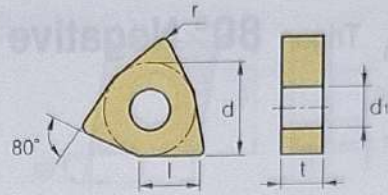


WN



Trigon 80° Negative



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

Machining types

- Continuous cutting
- General cutting
- Interrupted cutting

Inserts	Designation	Coated											Cermet	Coated	Uncoated	Dimensions (mm)					Cutting Condition		Available tool holders							
		NC3010	NC3120	NC3220	NC3030	NC9020	NC9025	PC8110	PC5300	PC5400	PC9030	NC6205	NC6210	CN1000	CN2000	CN20	CC105	CC115	U20	H01	G10	l	d	t	r	d ₁	f _n (mm/rev)	a _p (mm)	Designation	Page
 Medium	060402-VM																					6.5	9.525	4.76	0.2	3.81	0.05-0.30	0.90-3.50	MWLNRL B112	
	060404-VM	•	•	•			•															6.2	9.525	4.76	0.4	3.81	0.10-0.45	1.00-3.50	PWLNRL B130	
	060408-VM	•	•	•			•	•				•										6.1	9.525	4.76	0.8	3.81	0.10-0.50	1.00-4.00	WWLNRL B103	
	060412-VM																					6.0	9.525	4.76	1.2	3.81	0.13-0.60	1.30-4.00		
	080404-VM		•	•				•		•			•									8.4	12.7	4.76	0.4	5.16	0.05-0.30	0.90-5.00		
	080408-VM	•	•	•				•	•	•	•		•									8.3	12.7	4.76	0.8	5.16	0.10-0.50	1.00-5.00		
	080412-VM		•	•	•			•	•				•									8.2	12.7	4.76	1.2	5.16	0.10-0.50	1.00-5.00		
 Medium to finishing	060404-VQ												•									6.2	9.525	4.76	0.4	3.81	0.05-0.30	0.50-4.00	MWLNRL B112	
	060408-VQ																					6.1	9.525	4.76	0.8	3.81	0.08-0.30	0.80-4.00	PWLNRL B130	
	080404-VQ												•	•								8.4	12.7	4.76	0.4	5.16	0.05-0.30	0.50-4.00	WWLNRL B103	
	080408-VQ																					8.3	12.7	4.76	0.8	5.16	0.08-0.40	0.80-4.00		
 Finishing (Wiper)	080404-VW																					8.4	12.7	4.76	0.4	5.16	0.10-0.30	0.50-3.00	MWLNRL B112	
	080408-VW																					8.3	12.7	4.76	0.8	5.16	0.15-0.50	0.50-4.00	PWLNRL B130	
 Medium Roughing	080404-VK												•									8.4	12.7	4.76	0.4	5.16	0.15-5.00	0.08-6.00	MWLNRL B112	
	080408-VK												•	•								8.3	12.7	4.76	0.8	5.16	0.20-5.00	1.00-7.00	PWLNRL B130	
	080412-VK												•	•								8.2	12.7	4.76	1.2	5.16	0.25-5.00	1.30-7.00	WWLNRL B103	
	080416-VK																					8.1	12.7	4.76	1.6	5.16	0.25-6.00	1.89-6.00		
 Medium to finishing	080404-VP2		•					•	•	•												8.4	12.7	4.76	0.4	5.16	0.10-0.45	0.50-5.00	MWLNRL B112	
	080408-VP2		•						•	•	•											8.3	12.7	4.76	0.8	5.16	0.12-0.50	0.50-5.00	PWLNRL B130	
	080412-VP2																					8.2	12.7	4.76	1.2	5.16	0.05-0.30	0.10-3.00	WWLNRL B103	
 Medium	080404-VP3												•									8.4	12.7	4.76	0.4	5.16	0.10-0.45	0.50-5.00	MWLNRL B112	
	080408-VP3												•	•	•							8.3	12.7	4.76	0.8	5.16	0.12-0.50	0.50-5.00	PWLNRL B130	
	080412-VP3												•	•								8.2	12.7	4.76	1.2	5.16	0.05-0.30	0.10-3.00	WWLNRL B103	
 Medium Roughing	100608-B25						•															10.0	15.875	6.35	0.8	6.35	0.30-0.80	3.00-8.00	MWLNRL B112	
	130612-B25																					12.0	19.05	6.35	1.2	7.93	0.40-0.90	4.00-10.00	PWLNRL B130	