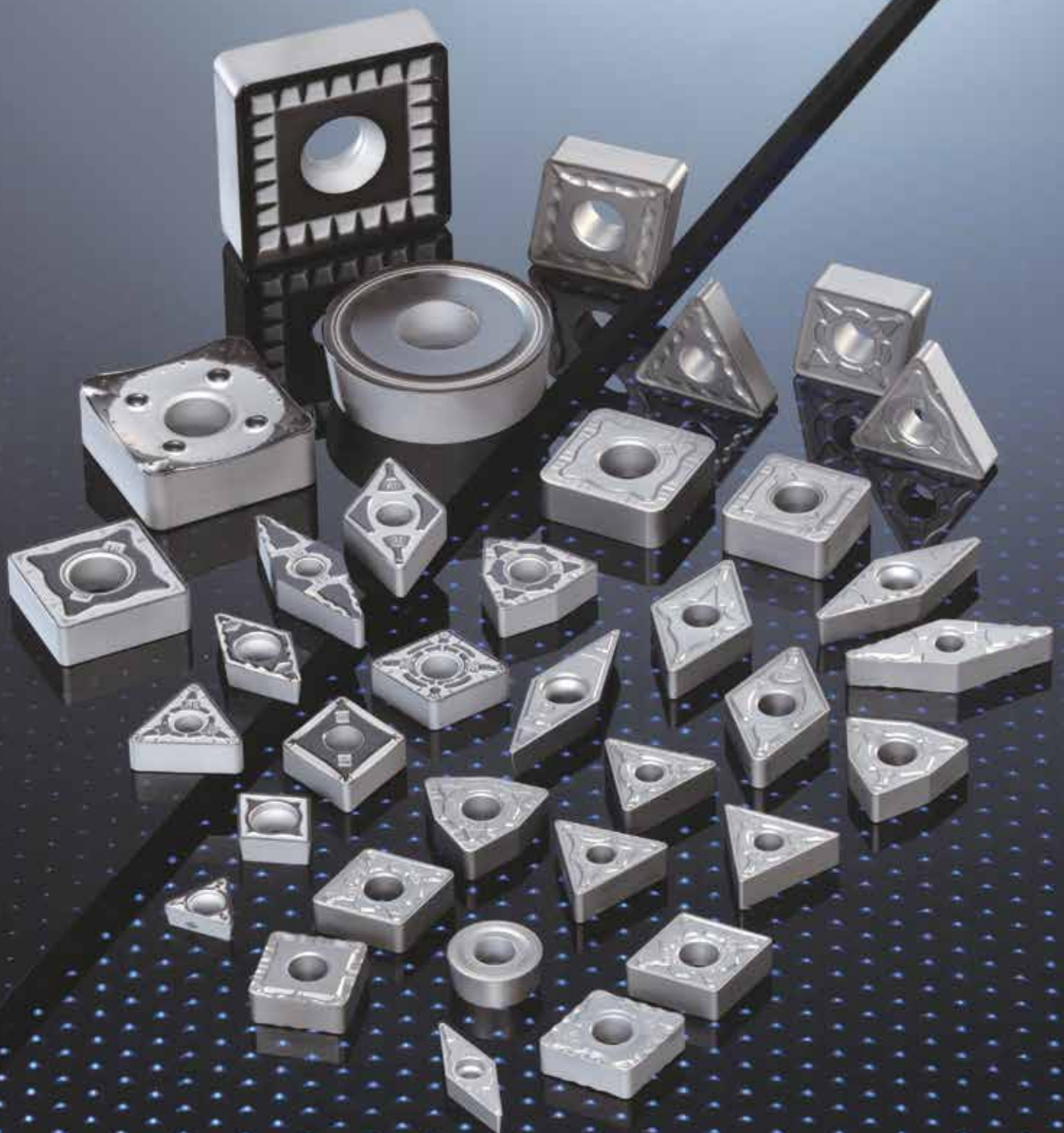


Coated Grades for Steel Turning

# AC8015P/AC8025P/AC8035P

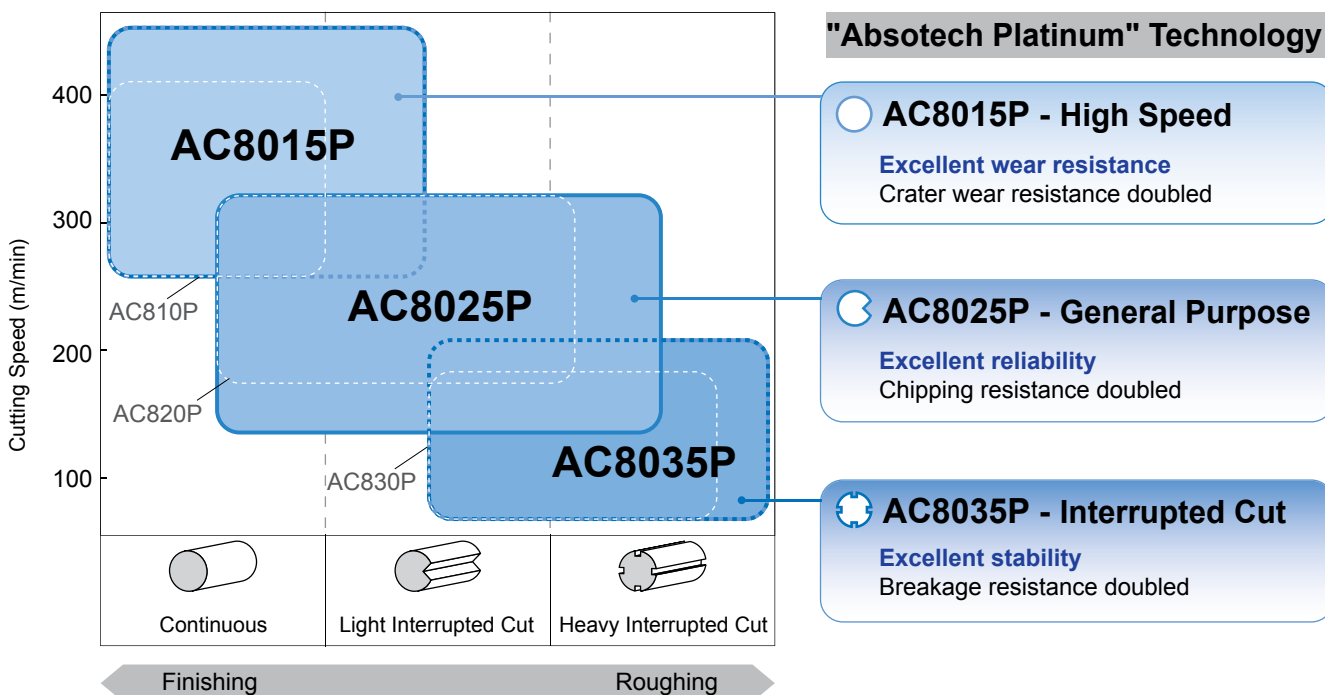
New Grades for Steel Turning, Creating "Absolutely Stable Cutting"



