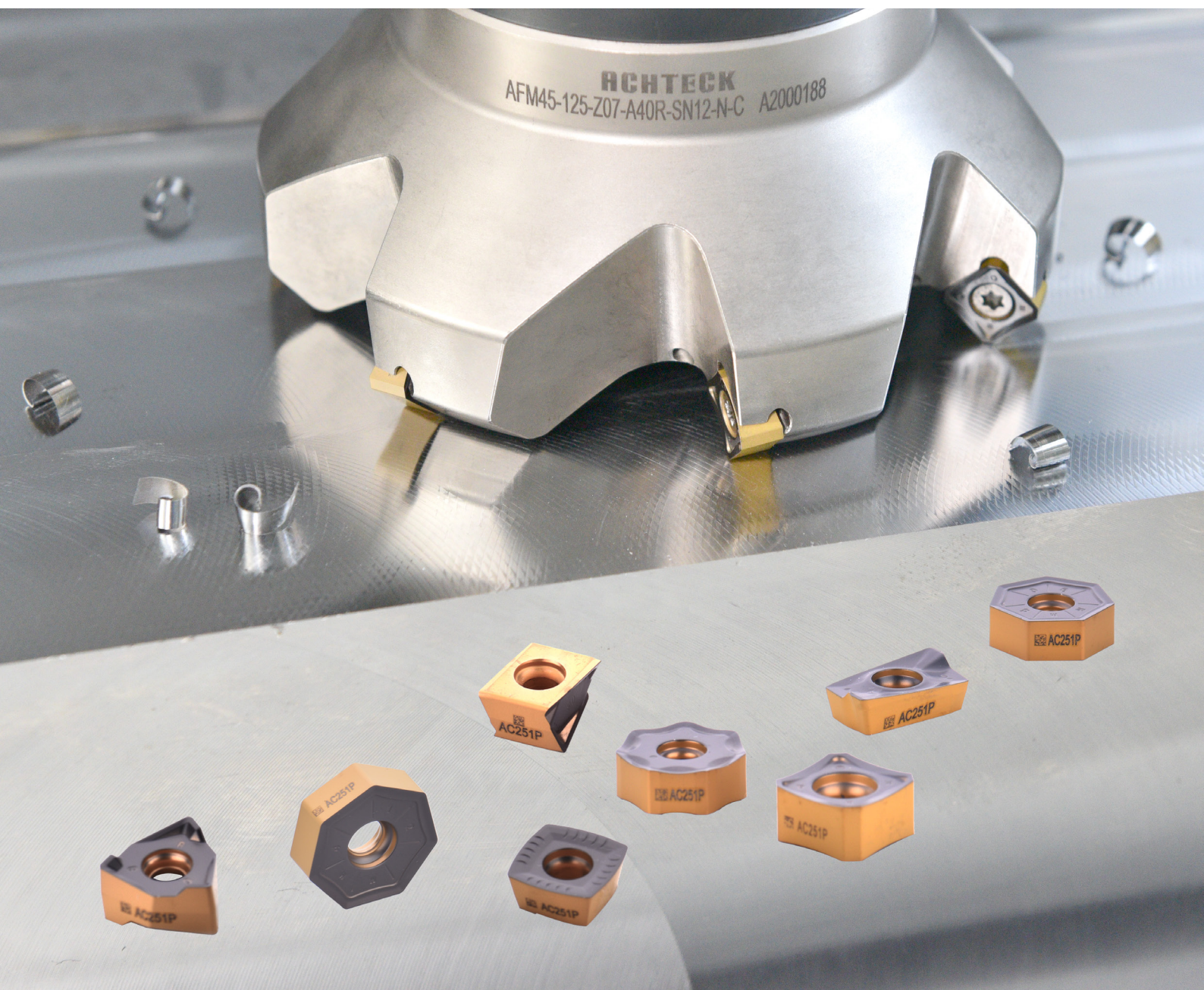


**NEW
PRODUCT!**

New CVD Milling Grade

New Steel Milling Grade AC251P

New Cast Iron Milling Grade AC151K

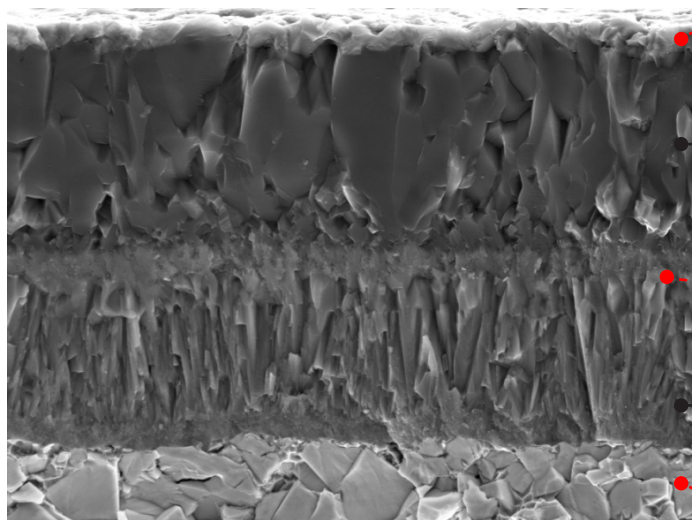


Grade Introduction

The new grade AC251P is for steel high speed milling and another new grade AC151K is for cast iron milling. Both grades are with new substrate. Two grades have good wear resistance as well as toughness to avoid chipping and edge breakage. Both grades are CVD grades, with high coating hardness and wear resistance. Excellent coating adhesion to avoid coating peeling for better tool life. New grades offer stable machining, excellent performance, and are better choices for customers.

