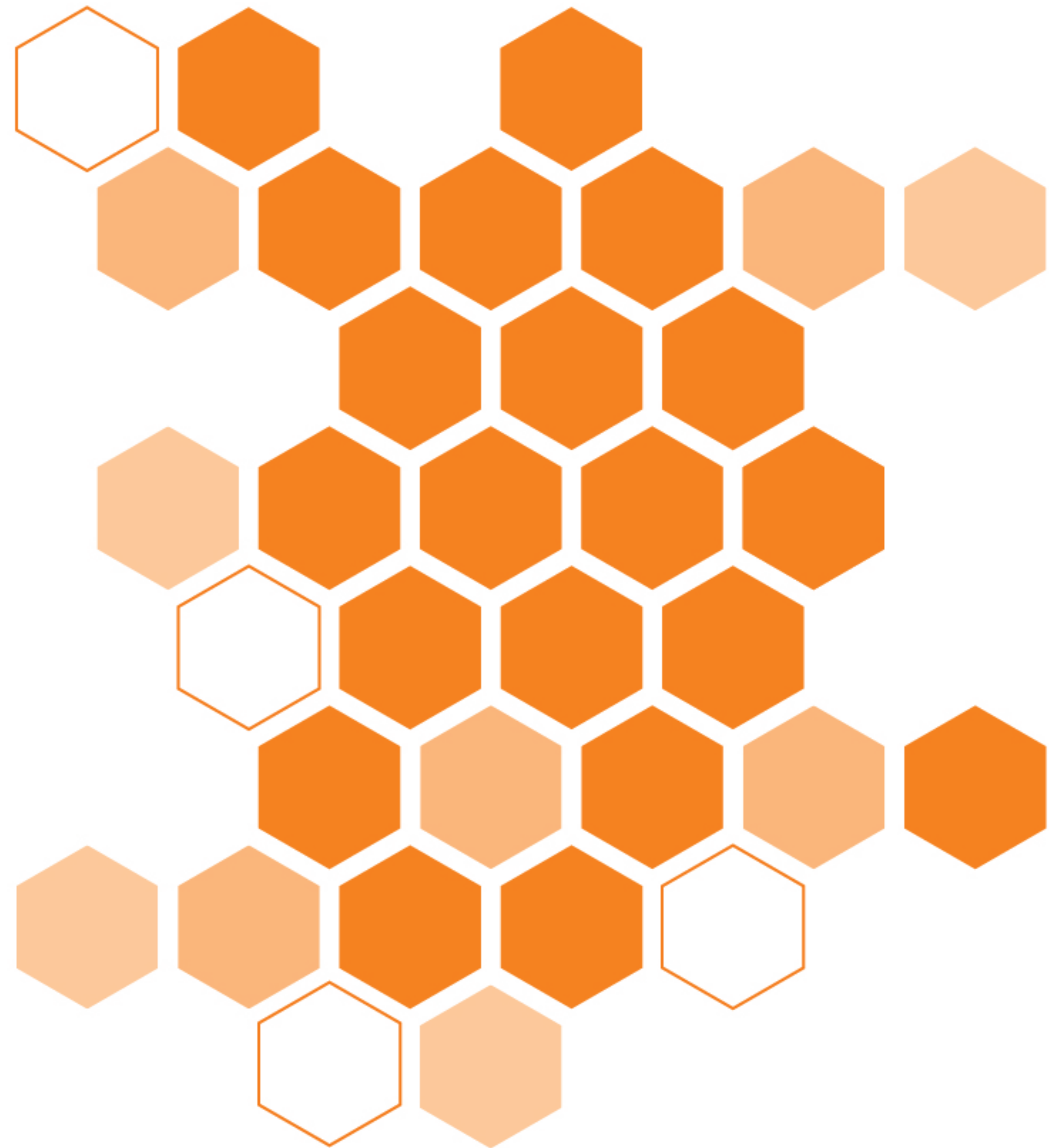
