HPMT
High Precision Machining Tools





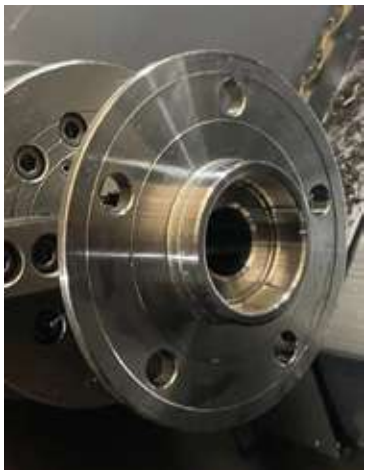
STEEL TURNING INSERTS

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P

CASE STUDY 1

CUTTING CONDITION			
Operation	:	Internal turning, Finishing	
Industry	:	Automotive	
Workpiece Material:	:	56Si7	
Workpiece Hardness	:	240 HB	
Workpiece Treatment	:	Machined	
TOOL TEST CONDITION			
Tool Producer	:	Competitor	HPMT
Insert	:	VNMG160408	VNMG160408
Chipbreaker	:	HQ	PM3
Grade	:	CA5525	HCP1000
Cooling	:	Emulsion	Emulsion
Cutting Speed (m/min)	:	420	420
Feed (mm/rev)	:	0.20	0.20
Depth of Cut ap (mm)	:	0.15	0.15
Machined Diameter (mm)	:	118	118
Machining Length (mm)	:	21	21
Tool Life (pcs/edge)	:	**60**	**70**





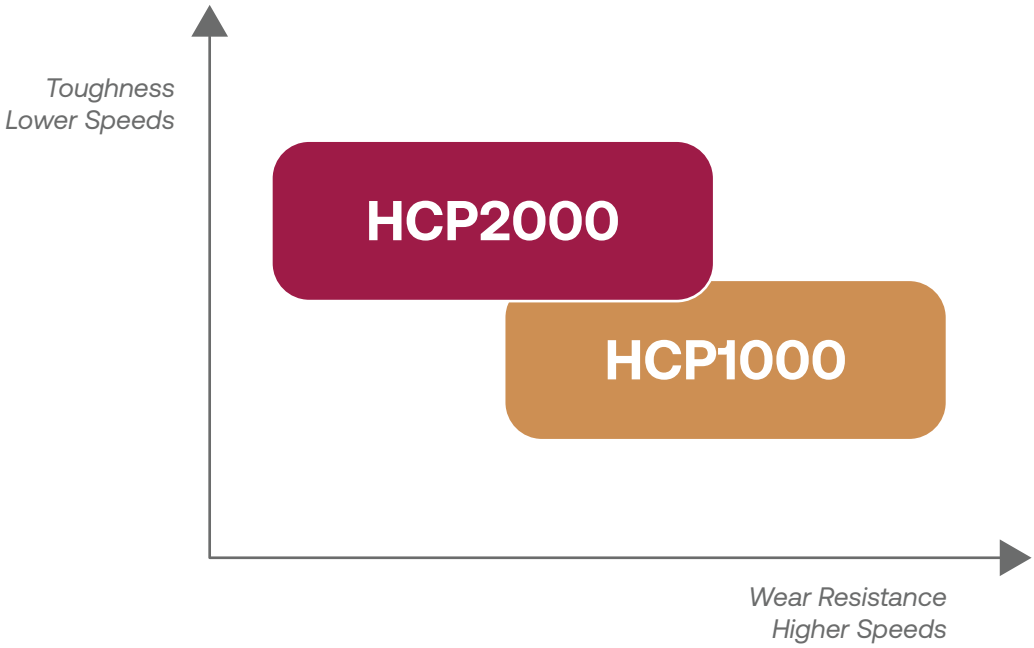
CASE STUDY 2

CUTTING CONDITION			
Operation	:	Longitudinal and Face Turning, Semi-Finishing	
Industry	:	Automotive	
Workpiece Material:	:	41Cr4	
Workpiece Hardness	:	200 HB	
Workpiece Treatment	:	Cast	
TOOL TEST CONDITION			
Tool Producer	:	Competitor	HPMT
Insert	:	WNMG080412	WNMG080412
Chipbreaker	:	PD5	PM3
Grade	:	AC252	HCP2000
Cooling	:	Emulsion	Emulsion
Cutting Speed (m/min)	:	268	268
Feed (mm/rev)	:	0.55	0.55
Depth of Cut ap (mm)	:	2	2
Machined Diameter (mm)	:	40-140	40-140
Machining Length (mm)	:	80	80
Tool Life (pcs/edge)	:	**20**	**25**



