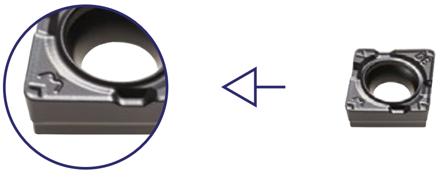
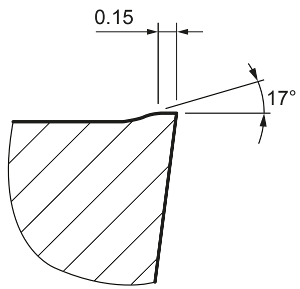
New Chipbreaker

Optimised by FEM:

- ▲ Positive **Masterfinish** geometry
- ▲ High surface quality



Example: CCMX 09T308-PWX



Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	GTCP125 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	170 – 240
		Low-alloyed steel	250 – 300	100 – 190
		High-alloyed steel	200	130 – 210
		Corrosion-resistant steel	200	130 – 210
M	Stainless steel	Ferritic	200	140 – 210
		Austenitic	180	100 – 210
		Duplex	230 – 260	–
		Martensitic	330	70 – 100
K	Cast iron	Grey cast iron	180	130 – 210
		Spheroidal cast iron	160	120 – 240
		Malleable/tempered iron	130	150 – 250

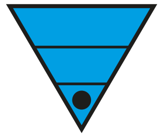
Application	Depth of cut / feed rate	
Chip groove	a_p [mm]	f [mm]
PWX	1 to 3.5	0.3 to 0.15

Ex: CCMX 09T308-PWX for CK60
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	○	X

Available Range

MASTERFINISH



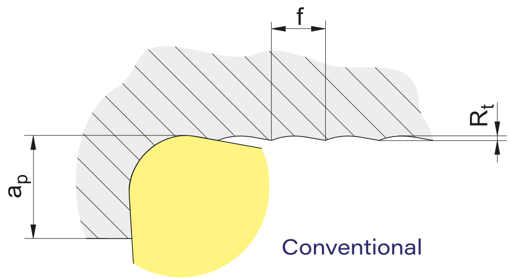
Steel extreme finishing – Masterfinish

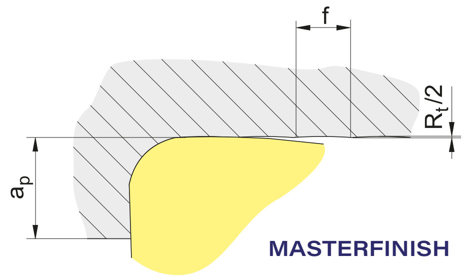
Insert	Designation	Chipbreaker	Material number	Available
	CCMX 09T304-PWXGTCP125	...-PWX	MM12078108	●
	CCMX 09T308-PWXGTCP125		MM12078100	●
	DCMX 070204-PWXGTCP125		MM12078103	●
	DCMX 11T304-PWX GTCP125		MM12078101	●
	DCMX 11T308-PWX GTCP125		MM12086875	●

Operating Principle

Improved surface finish:

With the same feed rate an insert with Masterfinish cutting edge reaches a roughness value R_a which is many times higher than the one of a conventional insert.



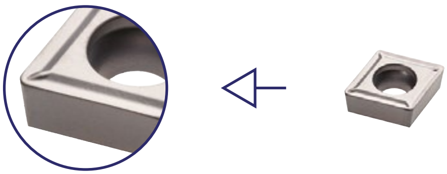


● available from stock, ○ available upon request

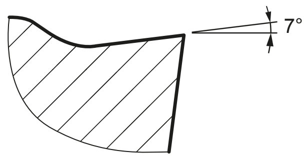
New Chipbreaker

Optimised by FEM:

- Increase life time
- Reduce temperature and stress



Example: DCMT 11T304-JF



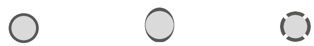
Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Cermet TCM10 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	230 – 270
		Low-alloyed steel	250 – 300	180 – 230
		High-alloyed steel	200	160 – 200
		Corrosion-resistant steel	200	230 – 270
M	Stainless steel	Ferritic	200	170 – 240
		Austenitic	180	200 – 240
		Duplex	230 – 260	–
		Martensitic	330	130 – 160
K	Cast iron	Grey cast iron	180	–
		Spheroidal cast iron	160	220 – 300
		Malleable/tempered iron	130	250 – 350

Application	Depth of cut / feed rate	
Chip groove	a_p [mm]	f [mm]
JF	0.10 to 1.65	0.20 to 0.05

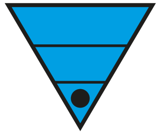
Ex: CCMT 09T304-JF
Different in each application



Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	X	X

Available Range

Turning steel pos finishing CERMET:



Insert	Designation	Chipbreaker	Material number	Available
	CCMT 060204-JFTCM10		MM11619142	●
	CCMT 09T304-JFTCM10		MM11619132	●
	DCMT 070204-JFTCM10		MM11619127	●
	DCMT 11T304-JF TCM10	... -JF	MM11619131	●
	TCGT 110202-JF TCM10		MM11622263	●
	TCMT 110204-JF TCM10		MM11619126	●
	WCGT 020102-JF TCM10		MM11619140	●

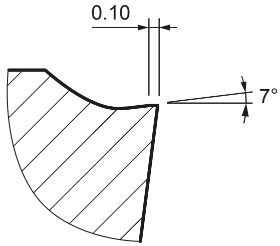
● available from stock, ○ available upon request

New Chipbreaker

WSF+:

▲ To optimise chip control

Example: CCMT 09T308-WSF+



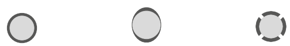
Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCP115 v_c [m/min]	Coated carbide GTCP125HP v_c [m/min]	Coated carbide GTCP125 v_c [m/min]	Coated carbide GTCP135 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	220 – 400	200 – 270	170 – 240	170 – 190
P	Steel	Low-alloyed steel	250 – 300	200 – 320	115 – 210	100 – 190	90 – 150
P	Steel	High-alloyed steel	200	180 – 320	150 – 240	130 – 210	120 – 200
P	Steel	Corrosion-resistant steel	200	200 – 320	150 – 240	130 – 210	140 – 180
M	Stainless steel	Ferritic	200	220 – 320	160 – 240	140 – 210	140 – 200
M	Stainless steel	Austenitic	180	–	115 – 240	100 – 210	110 – 190
M	Stainless steel	Duplex	230 – 260	–	–	–	80 – 150
M	Stainless steel	Martensitic	330	–	80 – 115	70 – 100	55 – 75
K	Cast iron	Grey cast iron	180	140 – 370	150 – 240	130 – 210	–
K	Cast iron	Spheroidal cast iron	160	190 – 430	140 – 270	120 – 240	–
K	Cast iron	Malleable/tempered iron	130	180 – 520	170 – 290	150 – 250	–

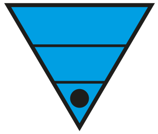
Application Chip groove	Depth of cut / feed rate a_p [mm]	Depth of cut / feed rate f [mm]
WSF+	0.50 to 2.25	0.14 to 0.07

