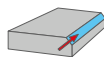
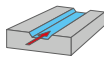
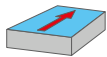


Overview HPKT... HPCT...

Application:

- 1) Face milling 2) Slot milling 3) Chamfering



Chipbreaker:

HCM: Steel – Cast iron*

SCM: Stainless Steel – Exotic* – Titanium*

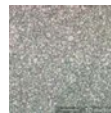
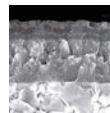
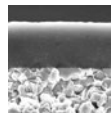
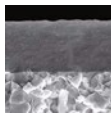
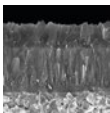
LMM: Aluminium and non-ferrous metals

6 effective cutting edges:



Grades:

GCP230 ■ GPP235 ■ GPM240 ■ GC5235 ■ CWN715 ■



* secondary application

Masterfinish:

Extremely soft, spindle-friendly cut. The very positive cutting edge chipbreaker paired with the new chipbreaker designs revolutionizes milling on small to medium sized milling machines.



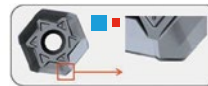
Masterfinish technology"

Indexing 6 times:



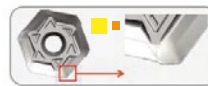
- ▲ Indexing of the insert without complete removal of the clamping screw is possible!
- ▲ Direct insert indexing saves valuable machine time.

Which chipbreaker to use?



HCM

Strong cutting edge for general steel applications and hard conditions milling.



SCM

Sharp cutting edge for general stainless steel applications and for finishing in steels.



LMM

Extremely sharp cutting edge for aluminum and non-ferrous metals.

Available range HPKT... HPCT...

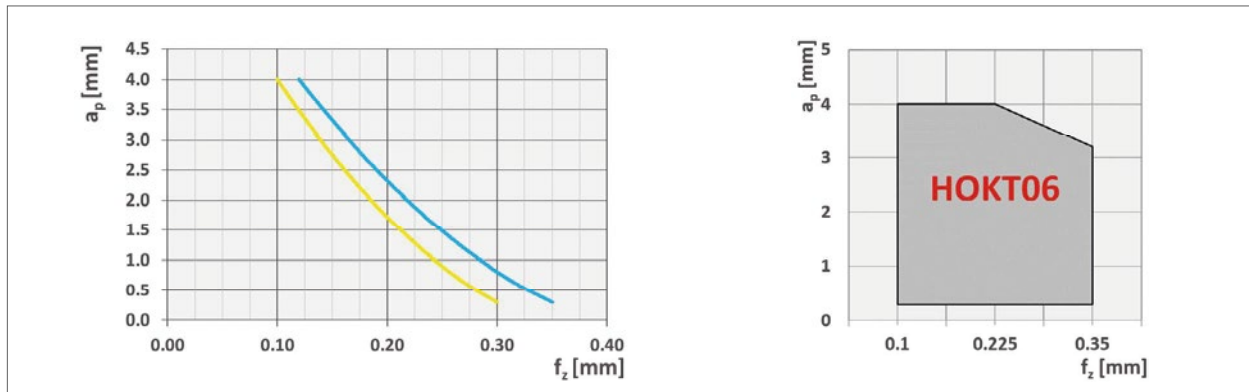
Insert	Designation	Chipbreaker	Material number	Available
	HPKT 0604AZER-HCM GTCP230	...-HCM	MM12193366	●
	HPKT 0604AZER-HCM GTPP235	...-HCM	MM12193369	●
	HPKT 0604AZER-SCM GTC5235	...-SCM	MM11526389	●
	HPCT 0604AZFR-LMM GTWN715	...-LMM	MM14652610	●

Body	Designation	ø Milling cutter	z	Material number	Available
 	C-SSM-H06-40.R.04-B32-50-110	40	4	MM11520454	●
	A-SSM-H06-40.R.04	40	4	MM11520455	●
	A-SSM-H06-50.R.05	50	5	MM11520456	●
	A-SSM-H06-63.R.06	63	6	MM11520457	●
	A-SSM-H06-80.R.07	80	7	MM11520458	●
	A-SSM-H06-100.R.09	100	9	MM11520459	●
	A-SSM-H06-125.R.10	125	10	MM11520460	●

