

FOLDER

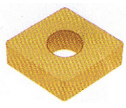
ISO TURNING

Focus on most utilized
ISO
inserts

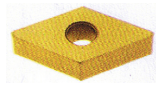


Insert shapes, carbide grades and chip breakers

ISO negative



CN..



DN..

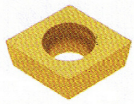


SN..

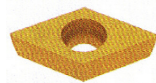


WN..

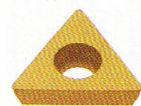
ISO positive



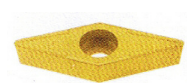
CC..



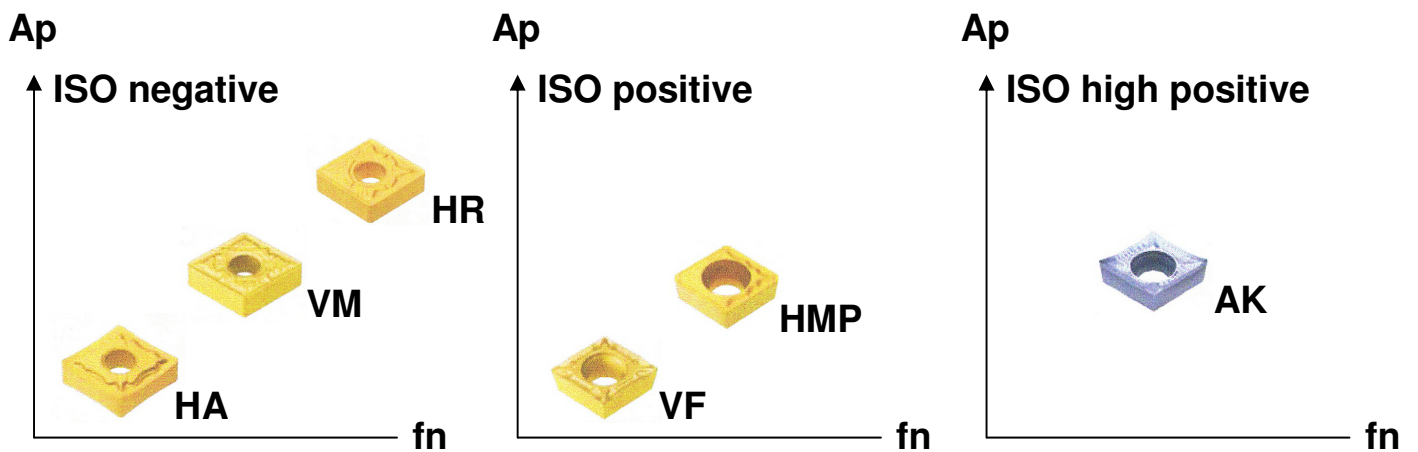
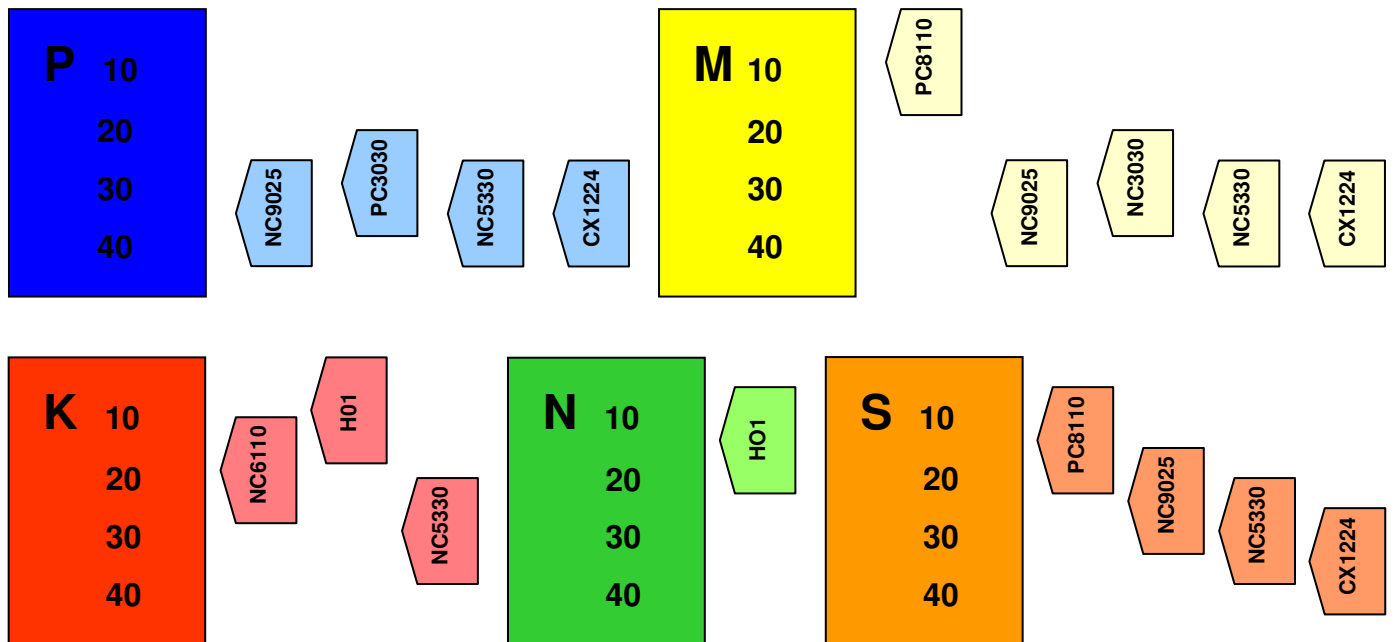
DC..



