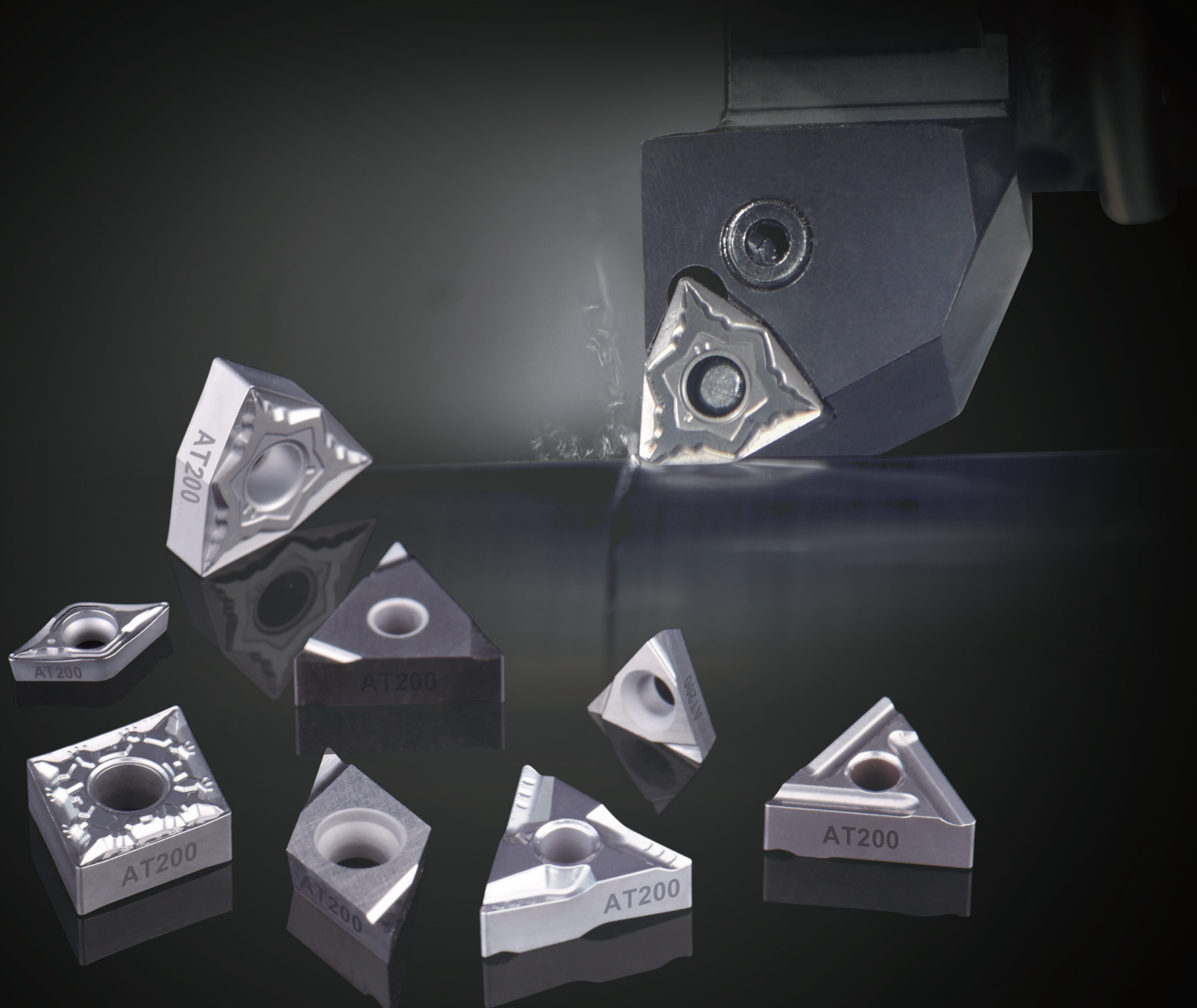


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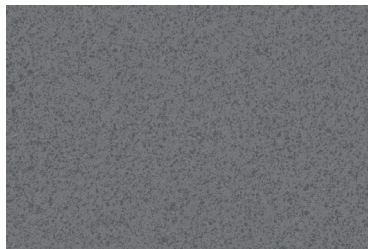
AT200

Металлокерамическая пластина

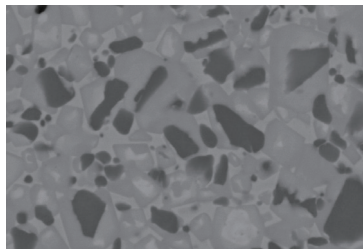


www.achtecktool.com

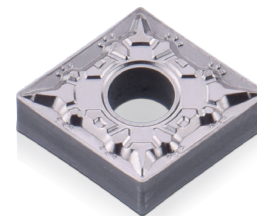
AT200



Равномерная двойная кристаллическая структура, реализующая чистовую и получистовую обработку, обеспечивающая учет износа, тепловых вибраций и стойкость к сколам.



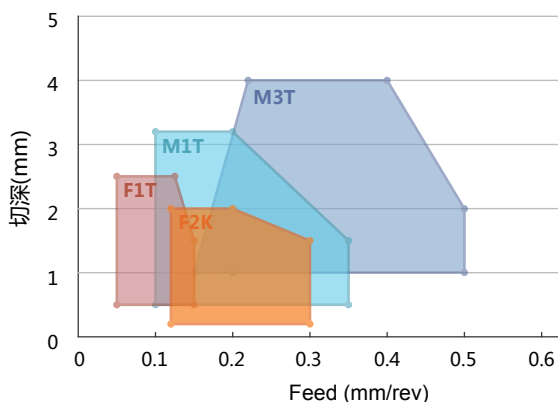
Посредством смешивания кобальт-никелевого связующего и специальных соединений с высокой температурой плавления образуются разнообразные специальные структуры типа «ядро-оболочка», которые могут сдерживать размягчение связующего в процессе резки и повышать жаропрочность и устойчивость к скалыванию.