Ex: CCMT 09T304-WSF+ for CK60
Different in each application



Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
X	○	X

Available Range



Turning steel pos finishing "P15":

Insert	Designation	Chipbreaker	Material number	Available
	CCMT 060204-WSF+ GTCP115		MM12030470	●
	CCMT 09T304-WSF+ GTCP115		MM12030511	●
	CCMT 09T308-WSF+ GTCP115		MM12030567	●
	CCMT 120404-WSF+ GTCP115	...-WSF+	MM12030568	●
	DCMT 070204-WSF+ GTCP115		MM12030692	●
	DCMT 11T304-WSF+ GTCP115		MM12167861	●

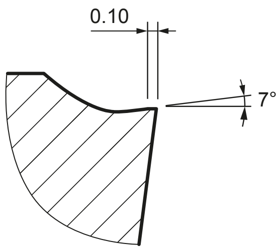
● available from stock, ○ available upon request

New Chipbreaker

WSF+:

▲ To optimise chip control

Example: CCMT 09T308-WSF+



Cutting Data

General cutting parameters depending on the application:

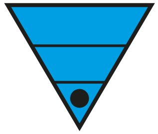
Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCP115 v_c [m/min]	GTCP125HP v_c [m/min]	GTCP125 v_c [m/min]	GTCP135 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	220 – 400	200 – 270	170 – 240	170 – 190
		Low-alloyed steel	250 – 300	200 – 320	115 – 210	100 – 190	90 – 150
		High-alloyed steel	200	180 – 320	150 – 240	130 – 210	120 – 200
		Corrosion-resistant steel	200	200 – 320	150 – 240	130 – 210	140 – 180
M	Stainless steel	Ferritic	200	220 – 320	160 – 240	140 – 210	140 – 200
		Austenitic	180	–	115 – 240	100 – 210	110 – 190
		Duplex	230 – 260	–	–	–	80 – 150
		Martensitic	330	–	80 – 115	70 – 100	55 – 75
K	Cast iron	Grey cast iron	180	140 – 370	150 – 240	130 – 210	–
		Spheroidal cast iron	160	190 – 430	140 – 270	120 – 240	–
		Malleable/tempered iron	130	180 – 520	170 – 290	150 – 250	–

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
WSF+	0.50 to 2.25	0.14 to 0.07

Ex: CCMT 09T304-WSF+ for CK60
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
X	○	X

Available Range



Turning steel pos finishing "P25":

Insert	Designation		Chipbreaker	Material number	Available
	CCMT 060202-WSF+	GTCP125		MM11684867	●
	CCMT 060204-WSF+	GTCP125		MM11684913	●
	CCMT 09T302-WSF+	GTCP125		MM11684916	●
	CCMT 09T304-WSF+	GTCP125		MM11684923	●
	CCMT 09T308-WSF+	GTCP125		MM11684931	●
	DCMT 070202-WSF+	GTCP125		MM11684952	●
	DCMT 070204-WSF+	GTCP125	...-WSF+	MM11684953	●
	DCMT 11T302-WSF+	GTCP125		MM11812677	●
	DCMT 11T304-WSF+	GTCP125		MM11686178	●
	DCMT 11T308-WSF+	GTCP125		MM11686185	●
	VCMT 110302-WSF+	GTCP125		MM11812680	●
	VCMT 110304-WSF+	GTCP125		MM11855132	●
	VCMT 160404-WSF+	GTCP125		MM11812683	●
	VCMT 160408-WSF+	GTCP125		MM12077363	●

● available from stock, ○ available upon request

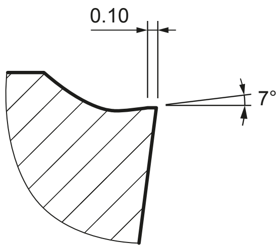
New Chipbreaker

NEW

WSF+:

▲ To optimise chip control

Example: CCMT 09T308-WSF+



Cutting Data

General cutting parameters depending on the application:

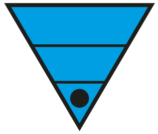
Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCP115 v_c [m/min]	GTCP125HP v_c [m/min]	GTCP125 v_c [m/min]	GTCP135 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	220 – 400	200 – 270	170 – 240	170 – 190
		Low-alloyed steel	250 – 300	200 – 320	115 – 210	100 – 190	90 – 150
		High-alloyed steel	200	180 – 320	150 – 240	130 – 210	120 – 200
		Corrosion-resistant steel	200	200 – 320	150 – 240	130 – 210	140 – 180
M	Stainless steel	Ferritic	200	220 – 320	160 – 240	140 – 210	140 – 200
		Austenitic	180	–	115 – 240	100 – 210	110 – 190
		Duplex	230 – 260	–	–	–	80 – 150
		Martensitic	330	–	80 – 115	70 – 100	55 – 75
K	Cast iron	Grey cast iron	180	140 – 370	150 – 240	130 – 210	–
		Spheroidal cast iron	160	190 – 430	140 – 270	120 – 240	–
		Malleable/tempered iron	130	180 – 520	170 – 290	150 – 250	–

Application Chip groove	Depth of cut a_p [mm]	Feed rate f [mm]
WSF+	0.50 to 2.25	0.14 to 0.07

Ex: CCMT 09T304-WSF+ for CK60
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
X	○	X

Available Range



Turning steel pos finishing "P25":

Insert	Designation	Chipbreaker	Material number	Available
	CCMT 060202-WSF+ GTCP125HP	...-WSF+	MM14659047	●
	CCMT 060204-WSF+ GTCP125HP		MM14659053	●
	CCMT 09T302-WSF+ GTCP125HP		MM14659058	●
	CCMT 09T304-WSF+ GTCP125HP		MM14659061	●
	CCMT 09T308-WSF+ GTCP125HP		MM14659065	●
	DCMT 070202-WSF+ GTCP125HP		MM14659070	●
	DCMT 070204-WSF+ GTCP125HP		MM14659109	●
	DCMT 11T302-WSF+ GTCP125HP		MM14659133	●
	DCMT 11T304-WSF+ GTCP125HP		MM14659135	●
	DCMT 11T308-WSF+ GTCP125HP		MM14659138	●

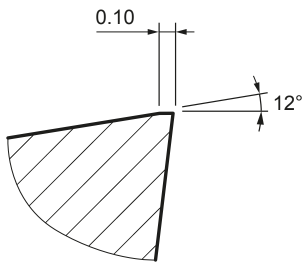
● available from stock, ○ available upon request

New Chipbreaker

Optimised by FEM:

- Increase life time
- Reduce temperature and stress
- Universal application

Example: CCMT 09T308-WM+



Cutting Data

General cutting parameters depending on the application:

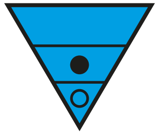
Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCP115 v_c [m/min]	GTCP125HP v_c [m/min]	GTCP125 v_c [m/min]	GTCP135 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	220 – 400	200 – 270	170 – 240	170 – 190
		Low-alloyed steel	250 – 300	200 – 320	115 – 210	100 – 190	90 – 150
		High-alloyed steel	200	180 – 320	150 – 240	130 – 210	120 – 200
		Corrosion-resistant steel	200	200 – 320	150 – 240	130 – 210	140 – 180
M	Stainless steel	Ferritic	200	220 – 320	160 – 240	140 – 210	140 – 200
		Austenitic	180	–	115 – 240	100 – 210	110 – 190
		Duplex	230 – 260	–	–	–	80 – 150
		Martensitic	330	–	80 – 115	70 – 100	55 – 75
K	Cast iron	Grey cast iron	180	140 – 370	150 – 240	130 – 210	–
		Spheroidal cast iron	160	190 – 430	140 – 270	120 – 240	–
		Malleable/tempered iron	130	180 – 520	170 – 290	150 – 250	–

Application Chip groove	Depth of cut a_p [mm]	Feed rate f [mm]
WM+	0.50 to 3.00	0.21 to 0.12

Ex: CCMT 09T304-WM+ for CK60
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	○	X

Available Range



Turning steel pos semi finishing "P15":

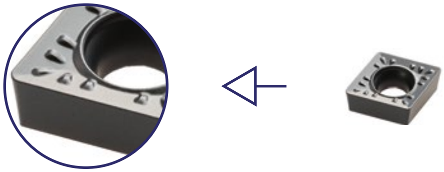
Insert	Designation	Chipbreaker	Material number	Available
	CCMT 060204-WM+ GTCP115	...-WM+	MM11865625	●
	CCMT 060208-WM+ GTCP115		MM12064721	●
	CCMT 09T304-WM+ GTCP115		MM11888980	●
	CCMT 09T308-WM+ GTCP115		MM11888982	●
	DCMT 11T304-WM+ GTCP115		MM11865628	●
	DCMT 11T308-WM+ GTCP115		MM11865630	●
	SCMT 120404-WM+ GTCP115		MM11865632	●
	TCMT 110204-WM+ GTCP115		MM12030597	●
	VBMT 160404-XM1+ GTCP115T	...-XM1+	MM12057972	●

● available from stock, ○ available upon request

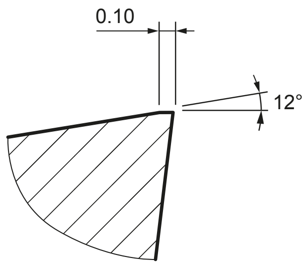
New Chipbreaker

Optimised by FEM:

- ▲ Increase life time
- ▲ Reduce temperature and stress
- ▲ Universal application



Example: CCMT 09T308-WM+



Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCP115 v_c [m/min]	GTCP125HP v_c [m/min]	GTCP125 v_c [m/min]	GTCP135 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	220 – 400	200 – 270	170 – 240	170 – 190
P	Steel	Low-alloyed steel	250 – 300	200 – 320	115 – 210	100 – 190	90 – 150
P	Steel	High-alloyed steel	200	180 – 320	150 – 240	130 – 210	120 – 200
P	Steel	Corrosion-resistant steel	200	200 – 320	150 – 240	130 – 210	140 – 180
M	Stainless steel	Ferritic	200	220 – 320	160 – 240	140 – 210	140 – 200
M	Stainless steel	Austenitic	180	–	115 – 240	100 – 210	110 – 190
M	Stainless steel	Duplex	230 – 260	–	–	–	80 – 150
M	Stainless steel	Martensitic	330	–	80 – 115	70 – 100	55 – 75
K	Cast iron	Grey cast iron	180	140 – 370	150 – 240	130 – 210	–
K	Cast iron	Spheroidal cast iron	160	190 – 430	140 – 270	120 – 240	–
K	Cast iron	Malleable/tempered iron	130	180 – 520	170 – 290	150 – 250	–

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
WM+	0.50 to 3.00	0.21 to 0.12

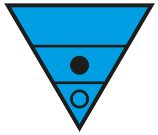
Ex: CCMT 09T304-WM+ for CK60

Different in each application

Consistent cutting depth	**Inconsistent cutting depth**	**Interrupted cut**
●	●	○

Available Range

Turning steel pos medium "P25":



Insert	Designation	Chipbreaker	Material number	Available
	CCMT 060204-WM+ GTCP125	...-WM+	MM11748108	●
	CCMT 060208-WM+ GTCP125		MM11748110	●
	CCMT 09T304-WM+ GTCP125		MM11748112	●
	CCMT 09T308-WM+ GTCP125		MM11748114	●
	CCMT 120404-WM+ GTCP125		MM11748116	●
	CCMT 120408-WM+ GTCP125		MM11748118	●
	CCMT 120412-WM+ GTCP125		MM11748120	●
	DCMT 070204-WM+ GTCP125		MM11748124	●
	DCMT 070208-WM+ GTCP125		MM11748127	●
	DCMT 11T304-WM+ GTCP125		MM11748129	●
	DCMT 11T308-WM+ GTCP125		MM11748131	●
	SCMT 09T304-WM+ GTCP125		MM11748539	●
	SCMT 09T308-WM+ GTCP125		MM11748556	●
	SCMT 120404-WM+ GTCP125		MM11748562	●
	SCMT 120408-WM+ GTCP125		MM11748566	●
	SCMT 120412-WM+ GTCP125		MM11748579	●
	TCMT 090204-WM+ GTCP125		MM11748602	●
	TCMT 110204-WM+ GTCP125		MM11748607	●
	TCMT 110208-WM+ GTCP125		MM11748609	●
	TCMT 16T304-WM+ GTCP125		MM11748620	●
	TCMT 16T308-WM+ GTCP125		MM11748622	●
	TCMT 16T312-WM+ GTCP125		MM11748625	●
	VCMT 110304-WM+ GTCP125		MM11749275	●
	VCMT 110308-WM+ GTCP125		MM11749283	●
	VCMT 160404-WM+ GTCP125		MM11687010	●
	VCMT 160408-WM+ GTCP125		MM11687012	●
	VBMT 160404-XM1+ GTCP125	...-XM1+	MM11687006	●
	VBMT 160408-XM1+ GTCP125		MM11687008	●
	WCMT 040204-WM+ GTCP125	...-WM+	MM11749299	●
	WCMT 040208-WM+ GTCP125		MM11749304	●
	WCMT 06T304-WM+ GTCP125		MM11749313	●
	WCMT 06T308-WM+ GTCP125		MM11749317	●
	WCMT 080404-WM+ GTCP125		MM11749333	●
	WCMT 080408-WM+ GTCP125		MM11749336	●
	WCMT 080412-WM+ GTCP125		MM11749340	●

● available from stock, ○ available upon request

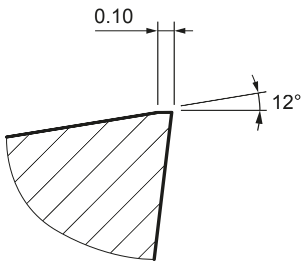
New Chipbreaker

NEW

Optimised by FEM:

- Increase life time
- Reduce temperature and stress
- Universal application

Example: CCMT 09T308-WM+



Cutting Data

General cutting parameters depending on the application:

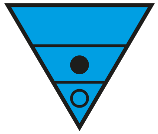
Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCP115 v_c [m/min]	GTCP125HP v_c [m/min]	GTCP125 v_c [m/min]	GTCP135 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	220 – 400	200 – 270	170 – 240	170 – 190
		Low-alloyed steel	250 – 300	200 – 320	115 – 210	100 – 190	90 – 150
		High-alloyed steel	200	180 – 320	150 – 240	130 – 210	120 – 200
		Corrosion-resistant steel	200	200 – 320	150 – 240	130 – 210	140 – 180
M	Stainless steel	Ferritic	200	220 – 320	160 – 240	140 – 210	140 – 200
		Austenitic	180	–	115 – 240	100 – 210	110 – 190
		Duplex	230 – 260	–	–	–	80 – 150
		Martensitic	330	–	80 – 115	70 – 100	55 – 75
K	Cast iron	Grey cast iron	180	140 – 370	150 – 240	130 – 210	–
		Spheroidal cast iron	160	190 – 430	140 – 270	120 – 240	–
		Malleable/tempered iron	130	180 – 520	170 – 290	150 – 250	–

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
WM+	0.50 to 3.00	0.21 to 0.12

Ex: CCMT 09T304-WM+ for CK60
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	●	○

Available Range



Turning steel pos medium "P25":

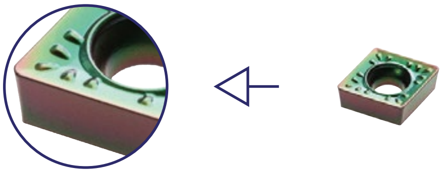
Insert	Designation	Chipbreaker	Material number	Available
	CCMT 060204-WM+ GTCP125HP	...-WM+	MM14658964	●
	CCMT 09T304-WM+ GTCP125HP		MM12360829	●
	CCMT 09T308-WM+ GTCP125HP		MM12360832	●
	CCMT 120404-WM+ GTCP125HP		MM14658965	●
	CCMT 120408-WM+ GTCP125HP		MM12310818	
	CCMT 120412-WM+ GTCP125HP		MM14658969	●
	DCMT 070204-WM+ GTCP125HP		MM14659032	●
	DCMT 11T304-WM+ GTCP125HP		MM14659038	●
	DCMT 11T308-WM+ GTCP125HP		MM14659043	●

● available from stock, ○ available upon request

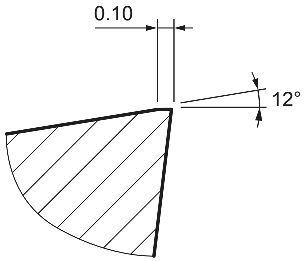
New Chipbreaker

Optimised by FEM:

- ▲ Increase life time
- ▲ Reduce temperature and stress
- ▲ Universal application



Example: CCMT 09T308-WM+



Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCP115 v_c [m/min]	GTCP125HP v_c [m/min]	GTCP125 v_c [m/min]	GTCP135 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	220 – 400	200 – 270	170 – 240	170 – 190
		Low-alloyed steel	250 – 300	200 – 320	115 – 210	100 – 190	90 – 150
		High-alloyed steel	200	180 – 320	150 – 240	130 – 210	120 – 200
		Corrosion-resistant steel	200	200 – 320	150 – 240	130 – 210	140 – 180
M	Stainless steel	Ferritic	200	220 – 320	160 – 240	140 – 210	140 – 200
		Austenitic	180	–	115 – 240	100 – 210	110 – 190
		Duplex	230 – 260	–	–	–	80 – 150
		Martensitic	330	–	80 – 115	70 – 100	55 – 75
K	Cast iron	Grey cast iron	180	140 – 370	150 – 240	130 – 210	–
		Spheroidal cast iron	160	190 – 430	140 – 270	120 – 240	–
		Malleable/tempered iron	130	180 – 520	170 – 290	150 – 250	–

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
WM+	0.50 to 3.00	0.21 to 0.12

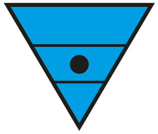
Ex: CCMT 09T304-WM+ for CK60

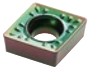
Different in each application

Consistent cutting depth	**Inconsistent cutting depth**	**Interrupted cut**
●	●	○

Available Range

Turning steel pos medium "P35":



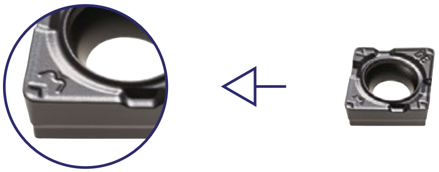
Insert	Designation		Chipbreaker	Material number	Available
	CCMT 060204-WM+	GTCP135		MM11854303	●
	CCMT 060208-WM+	GTCP135		MM11854307	●
	CCMT 09T304-WM+	GTCP135		MM11854315	●
	CCMT 09T308-WM+	GTCP135		MM11854322	●
	DCMT 070204-WM+	GTCP135		MM11854804	●
	DCMT 070208-WM+	GTCP135		MM11854807	●
	DCMT 11T304-WM+	GTCP135		MM11854850	●
	DCMT 11T308-WM+	GTCP135		MM11854863	●
	RCMT 0803MO-WM+	GTCP135		MM11882921	●
	RCMT 1003MO-WM+	GTCP135		MM11882920	●
	RCMT 1204MO-WM+	GTCP135	...-WM+	MM11855077	●
	SCMT 09T308-WM+	GTCP135		MM11855088	●
	SCMT 120408-WM+	GTCP135		MM11855090	●
	SCMT 120412-WM+	GTCP135		MM11855099	●
	TCMT 110204-WM+	GTCP135		MM11873284	●
	TCMT 110208-WM+	GTCP135		MM11873281	●
	TCMT 16T304-WM+	GTCP135		MM11855125	●
	TCMT 16T308-WM+	GTCP135		MM11855126	●
	VCMT 110304-WM+	GTCP135		MM11873280	●
	VCMT 110308-WM+	GTCP135		MM11873279	●
	VCMT 160404-WM+	GTCP135		MM11855136	●
	VCMT 160408-WM+	GTCP135		MM11855137	●

● available from stock, ○ available upon request

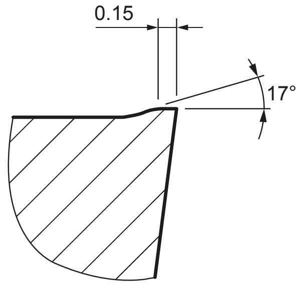
New Chipbreaker

Optimised by FEM:

- Positive **Masterfinish** geometry
- High surface quality



Example: CCMX 09T308-PWX



Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	GTCP125 v_c [m/min]	GTCP135 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	170 – 240	170 – 190
		Low-alloyed steel	250 – 300	100 – 190	90 – 150
		High-alloyed steel	200	130 – 210	120 – 200
		Corrosion-resistant steel	200	130 – 210	140 – 180
M	Stainless steel	Ferritic	200	140 – 210	140 – 200
		Austenitic	180	100 – 210	110 – 190
		Duplex	230 – 260	–	80 – 150
		Martensitic	330	70 – 100	55 – 75
K	Cast iron	Grey cast iron	180	130 – 210	–
		Spheroidal cast iron	160	120 – 240	–
		Malleable/tempered iron	130	150 – 250	–