Spare parts	Designation	Torque moment [Nm]	Material number	Available
	M4.0 x 11 – T15+	5	MM1345432	●
	Power screw M8.0 x 30.0 (only for A-SSM-H06-40.R.04)	15	MM11036880	●

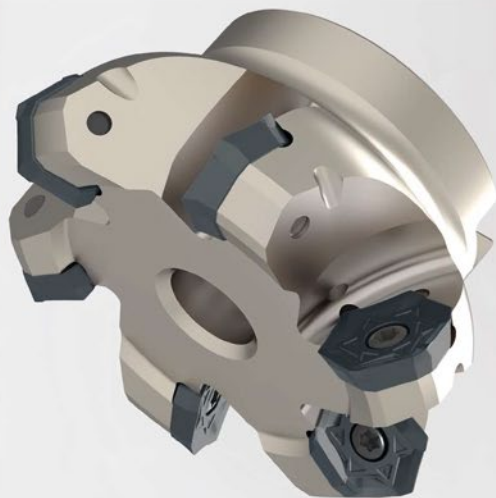
Cutting data HPKT... HPCT...

Starting Parameters:



Grades and Materials:

	Material group	Chipbreaker	Grade	v_c [m/min]	Cutting data f_z [mm]	a_p [mm]
P	Steel	HCM	GCP230 GPP235	220 – 60	0.12 – 0.3	4 – 0.3
M	Stainless steel	SCM	GC5235	200 – 60	0.1 – 0.25	4 – 0.3
N	Non-ferrous	LMM	GWN715	< 2000	0.05 – 0.35	4 – 0.3



Overview HOKT... HOCT...

Application:

- 1) Face milling 2) Slot milling 3) Chamfering



Chipbreaker:

HCM: Steel – Cast iron*

SCM: Stainless Steel – Exotic* – Titanium*

6 effective cutting edges:



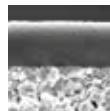
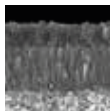
Grades:

GCP230 ■

GPP235 ■

GPM240 ■

GC5235 ■



Masterfinish:

Extremely soft, spindle-friendly cut. The very positive cutting edge chipbreaker paired with the new chipbreaker designs revolutionizes milling on small to medium sized milling machines.



"Masterfinish technology"

Indexing 6 times:



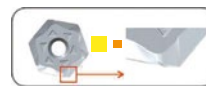
- ▲ Indexing of the insert without complete removal of the clamping screw is possible!
- ▲ Direct insert indexing saves valuable machine time.

Which chipbreaker to use?



HCM

Strong cutting edge for general steel applications and hard conditions milling.



SCM

Sharp cutting edge for general stainless steel applications and for finishing in steels.

Available range HOKT... HOCT...

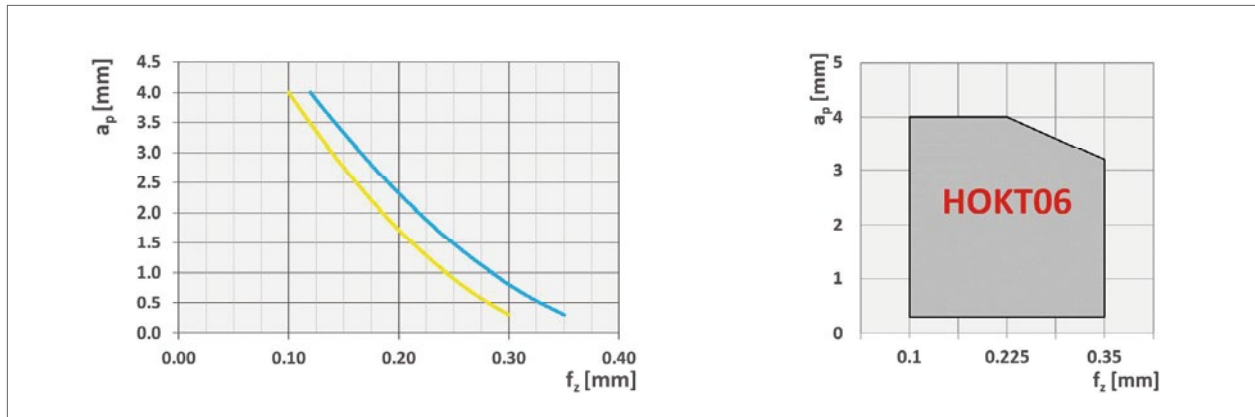
Insert	Designation	Chipbreaker	Material number	Available
	HOKT 0604AZER-HCM GTCP230	...-HCM	MM11950674	●
	HOKT 0604AZER-HCM GTPP235	...-HCM	MM11943817	●
	HOCT 0604AZER-SCM GTPM240	...-SCM	MM14652624	●
	HOCT 0604AZER-SCM GTC5235	...-SCM	MM12212264	●

