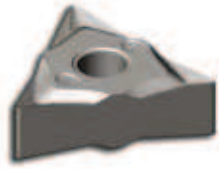


ALU-Turning

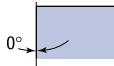


T



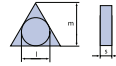
Shape
Triangle 60°

N



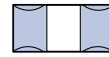
Clearance Angle
0° No rake

G



Tolerance
d ± 0.05 m ± 0.08
s ± 0.13

G



Insert Type
Pin / Top clamp
Double sided

Insert designation	Grade	l	s	r	Catalog Nr.	Page
TNGG 160404 ALU LT 05		16	4,76	0,4	T0001105	119

NN All Purpose Chipbreaker

Application Guide	Super Finishing	Finishing	Semi Finishing	Roughing	Interrupted Cut
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ISO standard inserts with extreme and unique positive chip breaker geometry, for Aluminum turning operations. Suitable mostly for external operations but good also for internal operations, Roughing - Finishing operations.

- 1 Not Recommended
- 2 Acceptable
- 3 Recommended
- 4 Excellent

Machining Recommendation Guide - Please see Pg. 8



Aluminium	Group No	Material Examples*	Brinell hardness HB	d.o.c [mm]		feed [mm/rev]		A max [mm ²]	V _c [m/min]		Optimal cutting conditions	
				min	max	min	max		min	max	d.o.c	feed
Si < 4%	13	AlMgSi 1	----	0.25	5.0	0.12	0.30	1.5	400	1200	0.5 to 3	0.23
4% < Si < 8%	13	AISI 6 Cu 4	----			0.10	0.25	1.2	250	600		
Si > 8%	14	AISI 12	----	Recommended to use TNGG 160404 NN - LT-10								

For high Si Aluminium, it is recommended to use TNGG 160404 NN. See cutting conditions below.

Si > 8%	14	AISI 12	----	0.20	4.0	0.10	0.30	0.80	200	400	0.5 to 1.2	0.15
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Insert designation	Super Finishing	Finishing	Semi Finishing	Roughing	Interrupted Cut
DNGG 110404 ALU					
	1 2 3 4	1 2 3 4	1 2 3 4	1 2 3 4	1 2 3 4