



P Steel	H Hardened Steel	M Stainless Steel	S HRSA's	K Cast Iron	N Non-Ferrous
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SWISS TURN PERFORMANCE GROUND INSERTS FOR SLIDING HEAD LATHES & SMALL PART TURNING

Korloy SWISS TURN inserts are designed for machining small parts in production turning environments, where contact time is short, high accuracy is needed or high quality surface roughness is required.


All SWISS TURN inserts are precision ground and PVD coated. This ensures a sharp but strong cutting edge and the optimal coating for small part machining.

- PC5300 grade: First choice for steel and stainless steel turning. Excellent for exotics where additional toughness is required.
- PC8110 grade: First choice for exotic turning or stainless steel applications where the highest cutting speeds are required.
- FS & MS chip breaker feature special surface treatment to achieve excellent surface finish.

1ST CHOICE FOR SMALL PART HIGH PRECISION MACHINING

CHIP BREAKER GUIDE


VP1



Medium chip breaker with reinforced cutting edge. Ideal for demanding applications or larger cut depths.

Depth of cut: 0.3-3.5mm
Feed rate: 0.05-0.30mm/rev


MS



Medium chip breaker with special surface treatment. Ideal for applications where good surface roughness is required in medium cutting range.

Depth of cut: 0.2-2.5mm
Feed rate: 0.03-0.25mm/rev

FS



Finishing chip breaker with special surface treatment. Best surface finish, surface roughness and chip control under small depth of cut.