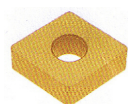
TC..



VC..



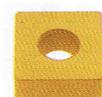
ISO negative / positive



| | | fn | Ap |
|----------------|--------|---------------------|----|
| CNMA 120404 | NC6110 | 0.10-0.30/0.50-5.00 | |
| CNMA 120408 | NC6110 | 0.15-0.50/1.00-5.00 | |
| CNMG 120404 HA | NC9025 | 0.05-0.20/0.30-3.50 | |
| CNMG 120404 HA | PC8110 | 0.05-0.20/0.30-3.50 | |
| CNMG 120404 VM | NC3030 | 0.05-0.30/0.50-5.00 | |
| CNMG 120408 HA | NC9025 | 0.10-0.40/0.50-3.50 | |
| CNMG 120408 HA | PC8110 | 0.10-0.40/0.50-3.50 | |
| CNMG 120408 HR | NC3030 | 0.20-0.50/1.00-6.00 | |
| CNMG 120408 HR | NC9025 | 0.20-0.50/1.00-6.00 | |
| CNMG 120408 VM | NC3030 | 0.10-0.50/0.50-5.00 | |



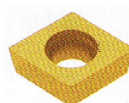
| | | fn | Ap |
|----------------|--------|---------------------|----|
| DNMA 150608 | NC6110 | 0.25-0.55/1.00-4.00 | |
| DNMG 150604 HA | NC9025 | 0.05-0.20/0.30-3.50 | |
| DNMG 150604 HA | PC8110 | 0.05-0.20/0.30-3.50 | |
| DNMG 150604 VM | NC3030 | 0.05-0.30/1.00-3.50 | |
| DNMG 150608 HA | NC9025 | 0.10-0.40/0.50-3.50 | |
| DNMG 150608 HA | PC8110 | 0.10-0.40/0.50-3.50 | |
| DNMG 150608 HR | NC3030 | 0.20-0.50/1.00-5.00 | |
| DNMG 150608 HR | NC5330 | 0.20-0.50/1.00-5.00 | |
| DNMG 150608 VM | NC3030 | 0.10-0.50/0.50-5.00 | |