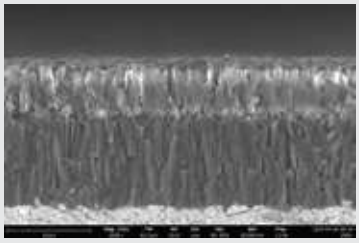


Grades Description



HCP1000: Unleash High-Speed Excellence

Redefine what's possible at high speeds. HCP1000 is meticulously designed for high-speed machining of all steel types, delivering unmatched performance even on steels up to 55 HRC.



SUPERIOR WEAR RESISTANCE

Features a high wear-resistant carbide substrate.

ADVANCED COATING

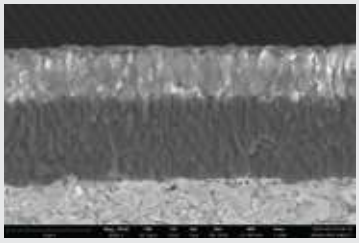
Enhanced with a cutting-edge MT-CVD TiCN-Al_2O_3 multilayer wear-resistant coating

OPTIMAL FOR FINISHING

Ideal for finishing and semi-finishing applications that demand speed and precision. Perfect for a wide range of steel types and hardness levels.

HCP2000: The Power of Balance in Medium-Speed Machining

Achieve the perfect harmony between toughness and wear resistance. HCP2000 is tailored for medium-speed machining, making it the go-to choice for semi-finishing and roughing tasks on steels up to 50 HRC and nodular cast iron.



ROBUST CARBIDE SUBSTRATE

Built to withstand demanding machining conditions.

ENHANCED COATING COMPOSITION

Coated with MT-CVD TiCN-Al_2O_3 featuring a higher TiCN content for improved toughness.

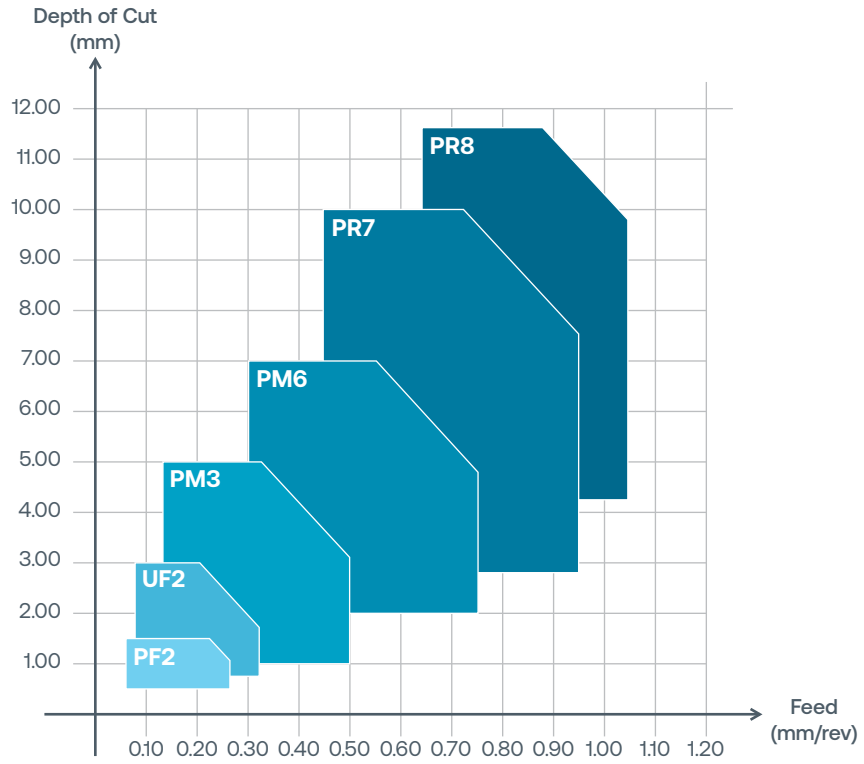
VERSATILE PERFORMANCE

Excels in both wear resistance and durability. Suitable for all steel types and nodular cast iron, ensuring flexibility in operations.