Body	Designation	ø Milling cutter	z	Material number	Available
	C-SSM-H06-40.R.04-B32-50-110	40	4	MM11520454	●
	A-SSM-H06-40.R.04	40	4	MM11520455	●
	A-SSM-H06-50.R.05	50	5	MM11520456	●
	A-SSM-H06-63.R.06	63	6	MM11520457	●
	A-SSM-H06-80.R.07	80	7	MM11520458	●
	A-SSM-H06-100.R.09	100	9	MM11520459	●
	A-SSM-H06-125.R.10	125	10	MM11520460	●

Spare parts	Designation	Torque moment [Nm]	Material number	Available
	M4.0 x 11 – T15+	5	MM1345432	●
	Power screw M8.0 x 30.0 (only for A-SSM-H06-40.R.04)	15	MM11036880	●

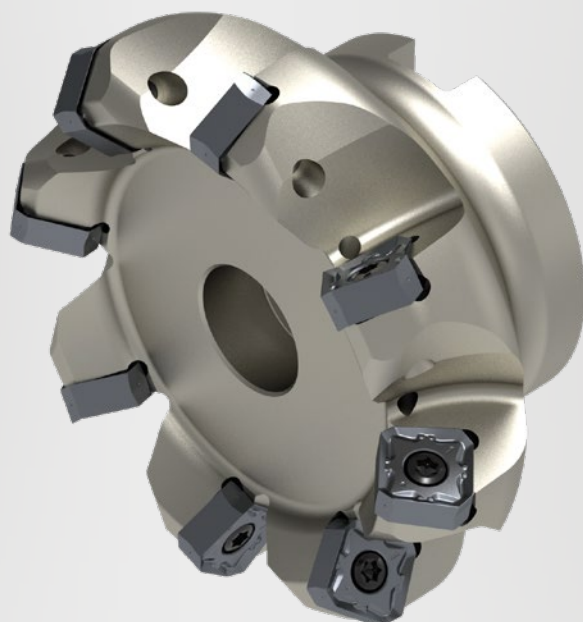
Cutting data HOKT... HOCT...

Starting parameters:



Grades and materials:

	Material group	Chipbreaker	Grade	v_c [m/min]	Cutting data f_z [mm]	a_p [mm]
P	Steel	HCM	GCP230 GPP235	220 – 60	0.12 – 0.35	4 – 0.3
M	Stainless steel	SCM	GPM240 GC5235	200 – 60	0.1 – 0.3	4 – 0.3



Overview SOKU

Application:

- 1) Face milling 2) Slot milling 3) Chamfering



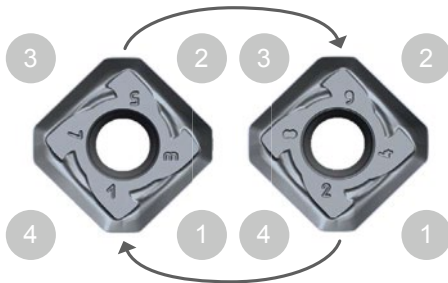
Chipbreaker:

HCM: Steel / Medium & roughing operations

SCM: Steel – Stainless Steel / Finishing

CCM: Cast iron

Indexing 4 times and reversible



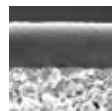
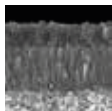
Grades:

GCP230 ■

GCP235 ■

GPP235 ■

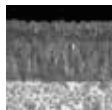
GPM240 ■



GC5235 ■

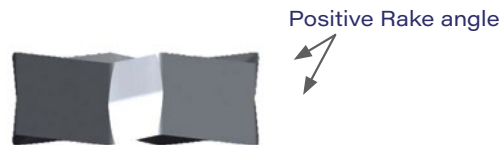
GCK215 ■

GPK220 ■



Customer benefits:

- ▲ Masterfinish" technology
- ▲ Double sided positive (positive rake angle)



Square double-sided insert!

Available in 2 dimensions:

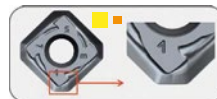


Which chipbreaker to use?