Превосходная технология обработки поверхности может эффективно уменьшить площадь контакта между инструментом и обрабатываемым материалом, тем самым уменьшая адгезию материала, подлежащего обработке, что позволяет продлить срок службы инструмента и обеспечить его отличную производительность.

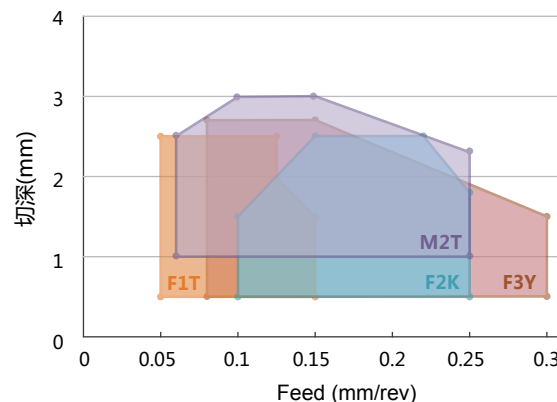
Chip breaker application

M-class негативная пластина



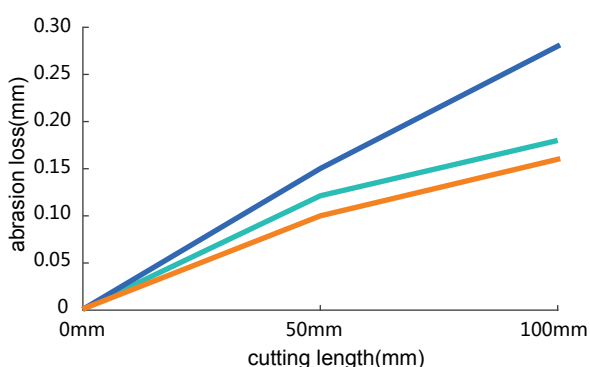
F1T: Низкое усилие резания, подходит для чистовой обработки.
F2K: С хорошей механической обработкой и прочной поверхностью для чистовой и полу-чистовой обработки
M1T: Большой угол наклона и низкое сопротивление, подходит для различных условий глубины резки
M3T: гладкий передний угол, подходит для средней черновой обработки с большой подачей

M-class позитивная пластина



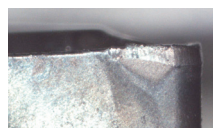
F1T: Низкое усилие резания, хорошее удаление стружки, подходит для чистовой обработки.
F2K: Универсальный стружколом, подходящий для чистовой и полу-чистовой обработки
M2T: Негативный угол подходит для полу-чистовой обработки
F3Y: Широкий спектр применения, подходит для чистовой и полу-чистовой обработки

Высокая износостойкость при высоких скоростях

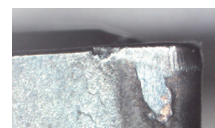


Обрабатываемый материал:
40CrNiMo(HB280-310)
Пластина: CNMG120408-F2K AT200
 $V_c=300\text{m/min}$ $f=0.15\text{mm/rev}$ $ap=1.0\text{mm}$ Dry
01

Achteck
Competitor B
Competitor C



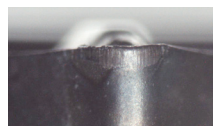
Achteck



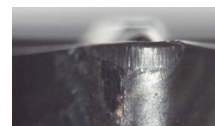
Competitor B



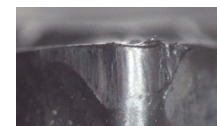
Competitor C



Achteck



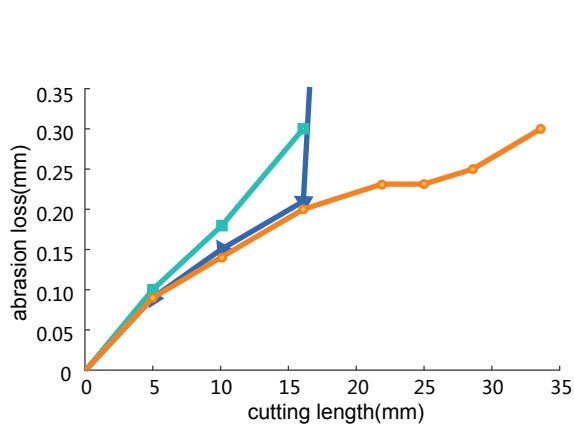
Competitor B



Competitor C

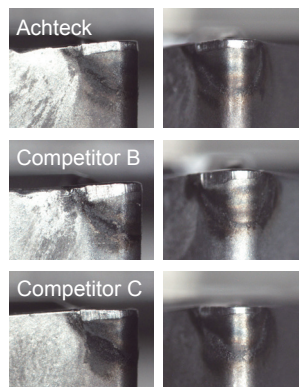
Непрерывная резка может обеспечить превосходную износостойкость и обеспечить контроль точности материала, подлежащего резке.

Срок службы

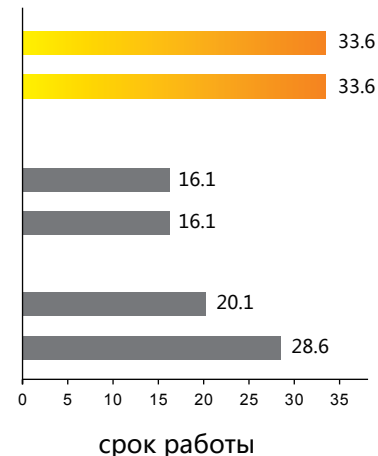


Обрабатываемый материал: 40CrNiMo(HB280-310)
Пластина: CNMG120404-F2K AT200
Vc=200m/min f=0.20mm/rev ap=1.0mm Wet

