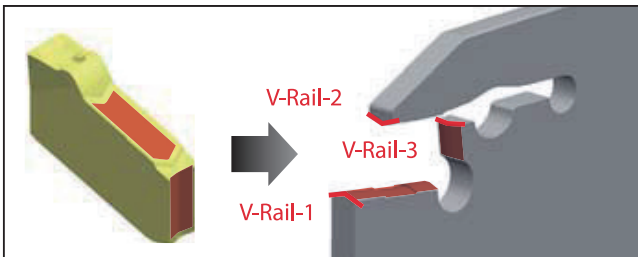


The Sawman-X Parting range is the 1st choice system for high performance parting off.

Sawman-X inserts feature a special treatment on the cutting edge for higher precision chip control and longer tools life. The three-way V-Rail clamping system provides enhanced stability and reduced vibration in high feed parting or deep grooving.

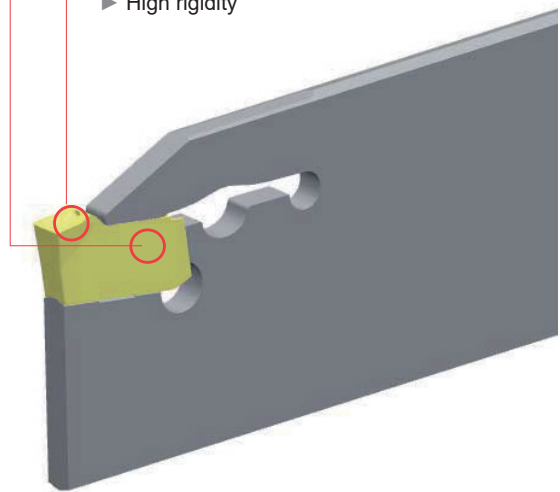
Three-Way V-Rail Clamping System

- ▶ Insert is tightly clamped in the tip seat, preventing tool pull out
- ▶ Minimized vibration during the machining increases stability.
- ▶ Stable high speed, high feed and high depth of cut machining is possible



Special Cutting Edge

- ▶ Exceptional chip control in high feed parting
- ▶ Stable performance during large depth of cut
- ▶ High rigidity



Recommended Cutting Conditions

Workpiece		Grade	CUTTING CONDITIONS	
			vc (m/min)	fn (mm/rev)
STEEL	Carbon Steel	PC5300	80-200	0.08-0.28
		PC3035	80-220	0.08-0.28
	Alloy Steel	PC5300	80-160	0.08-0.28
		PC3035	80-180	0.08-0.28
STAINLESS STEELS	316, 404, 17-4PH, Duplex	PC5300	80-160	0.08-0.28
CAST IRON	Grey Cast Iron	PC8110	100-220	0.10-0.28
		PC5300	100-200	0.10-0.28
	Modular Cast Iron	PC8110	80-200	0.10-0.25
		PC5300	80-180	0.10-0.25
HRSA	Inconel, Hastelloy, Titanium Alloys	PC8110	35-65	0.05-0.15
		PC5300	25-55	0.05-0.15