HCM

Strong cutting edge for general steel applications and hard conditions milling.



SCM

Sharp cutting edge for general stainless steel applications and for finishing in steels.



CCM

Strong cutting edge for cast iron applications.

Available range SOKU12

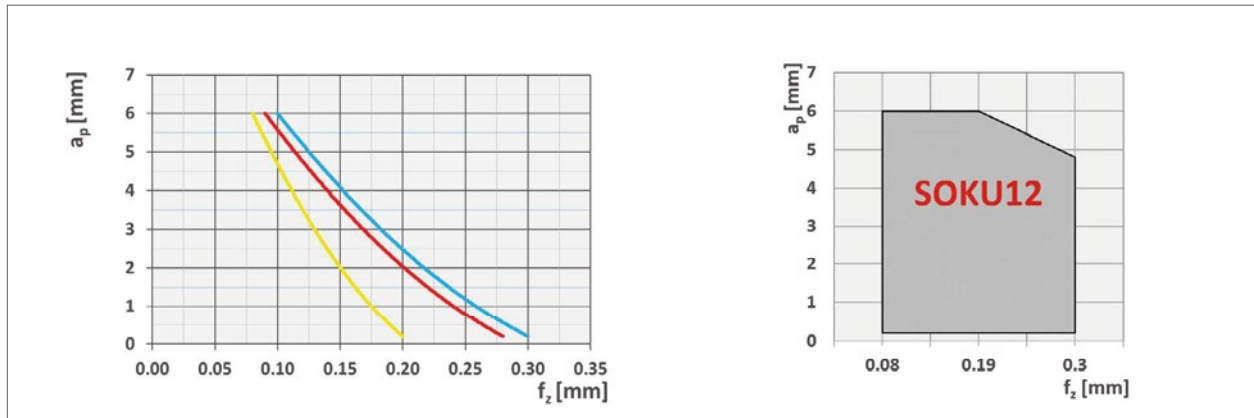
Insert	Designation	Chipbreaker	Material number	Available
	SOKU 1205AZER-HCM GTCP230	...-HCM	MM12193374	●
	SOKU 1205AZER-HCM GTCP235	...-HCM	MM12219854	●
	SOKU 1205AZER-HCM GTPP235	...-HCM	MM12193377	●
	SOKU 1205AZER-SCM GTPM240	...-SCM	MM11988963	●
	SOKU 1205AZER-SCM GTC5235	...-SCM	MM11906808	●
	SOKU 1205AZER-CCM GTCK215	...-CCM		○
	SOKU 1205AZER-CCM GTPK220	...-CCM		○

Body	Designation	ø Milling cutter	z	Material number	Available
	A-DSM-S12-40.R.04	40	4	MM11939775	●
	A-DSM-S12-50.R.05	50	5	MM11909357	●
	A-DSM-S12-63.R.06	63	6	MM11939774	●
	A-DSM-S12-80.R.08	80	8	MM11939772	●
	A-DSM-S12-100.R.10	100	10	MM11939771	●
	A-DSM-S12-125.R.12	125	12	MM11939769	●

Spare parts	Designation	Torque moment [Nm]	Material number	Available
	M4.0 x 11.0 – T15	5	MM11042274	●

Cutting data SOKU12

Starting parameters:



Grades and materials:

	Material group	Chipbreaker	Grade	v_c [m/min]	Cutting data f_z [mm]	a_p [mm]
P	Steel	HCM	GCP230	220 – 60	0.1 – 0.3	6 – 0.2
			GCP235			
			GPP235			
M	Stainless steel	SCM	GPM240	200 – 60	0.08 – 0.2	6 – 0.2
			GC5235			
K	Cast iron	CCM	GCK215	320 – 100	0.08 - 0.45	6 – 0.2
			GPK220			