# For Steel Turning

## AC8000P Series

### Application Range and Features



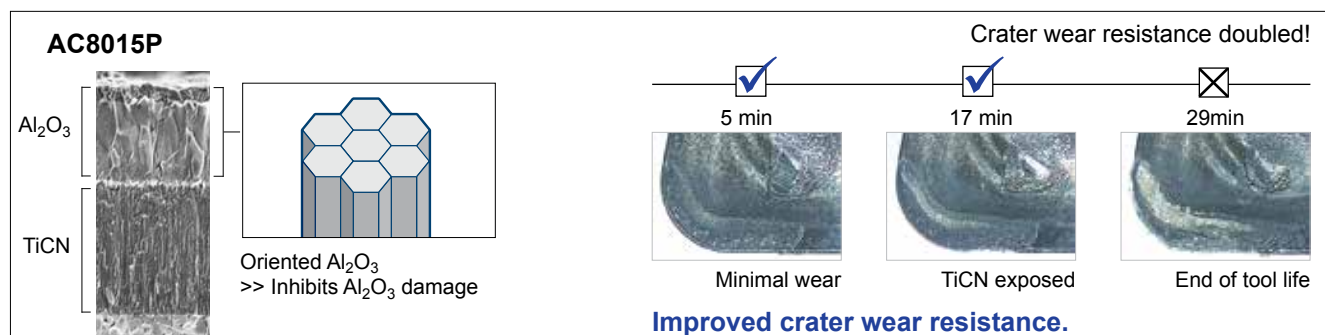
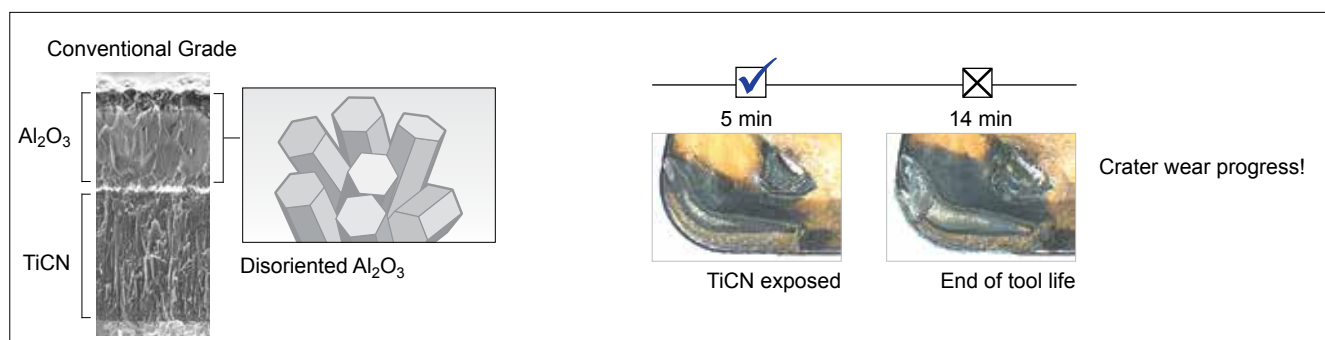
### Cutting Performance

#### AC8015P For High Speed

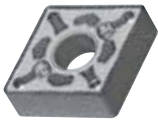


Reduced crater damage due to chip abrasion through optimized crystal orientation in the alumina layer.

Work Material: 100Cr6, 1.3505  
External continuous  
Insert: CNMG120408 NGU  
Cutting Conditions:  $v_c = 300\text{m/min}$ ,  $f = 0,3\text{mm}$ ,  $a_p = 1,5\text{mm}$ , wet