— Achteck
— Competitor B
— Competitor C

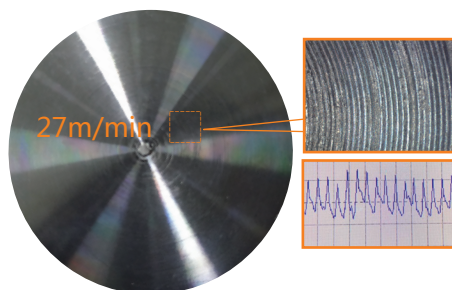
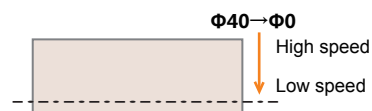


сравнение износа через 16 минут

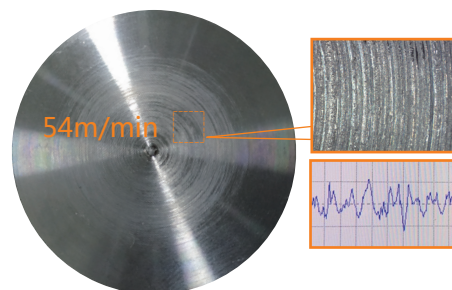


Отличное качество обработки

Обрабатываемый материал: S10C(HB90~95)
Пластины: CNMG120404-F2K AT200
Vc=90~0m/min f=0.10mm/rev ap=1.0mm Wet

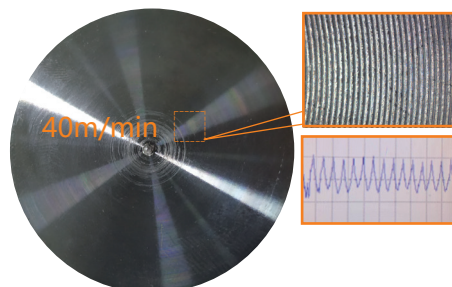


Ra:0.80um Rz:4.05um
AT200

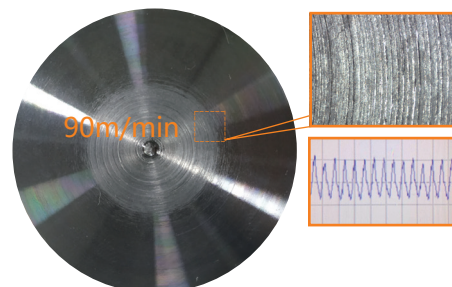


Ra:1.67um Rz:9.63um
Other manufacturers

Обрабатываемый материал: S10C(HB90~95)
Пластина: CNMG120404-F2K AT200
Vc=200~0m/min f=0.10mm/rev ap=1.0mm Wet



Ra:0.85um Rz:4.05um
AT200



Ra:1.21um Rz:5.26um
Other manufacturers

Примеры

Заготовка: крестовая ось

Материал: S45C

Пластина: CNMG120404 FK2

AT200

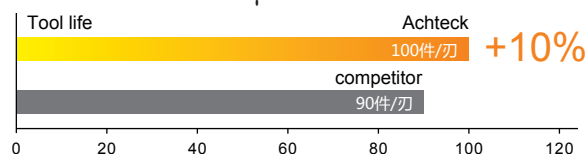
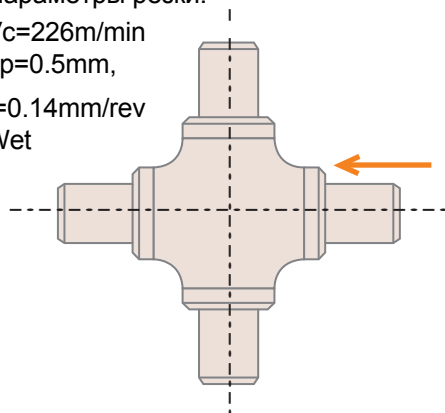
Параметры резки:

$V_c=226\text{m/min}$

$a_p=0.5\text{mm}$,

$f=0.14\text{mm/rev}$

Wet



AT200 имеет на 10% больший срок службы по сравнению с другими продуктами компании и отличается превосходной экономичностью.

Заготовка: трубное соединение

Материал: Q235

Пластина: TNMG160404R-M3T

AT200

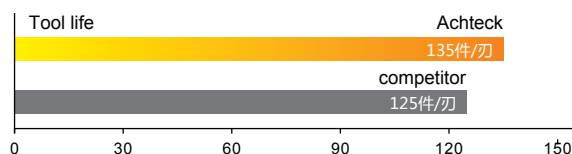
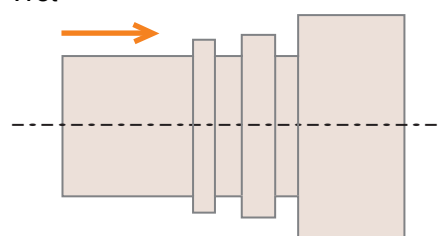
Параметры резки:

$V_c=125\sim135\text{m/min}$

$a_p=1.0\sim0.5\text{mm}$,

$f=0.36\sim0.15\text{mm/rev}$

Wet



Механическая обработка и чистовая обработка одновременно, со стабильной производительностью, отличной шероховатостью поверхности заготовки, без сколов

Заготовка: гидравлический штуцер

Материал: S45C

Пластина: TNGG 160404R-C AT200

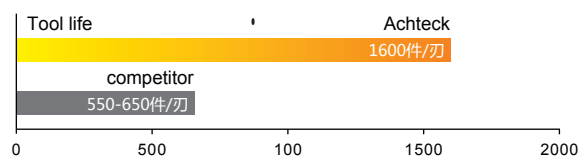
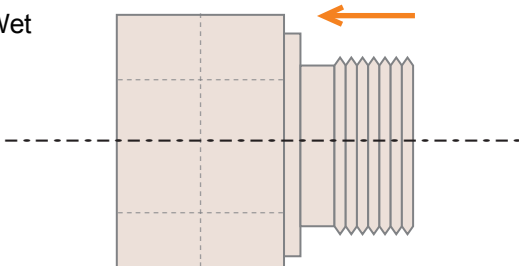
Параметры резки:

$V_c=125\text{m/min}$

$a_p=1.8\text{mm}$,

$f=0.15\sim0.20\text{mm/rev}$

Wet



300% длительный срок службы, стабильная производительность

Заготовка: колонная опора

Материал: S45C

Пластина: TPGT110304FL-F

AT200

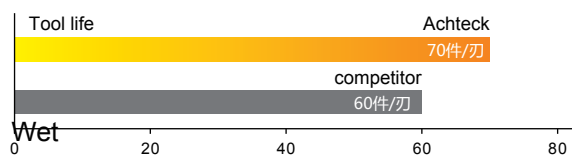
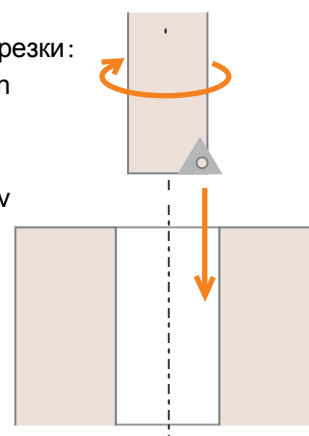
Параметры резки:

$V_c=306\text{m/min}$

$a_p=127\text{mm}$,

$a_e=0.12\text{mm}$,

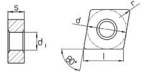
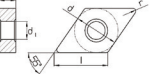
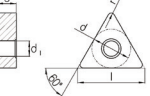
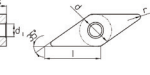
$f=0.06\text{mm/rev}$



Вращательное бурение, износостойкость инструмента превосходит другие компании, обеспечивая при этом необычайно обработанную поверхность.

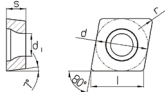
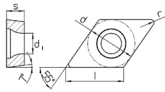
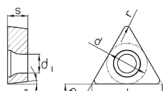
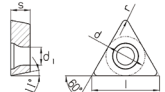
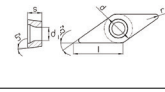
Варианты

Негативная M-class пластина

Insert	Designation	Recommended parameter		Dimension(mm)					Grade	geometry
		Feed	Cutting depth	d	l	s	d1	r	Mental ceramic	
									AT200	
 Finishing ~ semi-finishing	CNMG 120404-F2K	0.12-0.30	0.20-2.0	12.7	12.89	4.76	5.16	0.4	●	
	120408-F2K	0.12-0.30	0.20-2.0	12.7	12.89	4.76	5.16	0.8	●	
 Finishing ~ semi-finishing	DNMG 150404R-M1T	0.10-0.35	0.70-4.5	12.7	15.49	4.76	5.16	0.4	●	
	150404L-M1T	0.10-0.35	0.70-4.5	12.7	15.49	4.76	5.16	0.4	●	
 Finishing ~ semi-finishing	DNMG 150404-F2K	0.10-0.30	0.50-2.0	12.7	15.49	4.76	5.16	0.4	●	
	150408-F2K	0.10-0.30	0.50-2.0	12.7	15.49	4.76	5.16	0.8	●	
 Finishing	TNMG 160404-F1Y	0.08-0.20	0.05-2.0	9.525	16.50	4.76	3.81	0.4	●	
	160408-F1Y	0.08-0.20	0.05-2.0	9.525	16.50	4.76	3.81	0.8	●	
 Finishing ~ semi-finishing	TNMG 160404-F2K	0.08-0.22	0.40-2.0	9.525	16.50	4.76	3.81	0.4	●	
	160408-F2K	0.08-0.22	0.40-2.0	9.525	16.50	4.76	3.81	0.8	●	
 Medium machining	TNMG 160404R-M1T	0.10-0.30	0.70-3.5	9.525	16.50	4.76	3.81	0.4	●	
	160404L-M1T	0.10-0.30	0.70-3.5	9.525	16.50	4.76	3.81	0.4	●	
	160408R-M1T	0.10-0.30	0.70-3.5	9.525	16.50	4.76	3.81	0.8	●	
	160408L-M1T	0.10-0.30	0.70-3.5	9.525	16.50	4.76	3.81	0.8	●	
 Medium machining	TNMG 160404R-M2T	0.20-0.40	1.0-4.0	9.525	16.50	4.76	3.81	0.4	●	
	160404L-M2T	0.20-0.40	1.0-4.0	9.525	16.50	4.76	3.81	0.4	●	
	160408R-M2T	0.20-0.40	1.0-4.0	9.525	16.50	4.76	3.81	0.8	●	
	160408L-M2T	0.20-0.40	1.0-4.0	9.525	16.50	4.76	3.81	0.8	●	
 Medium machining	VNMG 160404-M3T	0.80-3.0	0.15-0.36	9.525	16.61	4.76	3.81	0.4	●	
	160408-M3T	1.0-2.5	0.17-0.36	9.525	16.61	4.76	3.81	0.8	●	
 Finishing	WNMG 080404-F1Y	0.08-0.20	0.05-2.0	12.7	8.69	4.76	5.16	0.4	●	
	080408-F1Y	0.08-0.20	0.05-2.0	12.7	8.69	4.76	5.16	0.8	●	
 Finishing	WNMG 080404-F1T	0.05-0.15	0.50-2.5	12.7	8.69	4.76	5.16	0.4	●	
	080408-F1T	0.05-0.15	0.50-2.5	12.7	8.69	4.76	5.16	0.8	●	
 Finishing ~ semi-finishing	WNMG 080404-F2K	0.08-0.22	0.40-2.0	12.7	8.69	4.76	5.16	0.4	●	
	080408-F2K	0.08-0.22	0.40-2.0	12.7	8.69	4.76	5.16	0.8	●	
 Medium machining	WNMG 080404-M3T	0.12-0.40	1.0-4.0	12.7	8.69	4.76	5.16	0.4	●	
	080408-M3T	0.17-0.55	1.2-4.0	12.7	8.69	4.76	5.16	0.8	●	

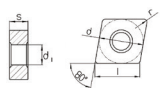
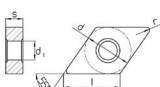
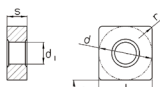
Note : ● For regular stock

