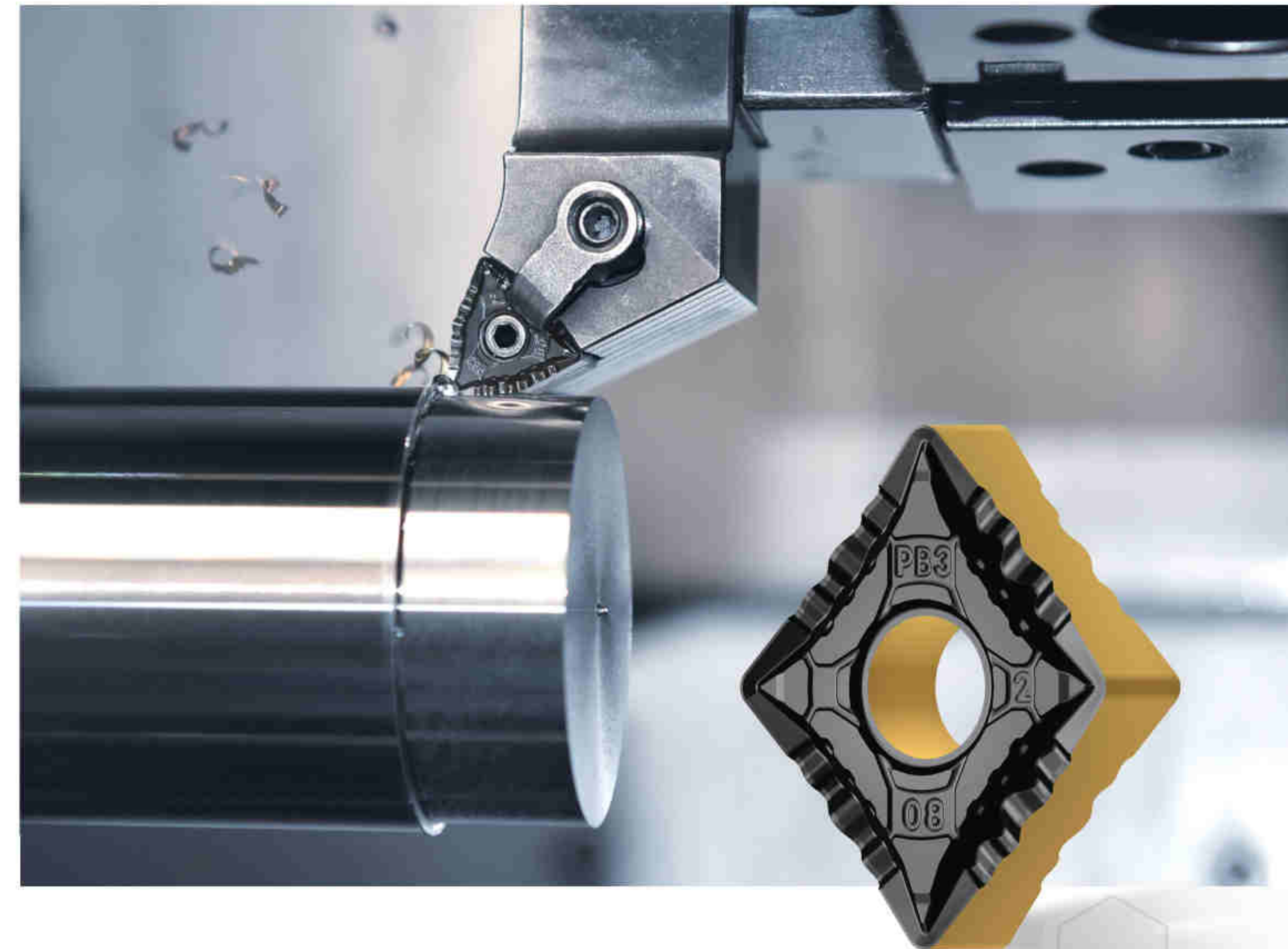
