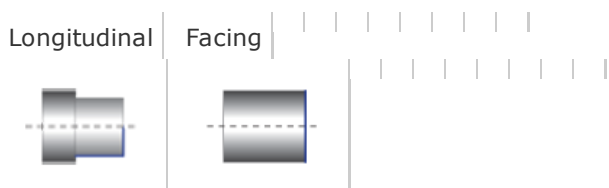
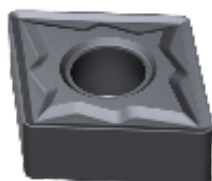


APPLICATION



GEOMETRY



C

N

M

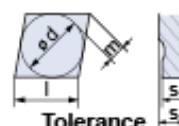
G



Shape



Clearance Angle



Tolerance
 d ± 0.08
 m ± 0.13
 s ± 0.13



Fixing
 Chip breaker

Product designation	Catalog Nr.	l	s	r	Tool Holders	Cutting Data			
CNMG 120404 NN LT 10	T0000491	12.00	4.76	0.4					
CNMG 120408 NM LT 10	T0001966	12.00	4.76	0.8					
CNMG 120408 NN LT 10	T0000059	12.00	4.76	0.8					
CNMG 120412 NN LT 10	T0000061	12.00	4.76	1.2					
NN: All purpose Chipbreaker	NM: For Steel and Cast Iron	The most popular general purpose Turning inserts	Use for Turning, Facing and Boring operations						

Application Guide	Finishing	Medium	Roughing / Interrupted cut
CNMG 120404 NN LT 10			
CNMG 120408 NM LT 10			
CNMG 120408 NN LT 10			

CNMG 120412 NN LT 10



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

Good
 Acceptable
 Not Recommended

Stainless Steel
/V_c

↑F ⇒
↑Productivity

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