



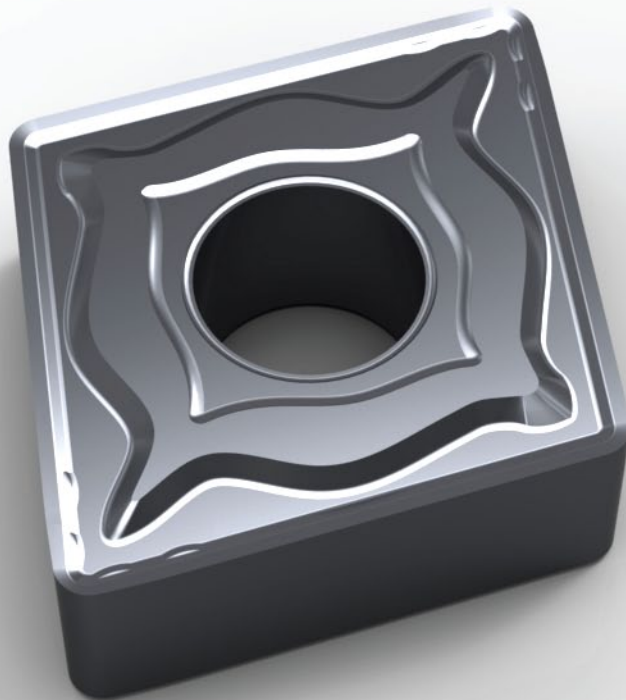
**LAMINA**  
TECHNOLOGIES

**magia**

 Swiss Quality

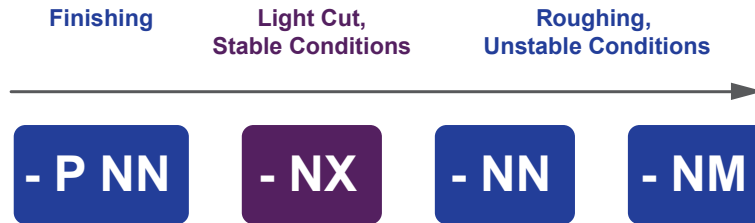


**NX Chipbreakers**



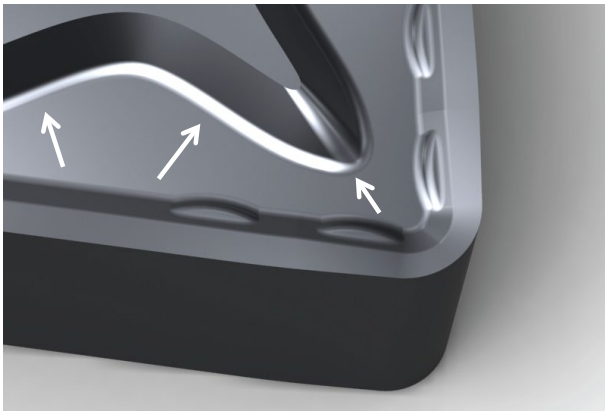
Lamina Technologies Marketing team is delighted to introduce you to our new NX chipbreaker dedicated to our Magia Line.

## Turning Chipbreakers



## Deflectors

Precisely positioned

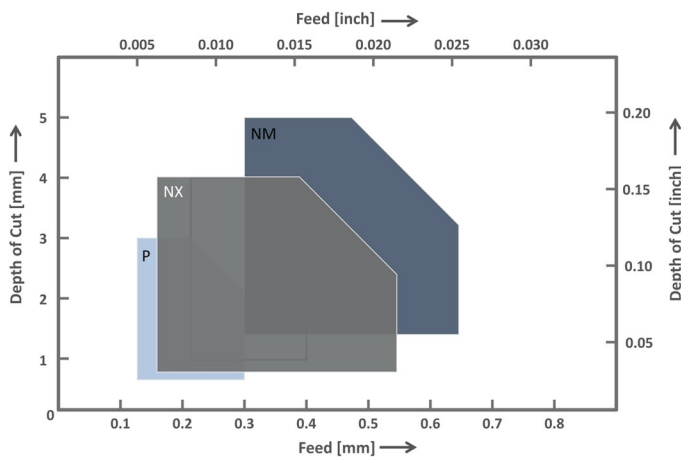


## NX Chipbreaker main advantages

- Increased performance in sticky materials
- Longer tool life in high cutting speed steel machining
- Predictable tool life, predictable crater growth

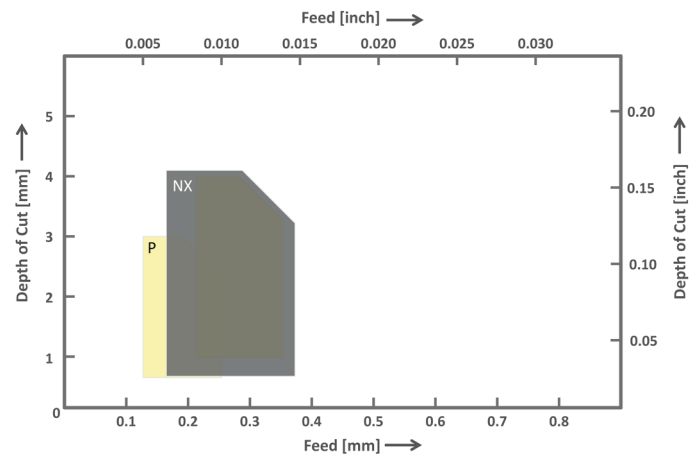
## Application Range:

