

PCD Grade for Non-Ferrous Metals Turning

MD220 VCGW Type



Suitable for Cutting Aluminum Alloys and Non-ferrous Metal Components on Small Automatic Lathes

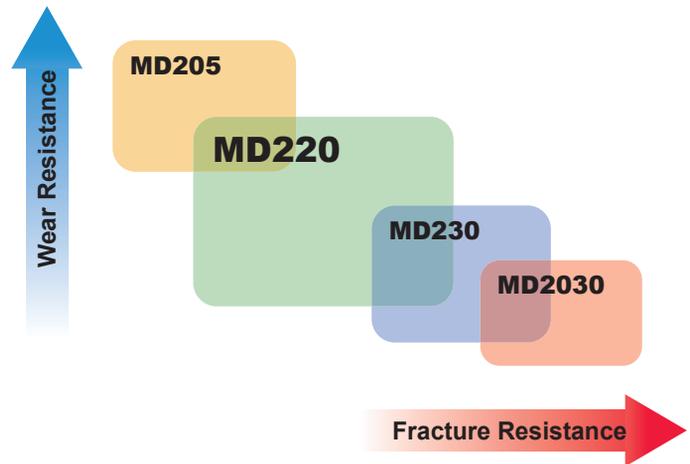
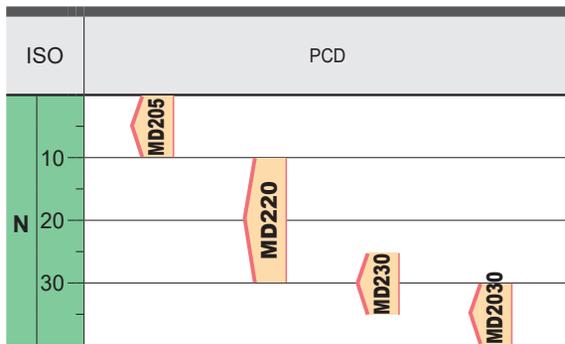
Proficient in various machining applications such as external turning and internal boring, because of the strong, tough edge and the availability to utilize both edge hands.



For General Machining MD220

Sintered medium grain diamond particles. Wear resistance and fracture resistance are superbly balanced. Applicable to general finishing of non-ferrous metals, non-metal cutting, and similar machining.

● Aluminum Alloy



Suitable for cutting materials such as nonferrous metals and fiber reinforced plastics (FRP) including aluminum alloys. It supports ultra high speed finish cutting.

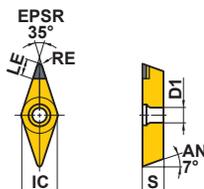
Positive Inserts (With Hole)

G Class

Flat Top



VCGW



(inch)

Order Number	MD220	Cutting Edges	IC	S	RE	D1	LE
VCGW220.2	●	1	.250	.125	.004	.110	.122
VCGW220.5	●	1	.250	.125	.008	.110	.118
VCGW221	●	1	.250	.125	.016	.110	.102

● : USA Stock (1 insert in one case)

Recommended Cutting Conditions

(inch)

Work Material	Cutting Speed vc (SFM)	Feed f (IPM)	Depth of Cut ap
Aluminium Alloy (Si ≤ 12%)	2625 (655—3935)	— .008	— .039
Aluminium Alloy (Si ≥ 13%)	1970 (655—3280)	— .008	— .039
Copper Alloy	2295 (655—3935)	— .008	— .039
Strengthened Plastic	1970 (330—3280)	— .016	— .039
Glass Fibre Reinforced Plastic	1640 (330—2625)	— .010	— .039
Carbon	1310 (330—1970)	— .012	— .039
Ceramics	165 (100—260)	— .004	— .039
Hard Rubber	1970 (985—2625)	— .006	— .039
Wood Inorganic Board	4265 (985—13120)	— .016	—
Cemented Carbide	50 (15—65)	— .008	— .020

For your safety

● Don't touch breakers and chips without gloves. ● Please machine within recommended application range, and exchange expired tools with new parts in advance. ● Please use safety cover and wear safety glasses. ● When using compounded cutting oils, please take fire prevention. ● When attaching inserts or spare parts, please use the attached wrench or driver. ● When using tools in revolution machining, please make a trial run to check run-out, vibration, abnormal sounds etc.

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(Tool specifications subject to change without notice.)

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