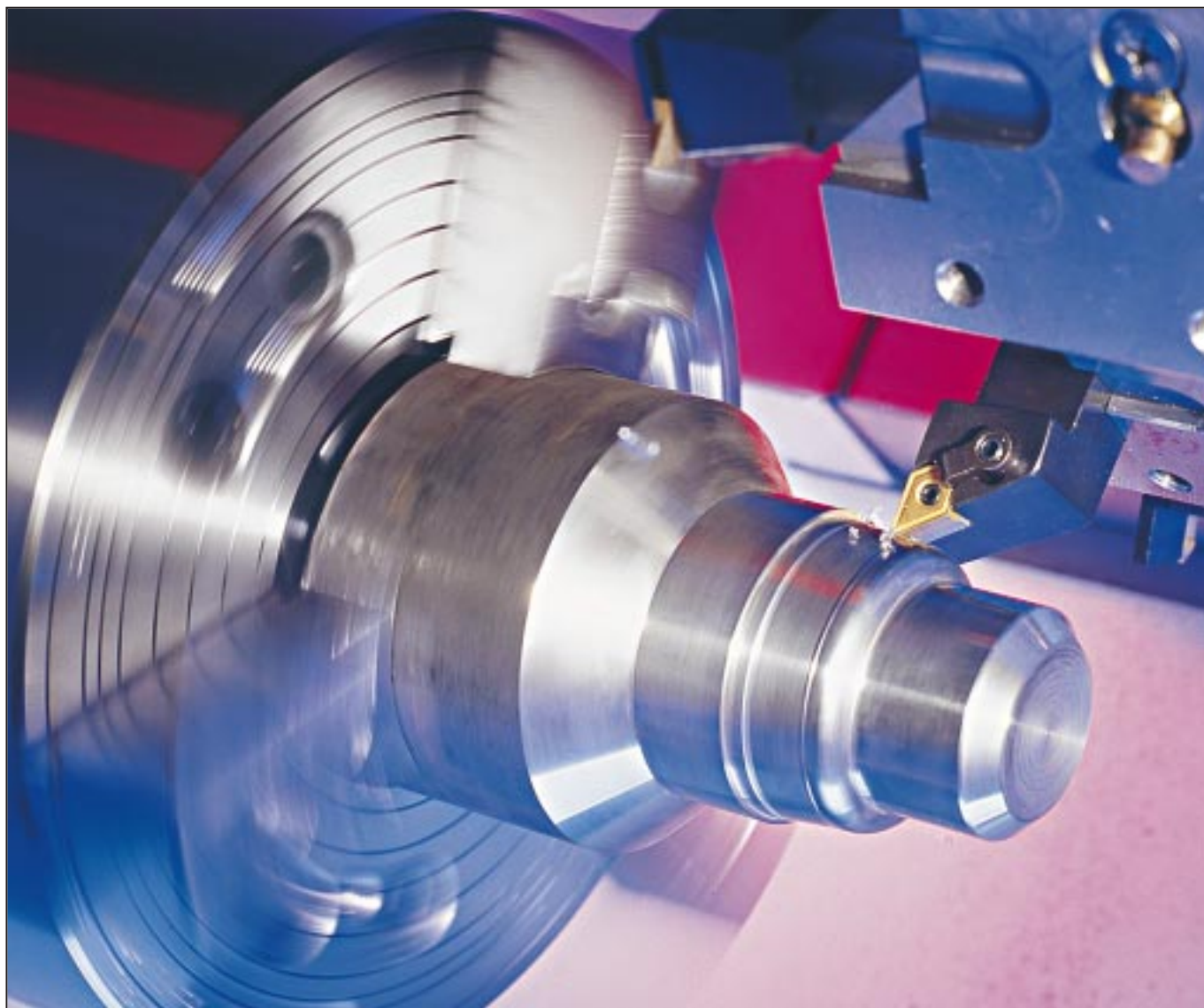


# MITSUBISHI CARBIDE

## Coated Grade **US735**

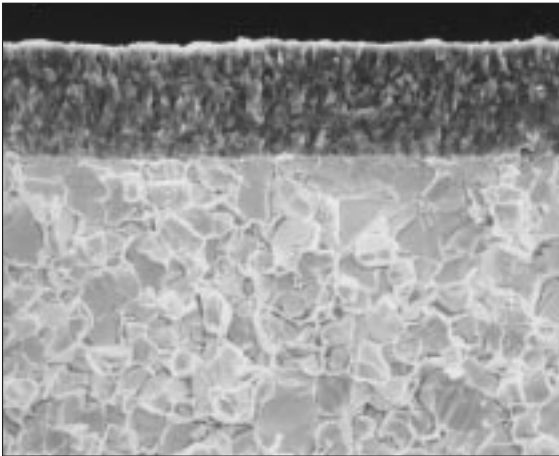
- Excellent for Use in Stainless Steel
- Good Performance in Nickel Base Alloys
- Good for Interrupted Cuts



# US735

<b>STAINLESS STEEL</b>  US735 Demonstrates Very Stable Cutting Conditions in Stainless Steel. The New Substrate Resists Chipping in Interrupted Cuts	<b>NICKEL ALLOY</b>  Good Performance in Nickel Base Alloys
<b>CARBON STEEL</b>  Use US735 in Interrupted Cuts at Low Speeds	<b>CHIPBREAKERS</b>  US735 is Available in the GH, MA, MS, MQ, SA, SH and SQ Chipbreakers