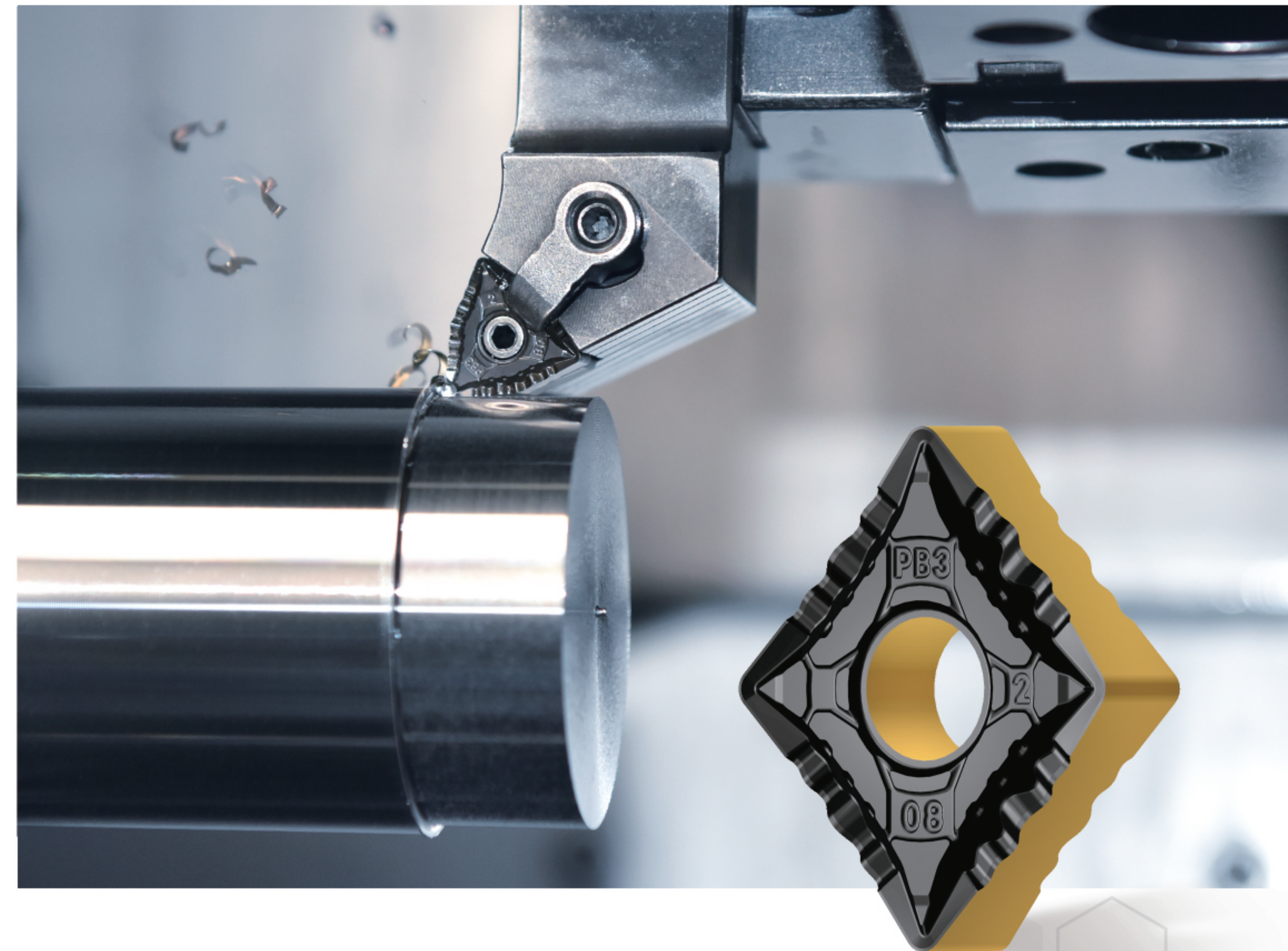


