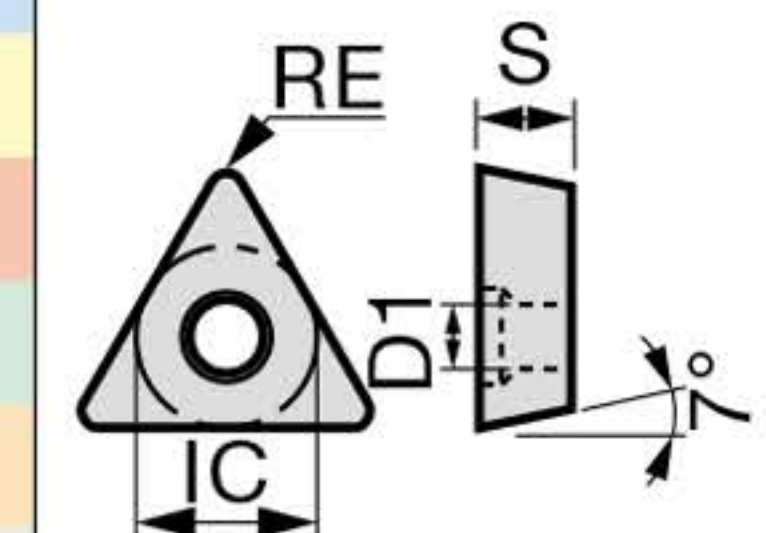
Application	Chipbreaker	Designation	Coated					Dimension (mm)			
			AH6225					RE	IC	S	D1
Finishing		JS DCGT070201M-JS	●					<0.1	6.35	2.38	2.8
		DCGT070202M-JS	●					<0.2	6.35	2.38	2.8
		DCGT11T301M-JS	●					<0.1	9.525	3.97	4.4
		DCGT11T302M-JS	●					<0.2	9.525	3.97	4.4
		DCGT11T304M-JS	●					<0.4	9.525	3.97	4.4

TC



Triangular, 60°
with hole
Positive 7°

P	Steel	● ✱
M	Stainless	● ●
K	Cast iron	
N	Non-ferrous	
S	Superalloy	
H	Hard material	



Application	Chipbreaker	Designation	Coated					Dimension (mm)			
			AH6225					RE	IC	S	D1
Finishing		JS TCGT110201M-JS	●					<0.1	6.35	2.38	2.8
		TCGT110202M-JS	●					<0.2	6.35	2.38	2.8
		TCGT110204M-JS	●					<0.4	6.35	2.38	2.8

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : New product

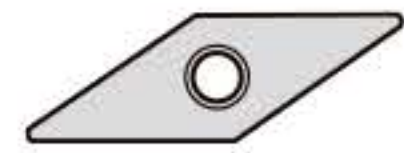
AH6200 SERIES

Insert POSITIVE TYPE

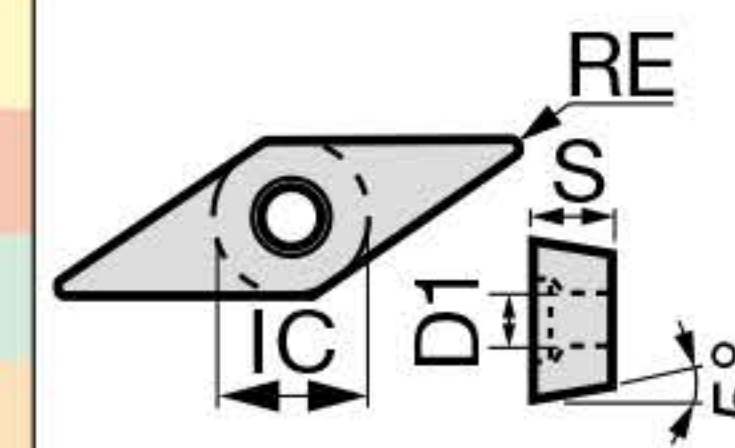
- : Continuous cutting
- (small) : Light interrupted cutting
- ✱ : Heavy interrupted cutting

VB

Rhombic, 35°
with hole
Positive 5°



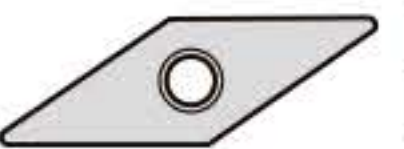
	P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material
Application	Coated					



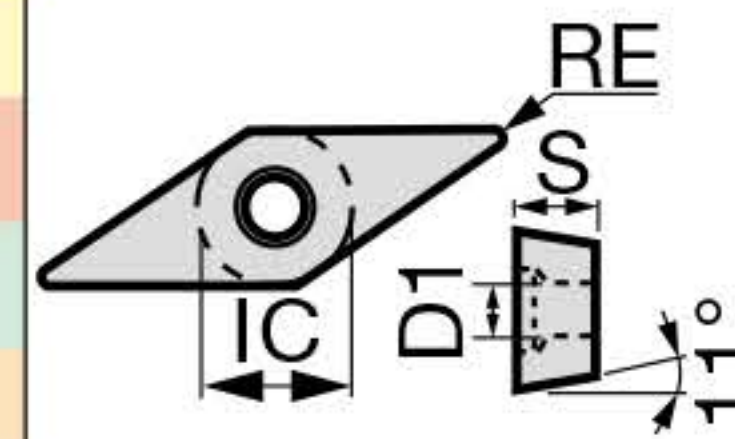
Application	Chipbreaker	Designation	Coated	Dimension (mm)			
				RE	IC	S	D1
Finishing	JS	VBGT110301M-JS	●	<0.1	6.35	3.18	2.8
		VBGT110302M-JS	●	<0.2	6.35	3.18	2.8
		VBGT110304M-JS	●	<0.4	6.35	3.18	2.8

VP

35° Rhombic
with hole
Positive 11°



	P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material
Application	Coated					



Application	Chipbreaker	Designation	Coated	Dimension (mm)			
				RE	IC	S	D1
Finishing	JS	VPGT110301M-JS	●	<0.1	6.35	3.18	2.8
		VPGT110302M-JS	●	<0.2	6.35	3.18	2.8
		VPGT110304M-JS	●	<0.4	6.35	3.18	2.8

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : New product

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Chipbreaker	Grade	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed: f (mm/rev)			
						RE < 0.05	RE < 0.1	RE < 0.2	RE < 0.4
M	Austenitic stainless steel	JS	AH6225	90 - 200	0.5 - 3	0.02 - 0.03	0.02 - 0.05	0.02 - 0.1	0.05 - 0.2
	Ferritic / martensite stainless steel	JS	AH6225	110 - 240	0.5 - 3	0.02 - 0.03	0.02 - 0.05	0.02 - 0.1	0.05 - 0.2
	Precipitation hardened stainless steel	JS	AH6225	60 - 110	0.5 - 3	0.02 - 0.03	0.02 - 0.05	0.02 - 0.1	0.05 - 0.2

CONTACT US



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