

# GS Chip-breaker

The revolution on HRSA Turning



NEW  
GS  
CHIP-BREAKER

PHH

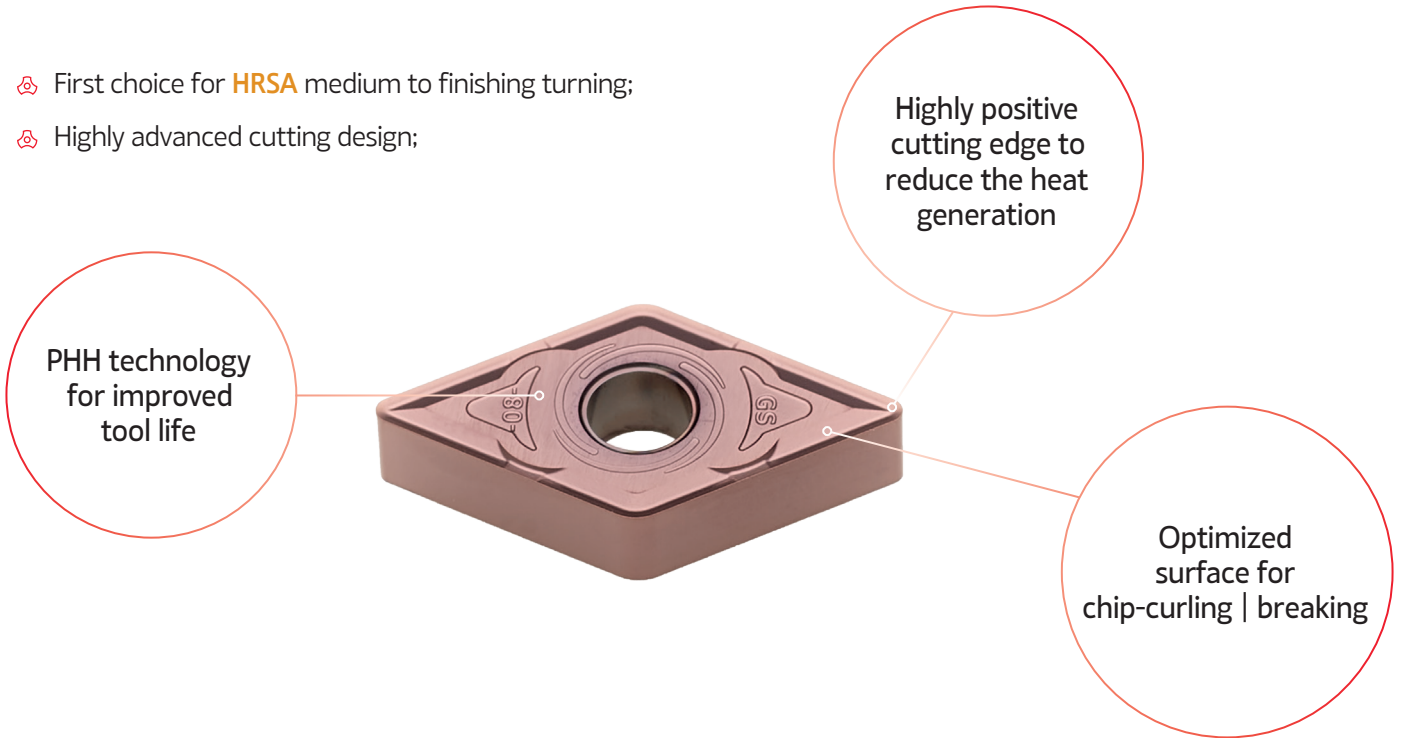
NEW  
GRADE



SINCE 1916

Designed especially for HRSA, the new chip-breaker **GS** combined with the latest PHH technology, offers exceptional performance in the exotic materials machining.

- ⚙ First choice for **HRSA** medium to finishing turning;
- ⚙ Highly advanced cutting design;



PHH GRADE | Grau PHH | Grado PHH

Product of the latest coating technology, the new PHH coating comes to revolutionize the turning of HRSA and stainless steel. PHH is a stable PVD coating that merges both high hardness and unmatched heat resistance.



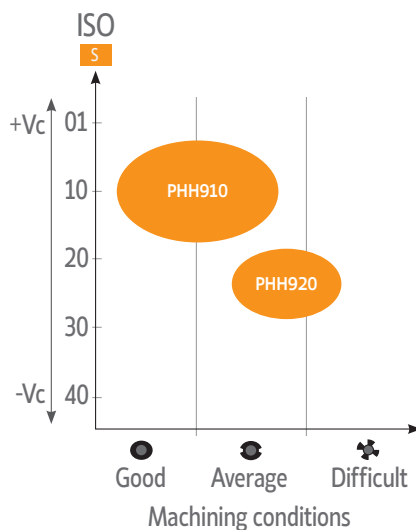
**PHH910** NEW  
M05-M10  
S05-S15

First choice for HRSA.

