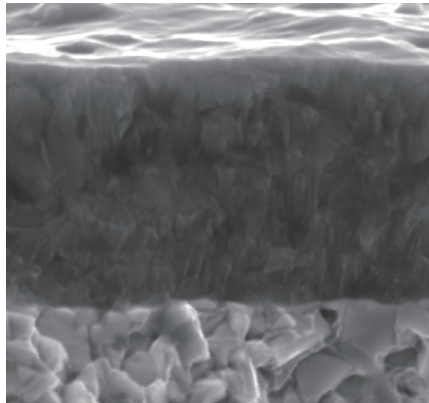


New Milling Grade For Steel- P4225



Features

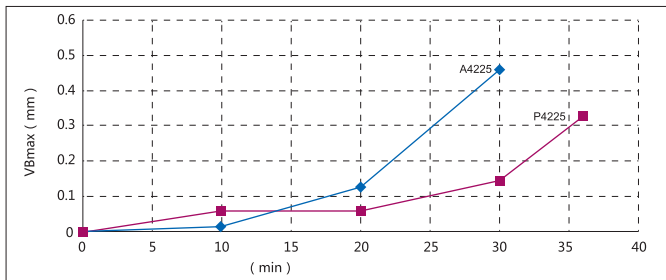


New PVD Coating	
•	Ti-based nitride layer with excellent welding resistance and low friction;
•	Nano-structure AlCrN coating improved oxidation and thermal resistance.
Substrate	
•	Micro-grain carbide substrate with high wear resistance.



Application: Suitable for semi-finishing to light roughing of steel materials under wet and dry.

Cutting Performance



Cutting Condition	
Material	40Cr
Insert	RDMW1204M0T-PM- P4225
Cutter	MPA100-050R04A22-RD12
Coolant	Dry Cooling
Cutting Speed	Vc=200m/min
mm/tooth	fz=0.5mm/t
Depth, Width	ap=1mm ae=35mm

Wear-resistance and stability are improved significantly

Recommended Cutting Data

Workpiece Materials	Material Hardness	Cutting Speed Vc (m/min)	Dimension	(fz) mm/tooth		
				(L) Light Cutting	(M) Medium Cutting	(H) Heavy Cutting
				PL/GL/BL	PM/GM	PR/GH
Low Carbon Steel	≤HB180	180 (150-230)	APMT	0.12 (0.05-0.15)	0.17 (0.1-0.2)	0.20 (0.1-0.25)
			R2.5	0.10 (0.05-0.15)	0.11 (0.08-0.15)	0.12 (0.08-0.2)
			R3.5/R4	0.11 (0.05-0.15)	0.12 (0.08-0.18)	0.15 (0.1-0.25)
			R5/R6	0.15 (0.1-0.25)	0.20 (0.15-0.3)	0.25 (0.2-0.35)
			R8	0.18 (0.1-0.25)	0.25 (0.1-0.35)	0.30 (0.1-0.45)
Carbon Steel, Alloy Steel	HB180-350	150 (120-200)	APMT	0.10 (0.05-0.13)	0.15 (0.1-0.18)	0.18 (0.1-0.23)
			R2.5	0.10 (0.05-0.15)	0.12 (0.08-0.15)	0.15 (0.08-0.2)
			R3.5/R4	0.12 (0.05-0.15)	0.15 (0.08-0.18)	0.18 (0.1-0.25)
			R5/R6	0.18 (0.1-0.25)	0.22 (0.15-0.3)	0.28 (0.2-0.35)
			R8	0.20 (0.1-0.25)	0.28 (0.1-0.35)	0.32 (0.1-0.45)