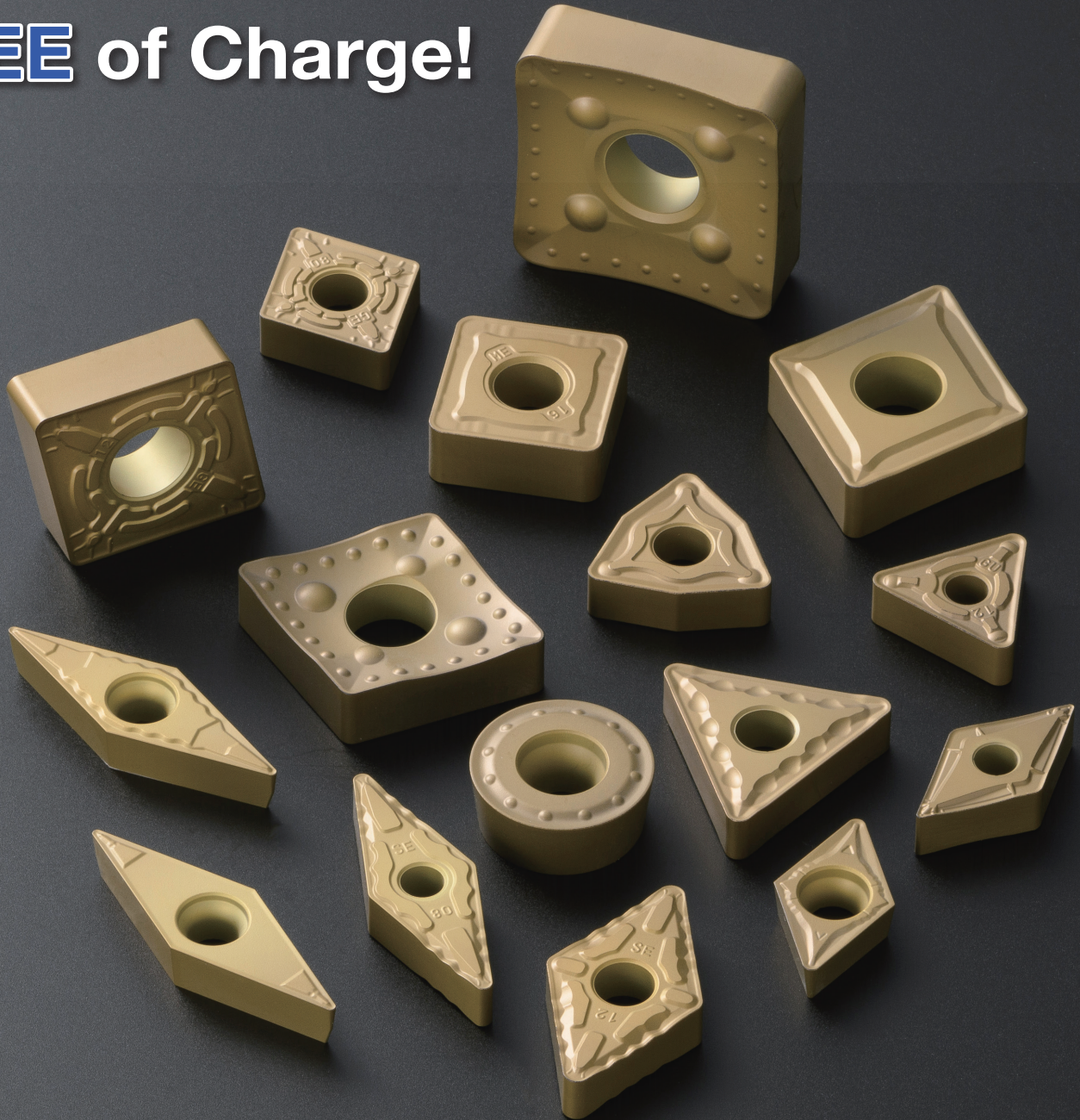




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*New*

## AC8115P

Steel Turning Grade for High-Speed Machining  
with Absotech™ CVD Coating Technology