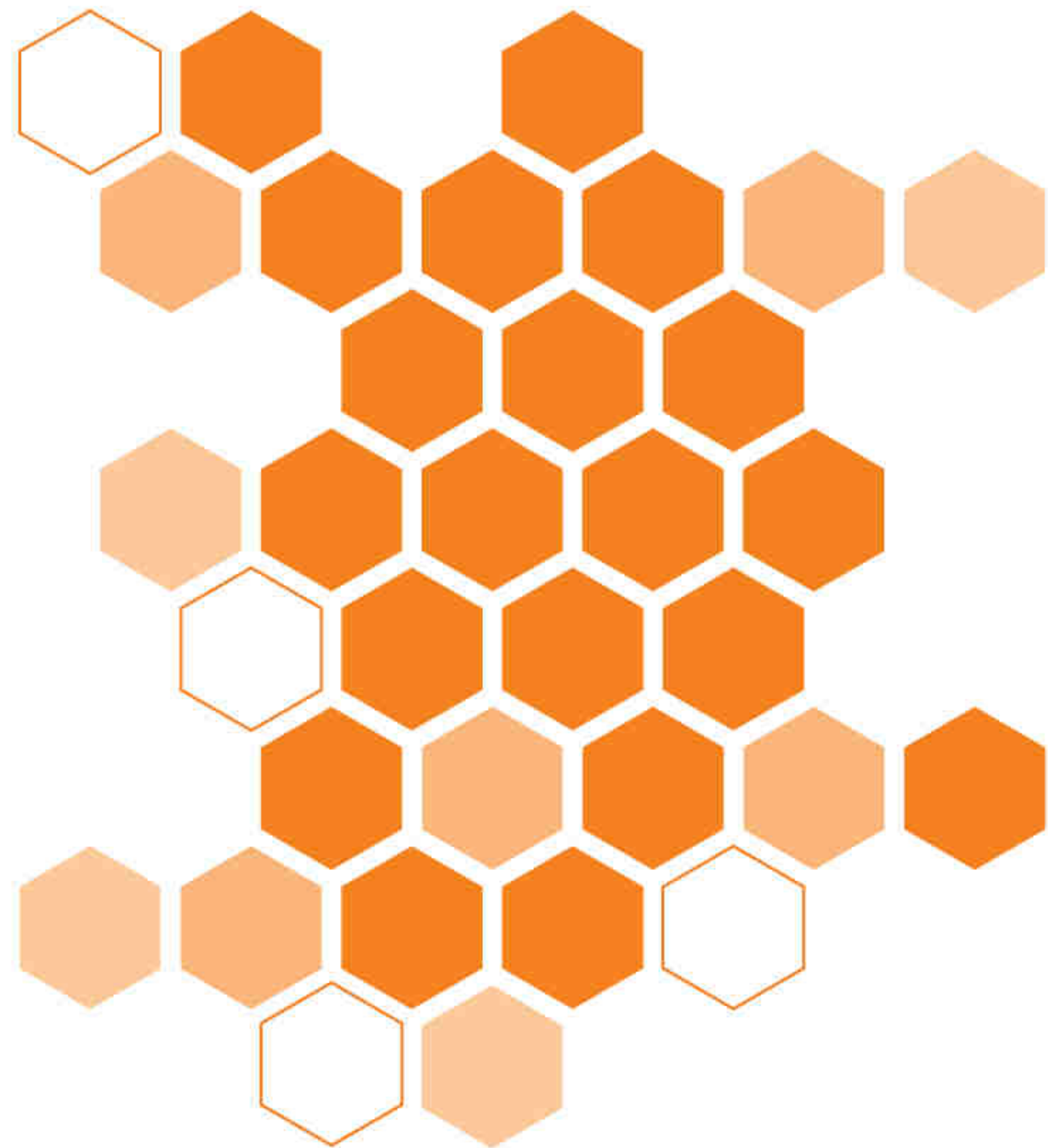