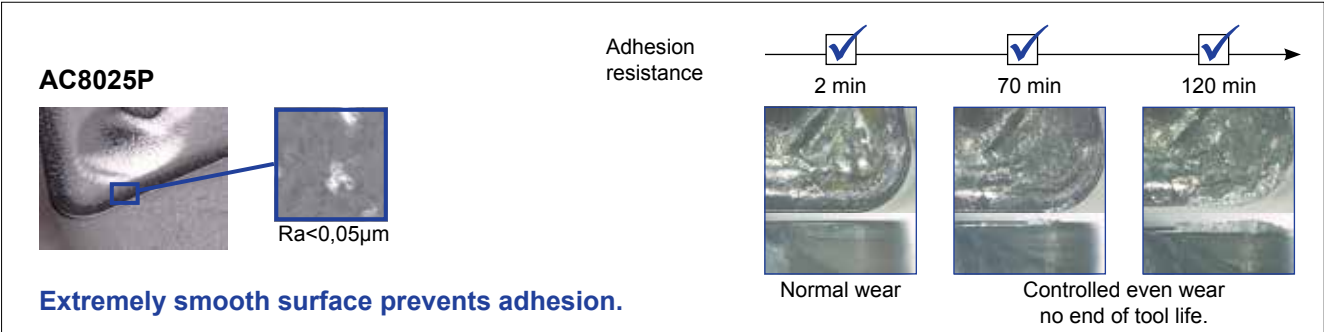
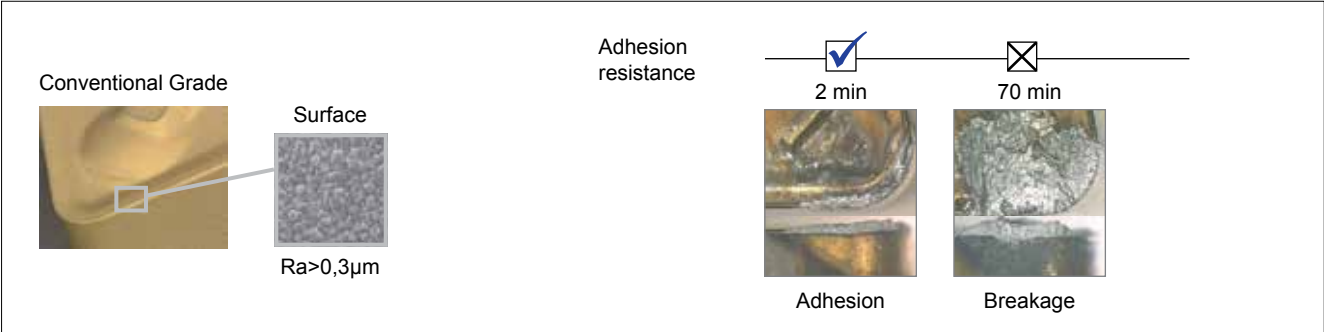


**AC8025P For General Purpose (1st Recommendation)**



Improved tool surface smoothness and significantly reduced adhesion through special surface treatment.

Work Material: 25CrMo4, 1.7218  
Facing  
Insert: CNMG120408 NGU  
Cutting Conditions:  $v_c = 100-300\text{m/min}$ ,  $f = 0,3\text{mm}$ ,  $a_p = 1,5\text{mm}$ , wet

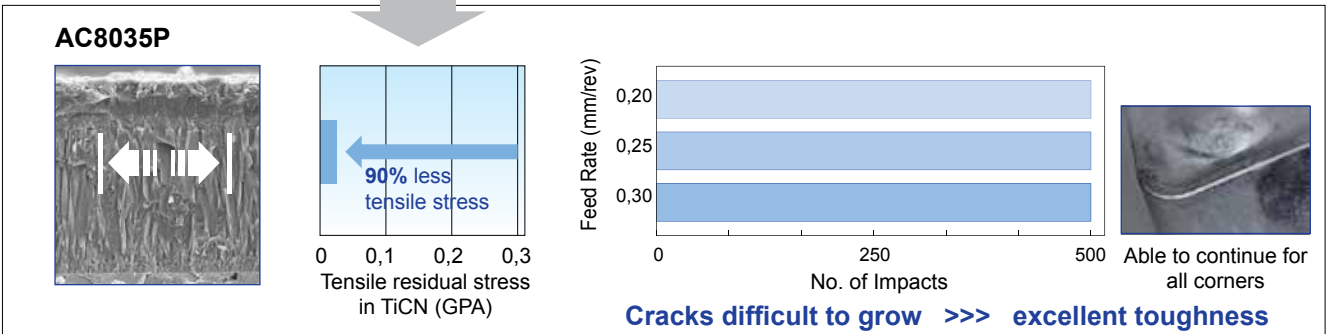
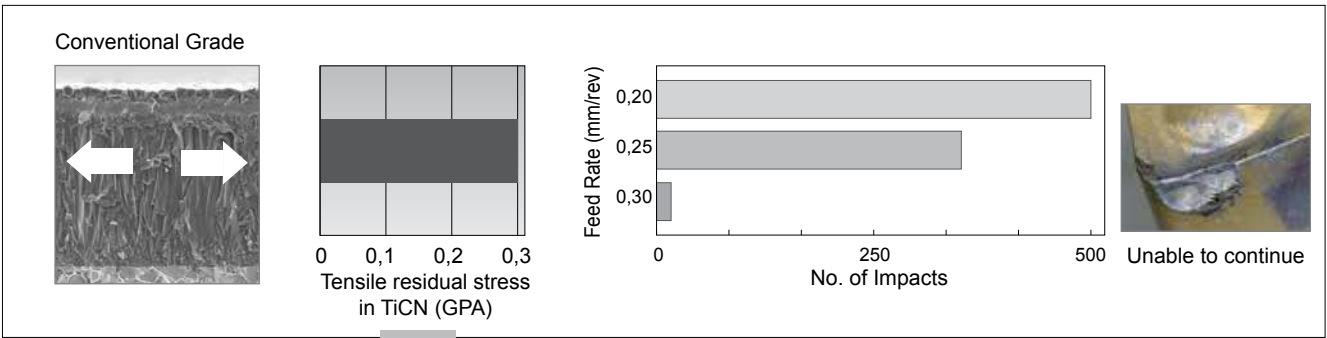


**AC8035P For Interrupted Cutting**



Drastically reduced tensile residual stress in coating through special surface treatment.

Work Material: 34CrMoS34, 1.7226  
Interrupted cut  
Insert: CNMG120408 NGU  
Cutting Conditions:  $v_c = 160\text{m/min}$ ,  $f = 0,2-0,3\text{mm}$ ,  $a_p = 2\text{mm}$ , dry



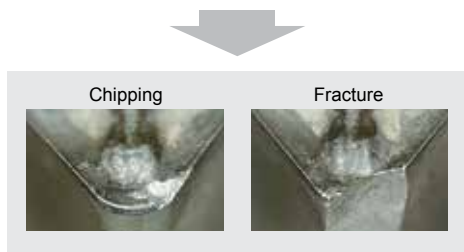
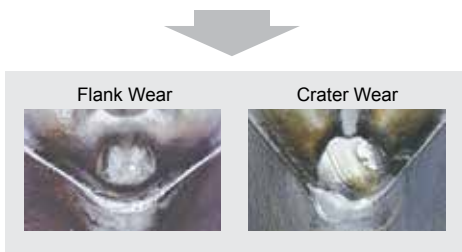
# For Steel Turning AC8000P Series