ACHTECK•TURN

NEW
PRODUCT!

New Chip Breaker **PB3**

for semi-finishing on Steels



GANZHOU ACHTECK TOOL TECHNOLOGY CO.,LTD.

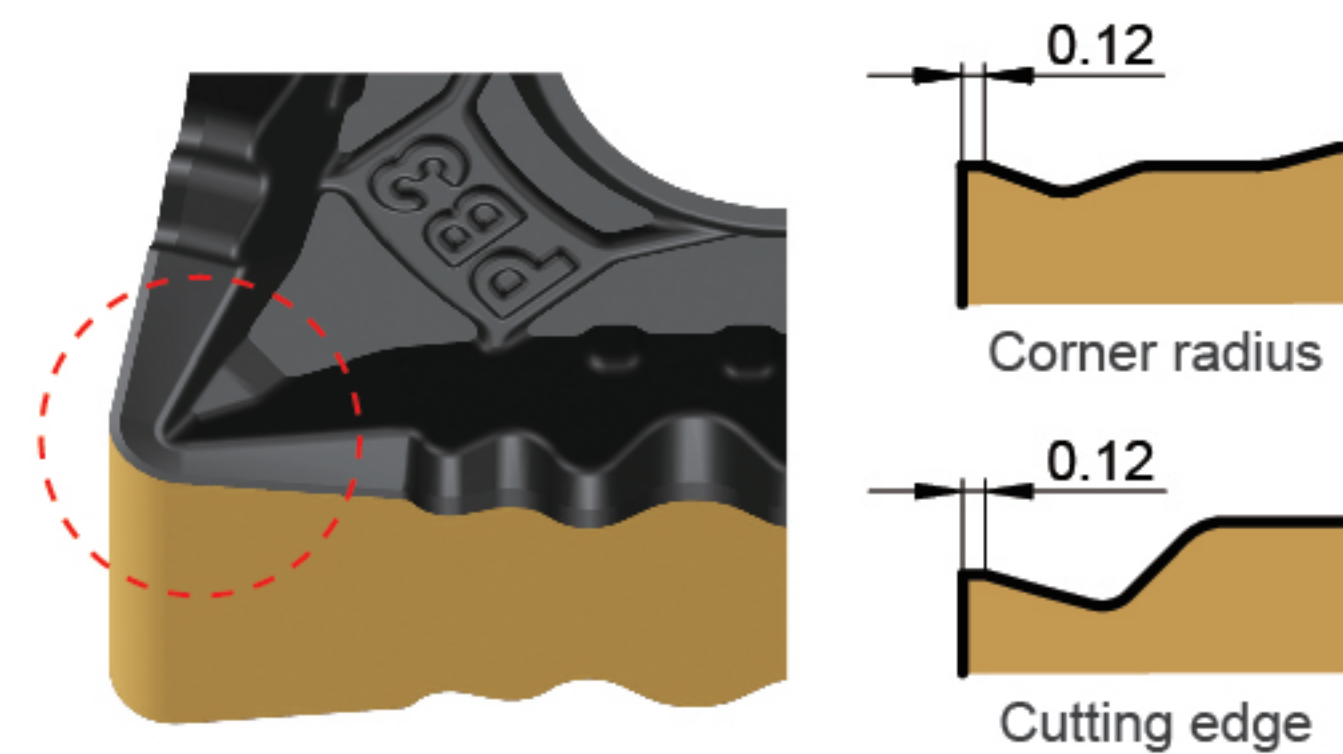
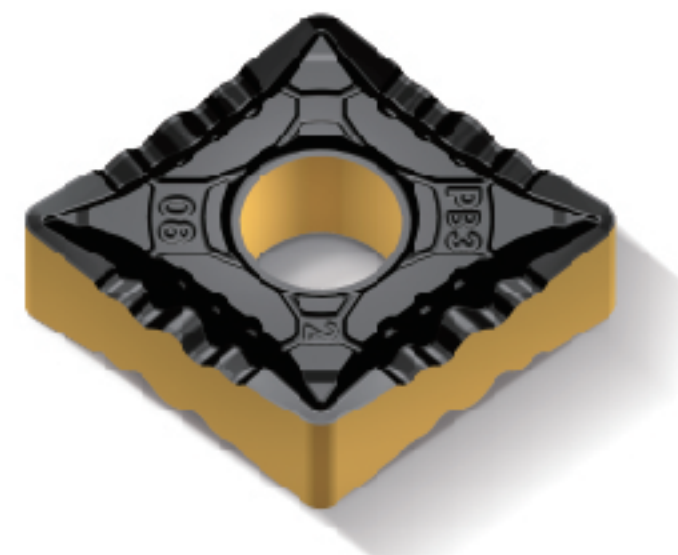
Address : Ganzhou Economic Development Area,Jiangxi,China
Tele : 0086-797-8166368 Fax : 0086-797-8166100 E-mail : alloysales@achtecktool.com