ACHTECK•TURN

NEW
PRODUCT! **New Chip Breaker** **PB3**

for semi-finishing on Steels



GANZHOU ACHTECK TOOL TECHNOLOGY CO.,LTD.

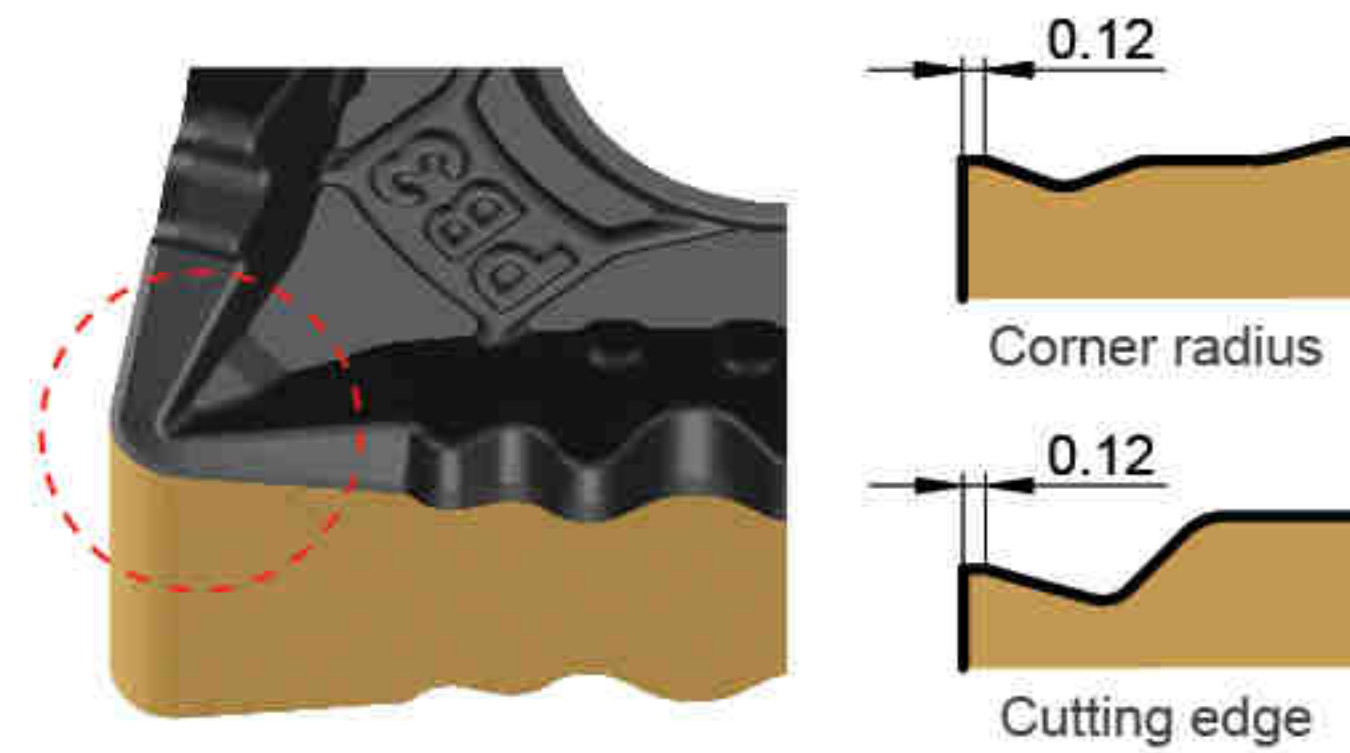
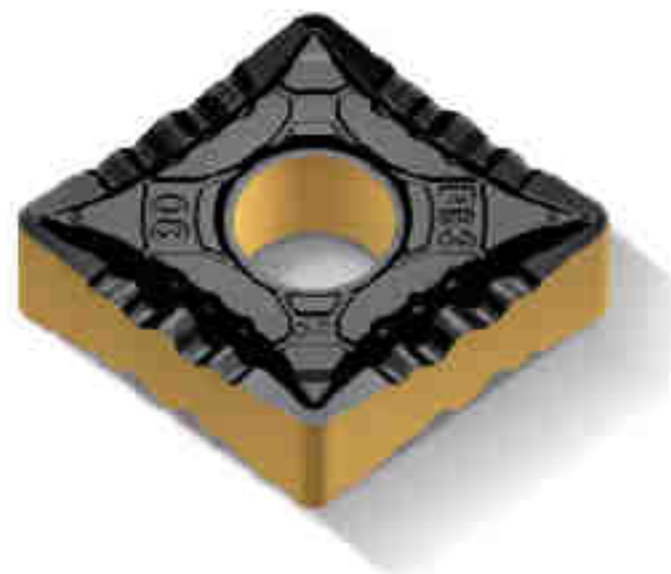
Address : Ganzhou Economic Development Area, Jiangxi, China
Tele : 0086-797-8166368 Fax : 0086-797-8166100 E-mail : alloysales@achtecktool.com

