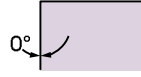


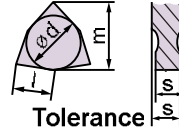
W N M G



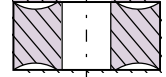
Shape



Clearance Angle



Tolerance



Fixing Chip breaker

s ± 0.13
For l = 06, d ± 0.05 m ± 0.08
For l = 08, d ± 0.08 m ± 0.13

* Available from Q2-2013

Insert Designation	Grade	l	s	r	Catalog Nr.
WNMG 060404 NN	LT 1000	6	4.76	0.4	T0001949
WNMG 060408 NN	LT 1000	6	4.76	0.8	T0001950
WNMG 060408 NX*	LT 1000	6	4.76	0.8	T0003014
WNMG 080404 NN	LT 1000	8	4.76	0.4	T0001951
WNMG 080408 NN	LT 1000	8	4.76	0.8	T0001952
WNMG 080408 NM	LT 1000	8	4.76	0.8	T0001969
WNMG 080408 NX	LT 1000	8	4.76	0.8	T0002742
WNMG 080412 NN	LT 1000	8	4.76	1.2	T0001953

Application Guide **NN** All purpose Chipbreaker **NX** All purpose Chipbreaker **NM** Steel and Cast Iron

Finishing Medium Roughing / Interrupted cut

WNMG 060404 NN	😊	😐	😞
WNMG 060408 NN	😐	😊	😐
WNMG 060408 NX	😊	😊	😐
WNMG 080404 NN	😊	😐	😞
WNMG 080408 NN	😐	😊	😊
WNMG 080408 NM	😞	😊	😊
WNMG 080408 NX	😐	😊	😊
WNMG 080412 NN	😞	😐	😊

😊 = 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

Stainless Steel
↑ V_C

↑ V_C ⇒
↑ **Productivity**

80° Trigon shape inserts, with 6 cutting edges. Suitable for all-purpose Turning, Facing and Boring operations.

Machine Recommendations Guide. Details on page 10

WNMG 080408 NX LT 1000

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/rev]		Amax [mm ²]	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	3.5	0.21	0.50	1.80	180	330	2.4	0.35	240	
		2	1045, 1060, 28Mn6	190 HB		3.5		0.50	1.80		280			220	
		3		250 HB		3.5		0.45	1.50		250			200	
	Low alloyed	2	6	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	3.5	0.21	0.45	1.20	120	280	2.4	0.32	200
			4,6		230 HB		2.8	0.21	0.45	1.20		250			180
			5,7		280 HB		2.8	0.18	0.40	1.20		210			150
			8		350 HB		2.5	0.18	0.40	1.00		180			130
	High alloyed	3	10	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	2.8	0.18	0.40	1.20	70	190	2.0	0.30	140
			10		280 HB		2.8		0.40	1.20		150			120
			11		320 HB		2.1		0.35	0.80		130			100
			11		350 HB		2.1		0.35	0.80		110			90
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	3.5	0.20	0.40	1.20	170	270	2.4	0.25	190	
				240 HB		3.5		0.40	1.00	160	220			170	
	Duplex	5	X2CrNiN23-4, S31500	290 HB	0.5	2.8	0.18	0.35	0.80	80	150	2.0	0.28	100	
				310 HB		2.8		0.35	0.80	70	140			90	
	Ferritic & Martensitic	6	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	3.5	0.22	0.40	1.00	170	250	2.4	0.32	190	
				42 HRc		2.8		0.40	1.00	120	190			130	
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	3.5	0.15	0.60	2.00	170	250	2.4	0.35	200	
				200 HB		3.5		0.60	1.80	160	230			180	
				250 HB		3.5		0.55	1.80	150	210			160	
	Malleable & Nodular	8	GGG40, GGG70, 50005	150 HB	0.5	3.5	0.15	0.50	1.50		250	2.4	0.30	180	
				200 HB		3.5		0.50	1.30	120	230			160	
				250 HB		3.5		0.50	1.20		190			140	
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800	240 HB	0.5	2.1	0.20	0.35		25	45	1.6	0.28	32	
				250 HB		2.1		0.35	0.70	25	45			30	
				350 HB		2.1		0.35		23	40			28	
	Ti based	10	TiAl6V4	-	0.5	2.8	0.20	0.40	0.80	45	65	1.6	0.33	55	
-				2.1		0.35		0.70	35	55	45				
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRc	0.5	1.8	0.11	0.30	0.60	50	100	1.6	0.25	80	
				50 HRc		1.5		0.25	0.40	40	90			70	
				55 HRc		1.5		0.20	0.30	40	80			60	
	Chilled Cast Iron	40	Ni-Hard 2	400 HB	0.5	1.5	0.11	0.25	0.40	40	60	1.2	0.18	50	
	White Cast Iron	41	G-X300CrMo15	55 HRc	0.5	1.5	0.11	0.20	0.30	30	50	0.8	0.15	40	
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	4.2	0.20	0.60	1.80	200	400	2.4	0.40	280