Steel Turning Chipbreakers

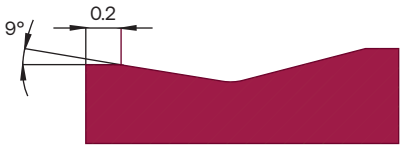
HPMT

P Carbon Steel



Chipbreakers

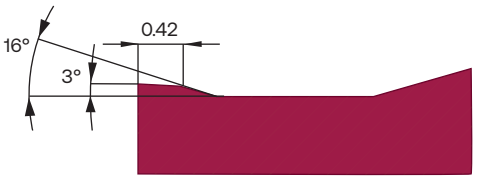
PF2



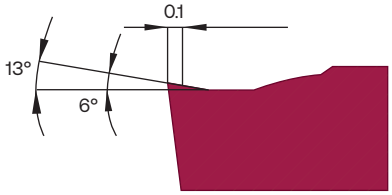


PM6





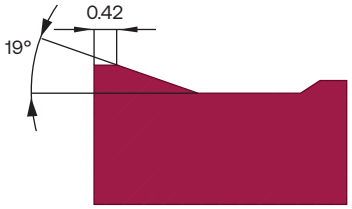
UF2



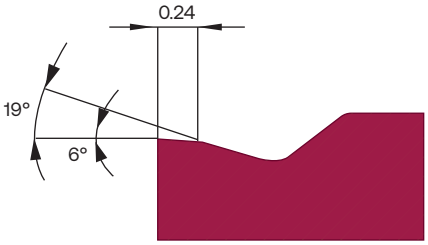


PR7





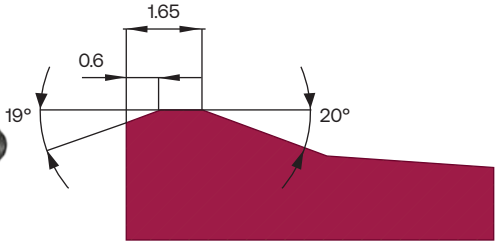
PM3





PR8





CCMT



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
CCMT060204-UF2 HCP1000	0.4	●			●				
CCMT060204-UF2 HCP2000	0.4		●		●				
CCMT060208-UF2 HCP1000	0.8	●			●				
CCMT060208-UF2 HCP2000	0.8		●		●				
CCMT09T304-UF2 HCP1000	0.4	●			●				
CCMT09T304-UF2 HCP2000	0.4		●		●				
CCMT09T308-UF2 HCP1000	0.8	●			●				
CCMT09T308-UF2 HCP2000	0.8		●		●				
CCMT120404-UF2 HCP1000	0.4	●			●				
CCMT120404-UF2 HCP2000	0.4		●		●				
CCMT120408-UF2 HCP1000	0.8	●			●				
CCMT120408-UF2 HCP2000	0.8		●		●				

CNMG



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
CNMG120404-PF2 HCP2000	0.4		●	●					
CNMG120404-PM3 HCP1000	0.4	●				●			
CNMG120404-PM3 HCP2000	0.4		●			●			
CNMG120408-PF2 HCP2000	0.8		●	●					
CNMG120408-PM3 HCP1000	0.8	●				●			
CNMG120408-PM3 HCP2000	0.8		●			●			
CNMG120412-PF2 HCP2000	1.2		●	●					
CNMG120412-PM3 HCP1000	1.2	●				●			
CNMG120412-PM3 HCP2000	1.2		●			●			
CNMG120412-PM6 HCP2000	1.2		●				●		
CNMG160612-PM6 HCP2000	1.2		●				●		
CNMG190612-PM6 HCP2000	1.2		●				●		
CNMG190616-PM6 HCP2000	1.6		●				●		

CNMM



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
CNMM190624-PR7 HCP1000	2.4	●						●	
CNMM190624-PR7 HCP2000	2.4		●					●	
CNMM250924-PR8 HCP1000	2.4	●							●
CNMM250924-PR8 HCP2000	2.4		●						●

DCMT



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
DCMT070204-UF2 HCP1000	0.4	●			●				
DCMT070204-UF2 HCP2000	0.4		●		●				
DCMT070208-UF2 HCP2000	0.8		●		●				
DCMT11T304-UF2 HCP2000	0.4		●		●				
DCMT11T308-UF2 HCP2000	0.8		●		●				