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
PWX	1 to 3.50	0.30 to 0.15

Ex: CCMX 09T308-PWX for 304
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	○	X

Available Range

MASTERFINISH

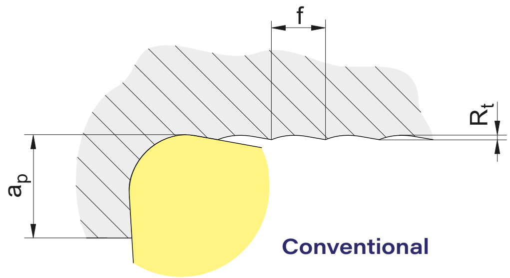
Heavy turning steel pos "P35" – Masterfinish:

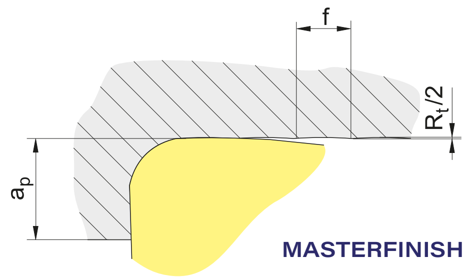
Insert	Designation	Chipbreaker	Material number	Available
	CCMX 09T304-PWXGTPM135M	...-PWX	MM12078102	●
	CCMX 09T308-PWXGTPM135M		MM12078097	●
	DCMX 11T304-PWX GTPM135M		MM12078099	●
	DCMX 11T308-PWX GTPM135M		MM12078094	●

Operating Principle

Improved surface finish

With the same feed rate an insert with Masterfinish cutting edge reaches a roughness value R_a which is many times higher than the one of a conventional insert.

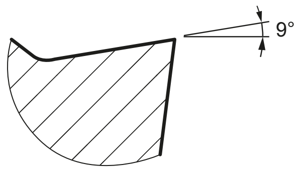




● available from stock, ○ available upon request

Cutting Data

Example: CCGT 09T301EN-EF



General cutting parameters depending on the application:

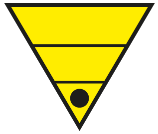
Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTP2120 v_c [m/min]
M	Stainless steel	Ferritic	200	150 – 200
		Austenitic	180	120 – 200
		Duplex	230 – 260	90 – 160
		Martensitic	330	60 – 80
K	Cast iron	Grey cast iron	180	120 – 160
		Spheroidal cast iron	160	120 – 160
		Malleable/tempered iron	130	140 – 220
	Non Ferrous		100	100 – 400
			130	100 – 400
			90	100 – 600
			100	100 – 400
	Exotic materials	Fe base	200	20 – 50
		Nickel or cobalt base	280	20 – 50
		Nickel or cobalt base	250	15 – 40
		Nickel or cobalt base		20 – 35
		Titanium	Rm 440*	80 – 140

Application / Chip groove	Depth of cut a_p [mm]	feed rate f [mm]
EN-EF	0.05 to 1.35	0.02 to 0.10

Ex: CCGT 09T0301EN-EF for 304
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	X	X

Available range



Turning stainless steel pos "Extreme finishing":

Insert	Designation		Chipbreaker	Material number	Available
	CCGT 060200EN-EF	GTP2120	...EN-EF	MM11204029	●
	CCGT 060201EN-EF	GTP2120		MM11203024	●
	CCGT 09T300EN-EF	GTP2120		MM11204030	●
	CCGT 09T301EN-EF	GTP2120		MM11203027	●
	DCGT 070200EN-EF	GTP2120		MM11204031	●
	DCGT 070201EN-EF	GTP2120		MM11203028	●
	DCGT 11T300EN-EF	GTP2120		MM11204035	●
	DCGT 11T301EN-EF	GTP2120		MM11203030	●
	VCGT 110300EN-EF	GTP2120		MM11204036	●
	VCGT 110301EN-EF	GTP2120		MM11203033	●
	VCGT 160400EN-EF	GTP2120		MM11204037	●
	VCGT 160401EN-EF	GTP2120		MM11203034	●

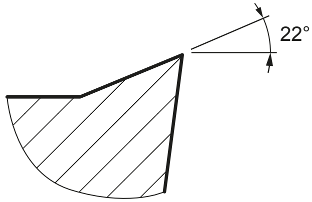
● available from stock, ○ available upon request

New Chipbreaker

Optimised by FEM:

- ▲ Increased tool life
- ▲ Small feed rate when bar turning

Example: CCGT 120408FN-LMF+



Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide 1279 v_c [m/min]
K	Cast iron	Grey cast iron	180	–
		Spheroidal cast iron	160	–
		Malleable/tempered iron	130	–
	Non Ferrous		100	100 – 2000
			130	100 – 800
			90	100 – 600
			100	100 – 300
	Exotic materials	Fe base	200	30 – 45
		Nickel or cobalt base	280	20 – 35
		Nickel or cobalt base	250	20 – 35
		Nickel or cobalt base		18 – 30
		Titanium	Rm 440*	60 – 120

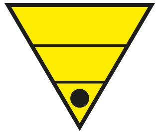
Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
LMF+	0.05 to 1.35	0.02 to 0.10

Ex: CCGT 120408FN-LMF+ for 304

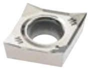
Different in each application

Consistent cutting depth	**Inconsistent cutting depth**	**Interrupted cut**
●	●	○

Available Range



Turning stainless steel pos finishing "M15":

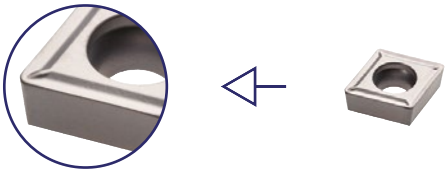
Insert	Designation		Chipbreaker	Material number	Available
	CCGT 060201FN-LMF+	1279		MM11973505	●
	CCGT 060202FN-LMF+	1279		MM11969606	●
	CCGT 060202FN-LMF+	1279		MM11969605	●
	CCGT 09T302FN-LMF+	1279		MM11969607	●
	CCGT 09T304FN-LMF+	1279		MM11969604	●
	CCGT 09T308FN-LMF+	1279		MM11969600	●
	CCGT 120404FN-LMF+	1279		MM11969598	●
	CCGT 120408FN-LMF+	1279		MM11969596	●
	DCGT 070201FN-LMF+	1279		MM11969599	●
	DCGT 070202FN-LMF+	1279		MM11969597	●
	DCGT 070204FN-LMF+	1279		MM11969595	●
	DCGT 11T302FN-LMF+	1279		MM11969591	●
	DCGT 11T304FN-LMF+	1279		MM11969585	●
	DCGT 11T308FN-LMF+	1279	...-LMF+	MM11969579	●
	SCGT 09T304FN-LMF+	1279		MM11969578	●
	SCGT 09T308FN-LMF+	1279		MM12042223	●
	SCGT 120408FN-LMF+	1279		MM12049241	●
	TCGT 110204FN-LMF+	1279		MM12044368	●
	VCGT 110302FN-LMF+	1279		MM11969577	●
	VCGT 110304FN-LMF+	1279		MM11969575	●
	VCGT 130302FN-LMF+	1279		MM11969568	●
	VCGT 130304FN-LMF+	1279		MM11969566	●
	VCGT 160404FN-LMF+	1279		MM11969535	●
	VCGT 160408FN-LMF+	1279		MM11969529	●
	VCGT 160412FN-LMF+	1279		MM11969360	●