www.achtecktool.com



Grade Application

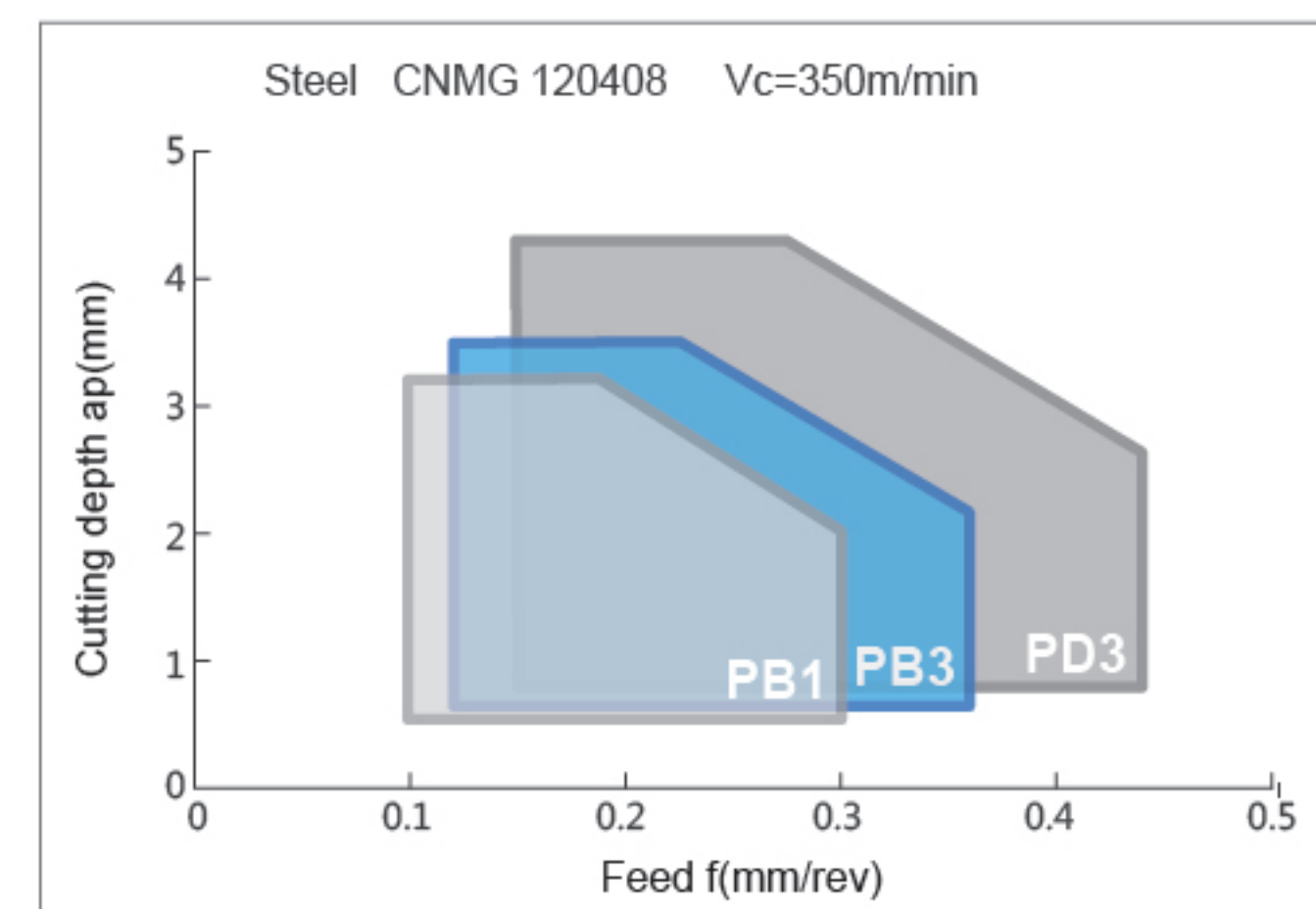
Application Range												Cutting Speed	
												m/min	
ISO	01	5	10	15	20	25	30	35	40	45	50	Vcmin	Vcmax
P			AC150P									160	458
					AC250P							120	380