Features

AC251P



Special post-treatment, smooth surface

Reduce built-up edge and chipping

Al₂O₃

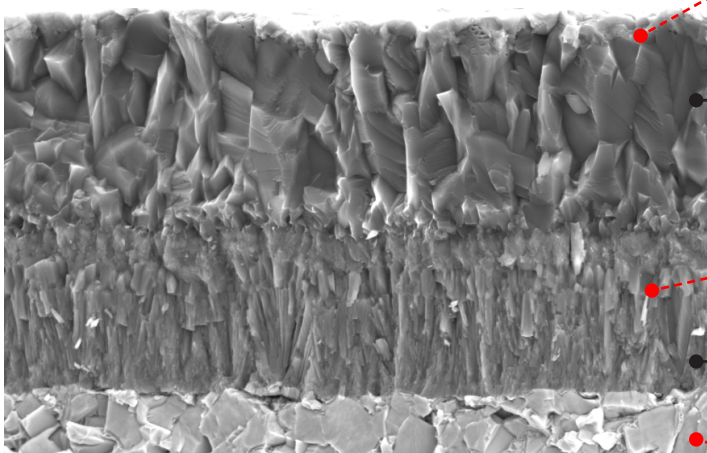
Gradient transitional layer

Strengthened coating adhesion reduces coating from peeling
 MT-TiCN

New substrate

High wear resistance and toughness, longer tool life

AC151K



Special surface post-treatment

Effectively reduce the residual stress of coating

Al₂O₃

Nano structured coating, good wear resistance

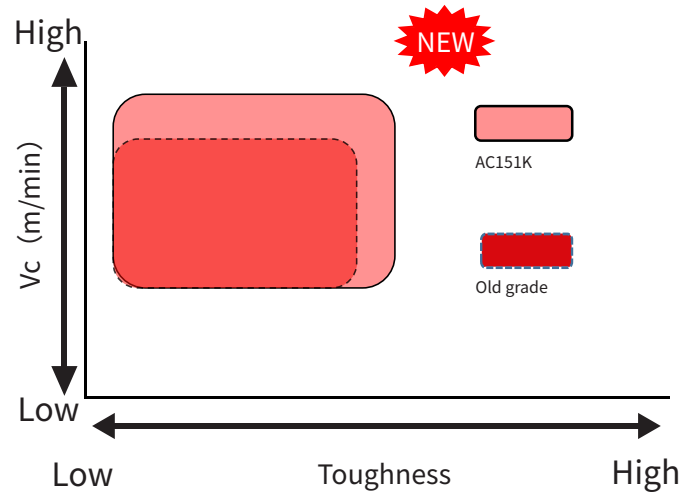
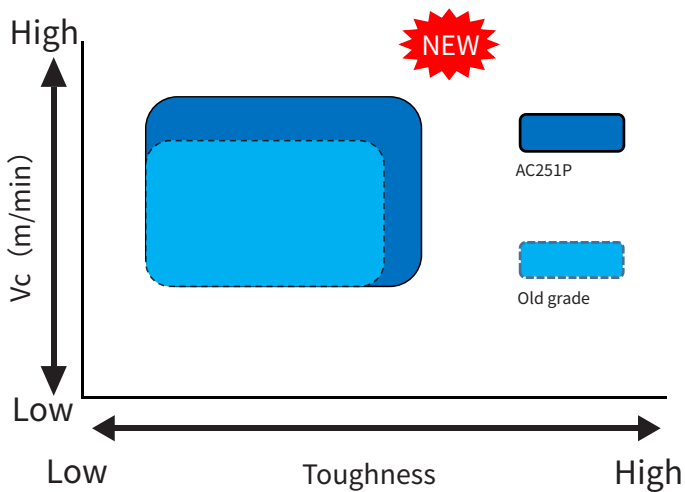
Fine crystal, and even wear resistance

MT-TiCN





Better wear resistance substrate

High hot hardness and wear resistance

Application






AC251P Applications

Material	Applications									
Application	Finishing			←————→				Roughing		
ISO Classification	10	15	20	25	30	35	40	45	50	
	 AC251P									
	 AC251P									

- From finish, semi-finish to rough milling
- Used in wet and dry machining conditions
- First choice for milling steel at medium and high speed
- Used in automotive, general machining and other industries

● AC151K Applications

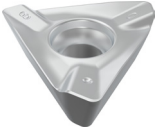

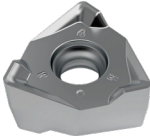
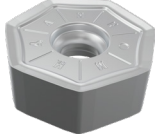
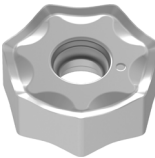
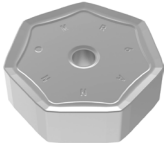

