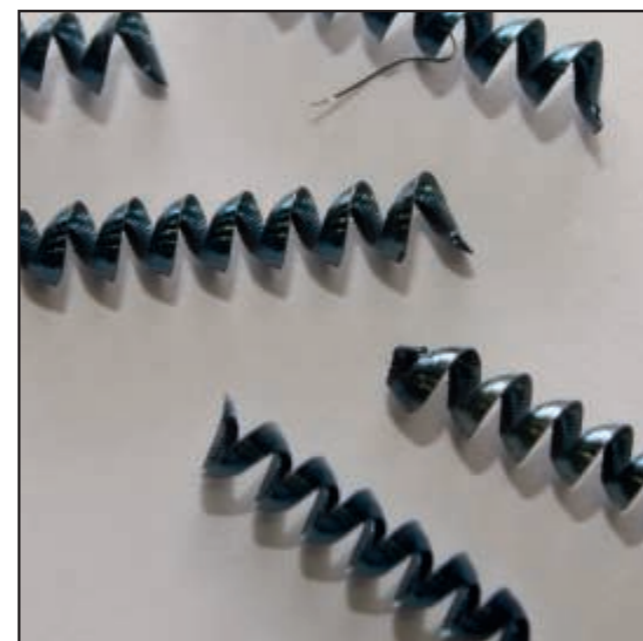


TURNING MACHINING OPTIMISATION TECHNIQUE

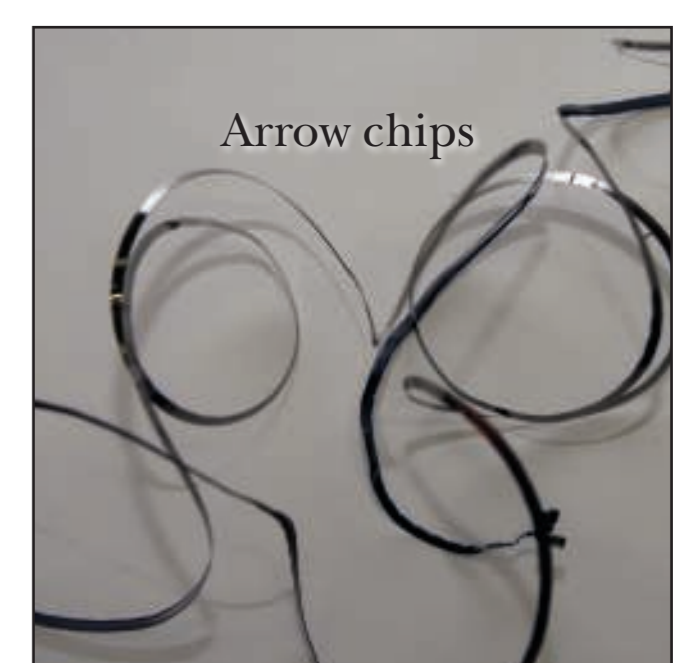
