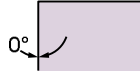


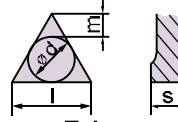
T N U X



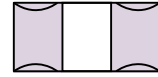
Shape



Clearance Angle



Tolerance
 $d \pm 0.08$
 $m \pm 0.13$
 $s \pm 0.13$



Fixing
 Chip breaker

Insert Designation	Grade	l	s	r	Catalog Nr.
TNUX 160404 R	LT 1000	16	4.76	0.4	T0001938
TNUX 160404 L	LT 1000	16	4.76	0.4	T0002794
TNUX 160408 R	LT 1000	16	4.76	0.8	T0001939
TNUX 160408 L	LT 1000	16	4.76	0.8	T0002795

60° Triangle shape inserts. Suitable for general Turning and longitudinal operations, where there is a concern for work piece vibrations.

Application Guide

	Finishing	Medium	Roughing / Interrupted cut	
TNUX 160404 R	😊	😐	😞	😊 = Good 😐 = Acceptable 😞 = Not recommended Finishing: d.o.c. = 0.30 - 1.50 mm fn = 0.08 - 0.20 mm/rev Medium: d.o.c. = 0.70 - 4.50 mm fn = 0.15 - 0.45 mm/rev Roughing d.o.c. = 3.00 - 7.00 mm fn = 0.35 - 0.70 mm/rev
TNUX 160404 L	😊	😐	😞	
TNUX 160408 R	😐	😊	😐	
TNUX 160408 L	😐	😊	😐	

Feed x d.o.c.
 =
 Amax

$V_c \Rightarrow$
 ↑ Productivity

Machine Recommendations Guide. Details on page 10

TNUX 160408 R&L LT 10 & LT 1000

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		Amax [mm²]	V _c [m/min]		Optimal cutting conditions					
					min	max	min	max		min	max	D.O.C.	Feed	V _c			
Steel	Non-alloyed	1	C35, Ck45, 1020,	125 HB	0.5	5.0	0.21	0.50	1.80	180	330	3.0	0.35	240			
		2	1045, 1060,	190 HB		5.0		0.50	1.80		280			220			
		3	28Mn6	250 HB		5.0		0.45	1.50		250			200			
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	5.0	0.21	0.45	1.20	120	280	3.0	0.32	200		
			4,6		230 HB		4.0	0.21	0.45	1.20	250	180					
			5,7		280 HB		4.0	0.18	0.40	1.20	210	150					
			8		350 HB		3.5	0.18	0.40	1.00	120	130					
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	4.0	0.18	0.40	1.20	70	190	2.5	0.30	140		
					280 HB				4.0	0.40		1.20			150	120	
					320 HB				3.0	0.35		0.80			130	100	
					350 HB				3.0	0.35		0.80			110	90	
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	5.0	0.20	0.40	1.20	170	270	3.0	0.35	190			
				240 HB				5.0	0.40	1.00	160			220	170		
	Duplex	5	14	X2CrNiN23-4, S31500	290 HB	0.5	4.0	0.18	0.35	0.80	80	150	2.5	0.28	100		
					310 HB				4.0	0.35	0.80	70			140	90	
	Ferritic & Martensitic	6	12	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	5.0	0.22	0.40	1.00	170	250	3.0	0.32	190		
					42 HRC				4.0	0.40	1.00	120			190	130	
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	5.0	0.15	0.60	2.00	170	250	3.0	0.35	200			
				200 HB				5.0	0.60	1.80	160			230	180		
				250 HB				5.0	0.55	1.80	150			210	160		
	Malleable & Nodular	8	17,19	GGG40, GGG70, 50005	150 HB	0.5	5.0	0.15	0.50	1.50	120	250	3.0	0.30	180		
					200 HB				5.0	0.50	1.30	230			160		
					250 HB				5.0	0.50	1.20	190			140		
High Temp. Alloys	Fe, Ni & Co based	9	31,32	Incoloy 800	0.5	3.0	0.20	0.35	0.70	25	45	2.0	0.28	32			
				33				Inconel 700	250 HB	3.0	0.35			0.70	25	45	30
				34				Stellite 21	350 HB	3.0	0.35			0.70	23	40	28
	Ti based	10	36	TiAl6V4	0.5	4.0	0.20	0.40	0.80	45	65	2.0	0.33	55			
37				T40				-	3.0	0.35	0.70			35	55	45	
Hardened Mat.	Steel	11	38	X100CrMo13,	0.5	2.5	0.11	0.30	0.60	50	100	2.0	0.25	80			
				440C,				50 HRC	2.0	0.25	0.40			40	90	70	
				G-X260NiCr42				55 HRC	1.5	0.20	0.30			40	80	60	
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.5	2.0	0.11	0.25	0.40	40	60	1.5	0.18	50			
	White Cast Iron	41	G-X300CrMo15	55 HRC	0.5	1.5	0.11	0.20	0.30	30	50	1.0	0.15	40			
NF	Al (>8%Si)	12	25	AISi12	130 HB	0.5	6.0	0.20	0.60	1.80	200	400	3.0	0.40	280		