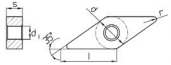
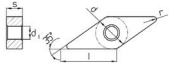
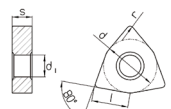
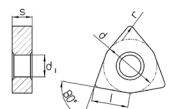
Позитивная M-class пластина

Insert	Designation	Recommended parameter		Dimension(mm)					Grade	geometry
		Feed	Cutting depth	d	l	s	d1	r	Mental ceramic	
									AT200	
(mm/rev)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		
 Finishing	CCMT 060204-F1T	0.05-0.15	0.3-1.5	6.35	6.45	2.38	2.8	0.4	●	
	CCMT 09T304-F1T	0.07-0.20	0.40-2.0	9.525	9.67	3.97	4.4	0.4	●	
	09T308-F1T	0.10-0.25	0.60-2.0	9.525	9.67	3.97	4.4	0.8	●	
 Finishing ~ semi-finishing	CCMT 060202-F2K	0.08-0.20	0.50-1.5	6.35	6.45	2.38	2.8	0.2	●	
	060204-F2K	0.08-0.20	0.50-1.5	6.35	6.45	2.38	2.8	0.4	●	
	CCMT 09T302-F2K	0.10-0.22	0.50-2.0	9.525	9.67	3.97	4.4	0.2	●	
	09T304-F2K	0.10-0.22	0.50-2.0	9.525	9.67	3.97	4.4	0.4	●	
 Medium machining	CCMT 060202-M2T	0.07-0.20	0.50-2.0	6.35	6.45	2.38	2.8	0.2	●	
	CCMT 09T304-M2T	0.70-3.5	0.10-0.25	9.525	9.67	3.97	4.4	0.4	●	
	09T308-M2T	0.13-0.30	1.0-3.5	9.525	9.67	3.97	4.4	0.8	●	
 Finishing	DCMT 070204-F1T	0.07-0.20	0.40-1.5	6.35	7.75	2.38	2.8	0.4	●	
	DCMT 11T304-F1T	0.10-0.25	0.60-1.5	9.525	11.62	3.97	4.4	0.4	●	
	11T308-F1T	0.10-0.25	0.60-1.5	9.525	11.62	3.97	4.4	0.4	●	
 Finishing ~ semi-finishing	DCMT 070204-F2K	0.08-0.20	0.50-1.5	6.35	7.75	2.38	2.8	0.4	●	
	DCMT 11T302-F2K	0.10-0.22	0.50-2.0	9.525	11.62	3.97	4.4	0.2	●	
	11T304-F2K	0.10-0.22	0.50-2.0	9.525	11.62	3.97	4.4	0.4	●	
 Finishing ~ semi-finishing	DCMT 11T304-F1Y	0.08-0.30	0.50-2.5	9.525	11.62	3.97	4.4	0.4	●	
 Finishing	TCMT 110204-F1T	0.10-0.25	0.60-2.0	6.35	11.0	2.38	2.8	0.4	●	
	TCMT 16T304-F1T	0.10-0.25	0.60-2.0	9.525	16.50	3.97	4.4	0.4	●	
 Finishing	TPMT 110304-F1T	0.10-0.25	0.60-2.0	6.35	11.0	3.18	3.3	0.4	●	
 Finishing ~ semi-finishing	TPMT 110304-F2K	0.10-0.25	0.50-2.0	6.35	11.0	3.18	3.3	0.4	●	
 Finishing ~ semi-finishing	VBMT 110304-F2K	0.10-0.20	0.50-1.5	6.35	11.07	3.18	2.8	0.4	●	
	VBMT 160404-F2K	0.05-0.25	0.50-2.0	9.525	16.61	4.76	4.4	0.4	●	

Note: : ● For regular stock

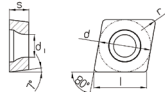
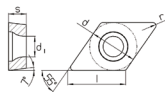
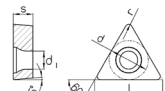
Негативная G-class пластина

