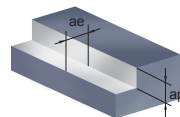


➤ Chipbreaker selection

Classification	Function	For finishing	For semi-finishing
P		-APF	-APM
M		-APF	-APM
S		-APF	-APM
K		-APF	-APM
N		-ALH	

1 Square shoulder milling



➤ Recommended cutting parameters (D: Diameter)

Workpiece material	Hardness HB	Insert grade	Cutting parameters				
			Vc(m/min)	fz(mm/z)		ae(mm)	
				-APF	-APM		
P	Low-carbon steel, Soft steel	YBC302	320 (240-400)	0.1 (0.08-0.2)	--	≤ 0.5D	
		YB9320	320 (200-400)	0.1 (0.08-0.2)	0.2 (0.1-0.3)		
		YBM253	300 (320-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)		
	High-carbon steel, Alloy steel	180-280	YBC302	280 (210-380)	0.1 (0.08-0.2)	--	≤ 0.5D
			YB9320	280 (180-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	
			YBM253	260 (150-380)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	
	Alloy tool steel	280-350	YBC302	260 (180-350)	0.1 (0.08-0.2)	--	≤ 0.5D
			YB9320	260 (160-330)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	
			YBM253	220 (150-280)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	
M	Stainless steel	YB9320	200 (110-300)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	≤ 0.5D	
		YBM253	180 (150-300)				
K	Cast iron	YB9320	180 (150-250)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	≤ 0.5D	
		YBD152	200 (150-250)	--	0.2 (0.1-0.3)		
S	Difficult-to-machine materials	YBS203	100 (60-120)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	≤ 0.5D	
		YBS303	100 (60-120)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	≤ 0.5D	
N				-ALH			
	Aluminium alloy	YD101	300-	0.2 (0.08-0.4)		≤ 0.5D	
		YD201	300-	0.2 (0.08-0.4)		≤ 0.5D	

Indexable milling tools

Square shoulder milling tools