● available from stock, ○ available upon request

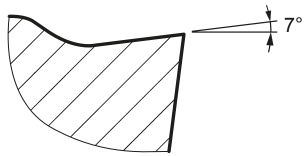
New Chipbreaker

Optimised by FEM:

- ▲ Increased tool life
- ▲ Small feed rate when bar turning



Example: DCMT 11T304-JF



Cutting Data

General cutting parameters depending on the application:

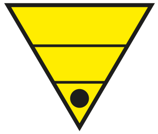
Work piece material		Type of treatment / alloy	Hardness HB	Cermet TCM10 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	230 – 270
P	Steel	Low-alloyed steel	250 – 300	180 – 230
P	Steel	High-alloyed steel	200	160 – 200
P	Steel	Corrosion-resistant steel	200	230 – 270
M	Stainless steel	Ferritic	200	170 – 240
M	Stainless steel	Austenitic	180	200 – 240
M	Stainless steel	Duplex	230 – 260	–
M	Stainless steel	Martensitic	330	130 – 160
K	Cast iron	Grey cast iron	180	–
K	Cast iron	Spheroidal cast iron	160	220 – 300
K	Cast iron	Malleable/tempered iron	130	250 – 350

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
JF	0.10 to 1.65	0.20 to 0.05

Ex: CCMT 09T304-JF
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
•	X	X

Available Range



Turning stainless steel pos finishing "CERMET":

Insert	Designation		Chipbreaker	Material number	Available
	CCMT 060204-JF	TCM10	... -JF	MM11619142	●
	CCMT 09T304-JF	TCM10		MM11619132	●
	DCMT 070204-JF	TCM10		MM11619127	●
	DCMT 11T304-JF	TCM10		MM11619131	●
	TCGT 110202-JF	TCM10		MM11622263	●
	TCMT 110204-JF	TCM10		MM11619126	●
	WCGT 020102-JF	TCM10		MM11619140	●

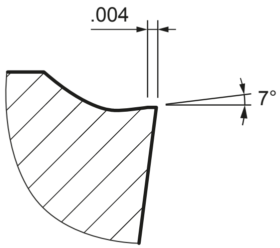
● available from stock, ○ available upon request

New Chipbreaker

WSF+:

▲ To optimise chip control

Example: CCMT 09T308-WSF+



Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCM120HP v_c [m/min]	GTPM125 v_c [m/min]	GTPM135M v_c [m/min]
P	Steel	non-alloyed steel 0 – 0.45% C	150 – 250	150 – 250	130 – 250	150 – 190
		low-alloyed steel	250 – 300	100 – 200	60 – 180	90 – 150
		high-alloyed steel	200	120 – 220	80 – 200	120 – 200
		corrosion-resistant steel	200	120 – 220	100 – 200	140 – 180
M	Stainless steel	Ferritic	200	190 – 250	120 – 250	140 – 200
		Austenitic	180	140 – 220	100 – 220	110 – 190
		Duplex	230 – 260	110 – 170	60 – 160	80 – 150
		Martensitic	330	40 – 100	40 – 100	55 – 75

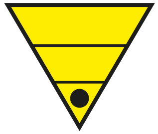
Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
WSF+	0.15 to 2.25	0.20 to 0.07

Ex: CCMT 09T304-WSF+ for 304
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	○	X

Available Range

Turning steel pos finishing "M20":



Insert	Designation		Chipbreaker	Material number	Available
	CCMT 060202-WSF+	GTCM120HP	...-WSF+	MM141573467	●
	CCMT 060204-WSF+	GTCM120HP		MM141573469	●
	CCMT 09T302-WSF+	GTCM120HP		MM141573473	●
	CCMT 09T304-WSF+	GTCM120HP		MM141573477	●
	DCMT 070202-WSF+	GTCM120HP		MM141573478	●
	DCMT 070204-WSF+	GTCM120HP		MM141573482	●
	DCMT 11T302-WSF+	GTCM120HP		MM141573483	●
	DCMT 11T304-WSF+	GTCM120HP		MM141573486	●
	VCMT 110302-WSF+	GTCM120HP		MM141573491	●
	VCMT 110304-WSF+	GTCM120HP		MM141573494	●
	VCMT 160404-WSF+	GTCM120HP		MM141573495	●
	VCMT 160408-WSF+	GTCM120HP		MM141573497	

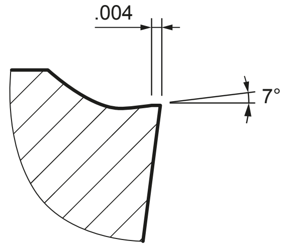
● available from stock, ○ available upon request

New Chipbreaker

WSF+:

▲ To optimise chip control:

Example: CCMT 09T308-WSF+



Cutting Data

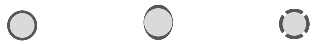
General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCM120HP v_c [m/min]	GTPM125 v_c [m/min]	GTPM135M v_c [m/min]
P	Steel	non-alloyed steel 0 – 0.45% C	150 – 250	150 – 250	130 – 250	150 – 190
		low-alloyed steel	250 – 300	100 – 200	60 – 180	90 – 150
		high-alloyed steel	200	120 – 220	80 – 200	120 – 200
		corrosion-resistant steel	200	120 – 220	100 – 200	140 – 180
M	Stainless steel	Ferritic	200	190 – 250	120 – 250	140 – 200
		Austenitic	180	140 – 220	100 – 220	110 – 190
		Duplex	230 – 260	110 – 170	60 – 160	80 – 150
		Martensitic	330	40 – 100	40 – 100	55 – 75

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
WSF+	0.15 to 2.25	0.20 to 0.07

Ex: CCMT 09T304-WSF+ for 304

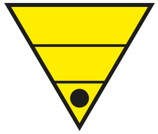
Different in each application



Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	○	X

Available Range

Turning steel pos finishing "M25":