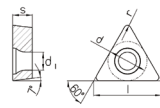
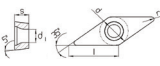
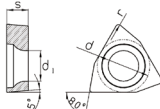
Insert	Designation	Recommended parameter		Dimension(mm)					Grade	geometry
		Feed	Cutting depth	d	l	s	d1	r	Mental ceramic	
									AT200	
(mm/rev)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		
 Sharp type	CNGG 120402FR-F	0.05-0.20	0.50-2.0	12.7	12.89	4.76	5.16	0.2	●	
	120402FL-F	0.05-0.20	0.50-2.0	12.7	12.89	4.76	5.16	0.2	●	
	120404FR-F	0.05-0.20	0.50-2.0	12.7	12.89	4.76	5.16	0.4	●	
	120404FL-F	0.05-0.20	0.50-2.0	12.7	12.89	4.76	5.16	0.4	●	
 Finishing ~ semi-finishing	CNGG 120402R-C	0.20-0.40	1.0-3.0	12.7	12.89	4.76	5.16	0.2	●	
	120402L-C	0.20-0.40	1.0-3.0	12.7	12.89	4.76	5.16	0.2	●	
	120404R-C	0.20-0.40	1.0-3.0	12.7	12.89	4.76	5.16	0.4	●	
	120404L-C	0.20-0.40	1.0-3.0	12.7	12.89	4.76	5.16	0.4	●	
	120408R-C	0.20-0.40	1.0-3.0	12.7	12.89	4.76	5.16	0.8	●	
	120408L-C	0.20-0.40	1.0-3.0	12.7	12.89	4.76	5.16	0.8	●	
 Sharp type	DNGG 110402FR-F	0.05-0.15	0.80-2.0	9.525	11.62	4.76	3.81	0.2	●	
	110402FL-F	0.05-0.15	0.80-2.0	9.525	11.62	4.76	3.81	0.2	●	
	110404FR-F	0.05-0.15	0.80-2.0	9.525	11.62	4.76	3.81	0.4	●	
	110404FL-F	0.05-0.15	0.80-2.0	9.525	11.62	4.76	3.81	0.4	●	
	110408FR-F	0.05-0.15	0.80-2.0	9.525	11.62	4.76	3.81	0.8	●	
	110408FL-F	0.05-0.15	0.80-2.0	9.525	11.62	4.76	3.81	0.8	●	
 Finishing ~ semi-finishing	DNGG 110402R-C	0.15-0.30	0.50-2.5	9.525	11.62	4.76	3.81	0.2	⊙	
	110402L-C	0.15-0.30	0.50-2.5	9.525	11.62	4.76	3.81	0.2	⊙	
	110404R-C	0.15-0.30	0.50-2.5	9.525	11.62	4.76	3.81	0.4	⊙	
	110404L-C	0.15-0.30	0.50-2.5	9.525	11.62	4.76	3.81	0.4	⊙	
	110408R-C	0.15-0.30	0.50-2.5	9.525	11.62	4.76	3.81	0.8	⊙	
	110408L-C	0.15-0.30	0.50-2.5	9.525	11.62	4.76	3.81	0.8	⊙	
 Finishing ~ semi-finishing	SNGG 120402R-C	0.20-0.40	1.0-3.0	12.7	12.70	4.76	5.16	0.2	⊙	
	120402L-C	0.20-0.40	1.0-3.0	12.7	12.70	4.76	5.16	0.2	⊙	
	120404R-C	0.20-0.40	1.0-3.0	12.7	12.70	4.76	5.16	0.4	⊙	
	120404L-C	0.20-0.40	1.0-3.0	12.7	12.70	4.76	5.16	0.4	⊙	
	120408R-C	0.20-0.40	1.0-3.0	12.7	12.70	4.76	5.16	0.8	⊙	
	120408L-C	0.20-0.40	1.0-3.0	12.7	12.70	4.76	5.16	0.8	⊙	
 Sharp type	TNGG 160402FR-F	0.05-0.20	0.50-2.0	9.525	16.50	4.76	3.81	0.2	●	
	160402FL-F	0.05-0.20	0.50-2.0	9.525	16.50	4.76	3.81	0.2	●	
	160404FR-F	0.05-0.20	0.50-2.0	9.525	16.50	4.76	3.81	0.4	●	
	160404FL-F	0.05-0.20	0.50-2.0	9.525	16.50	4.76	3.81	0.4	●	
 Finishing ~ semi-finishing	TNGG 160402R-C	0.20-0.40	1.0-3.0	9.525	16.50	4.76	3.81	0.2	●	
	160402L-C	0.20-0.40	1.0-3.0	9.525	16.50	4.76	3.81	0.2	●	
	160404R-C	0.20-0.40	1.0-3.0	9.525	16.50	4.76	3.81	0.4	●	
	160404L-C	0.20-0.40	1.0-3.0	9.525	16.50	4.76	3.81	0.4	●	
	160408R-C	0.20-0.40	1.0-3.0	9.525	16.50	4.76	3.81	0.8	●	
	160408L-C	0.20-0.40	1.0-3.0	9.525	16.50	4.76	3.81	0.8	●	

Insert	Designation	Recommended parameter		Dimension(mm)					Grade	geometry
		Feed	Cutting depth	d	l	s	d1	r	Mental ceramic	
									AT200	
(mm/rev)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		
 Sharp type	VNGG 160402FR-F	0.05-0.15	0.50-1.8	9.525	16.61	4.76	3.81	0.2	●	
	160402FL-F	0.05-0.15	0.50-1.8	9.525	16.61	4.76	3.81	0.2	●	
	160404FR-F	0.05-0.15	0.50-1.8	9.525	16.61	4.76	3.81	0.4	●	
	160404FL-F	0.05-0.15	0.50-1.8	9.525	16.61	4.76	3.81	0.4	●	
 Finishing - semi-finishing	VNGG 160402R-C	0.15-0.30	0.50-2.5	9.525	16.61	4.76	3.81	0.2	●	
	160402L-C	0.15-0.30	0.50-2.5	9.525	16.61	4.76	3.81	0.2	●	
	160404R-C	0.15-0.30	0.50-2.5	9.525	16.61	4.76	3.81	0.4	●	
	160404L-C	0.15-0.30	0.50-2.5	9.525	16.61	4.76	3.81	0.4	●	
	160408R-C	0.15-0.30	0.50-2.5	9.525	16.61	4.76	3.81	0.8	●	
	160408L-C	0.15-0.30	0.50-2.5	9.525	16.61	4.76	3.81	0.8	●	
 Sharp type	WNGG 060402FR-F	0.05-0.20	0.50-2.0	9.525	6.52	4.76	3.81	0.2	●	
	060402FL-F	0.05-0.20	0.50-2.0	9.525	6.52	4.76	3.81	0.2	●	
	060404FR-F	0.05-0.20	0.50-2.0	9.525	6.52	4.76	3.81	0.4	●	
	060404FL-F	0.05-0.20	0.50-2.0	9.525	6.52	4.76	3.81	0.4	●	
	060408FR-F	0.05-0.20	0.50-2.0	9.525	6.52	4.76	3.81	0.8	●	
	060408FL-F	0.05-0.20	0.50-2.0	9.525	6.52	4.76	3.81	0.8	●	
	WNGG 080402FR-F	0.05-0.20	0.50-2.0	12.7	8.69	4.76	5.16	0.2	●	
	080402FL-F	0.05-0.20	0.50-2.0	12.7	8.69	4.76	5.16	0.2	●	
	080404FR-F	0.05-0.20	0.50-2.0	12.7	8.69	4.76	5.16	0.4	●	
	080404FL-F	0.05-0.20	0.50-2.0	12.7	8.69	4.76	5.16	0.4	●	
	080408FR-F	0.05-0.20	0.50-2.0	12.7	8.69	4.76	5.16	0.8	●	
	080408FL-F	0.05-0.20	0.50-2.0	12.7	8.69	4.76	5.16	0.8	●	
 Finishing - semi-finishing	WNGG 060402R-C	0.20-0.40	1.0-3.0	9.525	6.52	4.76	3.81	0.2	●	
	060402L-C	0.20-0.40	1.0-3.0	9.525	6.52	4.76	3.81	0.2	●	
	060404R-C	0.20-0.40	1.0-3.0	9.525	6.52	4.76	3.81	0.4	●	
	060404L-C	0.20-0.40	1.0-3.0	9.525	6.52	4.76	3.81	0.4	●	
	060408R-C	0.20-0.40	1.0-3.0	9.525	6.52	4.76	3.81	0.8	●	
	060408L-C	0.20-0.40	1.0-3.0	9.525	6.52	4.76	3.81	0.8	●	
	WNGG 080402R-C	0.20-0.40	1.0-3.0	12.7	8.69	4.76	5.16	0.2	●	
	080402L-C	0.20-0.40	1.0-3.0	12.7	8.69	4.76	5.16	0.2	●	
	080404R-C	0.20-0.40	1.0-3.0	12.7	8.69	4.76	5.16	0.4	●	
	080404L-C	0.20-0.40	1.0-3.0	12.7	8.69	4.76	5.16	0.4	●	
	080408R-C	0.20-0.40	1.0-3.0	12.7	8.69	4.76	5.16	0.8	●	
	080408L-C	0.20-0.40	1.0-3.0	12.7	8.69	4.76	5.16	0.8	●	