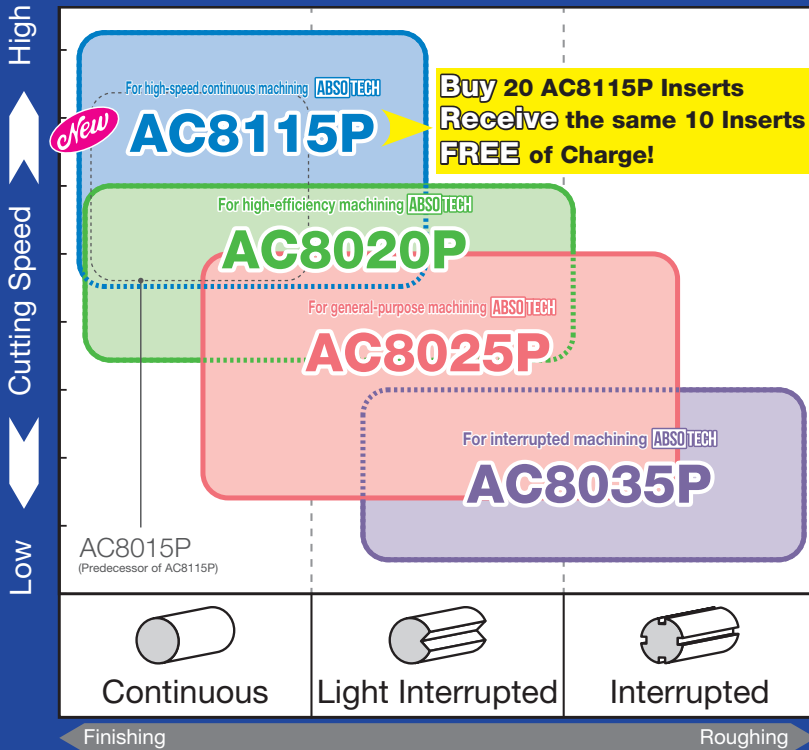
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**New AC8115P**

Steel Turning Grade for High-Speed Machining with Absotech™ CVD Coating Technology

**Application Range**



<b>AC8115P</b> <i>New</i>	CVD ABSOTECH	<b>Amazing Wear Resistance</b>	<b>Crater wear resistance 1.5x</b> against conventional tools
<b>AC8020P</b>	CVD ABSOTECH	<b>Standout Chipping Resistance</b>	<b>Chipping resistance in high-efficiency machining 2.5x</b> against conventional tools
<b>AC8025P</b>	CVD ABSOTECH	<b>Absolute Reliability</b>	<b>Adhesion resistance/chipping resistance 2x</b> against conventional tools
<b>AC8035P</b>	CVD ABSOTECH	<b>Exceptional Stability</b>	<b>Fracture resistance in interrupted machining 2x</b> against conventional tools

**AC8115P Recommended Cutting Conditions**

Insert Shape / Cutting Edge Length	Chipbreaker	Mild Steel (A283, etc.) Low Carbon Steel (1018, etc.) Low-alloy Steel (8620, etc.) 180HB or less			High Carbon Steel (1040, etc.) High-alloy Steel (4140, etc.) 180HB or more		
		Depth of Cut $a_p$ (inch)	Feed Rate $f$ (IPR)	Cutting Speed $v_c$ (SFM)	Depth of Cut $a_p$ (inch)	Feed Rate $f$ (IPR)	Cutting Speed $v_c$ (SFM)
CNM□43□ TNM□33□ DNM□43□ TNM□43□ SNM□43□ WNM□43□	EFE	.004 - .047	.004 - .016	623 - 1640	.004 - .047	.004 - .016	459 - 1476
	ELU/ESU/ESE	.020 - .079	.004 - .016	558 - 1640	.020 - .079	.004 - .016	427 - 1476
	ESEW	.020 - .098	.004 - .024	558 - 1640	.020 - .098	.004 - .024	427 - 1476
	EGU/EGE/EUX	.031 - .197	.004 - .018	558 - 1640	.031 - .197	.004 - .018	427 - 1476
	EMU	.071 - .236	.008 - .024	459 - 1444	.071 - .236	.008 - .024	361 - 1247
	EME	.039 - .236	.008 - .028	459 - 1444	.039 - .236	.008 - .028	361 - 1247
CNM□54□ SNM□54□	EHG	.118 - .315	.014 - .031	459 - 1444	.118 - .315	.014 - .031	361 - 1247
	EGU/EGE/EUX	.031 - .197	.006 - .018	459 - 1312	.031 - .197	.006 - .018	361 - 1247
	EMU	.071 - .236	.008 - .024	459 - 1181	.071 - .236	.008 - .024	361 - 984
	EME	.059 - .276	.008 - .028	459 - 1181	.059 - .276	.008 - .028	361 - 984
CNM□64□ SNM□64□ CNM□86□ SNM□86□ DNM□54□ TNM□54□	EHG	.118 - .315	.014 - .031	394 - 1083	.118 - .315	.014 - .031	295 - 886
	EMU	.071 - .236	.008 - .024	459 - 1181	.071 - .236	.008 - .024	361 - 984
	EME	.079 - .315	.008 - .028	459 - 1181	.079 - .315	.008 - .028	361 - 984
	EHG	.118 - .354	.014 - .031	394 - 1083	.118 - .354	.014 - .031	295 - 886

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