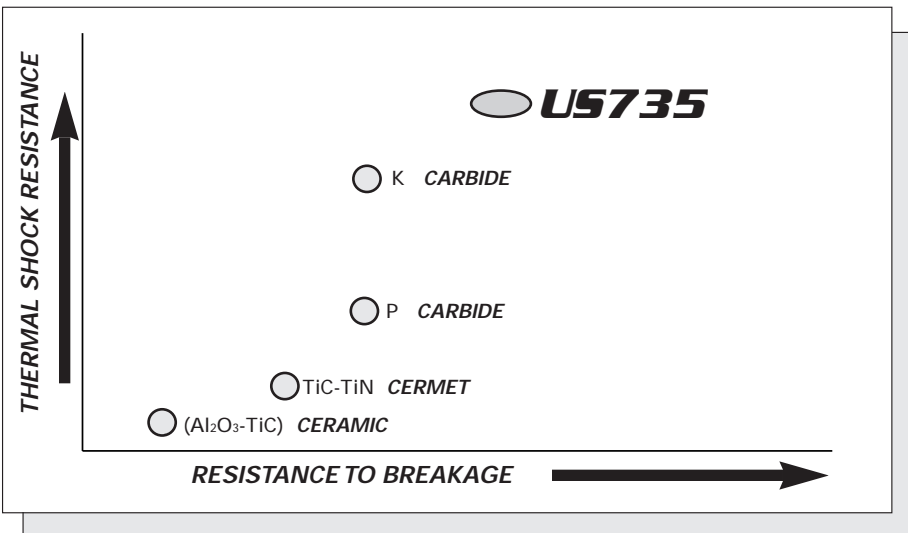
## → TECHNICAL DATA



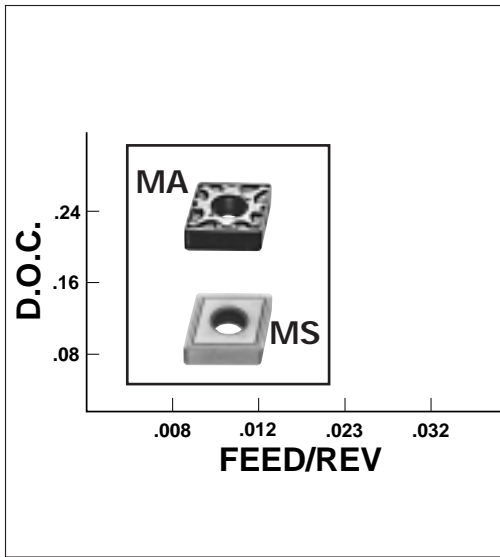
### US735 STRUCTURE

← TiN C.V.D. Coated Layer

← New Substrate Developed For Difficult Materials

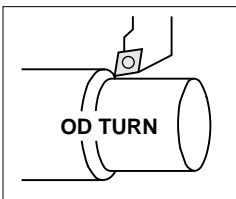


# US735 CUTTING CONDITIONS

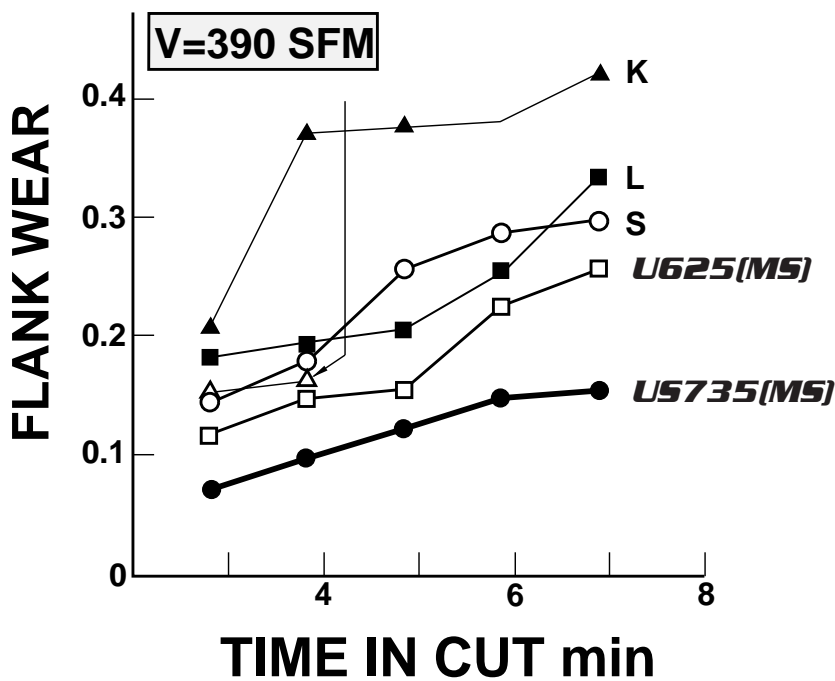


MATERIAL	V=SFM	F=IPR*	d=DOC
STAINLESS	230-450	.003-.023	.040-.240
NICKEL ALLOY	65-150	.004-.012	.020-.100
CARBON STEEL (HB150)	320-650	.004-.024	.040-.240

# US735 VS. COMPETITORS COATED GRADES



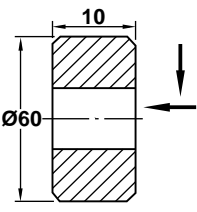
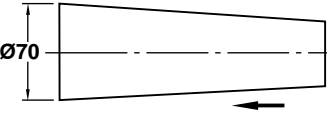