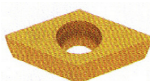
| | | fn | Ap |
|----------------|--------|---------------------|----|
| SNMM 120408 GH | NC3030 | 0.30-0.50/2.50-6.00 | |
| SNMM 120412 GH | NC3030 | 0.30-0.70/2.50-6.00 | |
| SNMM 190612 VH | NC3030 | 0.50-0.90/5.00-10.0 | |
| SNMM 190616 VH | NC3030 | 0.50-1.10/5.00-10.0 | |
| SNMM 190624 VH | NC3030 | 0.60-1.30/6.00-12.0 | |
| SNMM 250724 VH | NC3030 | 0.70-1.50/6.00-15.0 | |
| SNMM 190612 VT | NC3030 | 0.60-1.00/6.00-13.0 | |
| SNMM 190616 VT | NC3030 | 0.60-1.10/6.00-13.0 | |
| SNMM 190624 VT | NC3030 | 0.70-1.50/7.00-15.0 | |
| SNMM 250724 VT | NC3030 | 0.70-1.50/7.00-15.0 | |



| | | fn | Ap |
|----------------|--------|---------------------|----|
| WNMA 080408 | NC6110 | 0.15-0.50/1.00-5.00 | |
| WNMG 080404 HA | NC9025 | 0.05-0.20/0.30-0.35 | |
| WNMG 080404 HA | PC8110 | 0.05-0.20/0.30-0.35 | |
| WNMG 080408 HA | NC9025 | 0.10-0.40/0.50-3.50 | |
| WNMG 080408 HA | PC8110 | 0.10-0.40/0.50-3.50 | |
| WNMG 080408 HR | NC3030 | 0.20-0.50/0.50-4.00 | |
| WNMG 080408 VM | NC3030 | 0.20-0.50/0.50-4.00 | |

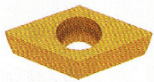


| | | fn | Ap |
|-----------------|--------|---------------------|----|
| CCMT 060202 HMP | NC5330 | 0.05-0.12/0.10-1.50 | |
| CCMT 060202 HMP | PC8110 | 0.05-0.12/0.10-1.50 | |
| CCMT 060202 VF | NC5330 | 0.03-0.10/0.05-1.00 | |
| CCMT 060202 VF | PC8110 | 0.03-0.10/0.05-1.00 | |
| CCMT 060204 HMP | NC5330 | 0.06-0.15/0.10-2.00 | |
| CCMT 060204 HMP | PC8110 | 0.06-0.15/0.10-2.00 | |
| CCMT 060204 VF | NC5330 | 0.04-0.12/0.10-1.00 | |
| CCMT 060204 VF | PC8110 | 0.04-0.12/0.10-1.00 | |
| CCMT 09T302 HMP | NC5330 | 0.06-0.12/0.10-2.50 | |
| CCMT 09T302 HMP | PC8110 | 0.06-0.12/0.10-2.50 | |
| CCMT 09T302 VF | NC5330 | 0.04-0.10/0.05-2.00 | |
| CCMT 09T302 VF | PC8110 | 0.04-0.10/0.05-2.00 | |
| CCMT 09T304 HMP | NC5330 | 0.08-0.15/0.10-3.00 | |
| CCMT 09T304 HMP | PC8110 | 0.08-0.15/0.10-3.00 | |
| CCMT 09T304 VF | NC5330 | 0.06-0.12/0.10-2.00 | |
| CCMT 09T304 VF | PC8110 | 0.06-0.12/0.10-2.00 | |



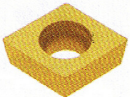
| | | fn | Ap |
|-----------------|--------|---------------------|----|
| DCMT 070202 HMP | NC5330 | 0.03-0.12/0.10-1.50 | |
| DCMT 070202 HMP | PC8110 | 0.03-0.12/0.10-1.50 | |
| DCMT 070202 VF | NC5330 | 0.03-0.10/0.05-1.00 | |
| DCMT 070202 VF | PC8110 | 0.03-0.10/0.05-1.00 | |
| DCMT 070204 HMP | NC5330 | 0.04-0.15/0.10-1.50 | |
| DCMT 070204 HMP | PC8110 | 0.04-0.15/0.10-1.50 | |

