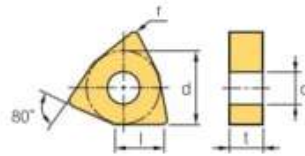


B Turning Insert (Negative)

WN



Dimensions (mm)			
Size	d	t	d ₁
06	9.525	4.76	3.81
08	12.7	4.76	5.16

Trigon **80° Negative**

Workpiece	Steel	P																	Machining types	
	Stainless steel	M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●		
	Cast iron	K	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●		
	Non-ferrous metal	N																●		
	Heat resistant alloy, Titanium alloy	S																●		
	Hardened steel	H																●		

● Continuous cutting
● General cutting
* Interrupted cutting

	Inserts	Designation	Cermet		Coated		Coated												Uncoated		Cutting Condition						
			CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	fn (mm/rev)	ap (mm)
Medium cutting	VP3 	WNGG 080404-VP3																								0.10-0.45	0.50-5.00
Roughing		WNMA 060404																								0.10-0.30	0.50-3.00
		060408												●												0.10-0.30	0.50-3.00
		060412																								0.10-0.40	1.00-3.00
		080404												●												0.15-0.60	1.00-5.00
		080408												●												0.15-0.60	1.00-6.00
		080412												●												0.15-0.70	1.50-6.00
		080416																								0.15-0.70	1.50-6.00
Finishing		WNMG 080404-VB						●	●		●															0.10-0.35	0.30-1.50
		080408-VB						●	●		●															0.15-0.45	0.50-2.00
		080412-VB						●	●																	0.18-0.45	0.80-2.50
Finishing		WNMG 060404-VF		●								●														0.07-0.30	0.50-1.50
		060408-VF																								0.10-0.40	0.50-1.50
		080404-VF							●			●														0.07-0.30	0.50-1.50
		080408-VF										●														0.10-0.40	0.50-1.50
		080412-VF																								0.20-0.50	0.50-1.50
Finishing	 [Mild steel]	WNMG 060404-VL																								0.05-0.25	0.20-1.50
		080404-VL																								0.05-0.25	0.10-1.00
		080408-VL								●		●														0.10-0.35	0.20-1.50
Finishing	 [wiper]	WNMG 060404-VW																								0.05-0.30	0.40-3.00
		060408-VW																								0.08-0.30	0.40-3.50
		080404-VW																								0.10-0.30	0.50-3.00
		080408-VW																								0.15-0.50	0.50-4.00
		080412-VW																								0.18-0.50	1.00-4.00
Medium to finishing		WNMG 060404-HA																					●	●	0.05-0.30	0.10-3.00	
		060408-HA																					●	●	0.10-0.40	0.80-3.50	
		080404-HA																					●	●	0.05-0.30	0.80-3.50	
		080408-HA																					●	●	0.10-0.40	0.80-3.50	
		080412-HA																								0.13-0.55	0.80-3.50

Cutting edge geometry A52~A61
 Recommended chip breaker B04~B11
 Code system B26~B27
 ● : Stock item

Available tool holders			
Designation	Page	Designation	Page
MWLNRL	B177	WWLNRL	B168
PWLNRL	B200		