Available range SOKU15

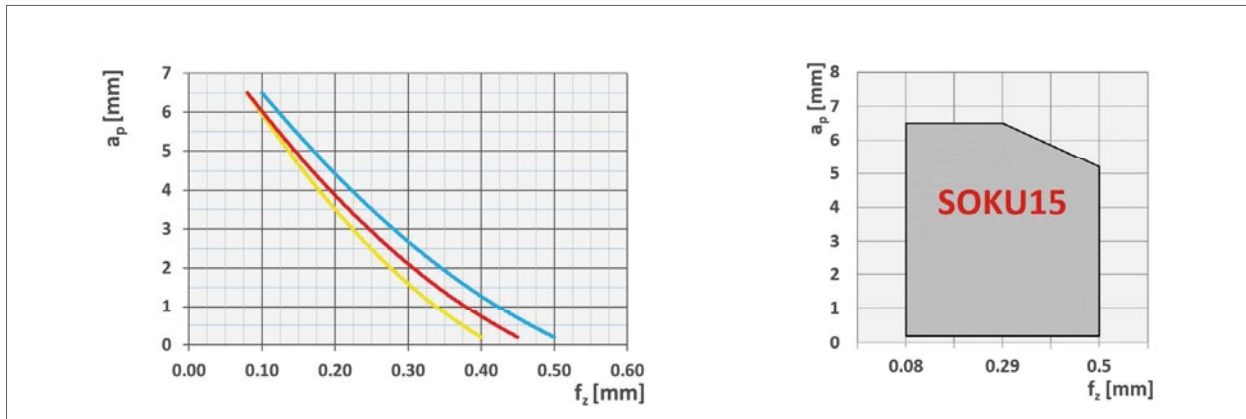
Insert	Designation	Chipbreaker	Material number	Available
	SOKU 1505AZER-HCM GTPC230	...-HCM	MM12237265	●
	SOKU 1505AZER-HCM GTPP235	...-HCM	MM12193379	●
	SOKU 1505AZER-HCM GTPC235	...-HCM	MM12219850	●
	SOKU 1505AZER-SCM GTPM240	...-SCM	MM11979060	●
	SOKU 1505AZER-SCM GTC5235	...-SCM	MM11526409	●
	SOKU 1505AZER-CCM GTCK215	...-CCM	MM12299379	●
	SOKU 1505AZER-CCM GTPK220	...-CCM	MM12145626	●

Body	Designation	ø Milling cutter	z	Material number	Available
	A-DSM-S15-40.R.04	40	4	MM11520461	●
	A-DSM-S15-50.R.04	50	4	MM11520462	●
	A-DSM-S15-63.R.05	63	5	MM11520463	●
	A-DSM-S15-80.R.06	80	6	MM11520464	●
	A-DSM-S15-100.R.07	100	7	MM11520465	●
	A-DSM-S15-125.R.08	125	8	MM11520466	●
	A-DSM-S15-160.R.10	160	10	MM11567193	●

Spare parts	Designation	Torque moment [Nm]	Material number	Available
	M4.5 x 13.0 – T20+	5	MM1345431	●
	Power screw M8.0 x 30.0 (only for A-DSM-S15.40.R.04)	15	MM1036880	●

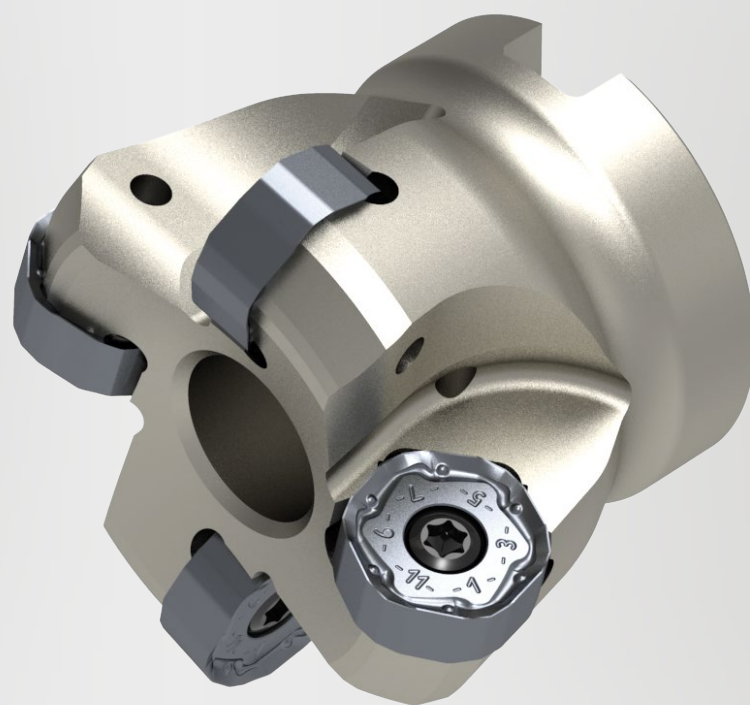
Cutting data SOKU15

Starting parameters:



Grades and materials

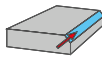
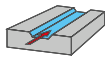
	Material group	Chipbreaker	Grade	v_c [m/min]	Cutting data f_z [mm]	a_p [mm]
P	Steel	HCM	GTCP230	220 – 60	0.1 – 0.5	6.5 – 0.2
			GTCP235			
			GTPP235			
M	Stainless steel	SCM	GTPM240	200 – 60	0.08 – 0.4	6.5 – 0.2
			GTC5235			
K	Cast iron	CCM	GTCK215	320 – 100	0.08 – 0.45	6.5 – 0.2
			GTPK220			



Overview HNKU / HOKU

Application:

- 1) Face milling 2) Slot milling 3) Chamfering

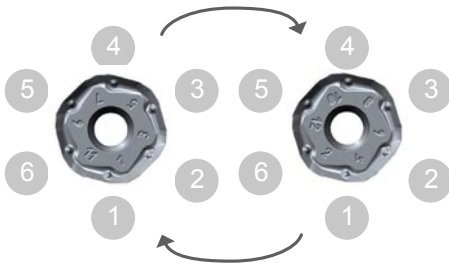


Chipbreaker:

HCM: Steel – Cast iron*

SCM: Stainless Steel – Exotic* – Titanium*

Indexing 6 times and reversible:



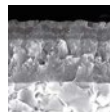
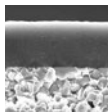
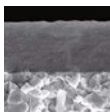
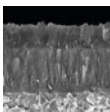
Grades:

GTCP230 ■

GTPP235 ■

GTPM240 ■

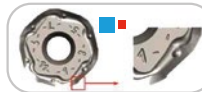
GTC5235 ■



Customer Benefits:

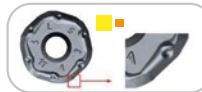
- ▲ Masterfinish geometry
- ▲ Maximised economy thanks to 12 cutting edges.

Which chipbreaker to use?



HCM

Strong cutting edge for general steel applications and hard conditions milling.



SCM

Sharp cutting edge for general stainless steel applications and for finishing in steels.

* secondary application

Available range HNKU

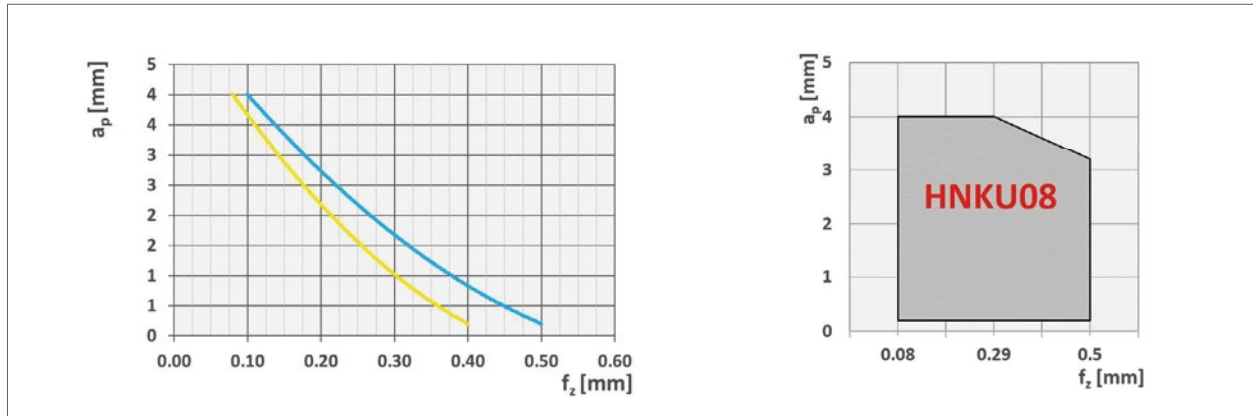
Insert	Designation	Chipbreaker	Material number	Available
	HNKU 0806AZER-HCM GTCP230	...-HCM	MM12193383	●
	HNKU 0806AZER-HCM GTPP235	...-HCM	MM12193384	●
	HNKU 0806AZER-SCM GTPM240	...-SCM		○
	HNKU 0806AZER-SCM GTC5235	...-SCM	MM11887368	●