ISO positive / high positive

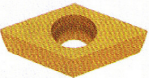


fn Ap

| | | |
|-----------------|--------|---------------------|
| DCMT 070204 VF | NC5330 | 0.04-0.12/0.05-1.00 |
| DCMT 070204 VF | PC8110 | 0.04-0.12/0.05-1.00 |
| DCMT 11T302 HMP | NC5330 | 0.03-0.12/0.10-1.50 |
| DCMT 11T302 HMP | PC8110 | 0.03-0.12/0.10-1.50 |
| DCMT 11T302 VF | NC5330 | 0.03-0.10/0.05-1.00 |
| DCMT 11T302 VF | PC8110 | 0.03-0.10/0.05-1.00 |
| DCMT 11T304 HMP | NC5330 | 0.04-0.15/0.10-1.50 |
| DCMT 11T304 HMP | PC8110 | 0.04-0.15/0.10-1.50 |
| DCMT 11T304 VF | NC5330 | 0.04-0.12/0.05-1.00 |
| DCMT 11T304 VF | PC8110 | 0.04-0.12/0.05-1.00 |
| DCMT 11T308 HMP | NC5330 | 0.08-0.25/0.10-2.50 |
| DCMT 11T308 HMP | PC8110 | 0.08-0.25/0.10-2.50 |
| DCMT 11T308 VF | NC5330 | 0.08-0.20/0.10-1.50 |
| DCMT 11T308 VF | PC8110 | 0.08-0.20/0.10-1.50 |



| | | |
|----------------|--------|---------------------|
| CCGT 060202 AK | H01 | 0.01-0.12/0.05-3.00 |
| CCGT 060204 AK | H01 | 0.02-0.15/0.10-3.00 |
| CCGT 09T302 AK | H01 | 0.02-0.12/0.10-4.00 |
| CCGT 09T304 AK | H01 | 0.02-0.15/0.10-5.00 |
| CCGT 09T308 AK | H01 | 0.03-0.25/0.10-5.00 |
| CCGT 120404 AK | CX1224 | 0.03-0.15/0.10-5.00 |
| CCGT 120408 AK | H01 | 0.04-0.25/0.10-5.00 |
| CCGT 120408 AK | CX1224 | 0.04-0.25/0.10-5.00 |



| | | |
|----------------|--------|---------------------|
| DCGT 070202 AK | CX1224 | 0.01-0.12/0.05-2.50 |
| DCGT 070202 AK | H01 | 0.01-0.12/0.05-2.50 |
| DCGT 070204 AK | CX1224 | 0.02-0.15/0.05-2.50 |
| DCGT 070204 AK | H01 | 0.02-0.15/0.05-2.50 |
| DCGT 070208 AK | CX1224 | 0.04-0.25/0.10-3.50 |
| DCGT 070208 AK | H01 | 0.04-0.25/0.10-3.50 |
| DCGT 11T302 AK | CX1224 | 0.01-0.12/0.05-4.00 |
| DCGT 11T302 AK | H01 | 0.01-0.12/0.05-4.00 |
| DCGT 11T304 AK | CX1224 | 0.02-0.15/0.05-4.00 |
| DCGT 11T304 AK | H01 | 0.02-0.15/0.05-4.00 |