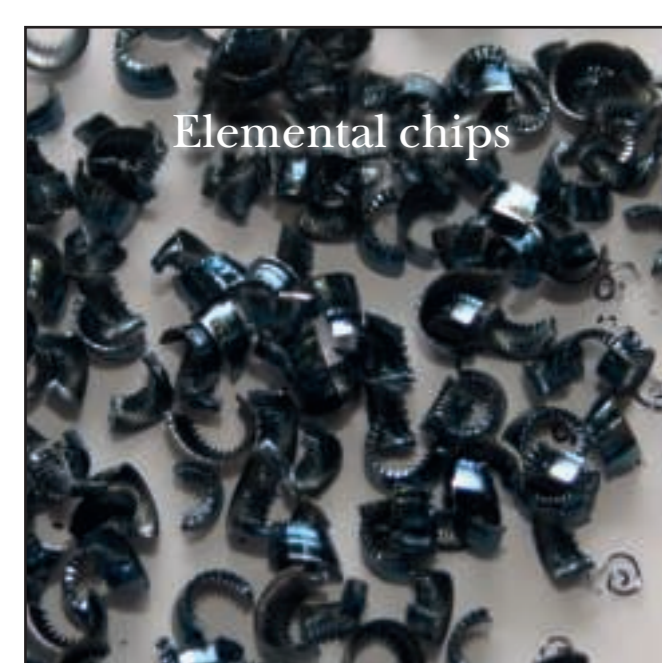
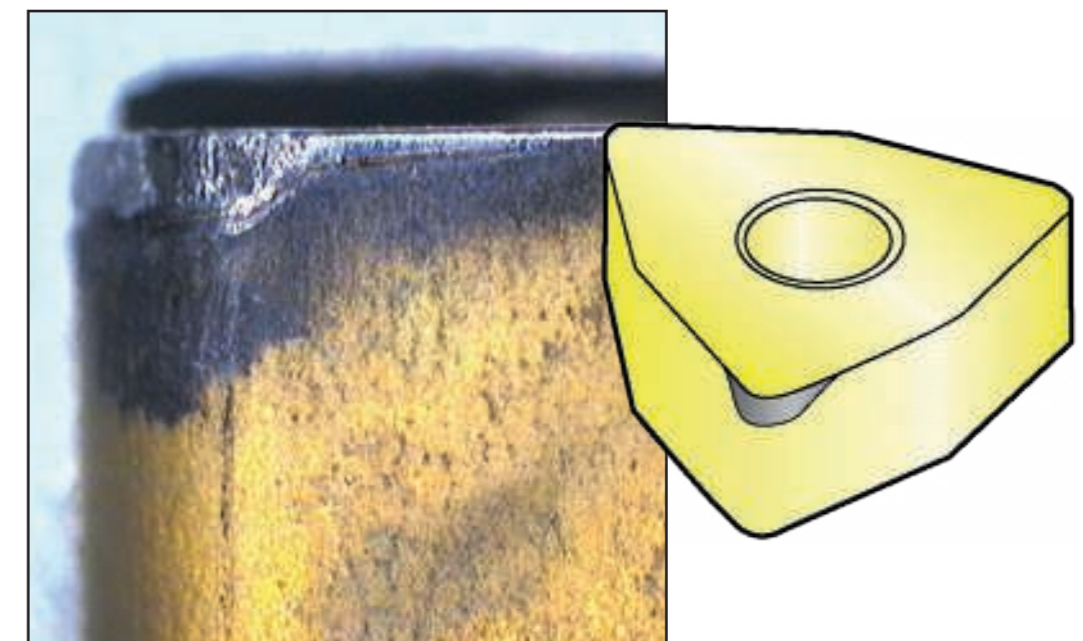
OUR MAIN TARGETS:
MAINTAIN CHIP CONTROL &
ACHIEVE BALANCED TOOL WEAR