Chip Breaker Features

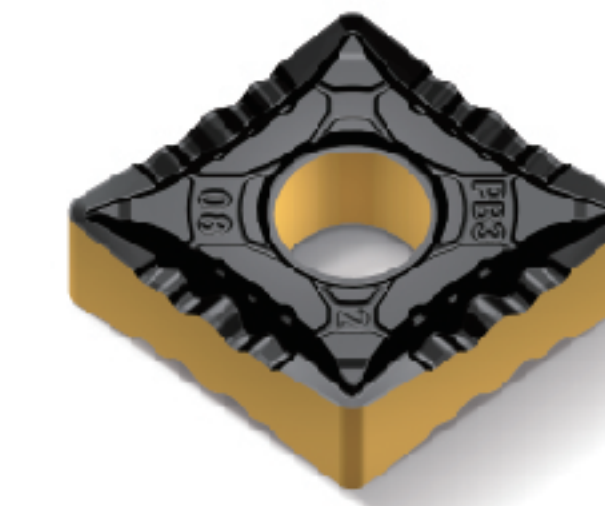
Excellent performance on small cutting depth with big feed rate, widely application range.

Superior effort on chip breaking during the spare parts machining of bearing.



Result of Chip Breaking

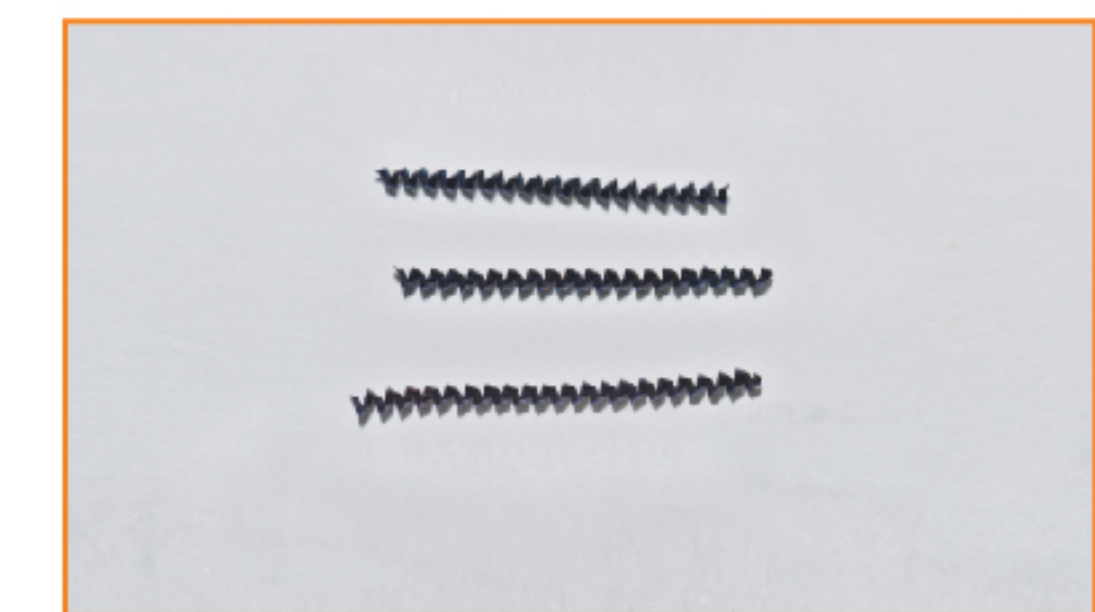
Cutting Conditions
Machined Materials: 20CrNiMo
Insert: CNMG 120408
Cutting Speed: 220m/min
Cutting Feed: 0.18mm/rev
Cutting Depth: 0.6mm
Condition: Dry cutting