DNMG



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
DNMG110412-PM3 HCP2000	1.2		●			●			
DNMG150404-PF2 HCP2000	0.4		●	●					
DNMG150404-PM3 HCP2000	0.4		●			●			
DNMG150408-PF2 HCP2000	0.8		●	●					
DNMG150408-PM3 HCP1000	0.8	●				●			
DNMG150408-PM3 HCP2000	0.8		●			●			
DNMG150412-PM3 HCP2000	1.2		●			●			
DNMG150604-PM3 HCP2000	0.4		●			●			
DNMG150608-PM3 HCP2000	0.8		●			●			
DNMG150608-PM6 HCP2000	0.8		●				●		
DNMG150612-PM3 HCP2000	1.2		●			●			
DNMG150612-PM6 HCP1000	1.2	●					●		
DNMG150612-PM6 HCP2000	1.2		●				●		

SCMT



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
SCMT09T304-UF2 HCP2000	0.4		●		●				
SCMT09T308-UF2 HCP2000	0.8		●		●				
SCMT120408-UF2 HCP2000	0.8		●		●				

SNMG

HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
SNMG120404-PM3 HCP2000	0.4		●		●				
SNMG120408-PM3 HCP1000	0.8	●			●				
SNMG120408-PM3 HCP2000	0.8		●		●				
SNMG120412-PM3 HCP2000	1.2		●		●				
SNMG150612-PM6 HCP2000	1.2		●			●			
SNMG190612-PM6 HCP2000	1.2		●			●			
SNMG190616-PM6 HCP2000	1.6		●			●			

SNMM

HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
SNMM190616-PR7 HCP2000	1.6		●					●	
SNMM190624-PR8 HCP2000	2.4		●						●
SNMM250724-PR8 HCP2000	2.4		●						●
SNMM250924-PR8 HCP2000	2.4		●						●

TCMT

HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
TCMT090204-UF2 HCP2000	0.4		●		●				
TCMT110204-UF2 HCP2000	0.4		●		●				
TCMT16T304-UF2 HCP2000	0.4		●		●				
TCMT16T308-UF2 HCP2000	0.8		●		●				

TNMG



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
TNMG160404-PF2 HCP1000	0.4	●		●					
TNMG160404-PF2 HCP2000	0.4		●	●					
TNMG160404-PM3 HCP1000	0.4	●				●			
TNMG160404-PM3 HCP2000	0.4		●			●			
TNMG160408-PF2 HCP1000	0.8	●		●					
TNMG160408-PF2 HCP2000	0.8		●	●					
TNMG160408-PM3 HCP1000	0.8	●				●			
TNMG160408-PM3 HCP2000	0.8		●			●			
TNMG160412-PF2 HCP1000	1.2	●		●					
TNMG160412-PF2 HCP2000	1.2		●	●					
TNMG160412-PM3 HCP1000	1.2	●				●			
TNMG160412-PM3 HCP2000	1.2		●			●			

VBMT



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
VBMT110304-UF2 HCP2000	0.4		●		●				
VBMT110308-UF2 HCP2000	0.8		●		●				
VBMT160404-UF2 HCP2000	0.4		●		●				
VBMT160408-UF2 HCP2000	0.8		●		●				

VNMG



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
VNMG160404-PF2 HCP1000	0.4	●		●					
VNMG160404-PF2 HCP2000	0.4		●	●					
VNMG160404-PM3 HCP2000	0.4		●			●			
VNMG160408-PF2 HCP1000	0.8	●		●					
VNMG160408-PF2 HCP2000	0.8		●	●					
VNMG160408-PM3 HCP1000	0.8	●				●			
VNMG160408-PM3 HCP2000	0.8		●			●			
VNMG160412-PF2 HCP2000	1.2		●	●					
VNMG160412-PM3 HCP2000	1.2		●			●			

WNMG



HPMT DESIGNATION	Corner (mm)	HCP 1000	HCP 2000	PF2	UF2	PM3	PM6	PR7	PR8
WNMG060408-PM3 HCP2000	0.8		●			●			
WNMG080404-PF2 HCP1000	0.4	●		●					
WNMG080404-PF2 HCP2000	0.4		●	●					
WNMG080404-PM3 HCP1000	0.4	●				●			
WNMG080404-PM3 HCP2000	0.4		●			●			
WNMG080408-PF2 HCP1000	0.8	●		●					
WNMG080408-PF2 HCP2000	0.8		●	●					
WNMG080408-PM3 HCP1000	0.8	●				●			
WNMG080408-PM3 HCP2000	0.8		●			●			
WNMG080412-PF2 HCP1000	1.2	●		●					
WNMG080412-PF2 HCP2000	1.2		●	●					
WNMG080412-PM3 HCP1000	1.2	●				●			
WNMG080412-PM3 HCP2000	1.2		●			●			

