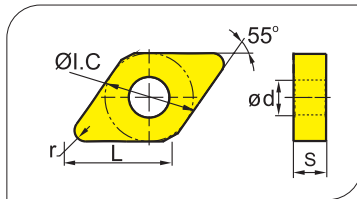


VN** Negative Insert-Negative WSP



		Ideal Machining Condition Gute Bearbeitungsbedingungen	Normal Machining Condition Normale Bearbeitungsbedingungen	Unfavorable Machining Condition Ungünstige Bearbeitungsbedingungen
P Steel / Stahl		●	●	●
M Stainless Steel / Rostfreier Stahl		●	●	●
K Cast iron / Gusseisen		●	●	●
N Non-ferrous material / Ne Metalle		●	●	●
S Heat-resistant steel / Warmfester Stahl		●	●	●

Insert Shape Schneid- plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall					
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151			YBD152	YBD252	YNG151	YNG151C	YC10	YC40
DF  Finishing Schlichten	DNMG110404-DF	11.6	9.525	4.76	3.81	0.4	○	○	●	●			○		○								○						
	DNMG110408-DF	11.6	9.525	4.76	3.81	0.8	●	●	○																				
	DNMG110412-DF	11.6	9.525	4.76	3.81	1.2		○																					
	DNMG150404-DF	15.5	12.7	4.76	5.16	0.4	○	○																					
	DNMG150408-DF	15.5	12.7	4.76	5.16	0.8	○	○																					
	DNMG150412-DF	15.5	12.7	4.76	5.16	1.2		○																					
	DNMG150604-DF	15.5	12.7	6.35	5.16	0.4	●	●	●	●			○		○														
	DNMG150608-DF	15.5	12.7	6.35	5.16	0.8	●	●	●	●																			
	DNMG150612-DF	15.5	12.7	6.35	5.16	1.2		○		●																			
WG  Wiper	DNMX110404-WG	11.6	9.525	4.76	3.81	0.4	●	○																					
	DNMX110408-WG	11.6	9.525	4.76	3.81	0.8	○	●	○	●																			
	DNMX150408-WG	15.5	12.7	4.76	5.16	0.8	○	○																					
	DNMX150412-WG	15.5	12.7	4.76	5.16	1.2		○																					
	DNMX150608-WG	15.5	12.7	6.35	5.16	0.8	○	●	○	●																			
	DNMX150612-WG	15.5	12.7	6.35	5.16	1.2	○	●																					
SF  Finishing Schlichten	DNMG110404-SF	11.6	9.525	4.76	3.81	0.4																		●					
	DNMG150404-SF	15.5	12.7	4.76	5.16	0.4																			●				
	DNMG150408-SF	15.5	12.7	4.76	5.16	0.8																			●				
	DNMG150604-SF	15.5	12.7	6.35	5.16	0.4																			●				
	DNMG150608-SF	15.5	12.7	6.35	5.16	0.8																			●				

Tool holder / Klemmhalter

DDJNR/L Kr:93°	PDJNR/L Kr:93°	PDNNR/L Kr:63°	MDJNR/L Kr:93°	MDPNN Kr:62°30'	PDSNR/L Kr:62°30'	PDUNR/L Kr:93°
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Insert code key
ISO Code

A50-A51

Grade selection reference
Sortenauswahl

A16/A37-A47

chip breaker selection reference
Spanbrecherauswahl

A28-A36

Recommended cutting parameters
Empfohlene Schnittparameter

A261-A263