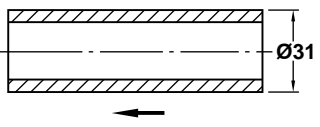
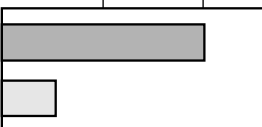
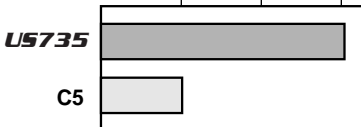
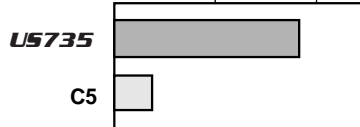
BAR STOCK 304 (HB150)



CONDITIONS  
 CNMG 432  
 V= 390  
 d= .080  
 f= .012

WATER SOLUBLE COOLANT

# U5735 FIELD TESTS

MATERIAL	SS304 	SS420 	SS304 
	WET	DRY	WET
INSERT	CNMG432MA	CNMG432MS	CNMG432MS
V=SFM	390	330	230
f=IPR	.012	.012	.006
d=DOC	.080	.100	.040
RESULTS	● TOOL LIFE  PARTS/EDGE 100 200  <b>U5735</b> 	● TOOL LIFE  PARTS/EDGE 1 2 3  <b>U5735</b> 	● TOOL LIFE  PARTS/EDGE 50 100  <b>U5735</b> 

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