Steel and Cast Iron

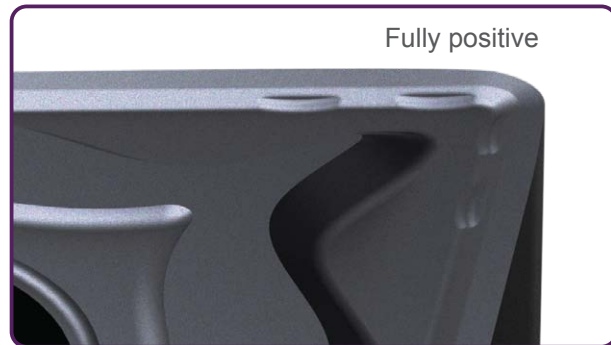
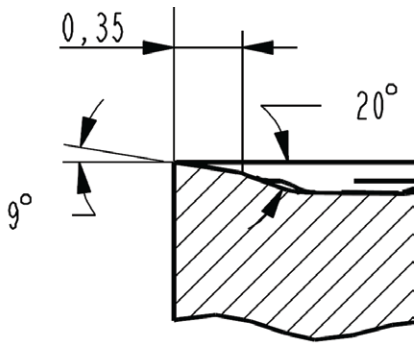


## Application Range:

Stainless and High Temperature Alloys



## Rake angle



## Tool Life: Roughing Steel

### Insert

CNMG 120408

### Material

42 CrMo 4 (4140)

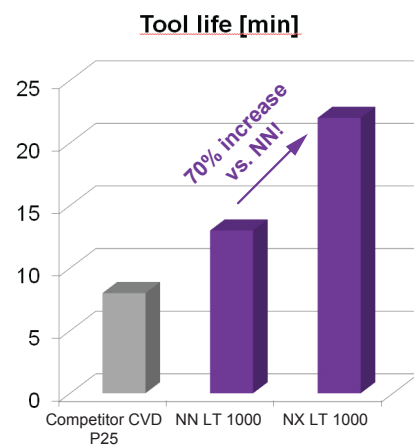
### Cutting Parameters

Cutting Speed = **300** m/min  
(985 sfm)

Feed = **0.30** mm/rev  
(0.012"/rev)

Depth of Cut = **2.00** mm  
(0.079")

With coolant



## Tool Life: Roughing Stainless

### Insert

CNMG 120408

### Material

X5CrNi18-10 (Stainless 304)

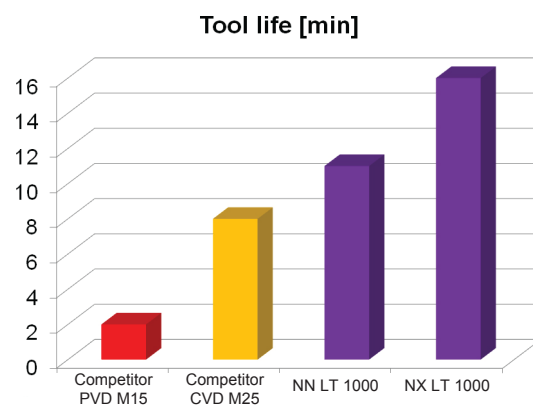
### Cutting Parameters

Cutting Speed = **230** m/min  
(760 sfm)

Feed = **0.30** mm/rev  
(0.012"/rev)

Depth of Cut = **2.00** mm  
(0.079")

With coolant



## NX Inserts range



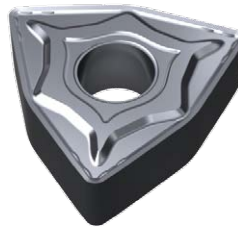
CNMG 120408 NX



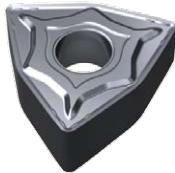
SNMG 120408 NX



TNMG 220408 NX



WNMG 080408 NX



WNMG 060408 NX



TNMG 160408 NX

# C

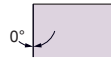
# N

# M

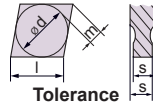
# G



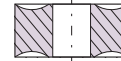
Shape



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.
CNMG 120408 NX*	LT 1000	12	4.76	0.8	T0002741
SNMG 120408 NX <sup>1</sup>	LT 1000	12	4.76	0.8	T0003011
TNMG 160408 NX <sup>1</sup>	LT 1000	16	4.76	0.8	T0003012
TNMG 220408 NX <sup>2</sup>	LT 1000	22	4.76	1.2	T0003013
WNMG 060408 NX <sup>1</sup>	LT 1000	6	4.76	0.8	T0003014
WNMG 080408 NX*	LT 1000	8	4.76	0.8	T0002742

\* Available

<sup>1</sup> Available from Q1 2013

<sup>2</sup> Available from Q2 2013