## Grades and Chipbreaker Selection Guide

1st Recommendation  
General Purpose **AC8025P**

1st Recommendation  
**NGU**

	Elevated Feed Rate Area	General Purpose	Tougher Cutting Edge
Finish ~ Small Depth	<b>NFE</b> <b>NSE</b>	<b>NSU</b>	<b>NSX</b>
General Purpose	<b>NGE</b>	<b>NGU</b>	<b>NUX</b>
Rough ~ Larger Cutting Depth	<b>NME</b>	<b>NMU</b>	<b>NMX</b>



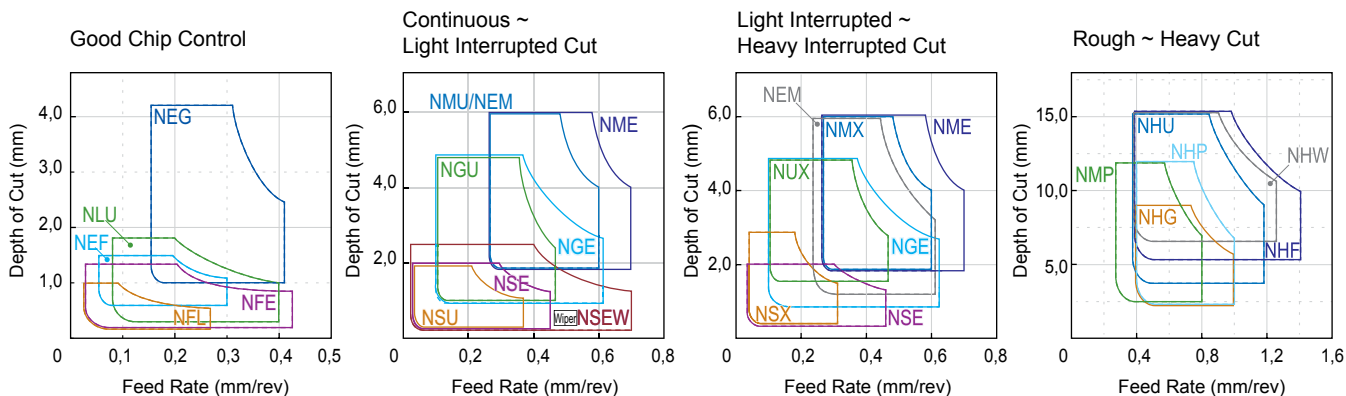
Better Wear Resistance  
High Speed **AC8015P**

Better Toughness  
Interrupted Cut **AC8035P**

1st Recommendation	<b>NGU</b>
Higher efficiency required	<b>NGE</b>

1st Recommendation	<b>NGU</b>
Higher stability required	<b>NUX</b>

## Chipbreaker Application Range



■ Recommended Cutting Conditions

**AC8015P**

Min - Optimum - Max

Insert Specification		Chipbreaker	Soft Steel, Low Carbon Steel, Low Alloy Steel < 180HB			High Carbon Steel, High Alloy Steel > 180HB		
			Depth of Cut $a_p$ (mm)	Feed Rate $f$ (mm/rev)	Cutting Speed $v_c$ (m/min)	Depth of Cut $a_p$ (mm)	Feed Rate $f$ (mm/rev)	Cutting Speed $v_c$ (m/min)
CNM_12 DNM_15 SNM_12	TNM_16 TNM_22 WNM_08	NFE	0,1 - <b>0,4</b> - 1,2	0,10 - <b>0,20</b> - 0,40	290 - <b>410</b> - 500	0,1 - <b>0,4</b> - 1,2	0,10 - <b>0,20</b> - 0,40	240 - <b>360</b> - 450
		NLU - NSU - NSE	0,5 - <b>1,5</b> - 2,0	0,10 - <b>0,20</b> - 0,40	170 - <b>310</b> - 470	0,5 - <b>1,5</b> - 2,0	0,10 - <b>0,20</b> - 0,40	130 - <b>260</b> - 420
		NSEW	0,5 - <b>1,5</b> - 2,5	0,10 - <b>0,40</b> - 0,60	170 - <b>310</b> - 470	0,5 - <b>1,5</b> - 2,5	0,10 - <b>0,40</b> - 0,60	130 - <b>260</b> - 420
		NGU - NGE - NUX	0,8 - <b>2,2</b> - 5,0	0,10 - <b>0,30</b> - 0,45	170 - <b>310</b> - 470	0,8 - <b>2,2</b> - 5,0	0,10 - <b>0,30</b> - 0,45	130 - <b>260</b> - 420
		NMU	1,8 - <b>3,0</b> - 6,0	0,20 - <b>0,35</b> - 0,60	140 - <b>280</b> - 400	1,8 - <b>3,0</b> - 6,0	0,20 - <b>0,35</b> - 0,60	110 - <b>240</b> - 350
		NME	1,0 - <b>3,0</b> - 6,0	0,20 - <b>0,45</b> - 0,70	140 - <b>280</b> - 400	1,0 - <b>3,0</b> - 6,0	0,20 - <b>0,45</b> - 0,70	110 - <b>240</b> - 350
CNM_16	SNM_15	NHG	3,0 - <b>4,5</b> - 8,0	0,35 - <b>0,50</b> - 0,80	140 - <b>280</b> - 400	3,0 - <b>4,5</b> - 8,0	0,35 - <b>0,50</b> - 0,80	110 - <b>240</b> - 350
		NGU - NGE - NUX	0,8 - <b>3,5</b> - 5,0	0,15 - <b>0,30</b> - 0,45	140 - <b>280</b> - 400	0,8 - <b>3,5</b> - 5,0	0,15 - <b>0,30</b> - 0,45	110 - <b>240</b> - 350
		NMU	1,8 - <b>4,5</b> - 6,0	0,20 - <b>0,40</b> - 0,60	140 - <b>240</b> - 330	1,8 - <b>4,5</b> - 6,0	0,20 - <b>0,40</b> - 0,60	110 - <b>200</b> - 280
		NME	1,5 - <b>4,5</b> - 7,0	0,20 - <b>0,50</b> - 0,70	140 - <b>240</b> - 330	1,5 - <b>4,5</b> - 7,0	0,20 - <b>0,50</b> - 0,70	110 - <b>200</b> - 280
CNM_19 CNM_25 DNM_19	SNM_19 SNM_25 TNM_27	NHG	3,0 - <b>5,0</b> - 8,0	0,35 - <b>0,60</b> - 0,80	120 - <b>210</b> - 300	3,0 - <b>5,0</b> - 8,0	0,35 - <b>0,60</b> - 0,80	90 - <b>170</b> - 250
		NMU	1,8 - <b>5,0</b> - 6,0	0,20 - <b>0,40</b> - 0,60	140 - <b>240</b> - 330	1,8 - <b>5,0</b> - 6,0	0,20 - <b>0,40</b> - 0,60	110 - <b>200</b> - 280
		NME	2,0 - <b>5,0</b> - 8,0	0,20 - <b>0,50</b> - 0,70	140 - <b>240</b> - 330	2,0 - <b>5,0</b> - 8,0	0,20 - <b>0,50</b> - 0,70	110 - <b>200</b> - 280
		NHG	3,0 - <b>6,5</b> - 9,0	0,35 - <b>0,60</b> - 0,80	120 - <b>210</b> - 300	3,0 - <b>6,5</b> - 9,0	0,35 - <b>0,60</b> - 0,80	90 - <b>170</b> - 250