fn Ap



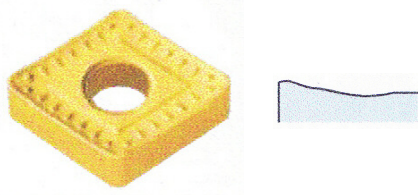
| | | |
|----------------|--------|---------------------|
| DCGT 11T308 AK | CX1224 | 0.03-0.25/0.05-4.00 |
| DCGT 11T308 AK | H01 | 0.03-0.25/0.05-4.00 |
| DCGT 11T312 AK | CX1224 | 0.05-0.40/0.10-4.00 |
| DCGT 11T312 AK | H01 | 0.05-0.40/0.10-4.00 |
| TCGT 110202 AK | CX1224 | 0.01-0.12/0.05-2.50 |
| TCGT 110202 AK | H01 | 0.01-0.12/0.05-2.50 |
| TCGT 110204 AK | CX1224 | 0.02-0.15/0.05-2.50 |
| TCGT 110204 AK | H01 | 0.02-0.15/0.05-2.50 |
| TCGT 110208 AK | CX1224 | 0.04-0.25/0.10-3.00 |
| TCGT 110208 AK | H01 | 0.04-0.25/0.10-3.00 |
| TCGT 160202 AK | CX1224 | 0.01-0.12/0.05-4.00 |
| TCGT 160202 AK | H01 | 0.01-0.12/0.05-4.00 |
| TCGT 16T304 AK | CX1224 | 0.02-0.15/0.05-4.00 |
| TCGT 16T304 AK | H01 | 0.02-0.15/0.05-4.00 |
| TCGT 16T308 AK | CX1224 | 0.04-0.25/0.10-5.00 |
| TCGT 16T308 AK | H01 | 0.04-0.25/0.10-5.00 |



| | | |
|----------------|--------|---------------------|
| VCGT 110302 AK | CX1224 | 0.01-0.12/0.05-2.00 |
| VCGT 110302 AK | H01 | 0.01-0.12/0.05-2.00 |
| VCGT 110304 AK | CX1224 | 0.02-0.15/0.05-2.00 |
| VCGT 110304 AK | H01 | 0.02-0.15/0.05-2.00 |
| VCGT 110308 AK | CX1224 | 0.04-0.25/0.10-2.00 |
| VCGT 110308 AK | H01 | 0.04-0.25/0.10-2.00 |
| VCGT 130302 AK | CX1224 | 0.01-0.12/0.05-2.50 |
| VCGT 130302 AK | H01 | 0.01-0.12/0.05-2.50 |
| VCGT 130304 AK | CX1224 | 0.02-0.15/0.05-2.50 |
| VCGT 130304 AK | H01 | 0.02-0.15/0.05-2.50 |
| VCGT 160402 AK | CX1224 | 0.01-0.12/0.05-3.50 |
| VCGT 160402 AK | H01 | 0.01-0.12/0.05-3.50 |
| VCGT 160404 AK | CX1224 | 0.02-0.15/0.05-3.50 |
| VCGT 160404 AK | H01 | 0.02-0.15/0.05-3.50 |
| VCGT 160408 AK | CX1224 | 0.04-0.25/0.10-3.50 |
| VCGT 160408 AK | H01 | 0.04-0.25/0.10-3.50 |

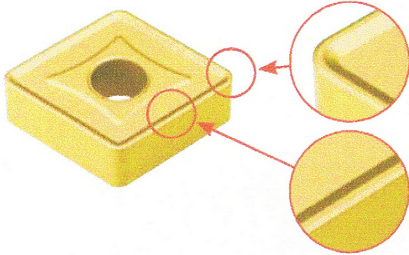
Heavy duty machining

GH



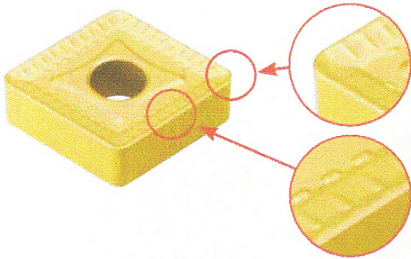
Strong cutting edge design
Negative T-land
Smooth chip flow by dot geometry

VH

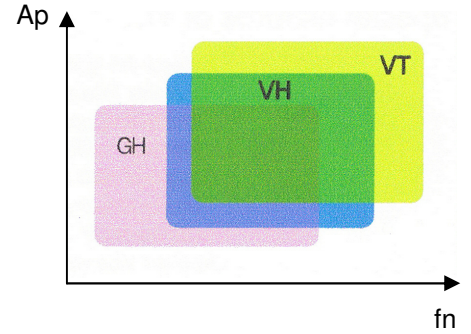


Strong cutting edge design
O T-land
High rake angle
Chip pocket for smooth chip flow

