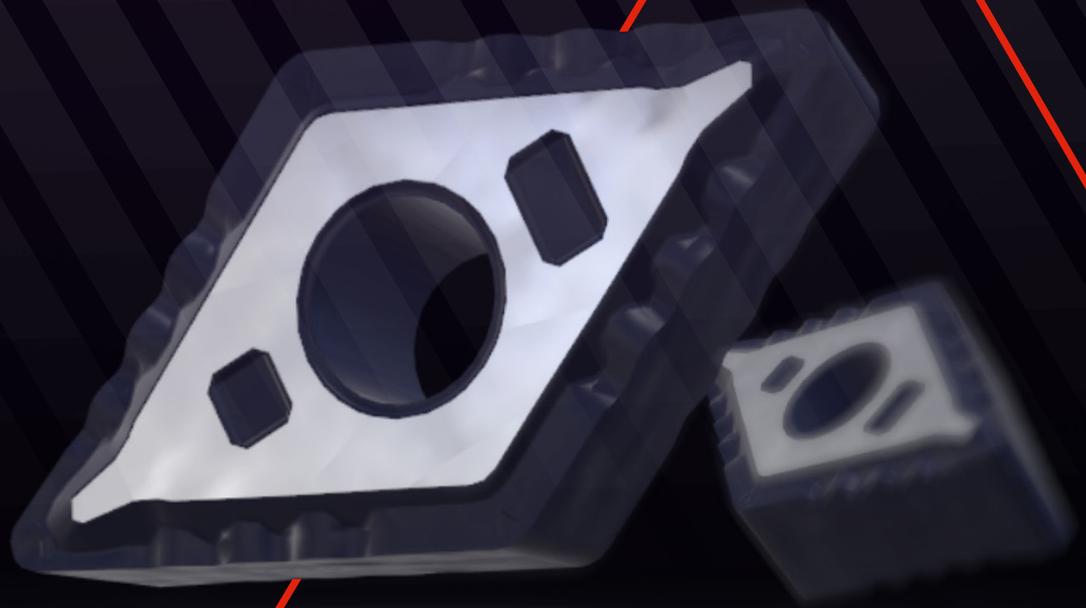


INTRODUCING

Chip Breaker -XU

A NEW GEOMETRY TO INCREASE YOUR PERFORMANCE
AND PROCESS RELIABILITY



CERATIZIT is a high-tech engineering group
specialized in tooling and hard material technologies.

Guarantees perfect chip breaking for high process reliability

After the successful commercial launch of the user-friendly CERATIZIT 3x3 concept – the complete package for the turning of steel, CERATIZIT extended the steel matrix with a new chip breaker. The new chip breaker -XU is an extension geometry between the chip breakers -F50 and -M50 for applications with chipping problems.

The -XU chip breaker is for close contour machining and general turning with varying depth of cut, ideally up to light roughing. It also covers a very large machining range.

In Europe-wide market testing the -XU showed itself as a problem solver for materials and applications where perfect chip breaking is required.

The -XU's focus is on long chipping materials and guarantees highest process reliability on turning centers and standard applications. In addition to the main chip breaker -M50, the -XU opens up further possibilities.

Application

- ▲ Close contour machining
- ▲ Finishing to light roughing
- ▲ Steel universal chip breaker
- ▲ Low cutting forces
- ▲ Ideally suited for general turning
- ▲ Draw turning
- ▲ For chip breaking problems

Surface polishing for maximum process reliability

Post-treated surface for perfect chip flow

Developed from perfect chip breaking geometry

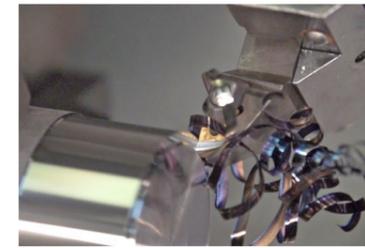
Benefits

- ▲ Highest process reliability for turning centers and unmanned production
- ▲ Secure transport of chips and small space requirement for swarf
- ▲ Reduced downtime and tooling costs
- ▲ Minimized risk of injury from stringing swarf

Outperforms the competition

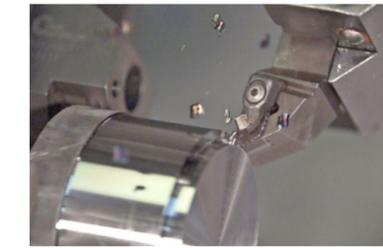
Steel CK60 1.1221 AISI 1060

Competitor



$v_c = 525 \text{ ft/min}$
 $a_p = .200 \text{ in}$
 $f_z = .014 \text{ in}$

Chip breaker -XU



$v_c = 525 \text{ ft/min}$
 $a_p = .200 \text{ in}$
 $f_z = .014 \text{ in}$

The chip breaker -XU guarantees perfect chip breaking for the highest process reliability.

Cutting data:

- ▲ Grades: CTCP115, CTCP125
- ▲ Cutting speeds v_c can be taken from the cutting data table in the main catalog.
- ▲ Depth of cut a_p and feed rate f_z are determined in the laboratory for each geometry (insert size/radius) so there is optimal cutting data for each geometry.
- ▲ This data is printed on the respective labels.

Program and Cutting Data -XU

Material no.		Designation	Cutting depth (inch)		Feed rate (inch/tooth)	
CTP115	CTCP125		$a_p \text{ min}$	$a_p \text{ max}$	$f_z \text{ min}$	$f_z \text{ max}$
11891297	11891298	CNMG 120404EN-XU	.012	.100	.003	.010
11891300	11891301	CNMG 120408EN-XU	.024	.120	.005	.012
11891302	11891303	CNMG 120412EN-XU	.036	.140	.006	.018
11890690	11890693	DNMG 150604EN-XU	.012	.100	.003	.010
11890696	11890713	DNMG 150608EN-XU	.024	.120	.005	.012
11809639	11809642	DNMG 150612EN-XU	.036	.140	.006	.032
11891304	11891305	VNMG 160404EN-XU	.012	.072	.003	.008
11891308	11891309	VNMG 160408EN-XU	.024	.080	.005	.012
11890716	11890718	WNMG 080404EN-XU	.012	.100	.003	.010
11890720	11890722	WNMG 080408EN-XU	.024	.120	.005	.014
11809646	11588487	WNMG 080412EN-XU	.036	.140	.006	.018

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