**AC8025P**

Min - Optimum - Max

Insert Specification		Chipbreaker	Soft Steel, Low Carbon Steel, Low Alloy Steel < 180HB			High Carbon Steel, High Alloy Steel > 180HB		
			Depth of Cut $a_p$ (mm)	Feed Rate $f$ (mm/rev)	Cutting Speed $v_c$ (m/min)	Depth of Cut $a_p$ (mm)	Feed Rate $f$ (mm/rev)	Cutting Speed $v_c$ (m/min)
CNM_12 DNM_15 SNM_12	TNM_16 TNM_22 WNM_08	NFE	0,1 - <b>0,4</b> - 1,2	0,10 - <b>0,25</b> - 0,45	150 - <b>250</b> - 350	0,1 - <b>0,4</b> - 1,2	0,10 - <b>0,25</b> - 0,40	120 - <b>210</b> - 300
		NLU - NSU - NSE	0,5 - <b>1,5</b> - 2,0	0,10 - <b>0,20</b> - 0,40	150 - <b>250</b> - 350	0,5 - <b>1,5</b> - 2,0	0,10 - <b>0,20</b> - 0,40	120 - <b>210</b> - 300
		NSEW	0,5 - <b>1,5</b> - 2,5	0,10 - <b>0,40</b> - 0,60	150 - <b>250</b> - 350	0,5 - <b>1,5</b> - 2,5	0,10 - <b>0,40</b> - 0,60	120 - <b>210</b> - 300
		NGU - NGE - NUX	0,8 - <b>2,2</b> - 5,0	0,10 - <b>0,30</b> - 0,45	150 - <b>230</b> - 300	0,8 - <b>2,2</b> - 5,0	0,10 - <b>0,30</b> - 0,45	100 - <b>180</b> - 270
		NMU	1,8 - <b>3,0</b> - 6,0	0,20 - <b>0,35</b> - 0,60	130 - <b>200</b> - 280	1,8 - <b>3,0</b> - 6,0	0,20 - <b>0,35</b> - 0,60	80 - <b>150</b> - 230
		NME	1,0 - <b>3,0</b> - 6,0	0,20 - <b>0,45</b> - 0,70	130 - <b>200</b> - 280	1,0 - <b>3,0</b> - 6,0	0,20 - <b>0,45</b> - 0,70	80 - <b>150</b> - 230
CNM_16	SNM_15	NHG	3,0 - <b>4,5</b> - 8,0	0,35 - <b>0,50</b> - 0,80	100 - <b>180</b> - 260	3,0 - <b>4,5</b> - 8,0	0,35 - <b>0,50</b> - 0,80	60 - <b>130</b> - 200
		NGU - NGE - NUX	0,8 - <b>3,5</b> - 5,0	0,15 - <b>0,30</b> - 0,45	130 - <b>200</b> - 280	0,8 - <b>3,5</b> - 5,0	0,15 - <b>0,30</b> - 0,45	100 - <b>160</b> - 230
		NMU	1,8 - <b>4,5</b> - 6,0	0,20 - <b>0,40</b> - 0,60	100 - <b>180</b> - 260	1,8 - <b>4,5</b> - 6,0	0,20 - <b>0,40</b> - 0,60	80 - <b>140</b> - 210
		NME	1,5 - <b>4,5</b> - 7,0	0,20 - <b>0,50</b> - 0,70	100 - <b>180</b> - 260	1,5 - <b>4,5</b> - 7,0	0,20 - <b>0,50</b> - 0,70	80 - <b>140</b> - 210
CNM_19 CNM_25 DNM_19	SNM_19 SNM_25 TNM_27	NHG	3,0 - <b>5,0</b> - 8,0	0,35 - <b>0,60</b> - 0,80	80 - <b>160</b> - 240	3,0 - <b>5,0</b> - 8,0	0,35 - <b>0,60</b> - 0,80	70 - <b>120</b> - 180
		NMU	1,8 - <b>5,0</b> - 6,0	0,20 - <b>0,40</b> - 0,60	100 - <b>180</b> - 260	1,8 - <b>5,0</b> - 6,0	0,20 - <b>0,40</b> - 0,60	80 - <b>140</b> - 210
		NME	2,0 - <b>5,0</b> - 8,0	0,20 - <b>0,50</b> - 0,70	100 - <b>180</b> - 260	2,0 - <b>5,0</b> - 8,0	0,20 - <b>0,50</b> - 0,70	80 - <b>140</b> - 210
		NHG	3,0 - <b>6,5</b> - 9,0	0,35 - <b>0,60</b> - 0,80	80 - <b>160</b> - 240	3,0 - <b>6,5</b> - 9,0	0,35 - <b>0,60</b> - 0,80	70 - <b>120</b> - 180
		NHF	4,5 - <b>8,0</b> - 13,5	0,45 - <b>0,80</b> - 1,10	135 - <b>170</b> - 220	4,5 - <b>8,0</b> - 13,5	0,45 - <b>0,80</b> - 1,15	105 - <b>140</b> - 190