Material	Applications								
Application	Finishing						Roughing		
ISO Classification	10	15	20	25	30	35	40	45	50
									

- From finish, semi-finish to rough milling
- Used in wet and dry milling
- First choice for milling cast iron at medium to high cutting speed
- Used in automobile, general machining and other industries

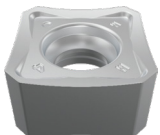


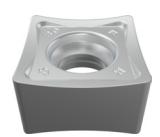
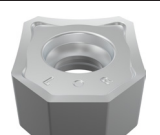


● Benefits for Customers

- Used under different machining conditions, high universality
- Stable performance during milling process, high reliability
- Suitable for higher milling parameters, effectively improve productivity
- Dramatically extend the tool life, effectively reduce the tool cost

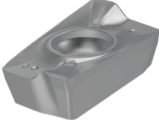

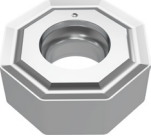
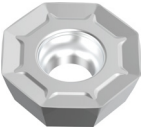


• **Product list**

Insert	Product Code	AC251P	AC151K
	TDMT 150508R-MM4	●	
	XDLT 120508ER-MM3	●	●
	WNGU 080608R-MM4	●	●
	WNMU 080608R-MM4	●	
	XNMU 070508-MM4	●	●
	XNMU 0705ANN-MM4	●	●
	XNMU 090612-MM4	●	●
	XNMU 0906ANN-MR6	●	●
	XNGU 0906ANN-MM4	●	●
	XNMU 070508-MM3N		●
	XNMU 070508-MM4N		●
	XNMU 0705ANN-MM4N	●	
	XNMF 0906ANN-MR6		●
	HNGX 0906ANN-MR6	●	●

Product list

Insert	Product Code	AC251P	AC151K
	SNGX 1206ANN-MM3	●	●
	SNGX 1206ANN-MM4	●	●
	SNMX 1206ANN-MM4	●	
	SNMX 1206ANN-MR6		●
	SNGX 1206ENN-MM4	●	
	SNGX 1206ZNN-MM3	●	●
	SNGX 1206ZNN-MM4	●	●
	SNGX 120608-MM4	●	●
	SNMX 120608-MM4		●
	SNMX 120612-MM4	●	●
	SNMX 120612-MR6	●	●
	SNMX 120620-RR2	●	
	SNHX 1206ANN-W		●
	SNHX 1206ENN-W		●
	SNHX 1206ZNN-W		●

• **Product list**

Insert	Product Code	AC251P	AC151K
	APMT 1604PDER	●	
	LNHU 090408ER-MR2	●	●
	LNHU 130608ER-MR2	●	●
	LNHU 160708ER-MR2		●
	ONMU 050408-MM4		●
	ODHT 0605APEN-MM3	●	●
	ODMT 060508EN-MM3	●	
	SDMT 09T308EN-MM3		●
	SDMT 09T308N-MM4		●
	SDMT 09T308N-MR2		●
	SDMT 09T320N-MR2		●
	SDMT 09T320N-MM4		●
	SDMT 120408N-MM4		●
	SDMT 120408N-MR2		●



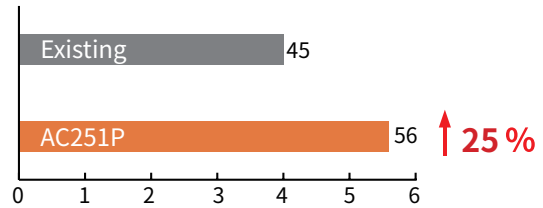
• **Success story**

Workpiece: Welded structural parts
 Material: 16MnCr5
 Milling Cutter: ASM90-063-Z06-A22R-LN13-C
 Insert: LNHU 130608ER-MR2
 Grade: AC251P
 Application: Rough milling



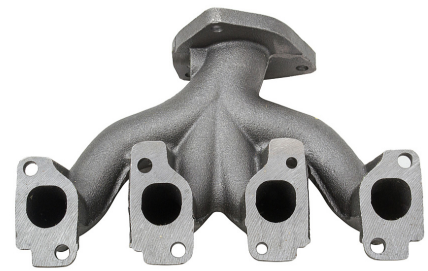
Milling Parameters:	Existing	AC251P
Vc [m/min]	300	300
fz [mm]	0.27	0.27
ap [mm]	2.5	2.5
Coolant	Emulsion	Emulsion
Tool Life(m)	45	56

Existing: Tool Life(m)



• **Success story**

Workpiece: Manifold
 Material: GGG50
 Milling Cutter: AFM45-125-Z08-A40R-XN07-C
 Insert: XNMU 070508-MM4
 Grade: AC151K
 Application: Rough milling platform



Milling Parameters:	AC301K	AC151K
Vc [m/min]	280	280
fz [mm]	0.15	0.15
ap [mm]	2.5	2.5
Coolant	Emulsion	Emulsion
Tool Life(pcs)	31	43

Comparison: Tool Life(pcs)