Other company



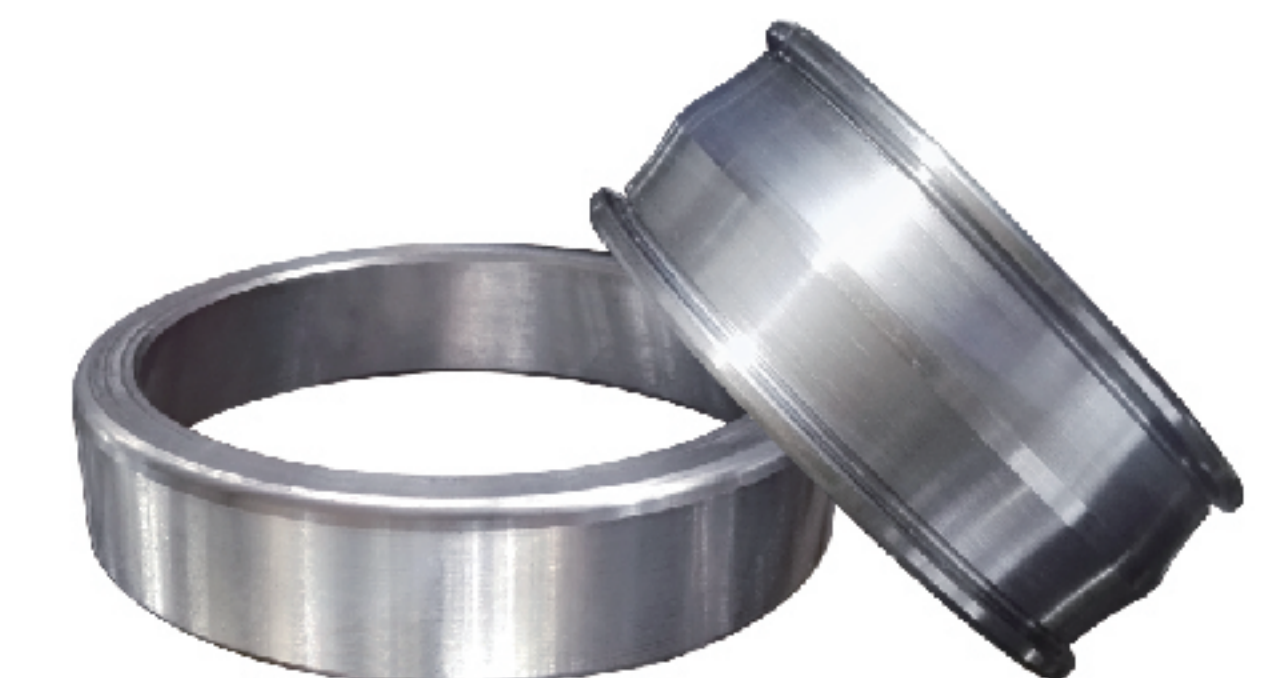
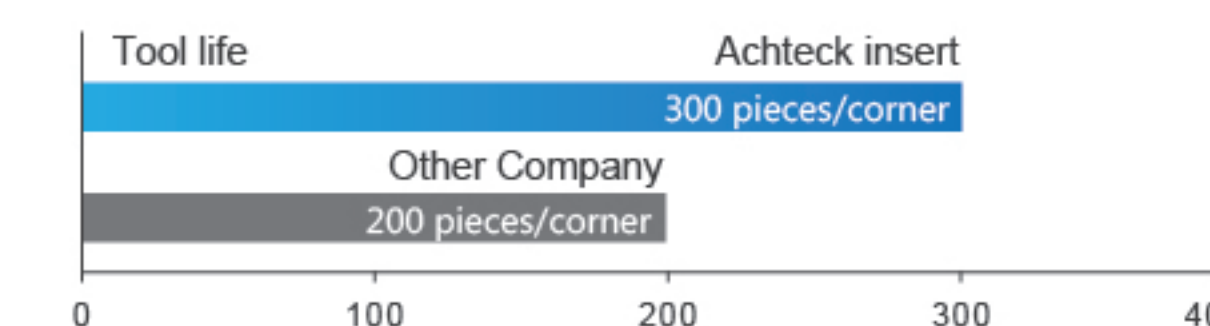
Chip breaker PB3