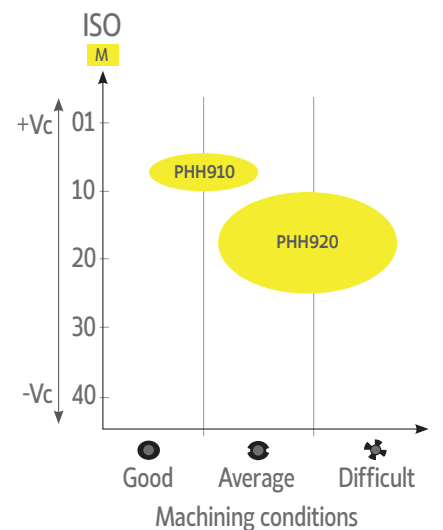
**PHH920** NEW  
M10-M25  
S15-S30

Solution for general turning of stainless steels and HRSA.

**S - HEAT RESISTANT / TITANIUM ALLOYS**






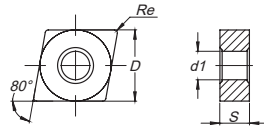







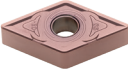




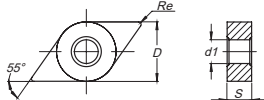
































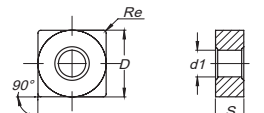












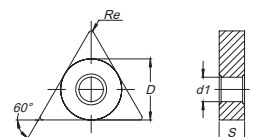












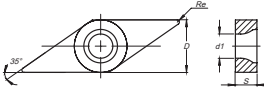













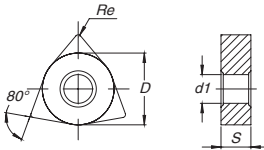


















**M - STAINLESS STEEL**




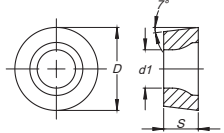




Inserts Pastilhas Plaquetas	(1) Geometry code	(2) Grade code	M		S		Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting Conditions Condições de Corte Condiciones de Corte				Technical drawing Desenho técnico Dibujo técnico		
			PVD		PVD		D	S	Re	d1	ap (mm)	Min	Max	fn (mm/rev)		Min	Max
			X6	Y3	X6	Y3											

NEGATIVE INSERTS

	1124514	CNMG 120404-GS					12,70	4,76	0,40	5,16	1,50	0,15	2,50	0,20	0,10	0,30	
	1124502	CNMG 120408-GS					12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,10	0,35	
	1124515	CNMG 120412-GS					12,70	4,76	1,20	5,16	2,00	0,30	4,00	0,30	0,10	0,45	
	1124688	DNMG 110404-GS					9,53	4,76	0,40	3,81	1,50	0,15	2,00	0,20	0,10	0,25	
	1124689	DNMG 110408-GS					9,53	4,76	0,80	3,81	2,00	0,20	2,50	0,25	0,10	0,30	
	1124511	DNMG 150404-GS					12,70	4,76	0,40	5,16	1,50	0,15	2,00	0,20	0,10	0,25	
	1124512	DNMG 150408-GS					12,70	4,76	0,80	5,16	2,00	0,20	2,50	0,25	0,10	0,30	
	1124513	DNMG 150412-GS					12,70	4,76	1,20	5,16	2,00	0,30	3,00	0,25	0,10	0,35	
	1124682	DNMG 150604-GS					12,70	6,35	0,40	5,16	1,50	0,15	2,00	0,20	0,10	0,25	
	1124683	DNMG 150608-GS					12,70	6,35	0,80	5,16	2,00	0,20	2,50	0,25	0,10	0,30	
	1124684	DNMG 150612-GS					12,70	6,35	1,20	5,16	0,30	0,30	3,00	0,30	0,10	0,35	
	1124556	SNMG 120408-GS					12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,15	0,40	
	1124557	SNMG 120412-GS					12,70	4,76	1,20	5,16	2,50	0,50	5,00	0,30	0,20	0,50	
	1124558	SNMG 120416-GS					12,70	4,76	1,60	5,16	2,50	0,50	5,00	0,40	0,20	0,50	
	1124508	TNMG 160404-GS					9,53	4,76	0,40	3,81	1,50	0,15	3,00	0,15	0,10	0,30	
	1124509	TNMG 160408-GS					9,53	4,76	0,80	3,81	2,00	0,20	3,00	0,25	0,10	0,30	
	1124510	TNMG 160412-GS					9,53	4,76	1,20	3,81	2,00	0,30	3,00	0,30	0,15	0,35	
	1124562	VNMG 160404-GS					9,53	4,76	0,40	3,81	1,00	0,15	2,00	0,15	0,05	0,20	
	1124563	VNMG 160408-GS					9,53	4,76	0,80	3,81	1,50	0,20	2,50	0,20	0,07	0,25	
	1124564	VNMG 160412-GS					9,53	4,76	1,20	3,81	1,50	0,30	3,00	0,20	0,10	0,25	
	1124690	WNMG 060404-GS					9,53	4,76	0,40	3,81	1,50	0,15	2,50	0,20	0,10	0,30	
	1124691	WNMG 060408-GS					9,53	4,76	0,80	3,81	2,00	0,20	3,00	0,25	0,10	0,35	
	1124559	WNMG 080404-GS					12,70	4,76	0,40	5,16	1,50	0,15	2,50	0,20	0,10	0,30	
	1124560	WNMG 080408-GS					12,70	4,76	0,80	5,16	2,00	0,20	3,00	0,25	0,10	0,35	
	1124561	WNMG 080412-GS					12,70	4,76	1,20	5,16	2,00	0,30	3,50	0,30	0,10	0,40	

