

Breakers for Aluminium Alloy Turning

AZ breaker



Superior chip control

- A unique corrugated chipbreaker geometry optimized for aluminium machining ensures precise chip flow control.

Excellent surface finishes

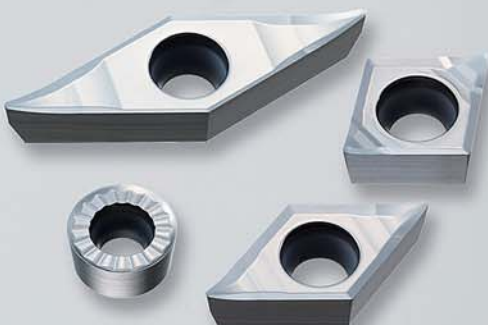
- High rake angle significantly reduces cutting resistance.
- Top face of the insert is mirror polished to dramatically improve welding resistance.

Burr prevention

- Unique curved cutting edge gives increased sharpness.
- G-class tolerance inserts for accurate performance.


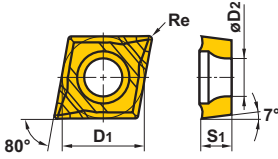
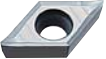
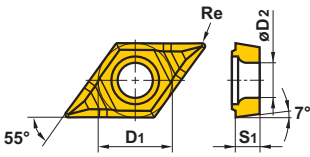

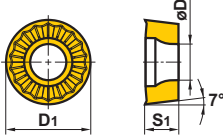

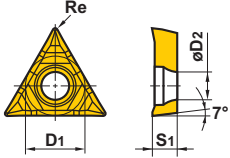

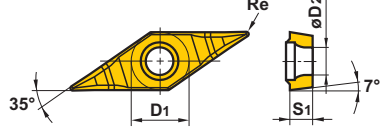
For different types of aluminium alloys

- Versatile micro-grain cemented carbide (HTi10) is used for the insert substrate to cover a wide range of materials such as pure aluminium and aluminium alloys.



Breakers for Aluminium Alloy Turning

Inserts

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		HTi10	D1	S1	Re	D2	
	CCGT060202-AZ	●	6.35	2.38	0.2	2.8	
	060204-AZ	●	6.35	2.38	0.4	2.8	
	09T302-AZ	●	9.525	3.97	0.2	4.4	
	09T304-AZ	●	9.525	3.97	0.4	4.4	
	09T308-AZ	●	9.525	3.97	0.8	4.4	
	120402-AZ	●	12.7	4.76	0.2	5.5	
	120404-AZ	●	12.7	4.76	0.4	5.5	
120408-AZ	●	12.7	4.76	0.8	5.5		
	DCGT070202-AZ	●	6.35	2.38	0.2	2.8	
	070204-AZ	●	6.35	2.38	0.4	2.8	
	11T302-AZ	●	9.525	3.97	0.2	4.4	
	11T304-AZ	●	9.525	3.97	0.4	4.4	
	11T308-AZ	●	9.525	3.97	0.8	4.4	
	RCGT0803M0-AZ	●	8	3.18	—	3.4	
	10T3M0-AZ	●	10	3.97	—	3.6	
	TCGT110202-AZ	●	6.35	2.38	0.2	2.8	
	110204-AZ	●	6.35	2.38	0.4	2.8	
	110208-AZ	●	6.35	2.38	0.8	2.8	
	16T302-AZ	●	9.525	3.97	0.2	4.4	
	16T304-AZ	●	9.525	3.97	0.4	4.4	
	16T308-AZ	●	9.525	3.97	0.8	4.4	
	VCGT160404-AZ	●	9.525	4.76	0.4	4.4	
	160408-AZ	●	9.525	4.76	0.8	4.4	
	160412-AZ	●	9.525	4.76	1.2	4.4	
	220530-AZ	●	12.7	5.56	3.0	5.5	

● : Inventory maintained.

Recommended Cutting Conditions

Work Material		Hardness	Grade	Cutting Speed (m/min)		
N	Pure Aluminium	20–50HB	HTi10	500–1200		
	Aluminium Alloy	Forged Products	Non Heat Treated	50–70HB	HTi10	500–1000
			Heat Treated	90–110HB	HTi10	300–700
	Cast Products	Si<12%	70–80HB	HTi10	200–500	
		Si≥12%	80–100HB	HTi10	150–400	

For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or spanner.

MITSUBISHI MATERIALS CORPORATION



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Design, Development and
Production of Cemented
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The Scope of the Registration:
Design, Development and
Production of Cutting Tools,
Wear-resistant Tools, Rock
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(Tools specifications subject to change without notice.)