www.achtecktool.com



● Grade Application

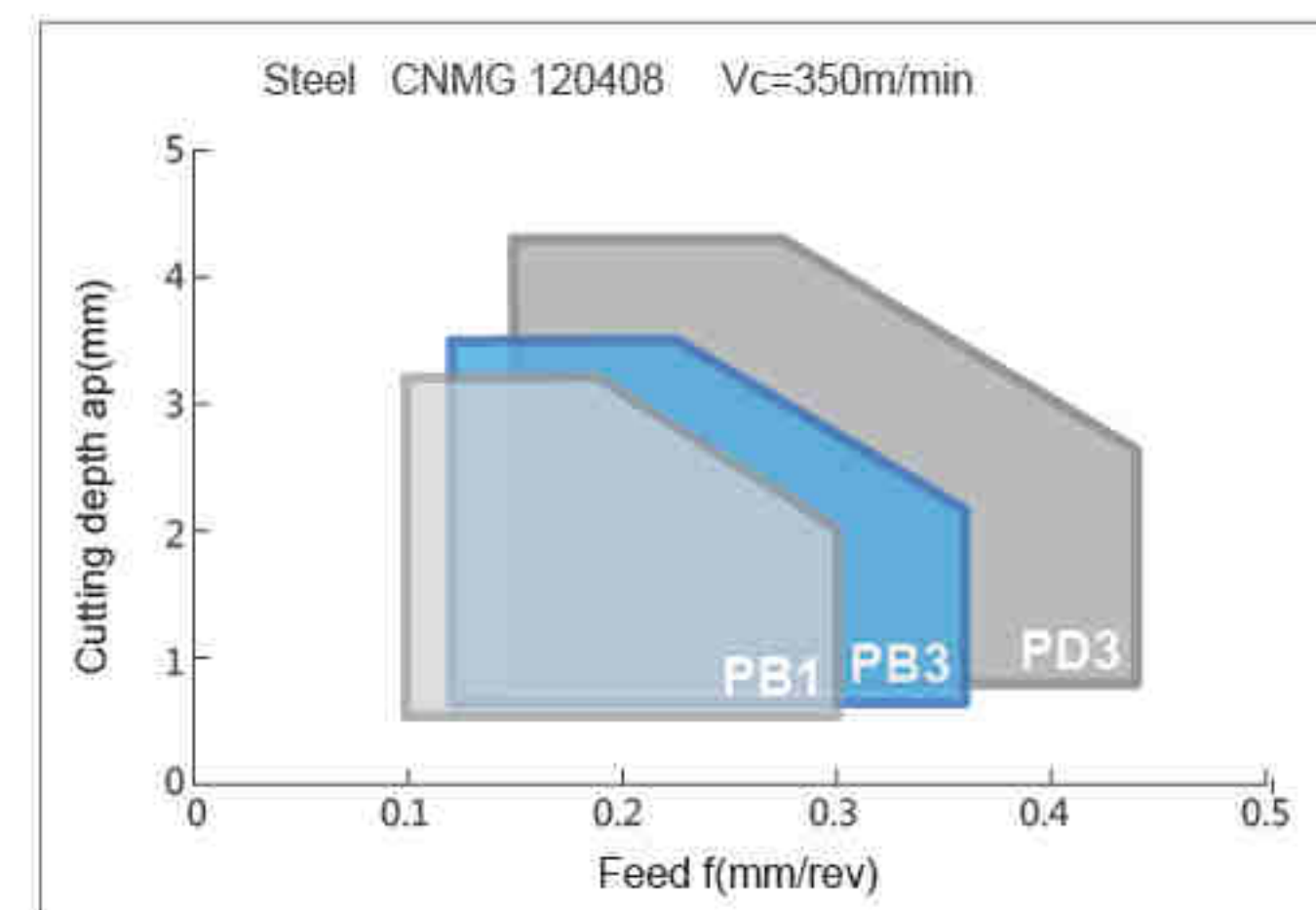
Application Range												Cutting Speed	
												m/min	
ISO	01	5	10	15	20	25	30	35	40	45	50	Vcmin	Vcmax
P			AC150P									160	458
				AC250P								120	380



