

# AMX Chipbreaker

For External machining | CNC automatic lathes



Ensure chip control even with a cutting depth of .012" (0.3mm) or less

**New** Lineup expansion radius **R .001" (0.03)** for ultra-precision finishing

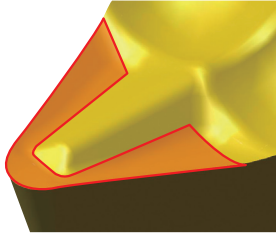
*CERtainly* | but not only | *CERamics*  
Outstanding solutions for demanding applications

**| Features**


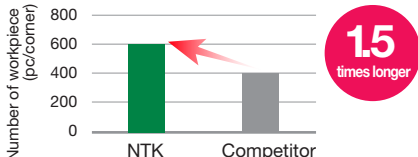
- Depth of cut ranges from .002" to .012" inch (0.05 to 0.3 mm).
- Specialized for ultra-low depth of cut and low feed machining, ideal for high-precision parts processing.
- Adding corner radius R .001" (0.03) for ultra-precision finishing.

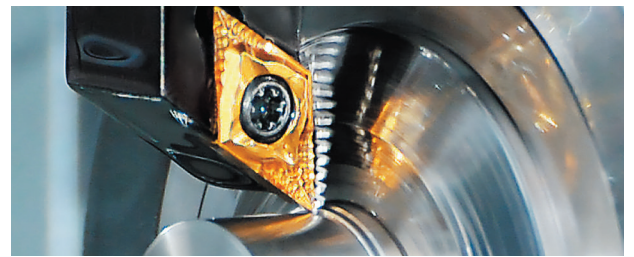
**| Sharp edge & double positive geometry**

Excellent cutting performance, effective in suppressing burrs and improving machining accuracy.

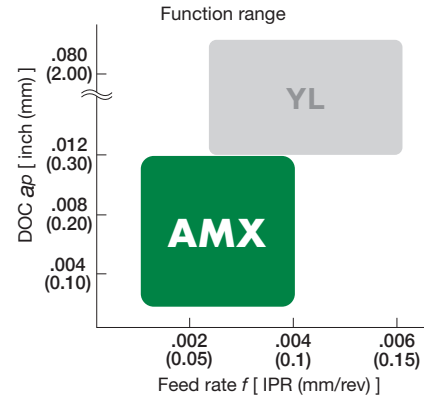


**| Practical example**

Insert	DCGT32.508MAMX (DCGT11T302MAMX) DM4	
Workpiece	S45C / C45 / 1045 	
Cutting condition	Cutting speed	310 SFM (94 m/min)
	Rotation speed	2500 rpm
	Feed rate	.003" IPR (0.08 mm/rev)
	DOC	.008" inch (0.2 mm)
	Coolant	WET
Results		



Ensure reliable chip control even with low depth of cut and low feed rate.



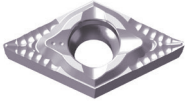
DOC .002" inch~ (0.05 mm~), Feed .0008" IPR~ (0.02 mm/rev~)  
Outstanding chip control

Chip shape «SUS304»  
vc=260 SFM (80 m/min) f=.0008" IPR (0.02 mm/rev)  
ap=.002" inch (0.05 mm) WET



Small curl diameter with stable chip control performance

**| Lineup**

Shape	Designation		IC		Thickness		Corner Radius		PVD grade				
	Inch	Metric	Inch	Metric	Inch	Metric	Inch	Metric	650	ST4	DM4	DT4	TM4
	DCGT21.501AMX	DCGT070200AMX	.250	6.35	.094	2.38	.001	0.03			●		●
	DCGT21.504MAMX	DCGT070201MAMX	.250	6.35	.094	2.38	.003	0.08		●	●	●	●
	DCGT21.508MAMX	DCGT070202MAMX	.250	6.35	.094	2.38	.007	0.18		●	●	●	●
	DCGT21.51MAMX	DCGT070204MAMX	.250	6.35	.094	2.38	.015	0.38			●	●	●
	DCGT32.501AMX	DCGT11T300AMX	.375	9.525	.156	3.97	.001	0.03			●		●
	DCGT32.504MAMX	DCGT11T301MAMX	.375	9.525	.156	3.97	.003	0.08	●	●	●	●	●
	DCGT32.508MAMX	DCGT11T302MAMX	.375	9.525	.156	3.97	.007	0.18	●	●	●	●	●
	DCGT32.51MAMX	DCGT11T304MAMX	.375	9.525	.156	3.97	.015	0.38	●	●	●	●	●

● NEW



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