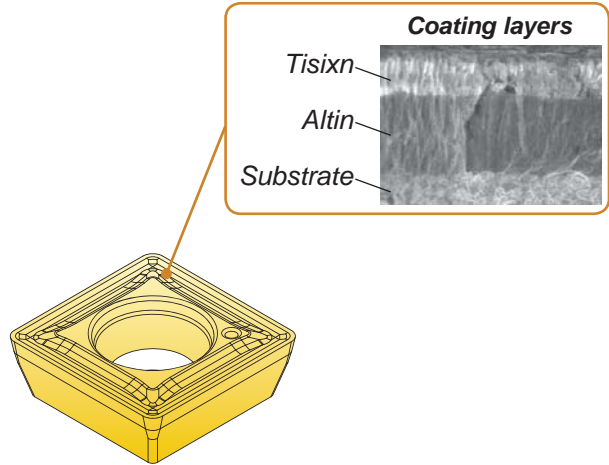


Grade Descriptions

Grade Code : CX31NS, CX41NS

Ingredient : Ti, Al, Si, N


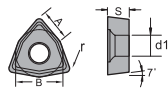




- Feature :
- Si contained
 - Improve the hardness and heat resistance
 - The Si NANO particles uniformly distributed
 - Effective protection of the substrate
 - Extend inserts life



Grade	ISO	Substrate (HRA)	Coating Type	Thickness	Coolant		Cutting Condition
					WET	DRY	
CX31NS	P20~P30 M15~M30 K30	91.6	TiSixN	Thin	★ ★	★	Medium Continuous
CX41NS	P20~P40 M20~M40 K30	90.0	TiSixN	Thin	★ ★	★	Rough Interrupted

Chip breaker design



Inserts	Designation	Grade					Dimensions (mm)						Drawing
		CX21NS	CX31NA	CX31NS	CX41NS	CX41NA	A	B	S	r	d1	t1	
	WCMT 030208-MM			✓	✓		3.8	5.56	2.38	0.8	2.8	-	
	WCMT 040208-MM			✓	✓		4.3	6.35	2.38	0.8	3.0	-	
	WCMT 050308-MM			✓	✓		5.4	7.94	3.18	0.8	3.4	-	
	WCMT 06T308-MM			✓	✓		6.5	9.53	3.97	0.8	4.0	-	
	WCMT 080412-MM			✓	✓		8.7	12.7	4.76	1.2	4.3	-	

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