Machining Case

Work piece: Bearing
Material: Gr15
Insert: VNMG 160412E-PB3 AC250P
Other Company: VNMG 160412 A XX P15
Machining Type: External turning
Cutting Parameter: Vc=260m/min ap=1mm
f=0.20mm/rev

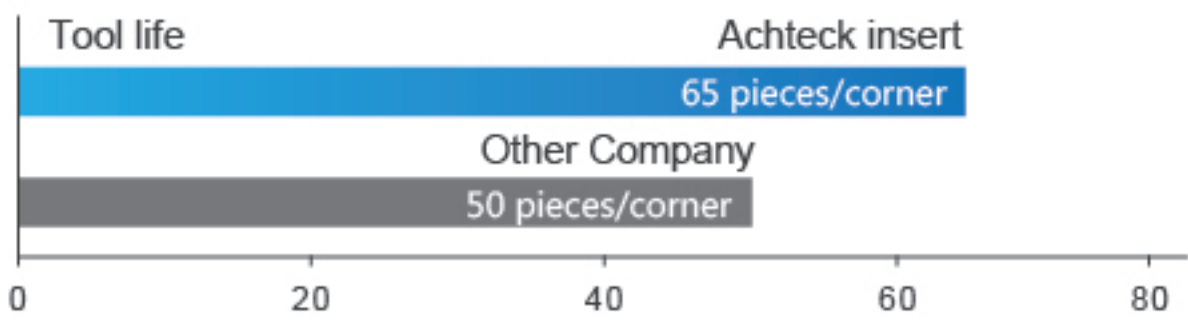
Condition: Dry cutting



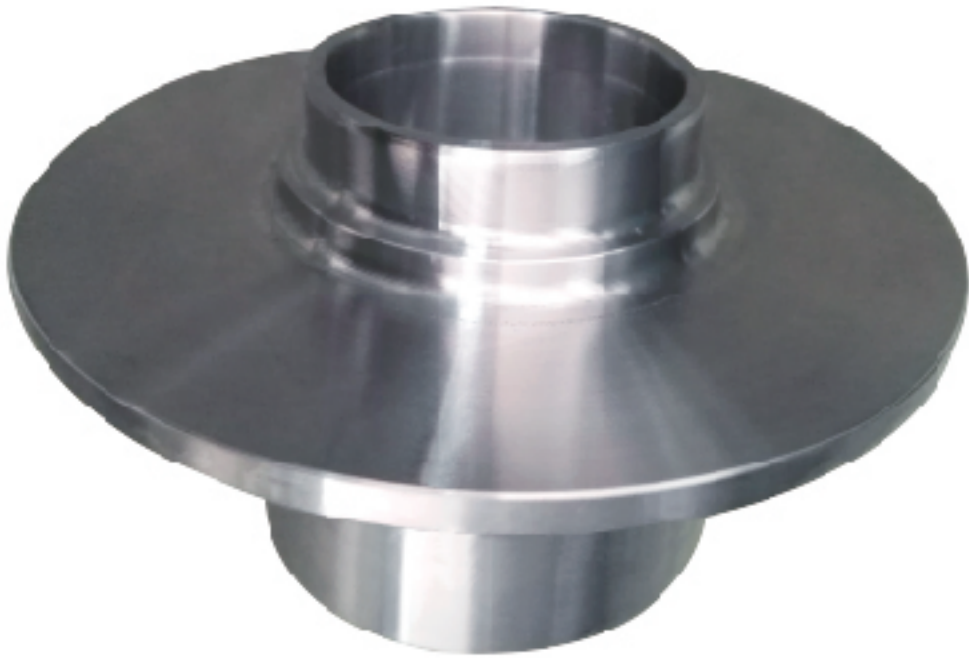
Comparison Result: Achteck tool life is 33% higher than competitor

Work piece: Joint CV Joint
Material: 65Mn
Insert: TNMG 160408E-PB3 AC150P
Other Company: TNMG 160408 B XX P15
Machining Type: End face turning
Cutting Parameter: Vc=220m/min ap=0.7-1.0mm
f=0.22mm/rev