1. OPTIMISE CHIP FORMATION

OPTIMUM CHIPS



FLANK WEAR



f (mm/rev) **-**
 Chipbreaker **-**

-
-

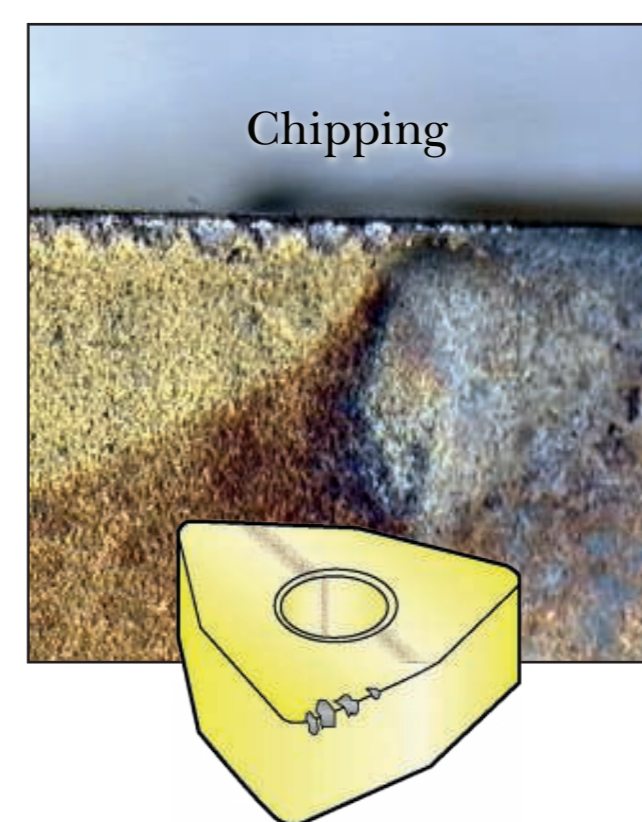
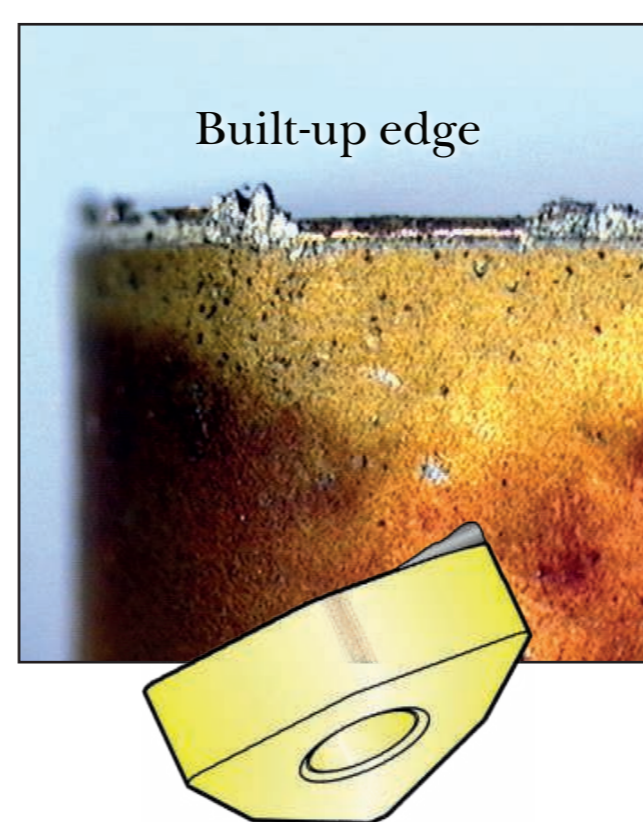
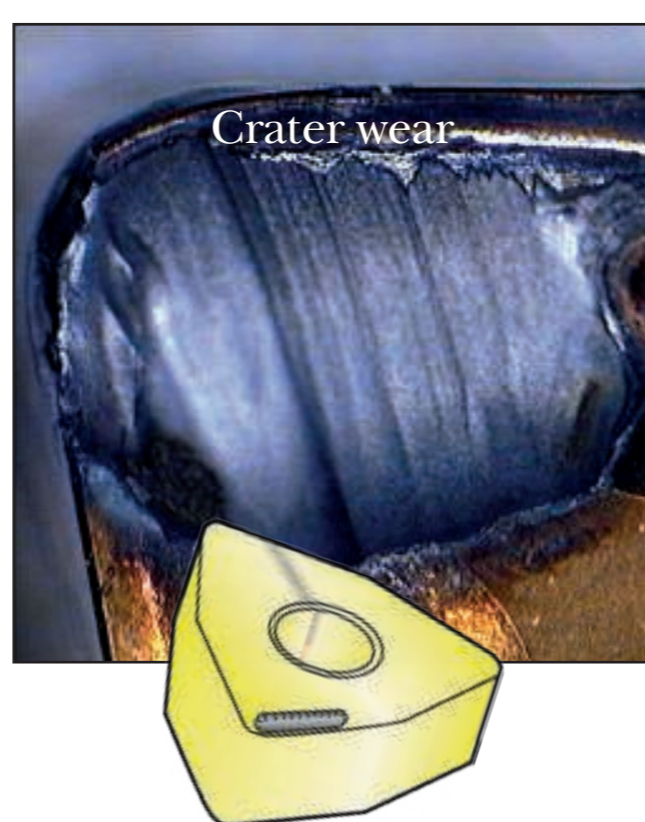
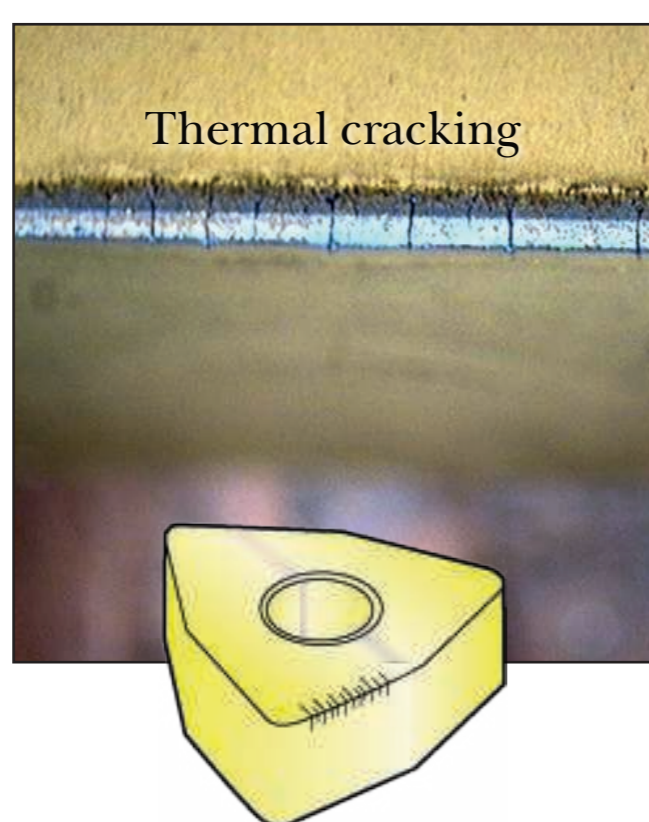
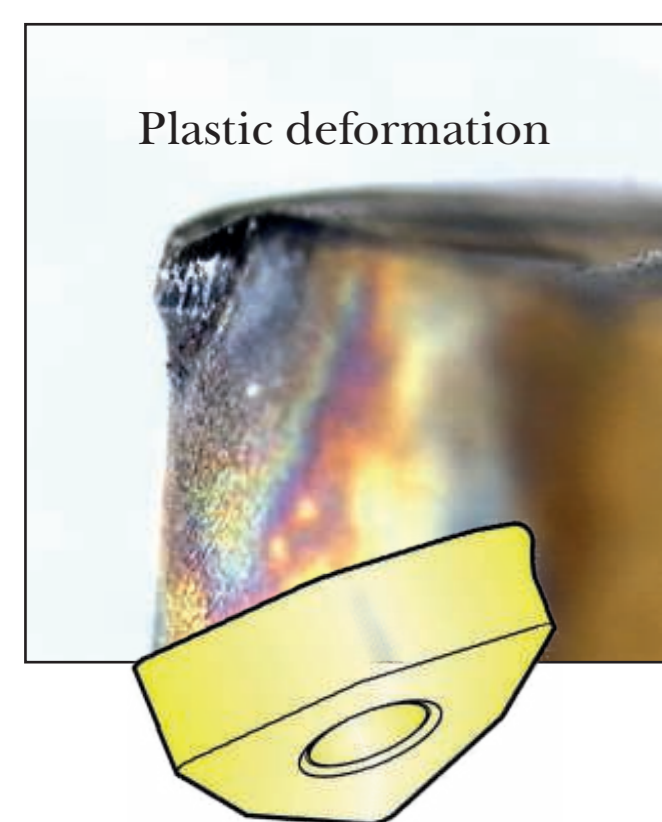
-
-

+
+

+
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+
+

2. OPTIMISE TOOL WEAR



v_c (m/min) **-**
 Carbide grade **+**

-
-

-
+

+
-

+
-

+
-

CHIPBREAKER SELECTION

RR					RR6	RR93	RR94	RR9	RR96	RR97
R		R2	R4	R5	R56	R57	R6	R68	R7	R8
MR		MR3	MR4		MR6	MR7				
M	M1		M3	M4	M5	M6				
MF	MF1	MF2	MF3	MF4	MF5					
FF	FF1	FF2								

Cutting edge strength (feed)
 Sharp **+** \longleftrightarrow Strong **-**

CARBIDE GRADE SELECTION

Grades	P				M				K				N				S				H							
	P01	P10	P20	P30	P40	P50	M01	M10	M20	M30	M40	K01	K10	K20	K30	K40	N01	N10	N20	N30	S01	S10	S20	S30	H01	H10	H20	H30
CVD																												
PVD																												
Cermel																												
Uncoated																												

More wear resistant **+** \longleftrightarrow Tougher **-**
 Valid per workpiece material group

This schedule represents the majority of cases. For specific cases (e.g. heavily nested chips/broken inserts) or specific measurements, please contact your business partner at Seco.