VT



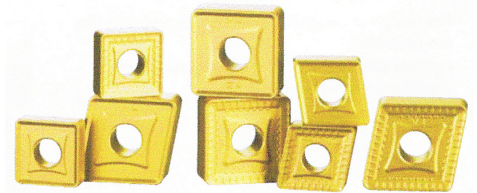
Strong cutting edge design
Negative T-land
Varied T-land width
Smooth chip flow by dot geometry



GH: $Ap=5.0\approx 12.0$ $fn=0.55\approx 1.20$

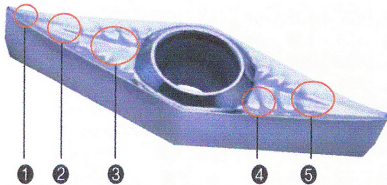
VH: $Ap=6.0\approx 15.0$ $fn=0.70\approx 1.40$

VT: $Ap=7.0\approx 17.0$ $fn=0.75\approx 1.60$



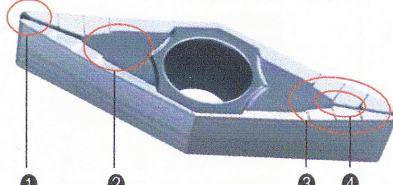
Aluminum machining

AK



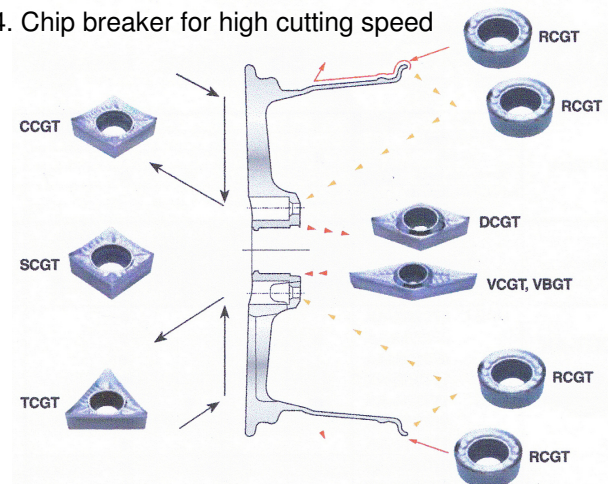
1. High rake angle => low cutting forces
2. Excellent chip control- and chip flow
3. Bumpy cutting geometry
4. Scharp cutting edges
5. Polished top face

AR



1. Flat corner cutting edge for high machining cutting loads
2. Polished top face
3. Segmented cutting edge for chip control
4. Chip breaker for high cutting speed

| | | |
|------------|---|--|
| AK: | $Ap=0.1\approx 5.0$ $fn=0.03\approx 0.5$ | H01 [non coated] ND1000 [PCD coating] |
| AR: | $Ap=0.5\approx 6.0$ $fn=0.05\approx 0.6$ | H01 [non coated] ND1000 [PCD coating] |