Recommended Cutting Speeds

HPMT

		Cutting Speed (Vc)							
		HCP 1000				HCP 2000			
		m/min		SFM		m/min		SFM	
		min	max	min	max	min	max	min	max
Carbon Steels	125 HB	250	420	820	1380	200	340	660	1120
	190 HB	220	360	720	1180	170	290	560	950
	250 HB	200	330	660	1080	160	260	520	850
Alloy Steels (<5% alloying elements)	180 HB	210	350	690	1150	170	280	560	920
	230 HB	190	310	620	1020	150	250	490	820
	280HB	170	290	560	950	140	230	460	750
	350 HB	150	250	490	820	120	200	390	660
Tool Steels (>5% alloying elements)	220 HB	140	230	460	750	110	180	360	590
	280 HB	120	200	390	660	100	160	330	520
	320 HB	90	150	300	490	70	120	230	390
	350 HB	80	130	260	430	60	100	200	330
Grey, Malleable, CGI Cast Irons	125 HB	270	450	890	1480	220	360	720	1180
	190 HB	240	400	790	1310	190	320	620	1050
	250 HB	210	350	690	1150	170	280	560	920
Nodular, ADI Cast Irons	180 HB	190	320	620	1050	160	260	520	850
	230 HB	170	290	560	950	140	230	460	750
	280HB	160	270	520	890	130	220	430	720
	350 HB	140	230	460	750	110	180	360	590
Tool Steels, White Cast Irons	45 HRC	50	90	160	300				
	55 HRC	40	60	130	200				

Technical Formula

Parameter	Metric Formula	Metric Unit	American Formula	American Unit
Cutting Speed	$V_c = \frac{D_m \times \pi \times n}{1000}$	m/min	$V_c = \frac{D_m \times n}{382}$	SFM
Rotation	$n = \frac{V_c \times 1000}{D_m \times \pi}$	RPM	$n = \frac{V_c \times 12}{D_m \times \pi}$	RPM
Cutting Time	$T_c = \frac{l_m}{f_n \times n}$	min	$T_c = \frac{l_m}{f_n \times n}$	min
Surface Roughness	$R_{max} = \frac{f_n^2}{r_\varepsilon} \times 125$	µm	$R_{max} = \frac{f_n^2}{r_\varepsilon} \times 4921.26$	µin
Metarial Removal Rate	MRR = Ap x fn x Vc	cm^3/min	MRR = Ap x fn x Vc x 12	in^3/min

Symbol	Designation	Metric Unit	American Unit
D_m	Machining Diameter	mm	in
f_n	Feed per Revolution	mm/rev	IPR
l_m	Machining Length	mm	in
r	Nose Radius	mm	in