Insert	Designation		Chipbreaker	Material number	Available
					●
	CCMT 060204-WSF+	GTPM125	...-WSF+	MM11782037	●
	CCMT 09T302-WSF+	GTPM125		MM11782051	●
	CCMT 09T304-WSF+	GTPM125		MM11782052	●
	CCMT 09T308-WSF+	GTPM125		MM11782054	●
	DCMT 070202-WSF+	GTPM125		MM11782055	●
	DCMT 070204-WSF+	GTPM125		MM11782056	●
	DCMT 11T302-WSF+	GTPM125		MM11812678	●
	DCMT 11T304-WSF+	GTPM125		MM11782058	●
	DCMT 11T308-WSF+	GTPM125		MM11782059	●
	TCMT 110202-WSF+	GTPM125		MM11906411	●
	VCMT 110302-WSF+	GTPM125		MM11812682	●
	VCMT 110304-WSF+	GTPM125		MM11855134	●
	VCMT 160404-WSF+	GTPM125		MM11812684	●

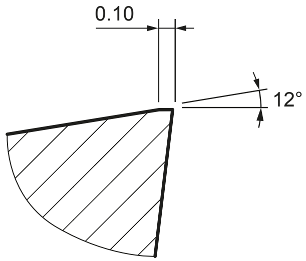
● available from stock, ○ available upon request

New Chipbreaker

Optimised by FEM:

- ▲ Increase life time
- ▲ Reduce temperature and stress
- ▲ Universal application

Example: CCMT 09T308-WM+



Cutting Data

General cutting parameters depending on the application:

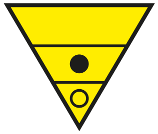
Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCM120HP v_c [m/min]	Coated carbide GTPM125 v_c [m/min]	Coated carbide GTPM135M v_c [m/min]
P	Steel	non-alloyed steel 0 – 0.45% C	150 – 250	150 – 250	130 – 250	150 – 190
		low-alloyed steel	250 – 300	100 – 200	60 – 180	90 – 150
		high-alloyed steel	200	120 – 220	80 – 200	120 – 200
		corrosion-resistant steel	200	120 – 220	100 – 200	140 – 180
M	Stainless steel	Ferritic	200	190 – 250	120 – 250	140 – 200
		Austenitic	180	140 – 220	100 – 220	110 – 190
		Duplex	230 – 260	110 – 170	60 – 160	80 – 150
		Martensitic	330	40 – 100	40 – 100	55 – 75

Application Chip groove	Depth of cut / feed rate a_p [mm]	Depth of cut / feed rate f [mm]
WSF+	0.15 to 2.25	0.20 to 0.07

Ex: CCMT 09T304-WM+ for 304
Different in each application

Consistent cutting depth	**Inconsistent cutting depth**	**Interrupted cut**
●	○	X

Available Range



Turning stainless steel pos "M20":

Insert	Designation		Chipbreaker	Material number	Available
	CCMT 060204-WM+	GTCM120HP		MM14600568	●
	CCMT 060208-WM+	GTCM120HP		MM14600574	●
	CCMT 09T304-WM+	GTCM120HP		MM14600569	●
	CCMT 09T308-WM+	GTCM120HP		MM14600577	●
	CCMT 120404-WM+	GTCM120HP		MM14600578	●
	CCMT 120408-WM+	GTCM120HP		MM14600581	●
	DCMT 070204-WM+	GTCM120HP		MM14600571	●
	DCMT 070208-WM+	GTCM120HP		MM14600550	●
	DCMT 11T304-WM+	GTCM120HP		MM14600584	●
	DCMT 11T308-WM+	CTCM120HP		MM14600586	●
	SCMT 09T304-WM+	GTCM120HP	...-WM+	MM14600587	●
	SCMT 09T308-WM+	GTCM120HP		MM12440389	●
	SCMT 120404-WM+	GTCM120HP		MM14620552	●
	SCMT 120408-WM+	GTCM120HP		MM14600588	●
	TCMT 090204-WM+	GTCM120HP		MM14479036	●
	TCMT 16T304-WM+	GTCM120HP		MM14600590	●
	TCMT 16T308-WM+	GTCM120HP		MM14479037	●
	VCMT 110304-WM+	GTCM120HP		MM14600591	●
	VCMT 110308-WM+	GTCM120HP		MM14620553	●
	VCMT 160404-WM+	GTCM120HP		MM14600594	●
	VCMT 160408-WM+	GTCM120HP		MM14600572	●

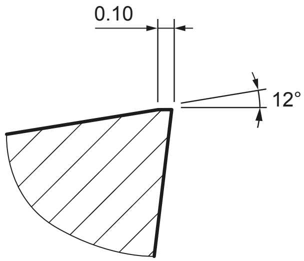
● available from stock, ○ available upon request

New Chipbreaker

Optimised by FEM:

- ▲ Increase life time
- ▲ Reduce temperature and stress
- ▲ Universal application

Example: CCMT 09T308-WM+



Cutting Data

General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCM120HP v_c [m/min]	Coated carbide GTPM125 v_c [m/min]	Coated carbide GTPM135M v_c [m/min]
P	Steel	non-alloyed steel 0 – 0.45% C	150 – 250	150 – 250	130 – 250	150 – 190
		low-alloyed steel	250 – 300	100 – 200	60 – 180	90 – 150
		high-alloyed steel	200	120 – 220	80 – 200	120 – 200
		corrosion-resistant steel	200	120 – 220	100 – 200	140 – 180
M	Stainless steel	Ferritic	200	190 – 250	120 – 250	140 – 200
		Austenitic	180	140 – 220	100 – 220	110 – 190
		Duplex	230 – 260	110 – 170	60 – 160	80 – 150
		Martensitic	330	40 – 100	40 – 100	55 – 75

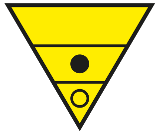
Application Chip groove	Depth of cut a_p [mm]	feed rate f [mm]
WSF+	0.15 to 2.25	0.20 to 0.07

Ex: CCMT 09T304-WM+ for 304
Different in each application

Consistent cutting depth	**Inconsistent cutting depth**	**Interrupted cut**
●	○	X

Available Range

Turning stainless steel pos "M25":



Insert	Designation		Chipbreaker	Material number	Available
	CCMT 060204-WM+	GTPM125		MM11748109	●
	CCMT 060208-WM+	GTPM125		MM11748111	●
	CCMT 09T304-WM+	GTPM125		MM11748113	●
	CCMT 09T308-WM+	GTPM125		MM11748115	●
	CCMT 120404-WM+	GTPM125		MM11748117	●
	CCMT 120408-WM+	GTPM125		MM11748119	●
	CCMT 120412-WM+	GTPM125		MM11748121	●
	DCMT 070204-WM+	GTPM125		MM11748126	●
	DCMT 070208-WM+	GTPM125		MM11748128	●
	DCMT 11T304-WM+	GTPM125		MM11748130	●
	DCMT 11T308-WM+	GTPM125		MM11748132	●
	SCMT 09T304-WM+	GTPM125		MM11748548	●
	SCMT 09T308-WM+	GTPM125		MM11748559	●
	SCMT 120404-WM+	GTPM125		MM11748564	●
	SCMT 120408-WM+	GTPM125		MM11748568	●
	SCMT 120412-WM+	GTPM125		MM11748592	●
	TCMT 090204-WM+	GTPM125	...-WM+	MM11748606	●
	TCMT 110204-WM+	GTPM125		MM11748608	●
	TCMT 110208-WM+	GTPM125		MM11748618	●
	TCMT 16T304-WM+	GTPM125		MM11748621	●
	TCMT 16T308-WM+	GTPM125		MM11748624	●
	TCMT 16T312-WM+	GTPM125		MM11748626	●
	VCMT 110304-WM+	GTPM125		MM11749277	●
	VCMT 110308-WM+	GTPM125		MM11749294	●
	VCMT 160404-WM+	GTPM125		MM11749295	●
	VCMT 160408-WM+	GTPM125		MM11749296	●
	WCMT 040204-WM+	GTPM125		MM11749303	●
	WCMT 040208-WM+	GTPM125		MM11749307	●
	WCMT 06T304-WM+	GTPM125		MM11749314	●
	WCMT 06T308-WM+	GTPM125		MM11749331	●
	WCMT 080404-WM+	GTPM125		MM11749335	●
	WCMT 080408-WM+	GTPM125		MM11749337	●
	WCMT 080412-WM+	GTPM125		MM11747968	●

