

H-Series Chip-Breaker for high efficiency in finishing

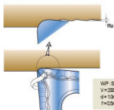
# Wiper Insert HW

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Fono: 055 787169



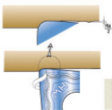
1. Upgraded toughness in a general feed rate.
2. High productivity and excellent toughness in high speed of cut and high feed rate.
3. Specially developed Recess cutting edge and Wiper cutting edge reduce cutting resistance.

General Insert



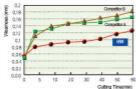
WP 9CM40  
V = 200m/min  
d = 10mm  
f = 0.5mm/rev

Wiper Insert HW



WP 9CM40  
V = 200m/min  
d = 10mm  
f = 0.5mm/rev

## HW Wear-resistance



KORLOY(HW)



Competitor A



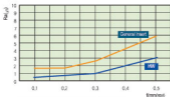
Competitor B

### Wear-resistance

1. Work-piece : SCM440(DIN 42CrMo 4)
2. Condition : V=200m/min, F=0.5mm/rev, d=0.5mm
3. Description : CMMG120408-HW(K15 Grade)

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## HW Surface-finishing



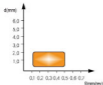
Description : CMMG120408-HW Grade : NC320  
V=200m/min d=1.0mm

## Feature of Cutting Edge



- R1(Rough Cutting edge) — Reduce Cutting resistance
- R2(Wiper Cutting edge) — Upgrade Surface finish

## HW Application & Recommendation



Description	Cutting Speed			feed f (mm/rev)	D.O.C d (mm)
	P10	P20	K15		
	NC310	NC320	NC315K		
CMMG00404-HW	200-350	180-300	150-270	0.1-0.5	0.3-1.5
CMMG00408-HW	200-350	180-300	150-270	0.1-0.5	0.5-2.0
CMMG00412-HW	200-350	180-300	150-270	0.1-0.5	0.8-2.0