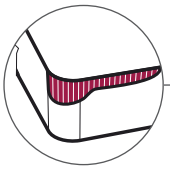
Recommended Feeds

HPMT

			UF2				PF2				PM3			
			Feed mm/rev		IPR		Feed mm/rev		IPR		Feed mm/rev		IPR	
			min	max	min	max	min	max	min	max	min	max	min	max
P	Carbon Steels	125 HB	0.13	0.32	0.005	0.013	0.11	0.25	0.004	0.010	0.19	0.52	0.008	0.021
		190 HB	0.12	0.30	0.005	0.012	0.11	0.23	0.004	0.009	0.18	0.48	0.007	0.019
		250 HB	0.12	0.29	0.005	0.011	0.10	0.22	0.004	0.009	0.17	0.46	0.007	0.018
	Alloy Steels (<5% alloying elements)	180 HB	0.12	0.29	0.005	0.012	0.10	0.23	0.004	0.009	0.18	0.48	0.007	0.019
		230 HB	0.11	0.28	0.005	0.011	0.10	0.22	0.004	0.009	0.17	0.45	0.007	0.018
		280HB	0.11	0.27	0.004	0.011	0.10	0.21	0.004	0.008	0.17	0.44	0.007	0.017
		350 HB	0.11	0.26	0.004	0.010	0.09	0.20	0.004	0.008	0.16	0.41	0.006	0.016
	Tool Steels (>5% alloying elements)	220 HB	0.10	0.25	0.004	0.010	0.09	0.19	0.004	0.008	0.15	0.40	0.006	0.016
		280 HB	0.10	0.24	0.004	0.009	0.09	0.18	0.003	0.007	0.15	0.38	0.006	0.015
		320 HB	0.09	0.22	0.004	0.009	0.08	0.17	0.003	0.007	0.14	0.35	0.005	0.014
		350 HB	0.09	0.21	0.004	0.008	0.08	0.16	0.003	0.006	0.13	0.34	0.005	0.013
K	Grey, Malleable, CGI Cast Irons	125 HB	0.13	0.33	0.005	0.013	0.12	0.26	0.005	0.010	0.20	0.54	0.008	0.021
		190 HB	0.13	0.31	0.005	0.012	0.11	0.24	0.004	0.010	0.19	0.51	0.007	0.020
		250 HB	0.12	0.29	0.005	0.012	0.10	0.23	0.004	0.009	0.18	0.48	0.007	0.019
	Nodular, ADI Cast Irons	180 HB	0.11	0.28	0.005	0.011	0.10	0.22	0.004	0.009	0.17	0.46	0.007	0.018
		230 HB	0.11	0.27	0.004	0.011	0.10	0.21	0.004	0.008	0.17	0.44	0.007	0.017
		280HB	0.11	0.26	0.004	0.010	0.09	0.21	0.004	0.008	0.16	0.43	0.006	0.017
		350 HB	0.10	0.25	0.004	0.010	0.09	0.19	0.004	0.008	0.15	0.40	0.006	0.016
H	Tool Steels, White Cast Irons	45 HRC	0.08	0.19	0.003	0.008	0.07	0.15	0.003	0.006	0.13	0.32	0.005	0.012
		55 HRC	0.08	0.18	0.003	0.007	0.07	0.14	0.003	0.006	0.12	0.30	0.005	0.012

			PM6				PR7				PR8			
			Feed mm/rev		IPR		Feed mm/rev		IPR		Feed mm/rev		IPR	
			min	max	min	max	min	max	min	max	min	max	min	max
P	Carbon Steels	125 HB	0.35	0.75	0.014	0.030	0.48	0.95	0.019	0.037	0.64	1.05	0.025	0.041
		190 HB	0.33	0.70	0.013	0.027	0.45	0.88	0.018	0.035	0.60	0.98	0.024	0.038
		250 HB	0.32	0.67	0.013	0.026	0.44	0.85	0.017	0.033	0.58	0.94	0.023	0.037
	Alloy Steels (<5% alloying elements)	180 HB	0.33	0.69	0.013	0.027	0.45	0.87	0.018	0.034	0.59	0.96	0.023	0.038
		230 HB	0.31	0.65	0.012	0.026	0.43	0.83	0.017	0.033	0.57	0.91	0.022	0.036
		280HB	0.30	0.63	0.012	0.025	0.42	0.80	0.016	0.032	0.55	0.89	0.022	0.035
		350 HB	0.29	0.60	0.011	0.024	0.40	0.76	0.016	0.030	0.53	0.84	0.021	0.033
	Tool Steels (>5% alloying elements)	220 HB	0.28	0.58	0.011	0.023	0.39	0.74	0.015	0.029	0.51	0.81	0.020	0.032
		280 HB	0.27	0.55	0.011	0.022	0.37	0.70	0.015	0.028	0.49	0.78	0.019	0.031
		320 HB	0.25	0.51	0.010	0.020	0.35	0.64	0.014	0.025	0.46	0.71	0.018	0.028
		350 HB	0.25	0.49	0.010	0.019	0.34	0.62	0.013	0.025	0.45	0.69	0.018	0.027
K	Grey, Malleable, CGI Cast Irons	125 HB	0.36	0.78	0.014	0.031	0.50	0.98	0.020	0.039	0.66	1.09	0.026	0.043
		190 HB	0.34	0.73	0.014	0.029	0.47	0.93	0.019	0.037	0.63	1.03	0.025	0.040
		250 HB	0.33	0.69	0.013	0.027	0.45	0.87	0.018	0.034	0.59	0.96	0.023	0.038
	Nodular, ADI Cast Irons	180 HB	0.32	0.66	0.012	0.026	0.43	0.84	0.017	0.033	0.57	0.93	0.023	0.036
		230 HB	0.30	0.63	0.012	0.025	0.42	0.80	0.016	0.032	0.55	0.89	0.022	0.035
		280HB	0.30	0.62	0.012	0.024	0.41	0.78	0.016	0.031	0.54	0.86	0.021	0.034
		350 HB	0.28	0.58	0.011	0.023	0.39	0.74	0.015	0.029	0.51	0.81	0.020	0.032
H	Tool Steels, White Cast Irons	45 HRC	0.23	0.46	0.009	0.018	0.32	0.58	0.012	0.023	0.42	0.64	0.017	0.025
		55 HRC	0.22	0.43	0.009	0.017	0.30	0.54	0.012	0.021	0.40	0.60	0.016	0.024

