

**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.


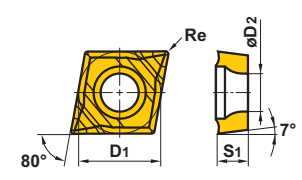
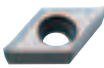
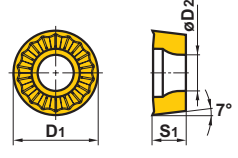

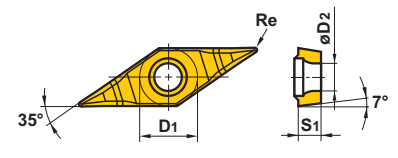
**For different types of aluminium alloys**

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



# AZ Breaker

## INSERTS

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		HTi10	D1	S1	Re	D2	
	CCGT09T304-AZ	●	9.525	3.97	0.4	4.4	
	DCGT11T304-AZ	●	9.525	3.97	0.4	4.4	
	RCGT0803M0-AZ	●	8	3.18	—	3.4	
	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	
Copper Alloy	90-110HB	HTi10	200-500			



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