**AC8035P**

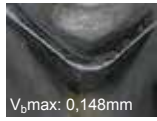
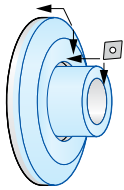
Min - Optimum - Max

Insert Specification		Chipbreaker	Soft Steel, Low Carbon Steel, Low Alloy Steel < 180HB			High Carbon Steel, High Alloy Steel > 180HB		
			Depth of Cut $a_p$ (mm)	Feed Rate $f$ (mm/rev)	Cutting Speed $v_c$ (m/min)	Depth of Cut $a_p$ (mm)	Feed Rate $f$ (mm/rev)	Cutting Speed $v_c$ (m/min)
CNM_12 DNM_15 SNM_12	TNM_16 TNM_22 WNM_08	NFE	0,1 - <b>0,4</b> - 1,2	0,10 - <b>0,25</b> - 0,45	120 - <b>200</b> - 300	0,1 - <b>0,4</b> - 1,2	0,10 - <b>0,25</b> - 0,45	120 - <b>180</b> - 250
		NLU - NSU - NSE	0,5 - <b>1,3</b> - 2,0	0,10 - <b>0,20</b> - 0,40	120 - <b>200</b> - 300	0,5 - <b>1,3</b> - 2,0	0,10 - <b>0,20</b> - 0,40	120 - <b>180</b> - 250
		NSEW	0,8 - <b>2,2</b> - 5,0	0,10 - <b>0,30</b> - 0,45	120 - <b>200</b> - 300	0,8 - <b>2,2</b> - 5,0	0,10 - <b>0,30</b> - 0,45	100 - <b>150</b> - 200
		NGU - NGE - NUX	1,8 - <b>3,0</b> - 6,0	0,20 - <b>0,35</b> - 0,60	100 - <b>180</b> - 250	1,8 - <b>3,0</b> - 6,0	0,20 - <b>0,35</b> - 0,60	80 - <b>130</b> - 180
		NMU	1,0 - <b>3,0</b> - 6,0	0,20 - <b>0,45</b> - 0,70	100 - <b>180</b> - 250	1,0 - <b>3,0</b> - 6,0	0,20 - <b>0,45</b> - 0,70	80 - <b>130</b> - 180
		NME	3,0 - <b>4,5</b> - 8,0	0,35 - <b>0,50</b> - 0,80	100 - <b>150</b> - 200	3,0 - <b>4,5</b> - 8,0	0,35 - <b>0,50</b> - 0,80	70 - <b>100</b> - 160
CNM_16	SNM_15	NHG	3,0 - <b>4,5</b> - 8,0	0,15 - <b>0,30</b> - 0,45	100 - <b>180</b> - 250	3,0 - <b>4,5</b> - 8,0	0,15 - <b>0,30</b> - 0,45	90 - <b>130</b> - 170
		NGU - NGE - NUX	0,8 - <b>3,5</b> - 5,0	0,20 - <b>0,40</b> - 0,60	100 - <b>150</b> - 200	0,8 - <b>3,5</b> - 5,0	0,20 - <b>0,40</b> - 0,60	70 - <b>110</b> - 150
		NMU	1,8 - <b>4,5</b> - 6,0	0,20 - <b>0,50</b> - 0,70	100 - <b>150</b> - 200	1,8 - <b>4,5</b> - 6,0	0,20 - <b>0,50</b> - 0,70	70 - <b>110</b> - 150
		NME	1,5 - <b>4,5</b> - 7,0	0,35 - <b>0,60</b> - 0,80	80 - <b>130</b> - 180	1,5 - <b>4,5</b> - 7,0	0,35 - <b>0,60</b> - 0,80	60 - <b>100</b> - 140
CNM_19 CNM_25 DNM_19	SNM_19 SNM_25 TNM_27	NHG	3,0 - <b>5,0</b> - 8,0	0,20 - <b>0,40</b> - 0,60	100 - <b>150</b> - 200	3,0 - <b>5,0</b> - 8,0	0,20 - <b>0,40</b> - 0,60	70 - <b>110</b> - 150
		NMU	2,0 - <b>5,0</b> - 8,0	0,20 - <b>0,50</b> - 0,70	100 - <b>150</b> - 200	2,0 - <b>5,0</b> - 8,0	0,20 - <b>0,50</b> - 0,70	70 - <b>110</b> - 150
		NME	3,0 - <b>6,5</b> - 9,0	0,35 - <b>0,60</b> - 0,80	80 - <b>130</b> - 180	3,0 - <b>6,5</b> - 9,0	0,35 - <b>0,60</b> - 0,80	60 - <b>100</b> - 140
		NHG	4,5 - <b>8,0</b> - 13,5	0,45 - <b>0,80</b> - 1,15	120 - <b>150</b> - 190	4,5 - <b>8,0</b> - 13,5	0,45 - <b>0,80</b> - 1,15	90 - <b>120</b> - 160
		NHF	5,0 - <b>8,0</b> - 13,5	0,80 - <b>1,20</b> - 1,60	70 - <b>110</b> - 150	5,0 - <b>8,0</b> - 13,5	0,80 - <b>1,20</b> - 1,60	50 - <b>80</b> - 120

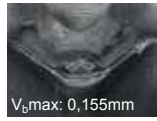
### Application Examples

#### Gear, 20CrMo5, 1.7218

AC8015P ensures minimal wear and 1,5 times higher tool life.