Condition: Wet cutting

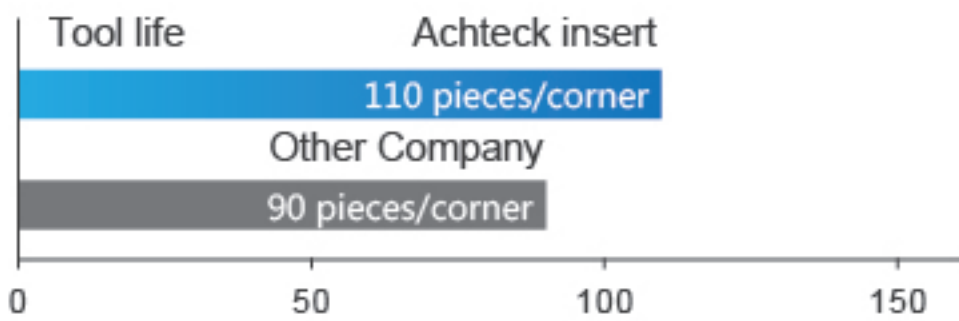


Comparison Result: Achteck tool life is 30% higher than competitor



Work piece: Wheel hub
Material: 65Mn
Insert: WNMG 080408E-PB3 AC150P
Other Company: WNMG 080408 B XX P15
Machining Type: End face turning
Cutting Parameter: Vc=320-220m/min ap=0.8mm
f=0.20mm/rev

Condition: Wet cutting



Comparison Result: Achteck tool life is 30% higher than competitor



Insert Stock

Insert picture	Designation	Application parameters		Grades	
				CVD coating	
		f (mm/rev)	ap(mm)	AC150P	AC250P
	CNMG 120404E-PB3	0.06-0.18	0.3-3.5	●	●
	CNMG 120408E-PB3	0.12-0.36	0.6-3.5	●	●
	CNMG 120412E-PB3	0.18-0.54	0.9-3.5	●	●
	DNMG 150404E-PB3	0.06-0.18	0.3-3.1	●	●
	DNMG 150408E-PB3	0.12-0.36	0.6-3.1	●	●
	DNMG 150412E-PB3	0.18-0.54	0.9-3.1	●	●
	DNGM 150604E-PB3	0.06-0.18	0.3-3.1	●	●
	DNMG 150608E-PB3	0.12-0.36	0.6-3.1	●	●
	DNMG 150612E-PB3	0.18-0.54	0.9-3.1	●	●
	TNMG 160404E-PB3	0.06-0.18	0.3-3.3	●	●
	TNMG 160408E-PB3	0.12-0.36	0.6-3.3	●	●
	TNMG 160412E-PB3	0.18-0.54	0.9-3.3	●	●
	VNMG 160404E-PB3	0.06-0.18	0.3-3.1	●	●
	VNMG 160408E-PB3	0.12-0.36	0.6-3.1	●	●
	VNMG 160412E-PB3	0.18-0.54	0.9-3.1	●	●
	WNMG 080404E-PB3	0.06-0.18	0.3-2.3	●	●
	WNMG 080408E-PB3	0.12-0.36	0.6-2.3	●	●
	WNMG 080412E-PB3	0.18-0.54	0.9-2.3	●	●

● Represent for standard stock

Recommended Cutting Parameters

Cutting Materials					Achteck turning insert grade application range					
ISO	Class	Material group	Hardness/strength		AC150P			AC250P		
					P10-25			P20-35		
					CVD			CVD		
					f(mm/rev)			f(mm/rev)		
					0.08	0.2	0.35	0.08	0.2	0.35
P	A	Non-alloy steels	<600 N/mm ²	<180HBN	485	378	270	380	260	160
	B		<950 N/mm ²	<280HBN	335	243	150	240	162	100
	C	Alloyed steels	700-950 N/mm ²	200-280 HBN	315	168	120	230	155	90
	D		950-1200 N/mm ²	280-355 HBN	285	150	90	180	137	75
	E		1200-1400 N/mm ²	355-415 HBN	235	110	70	135	92	55

* The recommended cutting conditions always refer to general conditions. These cutting conditions should be adjusted according to the practical machine rigidity, tools, work piece clamping and coolants. (f=mm/rpm needs to adjust according to corner radius)

ACHTECK