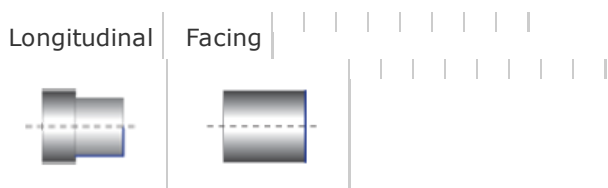


APPLICATION



GEOMETRY



C

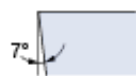
C

M

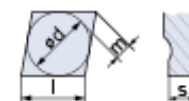
T



Shape



Clearance Angle



Tolerance

s ± 0.13
For l = 06/09, d ± 0.05 m ± 0.08
For l = 12, d ± 0.08 m ± 0.13



Fixing Chip breaker

Product designation	Catalog Nr.	l	s	r	Tool Holders	Cutting Data				
CCMT 060204 NN LT 10	T0000055	6.00	2.38	0.4						
CCMT 09T304 NN LT 10	T0000056	9.00	3.97	0.4						
CCMT 09T308 NN LT 10	T0000117	9.00	3.97	0.8						
CCMT 120404 NN LT 10	T0001456	12.00	4.76	0.4						
CCMT 120408 NN LT 10	T0001457	12.00	4.76	0.8						
CCMT 120412 NN LT 10	T0001776	12.00	4.76	1.2						
NN All purpose Chipbreaker	80° Diamond shape inserts, with positive chipbreaker geometry	Very popular and useful for Boring even of small diameters, Facing and external Turning operations								

Application Guide	Finishing	Medium	Roughing / Interrupted cut
CCMT 060204 NN LT 10			
CCMT 09T304 NN LT 10			
CCMT 09T308 NN LT 10			
CCMT 120404 NN LT 10			
CCMT 120408 NN LT 10			
CCMT 120412 NN LT 10			

<p>Finishing: d.o.c. = 0.30 - 1.50 mm fn = 0.08 - 0.20 mm/rev</p>	<p>Medium: d.o.c. = 0.70 - 4.50 mm fn = 0.15 - 0.45 mm/rev</p>	<p>Roughing: d.o.c. = 3.00 - 7.00 mm fn = 0.35 - 0.70 mm/rev</p>	<p> Good Acceptable Not Recommended</p>
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