**NUX AC8015P**  
(150pcs)

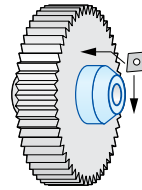


Competitor  
(100pcs)

Insert: CNMG120412 NUX  
Cutting Conditions:  $v_c = 280\text{m/min}$ ,  $f = 0,25\text{mm/rev}$ ,  $a_p = 2,0\text{-}2,5\text{mm}$ , wet

#### Gear, 34CrMo4, 1.7220

AC8015P ensures minimal crater wear and 1,5 times higher tool life.



**NGE AC8015P**  
(150pcs)

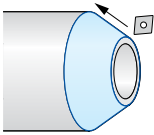


Conventional  
(100pcs)

Insert: CNMG120412 NGE  
Cutting Conditions:  $v_c = 200\text{-}260\text{m/min}$ ,  $f = 0,3\text{-}0,4\text{mm/rev}$ ,  $a_p = 1,5\text{mm}$ , wet

#### Carbon Steel

AC8015P's excellent chipping resistance ensures minimal damage and double tool life.



**NMU AC8015P**  
(25pcs)

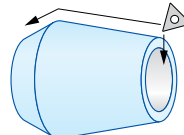


Competitor  
(12pcs)

Insert: CNMG120412 NMU  
Cutting Conditions:  $v_c = 160\text{m/min}$ ,  $f = 0,45\text{mm/rev}$ ,  $a_p = 2,5\text{mm}$ , wet

#### Tool Holder, 100Cr6, 1.3505

AC8015P ensures minimal crater breakage and 1,7 times higher tool life.



**NGE AC8015P**  
(500pcs)

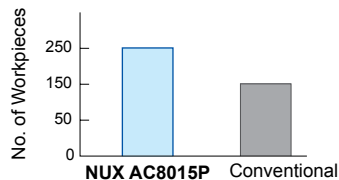
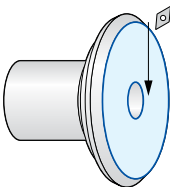


Competitor  
(300pcs)

Insert: TNMG160404 NGE  
Cutting Conditions:  $v_c = 210\text{-}270\text{m/min}$ ,  $f = 0,2\text{mm/rev}$ ,  $a_p = 3,3\text{mm}$ , wet

#### Hub, C55, 1.0535

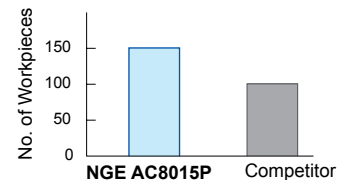
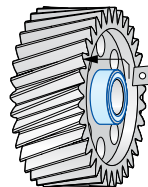
AC8015P ensures minimal wear and 1,7 times higher tool life.



Insert: DNMG150412 NUX  
Cutting Conditions:  $v_c = 240\text{m/min}$ ,  $f = 0,5\text{mm/rev}$ ,  $a_p = 1,0\text{-}2,5\text{mm}$ , wet

#### Gear, 34CrMo4, 1.7220

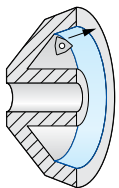
AC8015P's excellent chipping resistance ensures minimal damage and 1,5 times higher tool life.



Insert: CNMG120412 NGE  
Cutting Conditions:  $v_c = 200\text{-}260\text{m/min}$ ,  $f = 0,3\text{-}0,4\text{mm/rev}$ ,  $a_p = 2,0\text{mm}$ , wet

#### CVD Part, 20CrMo5, 1.7218

AC8015P's excellent chipping resistance ensures minimal damage.



**NSX AC8015P**  
(300pcs)




Conventional  
(300pcs)

Insert: WNMG080412 NSX  
Cutting Conditions:  $v_c = 300\text{m/min}$ ,  $f = 0,2\text{-}0,3\text{mm/rev}$ ,  $a_p = 1,0\text{mm}$ , wet

## Application Examples

**Axle End, C45, 1.0503**  
AC8025P ensures minimal crater wear.




$V_t$  max: 0.15mm  
**NMP AC8025P**  
(150pcs)

$V_t$  max: 0.83mm  
Competitor  
(150pcs)

Insert: CNMM120416 NMP  
Cutting Conditions:  $v_c = 180-200\text{m/min}$ ,  $f = 0,43-0,55\text{mm/rev}$ ,  $a_p = 1,0-3,0\text{mm}$ , wet

**Ring Gear, 15CrMo5**  
AC8025P ensures 1,5 times higher tool life.




**NME AC8025P**  
(150pcs)

Competitor  
(100pcs)

Insert: WNMG080416 NME  
Cutting Conditions:  $v_c = 250\text{m/min}$ ,  $f = 0,30-0,45\text{mm/rev}$ ,  $a_p = 2,5\text{mm}$ , wet

**Tool Holder, 15CrMo5, 1.7262**  
AC8025P's excellent chipping resistance ensures minimal damage.




**NEM AC8025P**  
(100pcs)

Competitor  
(100pcs)

Insert: DNMG150608 NEM  
Cutting Conditions:  $v_c = 150\text{m/min}$ ,  $f = 0,4\text{mm/rev}$ ,  $a_p = 4,0\text{mm}$ , wet

**Ring, C45, 1.0503**  
AC8025P 3 times higher tool life.




**NGE AC8025P**  
(450pcs)

Competitor  
(150pcs)

Insert: CNMG120408 NGE  
Cutting Conditions:  $v_c = 200-250\text{m/min}$ ,  $f = 0,25\text{mm/rev}$ ,  $a_p = 1,0\text{mm}$ , wet

**Cylinder, Soft Steel**  
AC8025P's excellent chipping resistance ensures minimal damage after attaining double tool life.




