

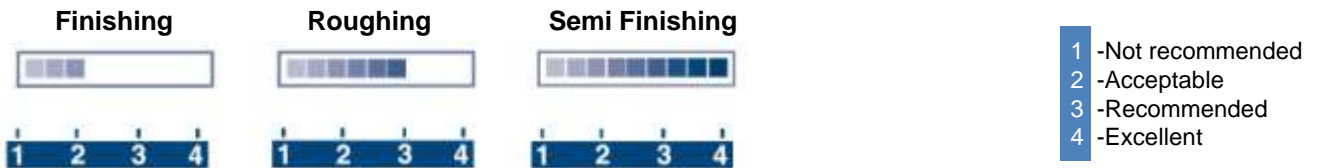


New Product:

## TNUX 160408 L LT-10

Lamina Technologies SA, the world leader of **Multi-Mat®** inserts, is pleased to announce the release of the TNUX 160408 L LT-10 insert, for left-hand profiling turning operations (similar to KNUX). This insert has 6 cutting corners and is PVD coated on Sub-micron substrate.

### Applications guide



### Applications

- TNUX 160408 L LT-10 is designed for:
- Semi finishing, finishing and roughing operations
  - Good for turning operations with unstable conditions

### Key advantages

- High productivity insert
- Positive geometry for low cutting forces performance
- Excellent chip control functionality
- Good for dry and wet machining (according to Lamina's specifications)
- Superior toughness & wear resistances for consistent performance and tool life
- **Multi -Mat®** product - one insert for multiple materials
- Top **Swiss** quality with proprietary sub-micron and PVD technologies

### Competing with

- Sandvik TNMG 160408 L-K

### Tool holders

Fits standard ISO tool holders for TNMG 160408 inserts

### Order

Catalog number: **T0001878**



## Cutting Conditions TNUX 160408 L LT-10

### Turning Tips:

- The cutting conditions are Lamina Technologies guidelines for optimal machining, however our inserts can work in a wider range of cutting conditions to meet special machining needs.
- If working according to our recommended cutting conditions A-max should be respected.
- For Stainless Steel, work over the minimum speed, as machining Stainless Steel at low speeds causes material sticking.
- Always verify that the tool holder and shim are in good condition (not damaged).
- If cutting chips are too long, we recommend increasing feed rate.
- If cutting chips are not controlled (vary in shape and size), we recommend increasing feed rate and reducing depth of cut.
- For internal boring operation, the tool holder should be as short as possible and shank as wide as possible.
- In any case of vibrations, we recommend reducing cutting speed, and increasing feed rate.
- In strong interrupted cut, feed rate should be reduced.

Material Group	No.	Material	Brinell	D.O.C.[mm]		Feed [mm/rev]		A max [mm2]	Vc [m/min]		Optimal cutting conditions				
				min	max	min	max		Min	Max	D.O.C.	Feed			
Low Carbon Steel	1	Ck 15 Ck45 1020 1045	150	0.20	5.00	0.18	0.45	1.80	180	350	3.00	0.35			
			180		4.00		0.45	1.80		300					
			210		4.00		0.40	1.50		250					
Alloy Steel	2	42 CrMo 4 S150-2 Ck60 4140 1060	180	0.20	4.00	0.15	0.40	1.20	120	280	3.00	0.30			
			230		4.00		0.40	1.20		250					
			280	3.00	0.35	1.20	210								
			320	3.00	0.35	1.00	180								
High Alloy Steel	3	X38CrMoV 5 X210 CrW 12 X90 CrMoV 8 H13 D2 HSS M42	220	0.20	3.00	0.12	0.40	1.20	70	190	2.50	0.28			
			280		3.00		0.40	1.20		150					
			320		3.00		0.35	0.80		130					
			350	3.00	0.35	0.80	100								
			400	0.50	2.50	0.11	0.30	0.50		50			90	2.00	0.25
			480		2.00		0.25	0.35		40			80	1.50	0.22
550	1.00	0.19	0.15		30		70	1.00	0.15						
Austenitic Stainless Steel	4	303/304	210 to 250	0.20	4.00	0.18	0.40	1.00	170	270	3.00	0.35			
	5	316 / 316L	230 to 270		3.00	0.15	0.35	0.80	160	210	3.00	0.32			
	6	316 Ti Duplex	-----		3.00	0.12	0.35	0.60	70	150	2.50	0.28			
Ferritic Stainless Steel	7	430/439/444	annealed	0.20	3.00	0.15	0.35	0.90	170	250	3.00	0.32			
Martensitic Stainless Steel	8	410/420 17-4-PH	annealed	0.20	3.00	0.15	0.35	0.90	170	250	3.00	0.32			
			treated						120	190					
Grey Cast Iron	9	GG 20	140 to 230	0.20	5.00	0.12	0.60	2.00	170	250	3.00	0.35			
		GG 25						1.80		230					
		GG 30						1.80		210					
Nodular Cast Iron	10	GGG 40	210	0.20	4.00	0.10	0.50	1.50	120	230	3.00	0.30			
		GGG 60	260					1.30		190					
		GGG 70	310					1.20		150					
		G-X260NiCr42	450	0.50	1.00	0.10	0.19	0.15		30			50	1.00	0.09
Ni Based Alloy	11	Inconel 625	-----	0.20	3.00	0.12	0.35	0.70	25	35	2.00	0.28			
		Inconel 718						0.70	28	40					
		Hastelloy C						0.80	40	65					
Ti Based Alloy	12	TiAl 6 V4	-----	0.20	3.00	0.12	0.35	0.80	35	60	2.00	0.30			
		T40					0.30	0.60	28	40	2.00	0.28			

