



Yverdon-les-Bains, 10th January 2011  
NPR00001

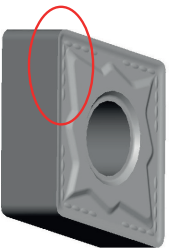
### Recommended Cutting Conditions

CNMG 120408 NM / WNMG 080408 NM

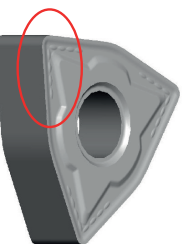
## NM Chipbreaker

We are now releasing two inserts with new chipbreakers, to be followed by other geometries:

• CNMG 120408 NM LT10

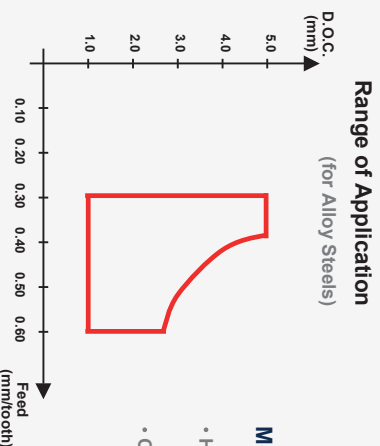


• WNMG 080408 NM LT10



### Main Advantages

- Chip jumping effect to delay craterization and increase tool life
- Extremely robust edge preparation
- Wide range of chip control (fragmentation range)



### Mostly recommended for:

- High Alloy Steel
- Cast Iron

Material Group	No.	Material	Brinell		d.o.c [mm]		feed [mm/rev]		Vc [m/min]		Optimal cutting conditions			
			min	max	min	max	min	max	min	max	d.o.c	Feed		
Low Carbon Steel	1	CK45	150	5.0	0.68	2.33					330			
		CK45	180	5.0	0.27	0.68	2.33	180	280	4.0	0.45			
		1020	210	5.0	0.60	1.95		250						
Alloy Steel	2	42 CrMo 4	180	5.0	0.60	1.95					280			
		Si50-2	230	5.0	0.60	1.50					250			
		CK60	280	5.0	0.53	1.50	120	190	4.0	0.35				
High Alloy Steel	3	X40 CrNiMo 5.1 40 NiCrMo 6 S 2-10-1-8 H13 D2 HSS M42	220	5.0	0.60	1.50	190				190			
			280	5.0	0.23	0.60	1.50	70			150			
			320	4.0	0.53	1.20			130			4.0	0.30	
			350	4.0	0.53	1.20			100					
			400	3.5	0.45	0.90	50	90	3.4			0.36		
			480	3.0	0.35	0.68	40	80	2.9			0.30		
			550	2.5	0.28	0.45	30	70	2.5			0.25		
			4	X8 CrNi 18 9	210 to 250									
			5	X2 CrNiMo 17 2 2	230 to 270									
			6	X6 CrNiMoTi 17 12 2	316 Ti									
7	X8 Cr 7	430	0.5	5.0	0.29	0.46	1.13	170	250	4.0	0.35			
Martensitic Stainless Steel	8	X15 Cr 13	410	0.5	5.0	0.29	0.46	1.13	170	250	4.0	0.35		
			annealed treated											
Grey Cast Iron	9	GG 20	140 to 230	0.5	5.0	0.20	0.90	2.03	170	230	4.0	0.60		
			GG 25	230				2.03	210					
			GG 40	210				1.73	220					
Nodular Cast Iron	10	GGG 50	280	0.5	5.0	0.20	0.70	1.50	120	190	4.0	0.50		
			GGG 70	310				1.35	150					
			G-X260NiC42	450	0.5	1.8	0.05	0.15	0.19	30	50	1.2	0.12	
Ni based Alloy	11	Inconel 625												
		Inconel 718												
Ti based Alloy	12	Hastelloy C												
		TAI 6 V4												
		T40												

NM Chipbreaker is not recommended for Exotic Alloy



### Ordering Information:

CNMG 120408 NM Catalog Nr. T0001966  
WNMG 080408 NM Catalog Nr. T0001967