$V_t$  max: 0.11mm  
**NSU AC8025P**  
(200pcs)

$V_t$  max: 0.11mm  
Competitor  
(100pcs)

Insert: DCMT11T308 NSU  
Cutting Conditions:  $v_c = 210\text{m/min}$ ,  $f = 0,15\text{mm/rev}$ ,  $a_p = 1,0\text{mm}$ , wet

**Bush, 20MnCr5, 1.7147**  
AC8025P ensures excellent flank wear resistance.

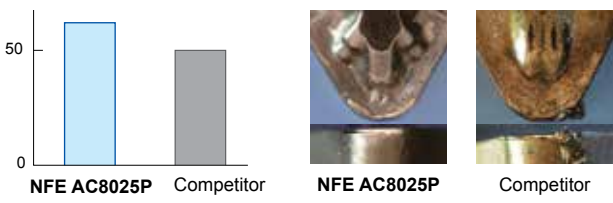


$V_t$  max: 0.14mm  
**NME AC8025P**  
(200pcs)

$V_t$  max: 0.21mm  
Competitor  
(200pcs)

Insert: CNMG120416 NME  
Cutting Conditions:  $v_c = 260\text{m/min}$ ,  $f = 0,5-1,0\text{mm/rev}$ ,  $a_p = 1,5-2,0\text{mm}$ , wet

**Front Cover, Soft Steel**  
AC8025P shows excellent finishing surface by combination of NFE type chipbreaker and ensures 1,2 times higher tool life.



**NFE AC8025P** Competitor

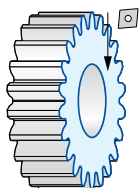
**NFE AC8025P** Competitor

Insert: TNMG160408 NFE  
Cutting Conditions: Facing:  $v_c = 450-480\text{m/min}$ ,  $f = 0,25-0,32\text{mm/rev}$ ,  $a_p = 0,05-0,25\text{mm}$ , wet  
Turning:  $v_c = 400\text{m/min}$ ,  $f = 0,2-0,3\text{mm/rev}$ ,  $a_p = 0,2-0,3\text{mm}$ , wet

### Application Examples

#### Planetary Pinion, C35, 1.0501

AC8035P's excellent breakage resistance ensures minimal damage.



**NUX AC8035P**  
(300pcs)



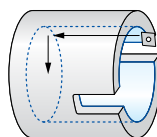
Conventional  
(200pcs)

Interrupted cut

Insert: CNMG120412 NUX  
Cutting Conditions:  $v_c = 180\text{m/min}$ ,  $f = 0,3\text{mm/rev}$ ,  $a_p = 2,0\text{mm}$ , wet

#### Automotive Part, C25, 1.0406

AC8035P's excellent breakage resistance ensures minimal damage and a reliable tool life.



$V_s \text{ max: } 0,23\text{mm}$   
**NUX AC8035P**  
(120pcs)



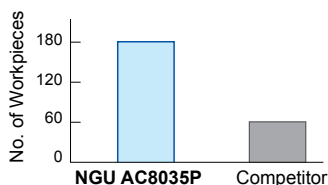
Conventional  
(120pcs)

Interrupted cut

Insert: CNMG120408 NUX  
Cutting Conditions:  $v_c = 100-130\text{m/min}$ ,  $f = 0,2\text{mm/rev}$ ,  $a_p = 1,0-3,2\text{mm}$ , wet

#### Flange, 19Mn5, 1.0482

AC8035P's excellent chipping resistance ensures minimal damage and 3 times tool life.

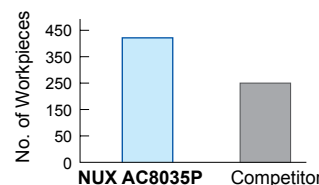
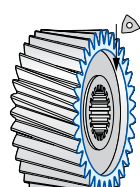


Roughing/Interrupted cut

Insert: TNMG160408 NGU  
Cutting Conditions:  $v_c = 100\text{m/min}$ ,  $f = 0,3\text{mm/rev}$ ,  $a_p = 1,5\text{mm}$ , wet

#### Gear, 34CrNiMo6, 1.6582

AC8035P's excellent chipping resistance ensures minimal damage and 1,7 times tool life.

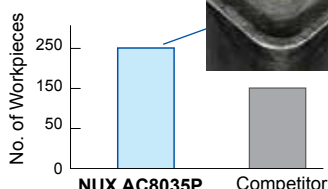
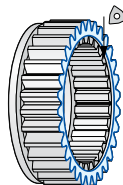


Roughing/Interrupted cut

Insert: WNMG080408 NUX  
Cutting Conditions:  $v_c = 180\text{m/min}$ ,  $f = 0,15-0,40\text{mm/rev}$ ,  $a_p = 1,0\text{mm}$ , wet

#### Reverse Gear, 20Cr4, 1.7027

AC8035P's excellent chipping resistance ensures minimal damage and 1,6 times tool life.

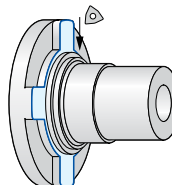


Roughing/Interrupted cut

Insert: WNMG080408 NUX  
Cutting Conditions:  $v_c = 230\text{m/min}$ ,  $f = 0,15-0,30\text{mm/rev}$ ,  $a_p = 1,0-2,0\text{mm}$ , wet

#### Flange, 41Cr4, 1.7035

AC8035P's excellent chipping resistance ensures minimal damage and 1,5 times tool life.



**NGU AC8035P**  
(90pcs)



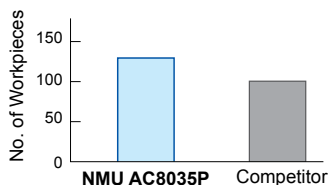
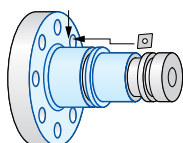
Competitor  
(60pcs)

Roughing/Interrupted cut

Insert: WNMG080412 NGU  
Cutting Conditions:  $v_c = 80-200\text{m/min}$ ,  $f = 0,2\text{mm/rev}$ ,  $a_p = 1,5\text{mm}$ , dry

#### Axle End

AC8035P's excellent chipping resistance ensures minimal damage and 1,3 times tool life.



Mill-Scaled Work /  
Continuous to Interrupted cut

Insert: CNMG190616 NMU  
Cutting Conditions:  $v_c = 140-280\text{m/min}$ ,  $f = 0,5\text{mm/rev}$ ,  $a_p = 5\text{mm}$ , dry



















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