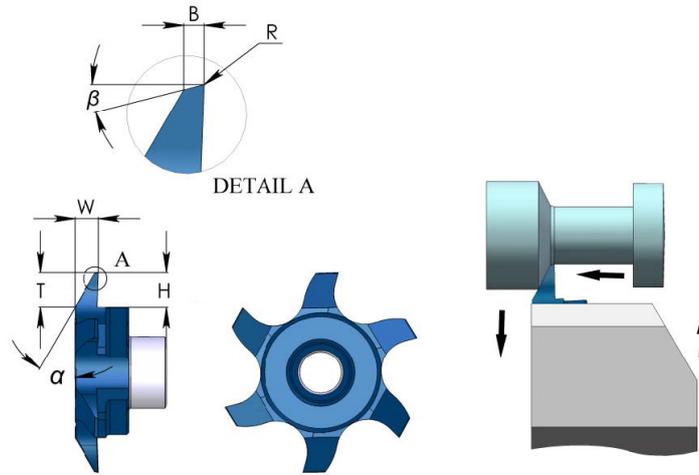


# Back Turning



Right Version

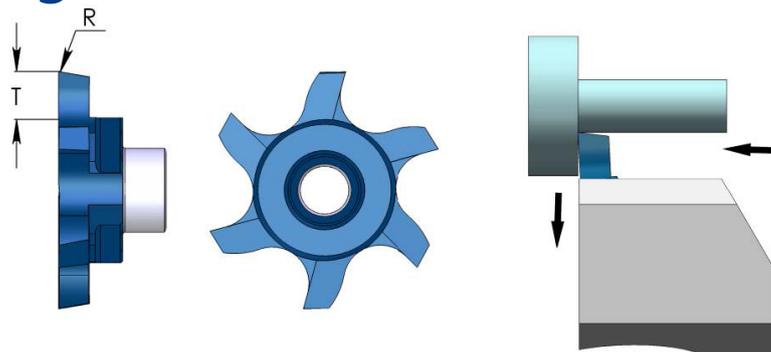
## Right hand cutting

Insert Type	Ordering Code	$\alpha^\circ$	$\beta^\circ$	R	W	H	B	T max	Feed mm/rev
G6	<b>G6B R A30</b>	30	12	0.1	2.6	3.8	0.5	3.8	0.05-0.12

	K20	BLU
P		●
M	●	●
K	●	○
N	●	
S	●	●
H		≤45 HRc

For L.H, specify G6B **L** instead of G6B **R**

# Front Turning



Right Version

## Right hand cutting

Insert Type	Ordering Code	T max	R	Feed mm/rev
G6	<b>G6F R T38</b>	3.8	0.1	0.05-0.12

	K20	BLU
P		●
M	●	●
K	●	○
N	●	
S	●	●
H		≤45 HRc

For L.H, specify G6F **L** instead of G6F **R**

● First choice    ○ Alternative

## Swiss-Line

- Swiss style lathes are becoming a popular alternative to large lathes and machining centers in many companies.
- CPT offers a large and versatile product line of inserts and toolholders, developed for automatic and Swiss style lathes.
- Designed for economic production of parting, grooving, profiling threading and chamfering.

## Polygon Inserts and Toolholders

**CPT extends the Swiss Line range by offering a new type of polygon inserts and toolholders for external turning, grooving, parting and threading on Swiss-Type machines. Specially designed for small parts machining.**



### Features

- High precision ground inserts.
- All inserts can be used with same toolholders.
- A combination of the latest carbide and coating technologies guarantees maximum tool life and improved productivity.
- Compatible with a wide range of materials.
- Coated holders provide abrasive resistance.

Carbide grades: BLU, GX7, K20

## 6 Cutting Edges G6 Turning Inserts and Toolholders

For grooving, parting-off and threading

### Benefits

- High productivity and cost efficiency due to six cutting edges
- One holder for all insert types - Maximum versatility
- High precision thanks to the fully ground profile



### Features

- Strong and stable clamping due to the unique insert shape
- Can be used with high machining parameters, and provides high surface finish
- Internal coolant provides the coolant liquid towards the cutting edge

### Application

- Multi-function inserts for grooving, parting, turning and threading
- Fits a large range of diameters from very small applications with a thin wall up to 60 mm diameter

Carbide grades: BLU, K20



Demonstration

## Carbide Grades

**BLU** PVD triple layer coated Sub-Micron grade for Steel, Stainless Steels, Super Alloys and hard materials up to 45 HRc.

**K20** Uncoated Sub-Micron carbide grade for Aluminum and non-ferrous materials, Stainless Steels and Titanium.

## Cutting Data

ISO Standard	Materials	Cutting Speed m/min	
		K20	BLU
<b>P</b>	Low & Medium Carbon Steels <0.55%C	-	80-150
	High Carbon Steels ≥0.55%C	-	70-120
	Alloy Steels, Treated Steels	-	40-80
<b>M</b>	Stainless Steel-Free Cutting	30-80	60-120
	Stainless Steel-Austenitic	20-70	30-90
	Cast Steels	30-80	50-120
<b>K</b>	Cast Iron	50-120	60-130
<b>N</b>	Aluminum ≤12%Si, Copper	120-250	-
	Aluminum >12%Si	90-200	-
	Synthetics, Duroplastics, Thermoplastics	70-150	-
<b>S</b>	Nickel Alloys, Titanium Alloys	20-50	30-70
<b>H</b>	Hardened Steel, ≤45HRc	-	20-50

# Product Identification - Ordering Codes

## G6 Inserts

