

Turning



C

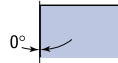
N

M

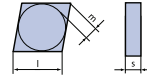
P



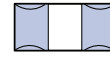
Shape
80° Diamond



Clearance Angle
0° No rake



Tolerance
d ± 0.05 m ± 0.08
s ± 0.13



Insert Type
Pin / Top clamp
Double sided

Insert designation	Grade	l	s	r	Catalog Nr.	Page
CNMP 120408 NN	LT 10	12	4,76	0,8	T0000062	33
CNMP 120412 NN	LT 10	12	4,76	1,2	T0000063	34

NN All Purpose Chipbreaker

	Application Guide	Super Finishing	Finishing	Semi Finishing	Roughing	Interrupted Cut
CNMP 120408 NN						
CNMP 120412 NN						

80° Diamond shape, double sided inserts with positive chip breaker geometry. Generates low cutting forces, suitable for High Temperature Alloys.

- 1** Not Recommended
- 2** Acceptable
- 3** Recommended
- 4** Excellent

Stainless Steel CNMP - TNMP - WNMP 1st CHOICE Exotic Material	CNMP TNMP WNMP	Exotic Material ! Cutting Conditions	Stainless Steel Vc
--	----------------------	--	-----------------------

Machining Recommendation Guide - Please see Pg. 8

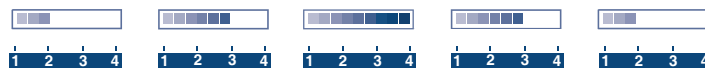


Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/rev]		A max [mm ²]	V _c [m/min]		Optimal cutting conditions	
				min	max	min	max		min	max	d.o.c	feed
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.50	5.0	0.21	0.45	1.8	180	350	3.0	0.35
			180		5.0		0.45	1.8		300		
			210		4.0		0.40	1.5		250		
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.50	5.0	0.21	0.40	1.2	120	280	3.0	0.30
			230		4.0		0.40	1.2		250		
			280		4.0	0.35	1.2	210				
			320		3.5	0.35	1.0	180				
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.50	4.0	0.18	0.40	1.2	70	190	2.5	0.28
			280		4.0		0.40	1.2		150		
			320		3.0		0.35	0.8		130		
			350	3.0	0.35	0.8	100					
			400	2.5	0.30	0.6	50	90	2.0	0.25		
			480	2.0	0.25	0.4	40	80	1.7	0.20		
550	1.7	0.20	0.3	30	70	1.0	0.18					
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.50	5.0	0.20	0.40	1.0	170	270	3.0	0.35
	5	X2 CrNiMo 17 2 2 316	230 to 270		4.0	0.18	0.35	0.8	160	210	3.0	0.32
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----		4.0	0.18	0.35	0.6	70	150	2.5	0.28
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.50	4.0	0.22	0.35	0.9	170	250	3.0	0.32
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed Treated	0.50	4.0	0.22	0.35	0.9	170	250	3.0	0.32
									120	190		
Grey Cast Iron	9	GG 20	140 to 230	0.50	5.0	0.15	0.60	2.0	170	250	3.0	0.35
		GG 25						1.8	230			
		GG 30						1.8	210			
Nodular Cast Iron	10	GGG 40	210	0.50	5.0	0.15	0.50	1.5	120	230	3.0	0.30
		GGG 50	260					1.3	190			
		GGG 70	310					1.2	150			
		G-X260NiCr42	450					0.50	1.7	0.11		
Nickel Based Alloys	11	Inconel 625	-----	0.50	3.0	0.20	0.35	0.7	25	35	2.0	0.28
		Inconel 718	-----					0.7	28	40		
		Hastelloy C	-----					0.8	40	65		
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	3.0	0.18	0.35	35	60	2.0	0.30	
		T40	-----				0.30	0.6	28	40	2.0	0.28

CNMP

Insert designation Super Finishing Finishing Semi Finishing Roughing Interrupted Cut

CNMP 120408 NN



Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/rev]		A max [mm ²]	V _c [m/min]		Optimal cutting conditions		
				min	max	min	max		min	max	d.o.c	feed	
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.50	5.0	0.27	0.68	3.1	180	330	4.0	0.50	
			180		5.0		0.68			280			
			210		5.0		0.60			250			
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.50	5.0	0.27	0.60	2.6	120	280	4.0	0.45	
			230		5.0		0.60			250			
			280		5.0	0.53	210						
			320		4.0	0.53	180						
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.50	5.0	0.23	0.60	2.0	70	190	4.0	0.40	
			280		5.0		0.60			150			
			320		4.0		0.53			130			
			350	4.0	0.53	100							
			400	0.50	3.5	0.14	0.45	1.2		50	90	3.4	0.36
			480		3.0		0.35	0.9		40	80	2.9	0.30
550	2.5	0.28	0.6	30	70	2.5	0.25						
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.50	5.0	0.26	0.52	1.7	170	270	4.0	0.40	
	5	X2 CrNiMo 17 2 2 316	230 to 270		5.0	0.23	0.46	1.4	160	210	4.0	0.36	
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----		5.0	0.23	0.46	1.0	70	150	4.0	0.32	
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.50	5.0	0.29	0.46	1.5	170	250	4.0	0.35	
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed Treated	0.50	5.0	0.29	0.46	1.5	170	250	4.0	0.35	
									120	190			
Grey Cast Iron	9	GG 20	140 to 230	0.50	5.0	0.20	0.90	3.0	170	250	4.0	0.60	
		GG 25						2.7		230			
		GG 30						2.7		210			
Nodular Cast Iron	10	GGG 40	210	0.50	5.0	0.20	0.70	2.3	120	230	4.0	0.50	
		GGG 50	260					2.0		190			
		GGG 70	310					1.8		150			
		G-X260NiCr42	450	0.50	1.8	0.06	0.15	0.3	30	50	1.2	0.12	
Nickel Based Alloys	11	Inconel 625	-----	0.50	5.0	0.26	0.46	1.4	25	35	3.0	0.38	
		Inconel 718	-----					1.4	28	40			
		Hastelloy C	-----					1.6	40	65			
Titanium Based Alloys	12	TiAl 6 V4	-----	0.50	5.0	0.23	0.46	1.6	35	60	3.0	0.38	
		T40	-----				0.39	1.2	28	40	3.0	0.32	