Gross EU-Pricelist 2012

| Insert shapes | Geometries | Carbide grades | €/St. |
|----------------------------|--------------|-----------------------------------|-------|
| CNMA 120404 / 08 | - | NC6110 | 7.70 |
| CNMG 120404 / 08 | HA / VM / HR | NC9025 / NC3030 / PC8110 | 7.70 |
| DNMA 150608 | - | NC6110 | 10.80 |
| DNMG 150604 / 08 | HA / VM / HR | NC9025 / NC3030 / NC5330 / PC8110 | 10.80 |
| SNMM 120408 / 12 | GN | NC3030 | 10.80 |
| SNMM 190612 / 16 / 24 | VH | NC3030 | 23.50 |
| SNMM 250724 | VH / VT | NC3030 | 46.30 |
| WNMA 080408 | - | NC6110 | 8.00 |
| WNMG 080404 / 08 | HA / VM / HR | NC9025 / NC3030 / PC8110 | 8.00 |
| CCMT 060202 / 04 | HMP / VF | NC5330 / PC8110 | 7.00 |
| CCMT 09T302 / 04 | HMP / VF | NC5330 / PC8110 | 8.10 |
| DCMT 070202 / 04 | HMP / VF | NC5330 / PC8110 | 8.00 |
| DCMT 11T302 / 04 / 08 | HMP / VF | NC5330 / PC8110 | 8.90 |
| CCGT 060202 / 04 | AK | H01 | 9.00 |
| CCGT 09T304 / 04 / 08 | AK | H01 | 10.60 |
| CCGT 120408 | AK | H01 | 11.80 |
| CCGT 120404 / 08 | AK | CX1224 | 14.80 |
| DCGT 070202 / 04 / 08 | AK | H01 | 9.00 |
| DCGT 070202 / 04 / 08 | AK | CX1224 | 11.20 |
| DCGT 11T302 / 04 / 08 / 12 | AK | H01 | 10.60 |
| DCGT 11T302 / 04 / 08 / 12 | AK | CX1224 | 13.20 |
| TCGT 110202 / 04 / 08 | AK | H01 | 9.30 |
| TCGT 110202 / 04 / 08 | AK | CX1224 | 11.60 |
| TCGT 16T302 / 04 / 08 | AK | H01 | 11.70 |
| TCGT 16T302 / 04 / 08 | AK | CX1224 | 14.60 |
| VCGT 110302 / 04 / 08 | AK | H01 | 11.20 |
| VCGT 110302 / 04 / 08 | AK | CX1224 | 14.00 |
| VCGT 130302 / 04 | AK | H01 | 12.00 |
| VCGT 130202 / 04 | AK | CX1224 | 14.90 |
| VCGT 160402 / 04 / 08 | AK | H01 | 12.70 |
| VCGT 160402 / 04 / 08 | AK | CX1224 | 15.80 |

Workpiece materials, carbide grades and cutting speeds

CVD coated

| ISO | Cutting conditions | Carbide grade | Cutting speed Vc in mm/min |
|----------|--------------------|---------------|----------------------------|
| P | smooth cut | NC3030 | 150 - 250 |
| | interrupted cut | NC5330 | 120 - 230 |
| | | NC9025 | 120 - 220 |
| | | CX1224 | 80 - 140 |
| M | smooth cut | NC3030 | 100 - 220 |
| | interrupted cut | NC5330 | 80 - 200 |
| | | NC9025 | 100 - 220 |
| | | CX1224 | 60 - 120 |
| K | smooth cut | NC6110 | 200 - 350 |
| | interrupted cut | NC5330 | 130 - 250 |
| S | smooth cut | - | - |
| | interrupted cut | NC5330 | 20 - 60 |
| | | NC9025 | 30 - 70 |
| | | CX1224 | 20 - 60 |

PVD coated

| ISO | Cutting conditions | Carbide grade | Cutting speed Vc in mm/min |
|----------|--------------------|---------------|----------------------------|
| P | smooth cut | PC8110 | 140 - 280 |
| | interrupted cut | - | - |
| M | smooth cut | PC8110 | 120 - 240 |
| | interrupted cut | - | - |
| S | smooth cut | PC8110 | 30 - 80 |
| | interrupted cut | - | - |

Non coated

| ISO | Cutting conditions | Carbide grade | Cutting speed Vc in mm/min |
|----------|--------------------|---------------|----------------------------|
| K | smooth cut | H01 | 100 - 200 |
| | interrupted cut | H01 | 80 - 140 |
| N | smooth cut | H01 | 300 - 800 |
| | interrupted cut | H01 | 200 - 500 |

**Insert tipped tooling for
turn-, mill-, drill- and
boring operations**

**Monoblock tooling for
turning-, milling- and drilling
operations**

Adapters

Mini tools

Tailer made tooling

Waterhuizerweg 50

9753 HS Haren [Gn]

The Netherlands

Mob.: 0031 [0] 6 48 27 77 13

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Internet: www.amwsystems.nl