Note : ● For regular stock

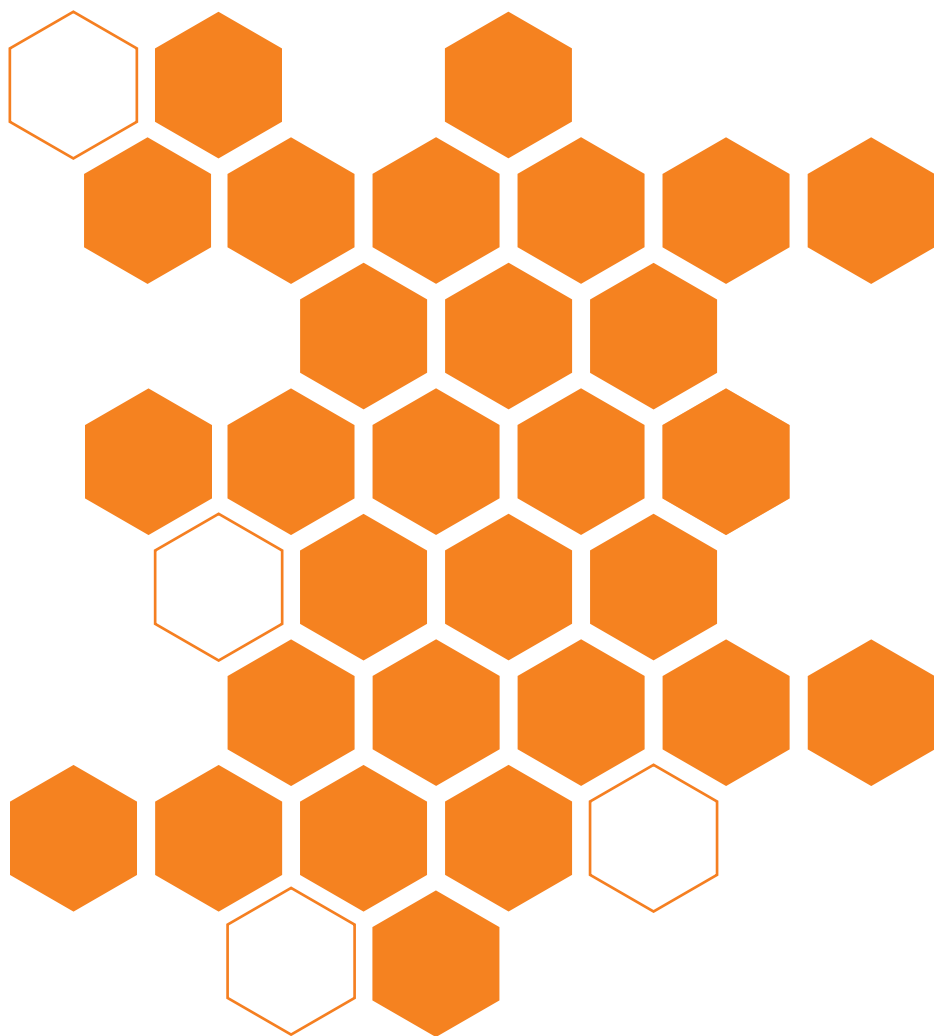
Позитивная G-class пластина(острый тип)