Chip Breaker Features

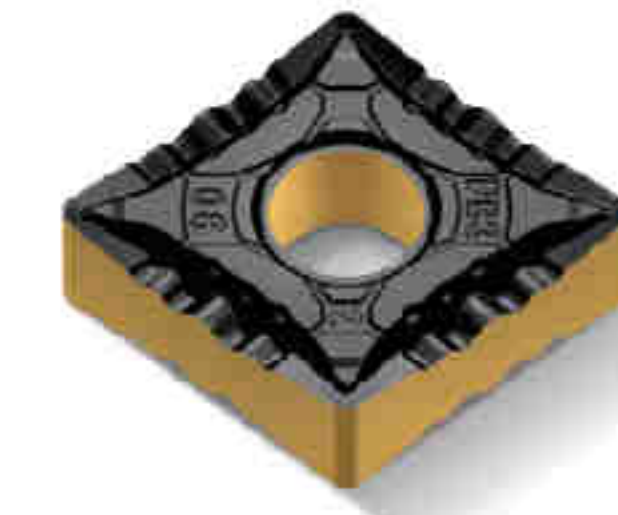
Excellent performance on small cutting depth with big feed rate, widely application range.

Superior effort on chip breaking during the spare parts machining of bearing.

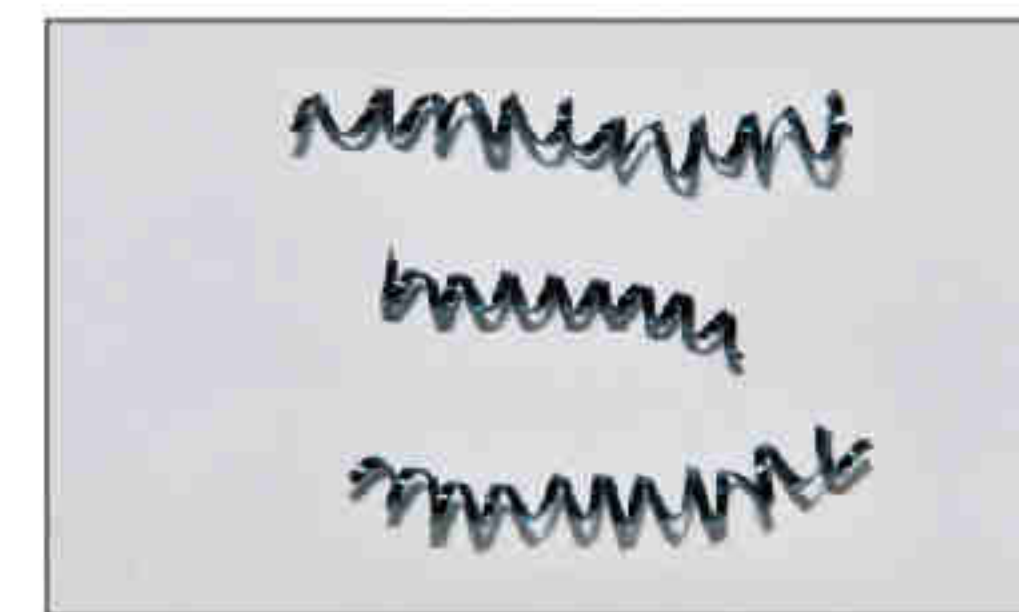


● Result of Chip Breaking

Cutting Conditions
 Machined Materials: 20CrNiMo
 Insert: CNMG 120408
 Cutting Speed: 220m/min
 Cutting Feed: 0.18mm/rev
 Cutting Depth: 0.6mm
 Condition: Dry cutting



Other company



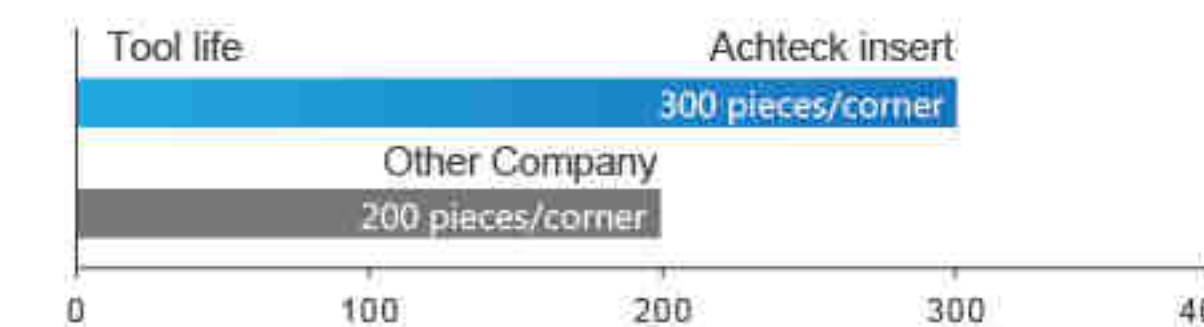
Chip breaker PB3



● Machining Case

Work piece: Bearing
 Material: Gr15
 Insert: VNMG 160412E-PB3 AC250P
 Other Company: VNMG 160412 A XX P15
 Machining Type: External turning
 Cutting Parameter: Vc=260m/min ap=1mm
 f=0.20mm/rev