Depth of cut: 0.1-1.5mm
Feed rate: 0.01-0.20mm/rev

GRADE		ORDER CODE		PRICE	FEED f_n (mm/rev)	DEPTH OF CUT a_p (mm)
ISO	RADIUS	PC5300	PC8110			
CCGT060201-FS	0.1	1-02-073888	1-02-076418		0.01-0.18	0.03-1.60
CCGT060202-FS	0.2	1-02-076419	1-02-076420		0.02-0.20	0.04-1.70
CCGT060204-FS	0.4	1-02-073936	1-02-073935		0.04-0.21	0.06-1.80
CCGT09T301-FS	0.1	1-02-076421	1-02-076422		0.01-0.20	0.04-1.80
CCGT09T302-FS	0.2	1-02-069405	1-02-069403		0.02-0.23	0.05-2.00
CCGT09T304-FS	0.4	1-02-076423	1-02-071329		0.04-0.23	0.08-2.00
CCGT09T308-FS	0.8	1-02-076462	1-02-076463		0.06-0.25	0.10-2.20
CCGT09T301-MS	0.1	1-02-075765	1-02-075764		0.02-0.23	0.05-2.00
CCGT09T302-MS	0.2	1-02-075767	1-02-075766		0.03-0.25	0.07-2.50
CCGT09T304-MS	0.4	1-02-075769	1-02-075768		0.05-0.25	0.09-2.50
CCGT060201-VP1	0.1	1-02-043964	1-02-043965		0.05-0.06	0.06-1.00
CCGT060202-VP1	0.2	1-02-043659	1-02-043660		0.03-0.10	0.08-1.50
CCGT060204-VP1	0.4	1-02-043661	1-02-043662		0.05-0.12	0.10-1.50
CCGT09T301-VP1	0.1	1-02-043794	1-02-043795		0.03-0.13	0.06-1.00
CCGT09T302-VP1	0.2	1-02-043835	1-02-043836		0.04-0.15	0.08-1.50
CCGT09T304-VP1	0.4	1-02-043837	1-02-043838		0.06-0.20	0.10-1.50
DCGT070201-FS	0.1	1-02-076464	1-02-076465		0.01-0.18	0.03-1.60
DCGT070202-FS	0.2	1-02-053393	1-02-076466		0.02-0.20	0.04-1.70
DCGT11T301-FS	0.1	1-02-076424	1-02-076425		0.01-0.20	0.04-1.80
DCGT11T302-FS	0.2	1-02-065403	1-02-065401		0.02-0.23	0.05-2.00
DCGT11T304-FS	0.4	1-02-065067	1-02-065065		0.04-0.23	0.08-2.00
DCGT11T308-FS	0.8	1-02-076467	1-02-076468		0.06-0.25	0.10-2.20
DCGT11T301-MS	0.1	1-02-075771	1-02-075770		0.02-0.23	0.05-2.00
DCGT11T302-MS	0.2	1-02-075773	1-02-075772		0.03-0.25	0.07-2.50
DCGT11T304-MS	0.4	1-02-075775	1-02-075774		0.05-0.25	0.09-2.50
DCGT070201-VP1	0.1	1-02-043900	1-02-043901		0.03-0.06	0.06-1.00
DCGT070202-VP1	0.2	1-02-043902	1-02-043903		0.03-0.10	0.08-1.50
DCGT070204-VP1	0.4	1-02-043904	1-02-043905		0.05-0.12	0.10-1.50
DCGT11T301-VP1	0.1	1-02-043893	1-02-043894		0.03-0.13	0.06-1.00
DCGT11T302-VP1	0.2	1-02-043750	1-02-043796		0.04-0.15	0.08-1.50
DCGT11T304-VP1	0.4	1-02-043751	1-02-043797		0.06-0.20	0.10-1.50
TCGT110201-FS	0.1	1-02-076469	1-02-076470		0.01-0.16	0.03-1.40
TCGT110202-FS	0.2	1-02-076471	1-02-026269		0.02-0.18	0.04-1.50
TCGT110204-FS	0.4	1-02-076472	1-02-076473		0.04-0.19	0.06-1.60
VBGT110301-FS	0.1	1-02-075480	1-02-075481		0.01-0.16	0.03-1.40
VBGT110302-FS	0.2	1-02-069408	1-02-069406		0.02-0.18	0.04-1.50
VBGT110304-FS	0.4	1-02-076426	1-02-076427		0.04-0.19	0.06-1.60
VBGT160401-FS	0.1	1-02-076474	1-02-076475		0.01-0.16	0.04-1.80
VBGT160402-FS	0.2	1-02-076476	1-02-076477		0.02-0.18	0.05-2.00
VBGT160404-FS	0.4	1-02-076478	1-02-076479		0.04-0.19	0.08-2.00
VCGT110301-FS	0.1	1-02-076428	1-02-076429		0.01-0.16	0.03-1.40
VCGT110302-FS	0.2	1-02-076430	1-02-076260		0.02-0.18	0.04-1.50
VCGT110304-FS	0.4	1-02-076431	1-02-076432		0.04-0.19	0.06-1.60
VCGT160402-FS	0.2	1-02-076433	1-02-076434		0.02-0.18	0.05-2.00
VCGT160404-FS	0.4	1-02-065070	1-02-065068		0.04-0.19	0.08-2.00
VCGT110301-MS	0.1	1-02-076480	1-02-076481		0.02-0.23	0.05-2.00
VCGT110302-MS	0.2	1-02-076484	1-02-076485		0.03-0.25	0.07-2.50
VCGT110304-MS	0.4	1-02-076488	1-02-076489		0.05-0.25	0.09-2.50
VCGT110301-VP1	0.1	1-02-045856	1-02-045857		0.02-0.15	0.05-0.50
VCGT110302-VP1	0.2	1-02-045858	1-02-045859		0.02-0.18	0.10-1.00
VCGT110304-VP1	0.4	1-02-045860	1-02-045861		0.03-0.18	0.15-1.20
VCGT160404-VP1	0.2	-	1-02-053320		0.05-0.20	0.18-1.80
VCGT160408-VP1	0.4	-	1-02-056954		0.06-0.20	0.20-1.80

RECOMMENDED CUTTING CONDITIONS

Material Group	Material	PC5300 (m/min)	PC8110 (m/min)
Steel	Low Carbon Steel	135-230	-
	Alloy Steel	105-175	-
	Pre-Hardened Steel	65-110	70-130
Stainless Steel	Austenitic Stainless (e.g.316)	100-165	115-190
	Martensitic Stainless (e.g.404)	120-200	140-230
	Duplex, PH	75-125	85-145
HRSA's	Inconel, Nickel Alloy	30-50	40-65
	Titanium, Ti-Alloy	35-60	45-75