POSITIVE INSERTS

	1124495	RCMT 0803M0-GS					8,00	3,18	-	3,40	1,00	0,20	2,00	0,25	0,15	0,40	
	1124496	RCMT 1003M0-GS					10,00	3,18	-	3,40	1,50	0,40	2,50	0,30	0,15	0,45	

 First choice | 1ª Escolha | 1ª Opción  Stock Items | Itens de stock  Available under request | Disponível sob consulta | Disponible bajo consulta

Insert Order Code: (1) Geometry code + (2) Grade code

# GS Chip-breaker

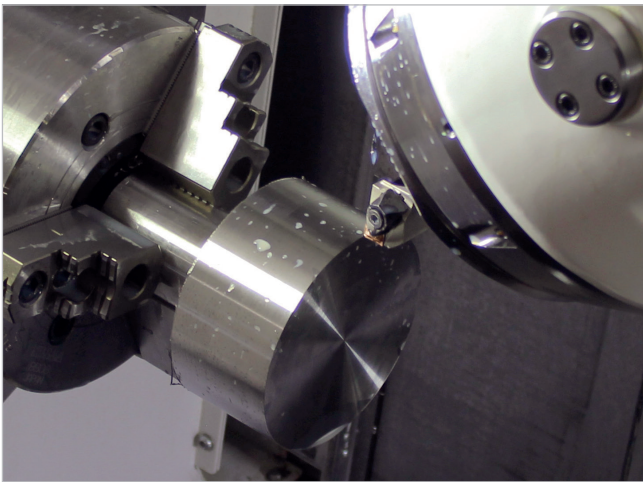
## The revolution on HRSA Turning

NEW

TEST REPORT | Relatório de teste | Informes de prueba

Toolholder: DCLN L 2525 M12

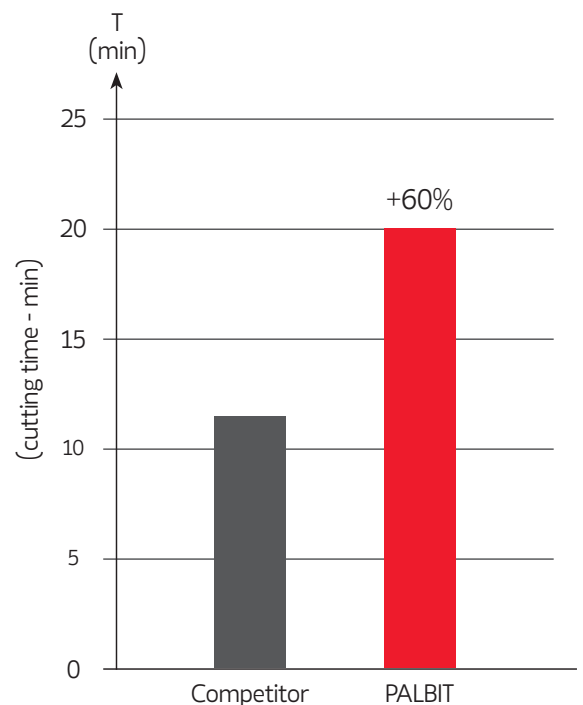
Insert: CNMG 120408-GS PHH910 vs Competitor Equivalent



Workpiece Material: Inconel 625 Alloy

Cutting speed: $V_c$	85 m/min
Feed per tooth: $f_n$	0,12 mm/rev
Depth of cut: $a_p$	0,5 mm
Operation	External turning
Coolant	Emulsion

T -  $V_{bmax}$  (0,4 mm)



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