Condition: Dry cutting



Comparison Result: Achteck tool life is 33% higher than competitor

Work piece: Joint CV Joint
 Material: 65Mn
 Insert: TNMG 160408E-PB3 AC150P
 Other Company: TNMG 160408 B XX P15
 Machining Type: End face turning
 Cutting Parameter: $V_c=220\text{m/min}$ $a_p=0.7-1.0\text{mm}$
 $f=0.22\text{mm/rev}$



Condition: Wet cutting

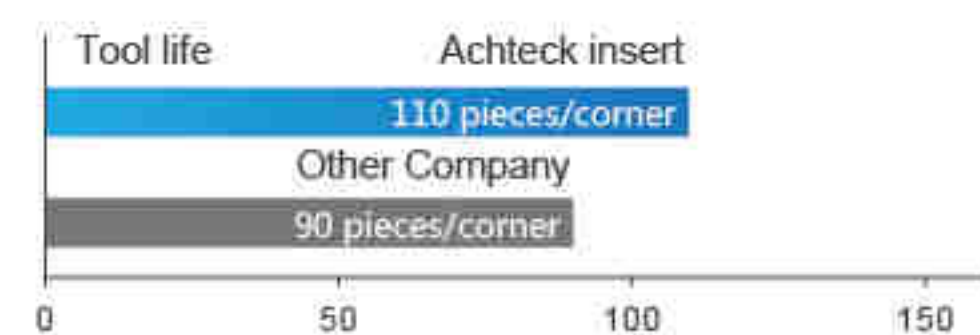


Comparison Result: Achteck tool life is 30% higher than competitor

Work piece: Wheel hub
 Material: 65Mn
 Insert: WNMG 080408E-PB3 AC150P
 Other Company: WNMG 080408 B XX P15
 Machining Type: End face turning
 Cutting Parameter: $V_c=320-220\text{m/min}$ $a_p=0.8\text{mm}$
 $f=0.20\text{mm/rev}$



Condition: Wet cutting



Comparison Result: Achteck tool life is 30% higher than competitor

Insert Stock

Insert picture	Designation	Application parameters		Grades	
				CVD coating	
		f (mm/rev)	ap (mm)	AC150P	AC250P
	CNMG 120404E-PB3	0.06-0.18	0.3-3.5	●	●
	CNMG 120408E-PB3	0.12-0.36	0.6-3.5	●	●
	CNMG 120412E-PB3	0.18-0.54	0.9-3.5	●	●
	DNMG 150404E-PB3	0.06-0.18	0.3-3.1	●	●
	DNMG 150408E-PB3	0.12-0.36	0.6-3.1	●	●
	DNMG 150412E-PB3	0.18-0.54	0.9-3.1	●	●
	DNGM 150604E-PB3	0.06-0.18	0.3-3.1	●	●
	DNMG 150608E-PB3	0.12-0.36	0.6-3.1	●	●
	DNMG 150612E-PB3	0.18-0.54	0.9-3.1	●	●
	TNMG 160404E-PB3	0.06-0.18	0.3-3.3	●	●
	TNMG 160408E-PB3	0.12-0.36	0.6-3.3	●	●
	TNMG 160412E-PB3	0.18-0.54	0.9-3.3	●	●
	VNMG 160404E-PB3	0.06-0.18	0.3-3.1	●	●
	VNMG 160408E-PB3	0.12-0.36	0.6-3.1	●	●
	VNMG 160412E-PB3	0.18-0.54	0.9-3.1	●	●
	WNMG 080404E-PB3	0.06-0.18	0.3-2.3	●	●
	WNMG 080408E-PB3	0.12-0.36	0.6-2.3	●	●
	WNMG 080412E-PB3	0.18-0.54	0.9-2.3	●	●

● Represent for standard stock

