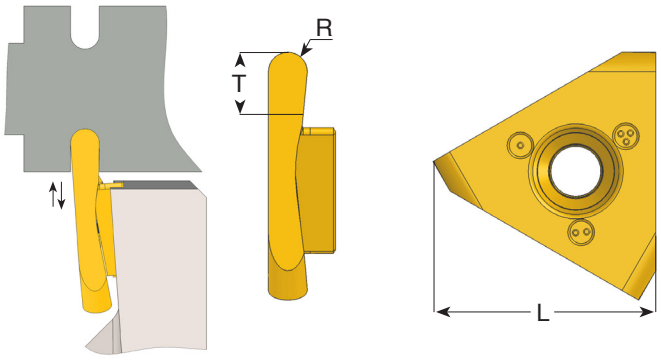
Grooving and Profiling (full radius)



Right Version

Right hand cutting

Insert Size L	Ordering Code	R ±0.03	T max	Feed mm/rev	
				Radial	Axial
19	**GR19 R R02 T15**	0.25	1.5	0.01-0.06	0.02-0.10
	GR19 R R04 T18	0.40	2.0	0.01-0.06	0.02-0.10
	GR19 R R05 T22	0.50	2.5	0.02-0.07	0.02-0.10
	GR19 R R06 T26	0.60	3.0	0.02-0.07	0.02-0.10
	GR19 R R08 T33	0.80	3.5	0.04-0.09	0.02-0.20
	GR19 R R10 T40	1.00	4.0	0.05-0.10	0.02-0.20
20	**GR20 R R12 T50**	1.25	6.0	0.05-0.10	0.02-0.20
	GR20 R R15 T60	1.50	6.0	0.05-0.10	0.02-0.20

	K20	BLU
P		●
M	●	●
K	●	○
N	●	
S	●	●
H		≤45 HRc

For L.H, specify GR19 L instead of GR19 R

● First choice ○ Alternative

Swiss-Line

- Swiss style lathes are becoming a popular alternative to large lathes and machining centers in many companies.
- CPT offers a large and versatile product line of inserts and toolholders, developed for automatic and Swiss style lathes.
- Designed for economic production of parting, grooving, profiling threading and chamfering.

Polygon Inserts and Toolholders

CPT extends the Swiss Line range by offering a new type of polygon inserts and toolholders for external turning, grooving, parting and threading on Swiss-Type machines. Specially designed for small parts machining.

Features

- High precision ground inserts.
- All inserts can be used with same toolholders.
- A combination of the latest carbide and coating technologies guarantees maximum tool life and improved productivity.
- Compatible with a wide range of materials.
- Coated holders provide abrasive resistance.

Carbide grades: BLU, GX7, K20

3 Cutting Edges Swiss Line Inserts (16 mm)

Carbide Grades

GX7

New generation of PVD triple layer coated Sub-Micron grade for wide range of materials as: Steel, Stainless Steels, Titanium and hard materials up to 58 HRc.
With high toughness for optimized performance.

K20

Uncoated Sub-Micron carbide grade for Aluminum and non-ferrous materials, Stainless Steels and Titanium.

Cutting Data

ISO Standard	Materials	Cutting Speed m/min	
		K20	GX7
P	Low & Medium Carbon Steels <0.55%C	-	80-150
	High Carbon Steels ≥0.55%C	-	70-120
	Alloy Steels, Treated Steels	-	40-80
M	Stainless Steel-Free Cutting	30-80	60-120
	Stainless Steel-Austenitic	20-70	30-90
	Cast Steels	30-80	50-120
K	Cast Iron	50-120	50-120
N	Aluminum ≤12%Si, Copper	120-250	-
	Aluminum >12%Si	90-200	-
	Synthetics, Duroplastics, Thermoplastics	70-150	-
S	Nickel Alloys, Titanium Alloys	20-50	30-70
H	Hardened Steel, 45-58HRc	-	20-50

Product Identification - Ordering Codes

Polygon Inserts