Body	Designation	ø Milling cutter	z	Material number	Available
	A-DSM-H08-40.R.04	40	4	MM11590448	●
	A-DSM-H08-50.R.04	50	4	MM11561804	●
	A-DSM-H08-63.R.05	63	5	MM11561802	●
	A-DSM-H08-80.R.06	80	6	MM11561800	●
	A-DSM-H08-100.R.08	100	8	MM12152205	●
	A-DSM-H08-125.R.09	125	9	MM12152207	●

Spare parts	Designation	Torque moment [Nm]	Material number	Available
	M4.0 x 11.0 – T15+	5	MM1345432	●

Cutting data HNKU

Starting Parameters:



Grades and Materials:

				Cutting data		
	Material group	Chipbreaker	Grade	v_c [m/min]	f_z [mm]	a_p [mm]
P	Steel	HCM	GTCP230	220 – 60	0.1 – 0.5	4 – 0.2
			GTPP235			
M	Stainless steel	SCM	GTPM240	200 – 60	0.08 – 0.4	4 – 0.2
			GTC5235			

Available range HOKU

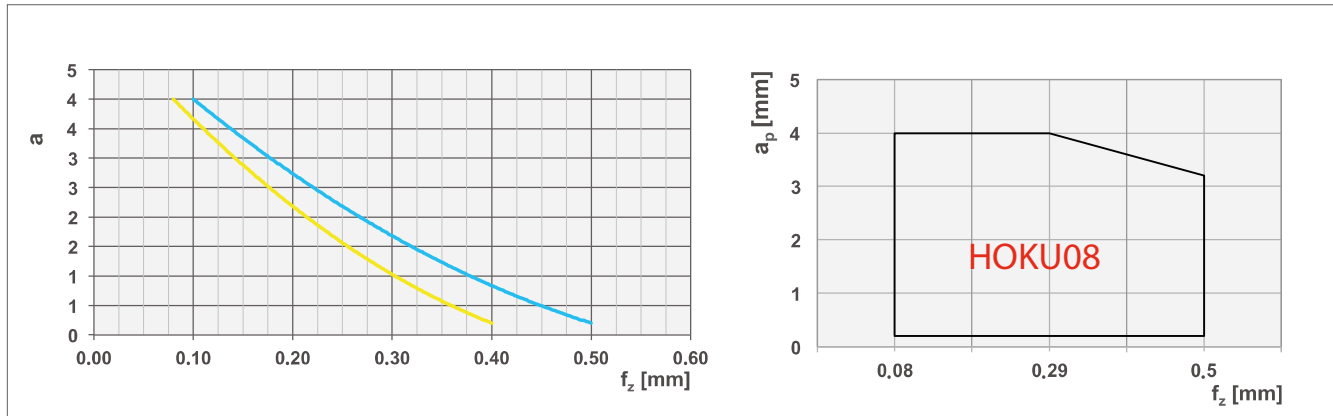
Insert	Designation	Chipbreaker	Material number	Available
	HOKU 0806AZER-HCM GTCP230	...-HCM	MM12623510	●
	HOKU 0806AZER-HCM GTPP235	...-HCM	MM12623511	●
	HOKU 0806AZER-SCM GTPM240	...-SCM	MM12630187	●
	HOKU 0806AZER-SCM GTC5235	...-SCM	MM12623507	●

Body	Designation	ø Milling cutter	z	Material number	Available
	A-DSM-H08-40.R.04	40	4	MM11590448	●
	A-DSM-H08-50.R.04	50	4	MM11561804	●
	A-DSM-H08-63.R.05	63	5	MM11561802	●
	A-DSM-H08-80.R.06	80	6	MM11561800	●
	A-DSM-H08-100.R.08	100	8	MM12152205	●
	A-DSM-H08-125.R.09	125	9	MM12152207	●

Spare parts	Designation	Torque moment [Nm]	Material number	Available
	M4.0 x 11.0 – T15+	5	1345432	●

Cutting data HOKU

Starting Parameters:



Grades and Materials:

				Cutting data		
	Material group	Chipbreaker	Grade	v_c [m/min]	f_z [mm]	a_p [mm]
P	Steel	HCM	GTCP230	220 – 60	0.1 – 0.5	4 – 0.2
			GTPP235			
M	Stainless steel	SCM	GTPM240	200 – 60	0.08 – 0.4	4 – 0.2
			GTC5235			