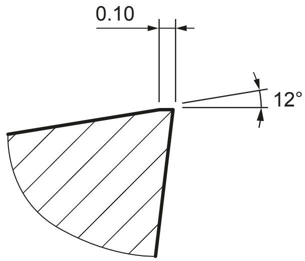
● available from stock, ○ available upon request

New Chipbreaker

Optimised by FEM:

- ▲ Increase life time
- ▲ Reduce temperature and stress
- ▲ Universal application

Example: CCMT 09T308-WM+



Cutting Data

General cutting parameters depending on the application:

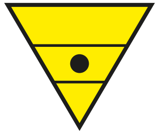
Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCM120HP v_c [m/min]	GTPM125 v_c [m/min]	GTPM135M v_c [m/min]
P	Steel	non-alloyed steel 0 – 0.45% C	150 – 250	150 – 250	130 – 250	150 – 190
		low-alloyed steel	250 – 300	100 – 200	60 – 180	90 – 150
		high-alloyed steel	200	120 – 220	80 – 200	120 – 200
		corrosion-resistant steel	200	120 – 220	100 – 200	140 – 180
M	Stainless steel	Ferritic	200	190 – 250	120 – 250	140 – 200
		Austenitic	180	140 – 220	100 – 220	110 – 190
		Duplex	230 – 260	110 – 170	60 – 160	80 – 150
		Martensitic	330	40 – 100	40 – 100	55 – 75

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
WSF+	0.15 to 2.25	0.20 to 0.07

Ex: CCMT 09T304-WM+ for 304
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	○	X

Available Range



Turning stainless steel pos "M35":

Insert	Designation		Chipbreaker	Material number	Available
	CCMT 09T304-WM+	GTPM135M	...-WM+	MM11854319	●
	CCMT 09T308-WM+	GTPM135M		MM11854326	●
	DCMT 11T304-WM+	GTPM135M		MM11854853	●
	DCMT 11T308-WM+	GTPM135M		MM11854898	●
	TCMT 110204-WM+	GTPM135M		MM11855120	●
	TCMT 110208-WM+	GTPM135M		MM11855122	●
	VCMT 110304-WM+	GTPM135M		MM11855131	●
	VCMT 110308-WM+	GTPM135M		MM11855135	●

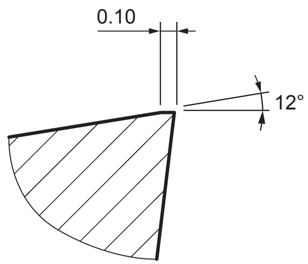
● available from stock, ○ available upon request

New Chipbreaker

Optimised by FEM:

- ▲ Increase life time
- ▲ Reduce temperature and stress
- ▲ Universal application

Example: CCMT 09T308-WM+



Cutting Data

General cutting parameters depending on the application:

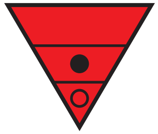
Work piece material		Type of treatment / alloy	Hardness HB	Coated carbide GTCK120 v_c [m/min]
P	Steel	Non-alloyed steel 0 – 0.45% C	150 – 250	200 – 340
		Low-alloyed steel	250 – 300	150 – 290
		High-alloyed steel	200	150 – 290
		Corrosion-resistant steel	200	160 – 290
K	Cast iron	Grey cast iron	180	150 – 400
		Spheroidal cast iron	160	200 – 450
		Malleable/tempered iron	130	200 – 550

Application Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
WM+	1.00 to 3.00	0.41 to 0.22

Ex: CCMT 09T308-WM+ for GG25
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	●	X

Available Range



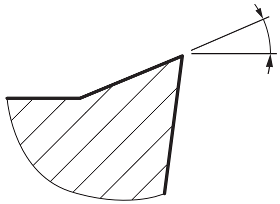
Turning cast iron pos "K20":

Insert	Designation	Chipbreaker	Material number	Available
	CCMT 060204-WM+ GTCK120		MM11865626	●
	CCMT 09T304-WM+ GTCK120		MM11821845	●
	CCMT 09T308-WM+ GTCK120		MM11821847	●
	CCMT 120408-WM+ GTCK120		MM11865627	●
	DCMT 070204-WM+ GTCK120		MM11905454	●
	DCMT 11T304-WM+ GTCK120		MM11821849	●
	DCMT 11T308-WM+ GTCK120		MM11821857	●
	SCMT 09T304-WM+ GTCK120	...-WM+	MM12001751	●
	SCMT 09T308-WM+ GTCK120		MM11855086	●
	SCMT 120408-WM+ GTCK120		MM11855089	●
	TCMT 090204-WM+ GTCK120		MM11905457	●
	TCMT 110204-WM+ GTCK120		MM11905458	●
	TCMT 110208-WM+ GTCK120		MM11905456	●
	TCMT 16T304-WM+ GTCK120		MM11821858	●
	TCMT 16T308-WM+ GTCK120		MM11780842	●

● available from stock, ○ available upon request

Cutting Data

Example: CCGT 120408FN-LMF+



General cutting parameters depending on the application:

Work piece material		Type of treatment / alloy	Hardness HB	Uncoated carbide H216T v_c [m/min]
K	Cast iron	Grey cast iron	180	120 – 160
		Spheroidal cast iron	160	130 – 170
		Malleable/tempered iron	130	140 – 200
N	Non Ferrous	Aluminium wrought alloys	100	100 – 2000
		Aluminium cast alloys	130	100 – 800
		Copper and copper alloys	90	100 – 600
		Non-metall materials	100	100 – 300
S	Exotic materials	Fe base	200	30 – 45
		Nickel or cobalt base	280	20 – 35
		Nickel or cobalt base	250	20 – 35
		Nickel or cobalt base	–	18 – 30
		Titanium	Rm 440*	60 – 120

Application / Chip groove	Depth of cut / feed rate a_p [mm]	f [mm]
LMF+	1,5 to 6,5	0,50 to 0,20

Ex: CCGT 120408FN-LMF+ for AlMg 1
Different in each application

Consistent cutting depth	Inconsistent cutting depth	Interrupted cut
●	●	○