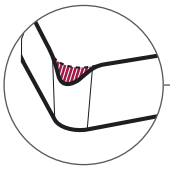
Troubleshooting



Flank Wear

Occurs from abrasion by hard particles, reducing the tool's flank surface.

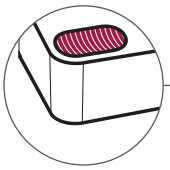
Solutions :
Lower cutting speed or use a harder grade.



Plastic Deformation

Tool material yields under excessive thermal and mechanical stress.

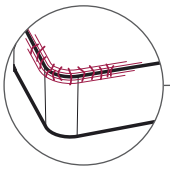
Solutions :
Opt for a harder grade, reduce cutting speed, or lower feed rate.



Crater Wear

Affects the tool's rake face, caused by high-speed abrasion and diffusion between the tool and workpiece.

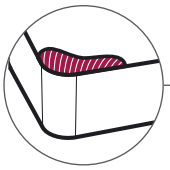
Solutions :
Decrease cutting speed, improve coolant flow, or switch to a harder grade.



Thermal Cracks

Caused by rapid temperature changes during interrupted cuts, worsened by improper coolant us

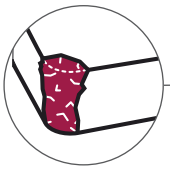
Solutions :
Use a tougher grade, direct coolant properly, reduce speed, or turn off coolant.



Built-up Edge (BUE)

Material from the workpiece sticks to the cutting tool due to pressure welding, common with sticky materials at low speeds.

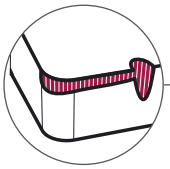
Solutions :
Adjust cutting speed to the optimal range, alter feed rate, or select a sharper chipbreaker.



Edge Chipping / Breakage

Results from excessive mechanical stress, possible from high feed rates, deep cuts, or improper tool setup.

Solutions :
Ensure parameters are correct, check toolholder and shim, use the appropriate tool. If breakage persists, retry with a new edge and diagnose before failure.



Notch Wear

Localized damage along the depth-of-cut line from adhesive and abrasive wear, typical in machining stainless steels and superalloys.

Solutions :
Vary depth of cut, use conical passes, or choose a harder grade or sharper chipbreaker.

