

THE NEW VALUE FRONTIER



CJ

Chipbreaker for Shaft Machining

Advantages:

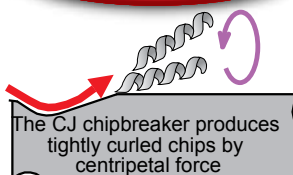
1. Good chip evacuation at small depths of cut and high feed rates. Low cutting resistance.
2. Improved chip evacuation when profiling and pulling up.
3. Combined with the CA55 series, high efficiency and long tool life is assured for shaft profiling.

Moderately positive chipbreaker for large D.O.C and high feed rates

Promotes tightly curled chips for small D.O.C and high feed rates

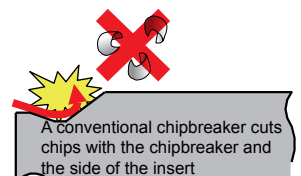
Improved chip evacuation when up facing

CJ chipbreaker

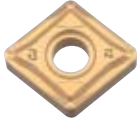




Smooth and stable machining at high feed rates

Conventional chipbreaker

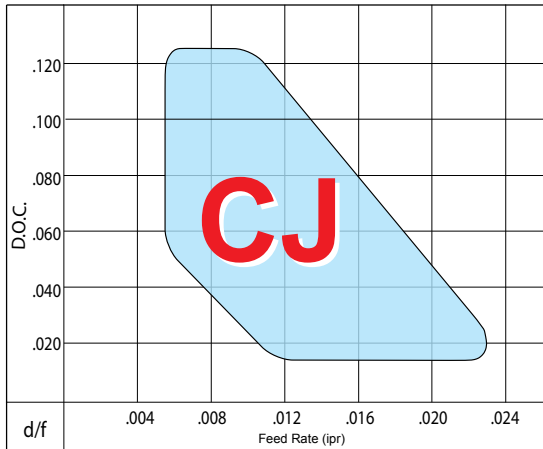


Chips may weld to the surface and damage the workpiece

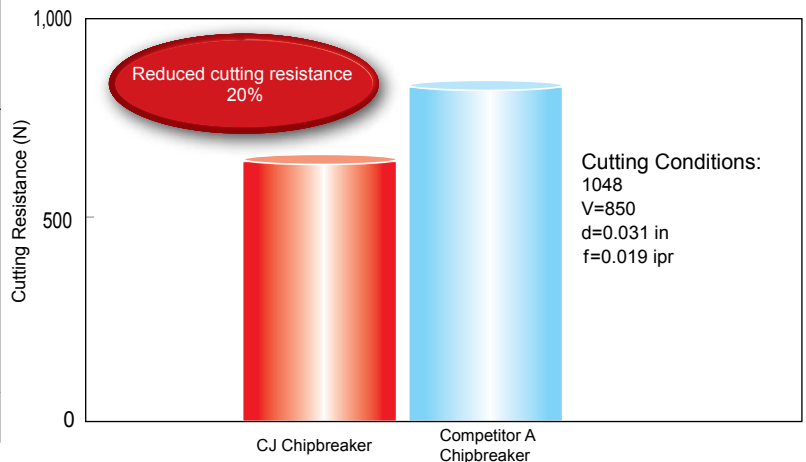
Shape	Description	Dimension				CVD Coated Carbide			
		I.C.	Thickness	Hole	Corner-R	CA5505	CA5515	CA5525	CA5535
	CNMG 432CJ	.500	.187	.203	.031	○	○	●	○
	433CJ				.047	○	●	●	○
	CNMG 543CJ	.625	.250	.250	.047	○	○	○	○
	544CJ				.063	○	○	○	○
	DNMG 432CJ	.500	.187	.203	.031	○	○	●	○
	433CJ				.047	○	●	●	○
	DNMG 442CJ	.500	.250	.203	.031	○	○	○	○
	443CJ				.047	○	○	●	○
	WNMG 432CJ	.500	.187	.203	.031	○	○	●	○
	433CJ				.047	○	●	●	○

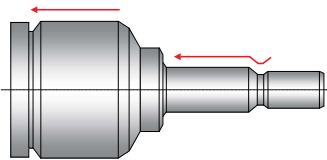


● : Std. Stock ○ : World Express

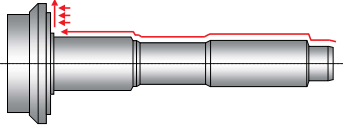


Chip Control Range



Cutting Force Comparison



1050	
CV Joint V=800 sfm d=0.020 - .040 in f=0.012 ipr Coolant DNMG433CJ CA5515	
CJ Chipbreaker	130 pcs/edge 
Competitor B	100 pcs/edge 
The CJ chipbreaker improved tool life more than 30% compared to comp. B, and demonstrated better chip control. <small>Evaluation from the user</small>	

1045	
Shaft V=500-800 sfm d=0.020 - .040 in f=0.008 ipr Coolant DNMG433CJ CA5515	
CJ Chipbreaker	90 pcs/edge 
Competitor C	80 pcs/edge 
The CJ chipbreaker promotes better chip evacuation and maintains a more stable edge condition in comparison with comp. C.	