Insert	Designation	Recommended parameter		Dimension(mm)					Grade	geometry
		Feed	Cutting depth	d	l	s	d1	r	Mental ceramic	
									AT200	
(mm/rev)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		
 Sharp type	CCGT 060202FR-F	0.02-0.10	0.02-0.40	6.35	6.45	2.38	2.8	0.2	●	
	060202FL-F	0.02-0.10	0.02-0.40	6.35	6.45	2.38	2.8	0.2	●	
	060204FR-F	0.02-0.10	0.02-0.40	6.35	6.45	2.38	2.8	0.4	●	
	060204FL-F	0.02-0.10	0.02-0.40	6.35	6.45	2.38	2.8	0.4	●	
	CCGT 09T302FR-F	0.02-0.10	0.02-0.50	9.525	9.67	3.97	4.4	0.2	●	
	09T302FL-F	0.02-0.10	0.02-0.50	9.525	9.67	3.97	4.4	0.2	●	
	09T304FR-F	0.02-0.10	0.02-0.50	9.525	9.67	3.97	4.4	0.4	●	
	09T304FL-F	0.02-0.10	0.02-0.50	9.525	9.67	3.97	4.4	0.4	●	
 Sharp type	DCGT 070202FR-F	0.03-0.18	0.05-0.40	6.35	7.75	2.38	2.8	0.2	●	
	070202FL-F	0.03-0.18	0.05-0.40	6.35	7.75	2.38	2.8	0.2	●	
	070204FR-F	0.03-0.18	0.05-0.40	6.35	7.75	2.38	2.8	0.4	●	
	070204FL-F	0.03-0.18	0.05-0.40	6.35	7.75	2.38	2.8	0.4	●	
	DCGT 11T302FR-F	0.02-0.18	0.02-0.40	9.525	11.62	3.97	4.4	0.2	●	
	11T302FL-F	0.02-0.18	0.02-0.40	9.525	11.62	3.97	4.4	0.2	●	
	11T304FR-F	0.02-0.18	0.02-0.40	9.525	11.62	3.97	4.4	0.4	●	
	11T304FL-F	0.02-0.18	0.02-0.40	9.525	11.62	3.97	4.4	0.4	●	
 Sharp type	DCGT 11T302FR-M	0.02-0.10	0.10-4.0	9.525	11.62	3.97	4.4	0.2	●	
	11T302FL-M	0.02-0.10	0.10-4.0	9.525	11.62	3.97	4.4	0.2	●	
	11T304FR-M	0.02-0.10	0.10-4.0	9.525	11.62	3.97	4.4	0.4	●	
	11T304FL-M	0.02-0.10	0.10-4.0	9.525	11.62	3.97	4.4	0.4	●	
 Sharp type	TBGT 060102FR-F	0.03-0.07	0.10-0.50	3.97	6.90	1.59	2.3	0.2	●	
	060102FL-F	0.03-0.07	0.10-0.50	3.97	6.90	1.59	2.3	0.2	●	
	060104FR-F	0.03-0.07	0.10-0.50	3.97	6.90	1.59	2.3	0.4	●	
	060104FL-F	0.03-0.07	0.10-0.50	3.97	6.90	1.59	2.3	0.4	●	
	TPGT 080202FR-F	0.02-0.10	0.20-0.80	4.76	8.20	2.38	2.3	0.2	●	
	080202FL-F	0.02-0.10	0.20-0.80	4.76	8.20	2.38	2.3	0.2	●	
	080204FR-F	0.02-0.10	0.20-0.80	4.76	8.20	2.38	2.3	0.4	●	
	080204FL-F	0.02-0.10	0.20-0.80	4.76	8.20	2.38	2.3	0.4	●	
	TPGT 090202FR-F	0.20-0.80	0.02-0.10	5.56	9.60	2.38	2.5	0.2	●	
	090202FL-F	0.20-0.80	0.02-0.10	5.56	9.60	2.38	2.5	0.2	●	
	090204FR-F	0.20-0.80	0.02-0.10	5.56	9.60	2.38	2.5	0.4	●	
	090204FL-F	0.20-0.80	0.02-0.10	5.56	9.60	2.38	2.5	0.4	●	
	TPGT 110302FR-F	0.02-0.12	0.20-0.80	6.35	11.0	3.18	3.3	0.2	●	
	110302FL-F	0.02-0.12	0.20-0.80	6.35	11.0	3.18	3.3	0.2	●	
	110304FR-F	0.02-0.12	0.20-0.80	6.35	11.0	3.18	3.3	0.4	●	
	110304FL-F	0.02-0.12	0.20-0.80	6.35	11.0	3.18	3.3	0.4	●	

Insert	Designation	Recommended parameter		Dimension(mm)					Grade	geometry
		Feed	Cutting depth	d	l	s	d1	r	Mental ceramic	
									AT200	
(mm/rev)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		
 Sharp type	TCGT 110202FR-F	0.02-0.12	0.20-0.80	6.35	11.0	2.38	3.3	0.2	●	
	110202FL-F	0.02-0.12	0.20-0.80	6.35	11.0	2.38	3.3	0.2	●	
	110204FR-F	0.02-0.12	0.20-0.80	6.35	11.0	2.38	3.3	0.4	●	
	110204FL-F	0.02-0.12	0.20-0.80	6.35	11.0	2.38	3.3	0.4	●	
 Sharp type	VBGT 110301FR-F	0.02-0.18	0.02-0.40	6.35	11.07	3.18	2.8	0.1	●	
	110301FL-F	0.02-0.18	0.02-0.40	6.35	11.07	3.18	2.8	0.1	●	
	110302FR-F	0.02-0.18	0.02-0.40	6.35	11.07	3.18	2.8	0.2	●	
	110302FL-F	0.02-0.18	0.02-0.40	6.35	11.07	3.18	2.8	0.2	●	
	110304FR-F	0.02-0.18	0.02-0.40	6.35	11.07	3.18	2.8	0.4	●	
	110304FL-F	0.02-0.18	0.02-0.40	6.35	11.07	3.18	2.8	0.4	●	
	VBGT 160402FR-F	0.02-0.18	0.05-0.30	9.525	16.61	4.76	4.4	0.2	●	
	160402FL-F	0.02-0.18	0.05-0.30	9.525	16.61	4.76	4.4	0.2	●	
 Sharp type	VBGT 110302FR-Y	0.08-0.22	0.50-1.80	6.35	11.07	3.18	2.8	0.2	●	
	110302FL-Y	0.08-0.22	0.50-1.80	6.35	11.07	3.18	2.8	0.2	●	
	110304FR-Y	0.08-0.22	0.50-1.80	6.35	11.07	3.18	2.8	0.4	●	
	110304FL-Y	0.08-0.22	0.50-1.80	6.35	11.07	3.18	2.8	0.4	●	
 Sharp type	WBGT 060102FR-F	0.02-0.10	0.20-0.80	3.97	6.50	1.59	2.3	0.2	●	
	060102FL-F	0.02-0.10	0.20-0.80	3.97	6.50	1.59	2.3	0.2	●	
	060104FR-F	0.02-0.10	0.20-0.80	3.97	6.50	1.59	2.3	0.4	●	
	060104FL-F	0.02-0.10	0.20-0.80	3.97	6.50	1.59	2.3	0.4	●	

Note : ● For regular stock

ACHTECK



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