Frequently Asked Questions

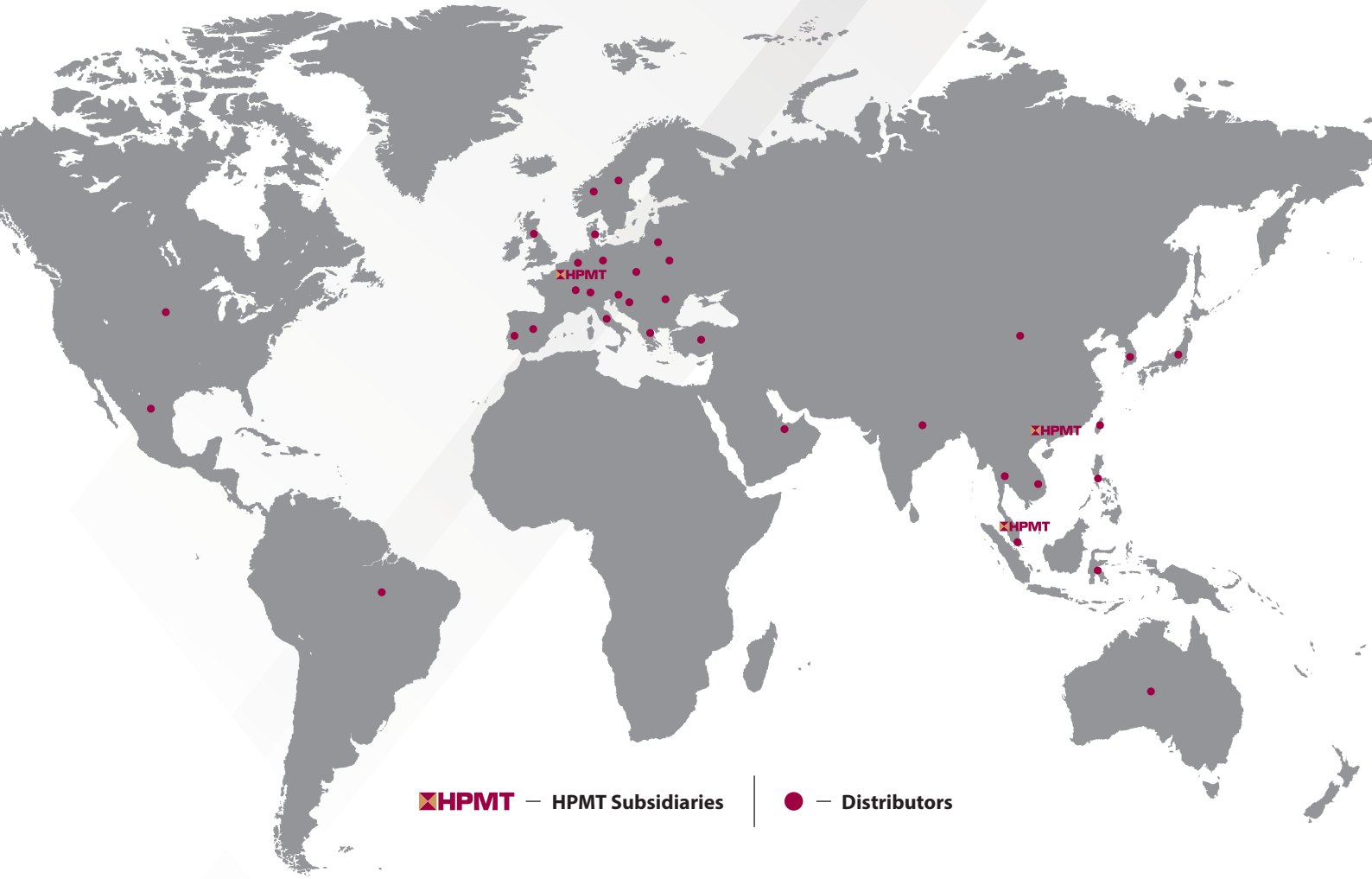
WHY IS HPMT EXPANDING INTO THE CARBIDE INSERTS BUSINESS?
We are expanding to offer you a complete range of tooling solutions. As tools get larger, using indexable carbide inserts becomes more efficient and sustainable. A wider range of products allows us to offer more tailored and innovative solutions to meet your specific needs. It also enables us to achieve economies of scope in production, R&D, sales, and marketing, which can improve our efficiency and lead to better pricing and service for you.

WHAT ADVANTAGES DO I GAIN FROM SOURCING TOOLS FROM A SINGLE SUPPLIER LIKE HPMT?
By consolidating your tooling needs with us, you streamline the procurement process and cut down on administrative tasks, which enhances supplier communication. Increased efficiency and potential cost savings arise from bulk purchasing and streamlined logistics. Consolidating services under one roof reduces complexity and improves the management of your supply chain.

WILL THE QUALITY OF HPMT'S CARBIDE INSERTS MATCH YOUR SOLID CARBIDE TOOLS?
Absolutely. We are committed to delivering the same high-quality standards across all our products. Our carbide inserts undergo rigorous testing to ensure they meet the performance and reliability you expect from HPMT.

HOW WILL HPMT SUPPORT ME DURING THIS TRANSITION TO INCLUDE CARBIDE INSERTS?
We are here to provide full support, including technical assistance, product training, and after-sales service, to ensure you seamlessly integrate our carbide inserts into your operations.

DOES THIS MOVE MEAN HPMT IS SHIFTING FOCUS AWAY FROM SOLID CARBIDE TOOLS?
Not at all. We remain dedicated to our solid carbide tools while enhancing our offerings to include carbide inserts. Our goal is to provide a comprehensive tooling solution that covers all your machining needs.



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