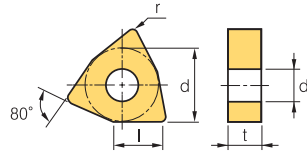


# B Turning Insert (Negative)

WN○○○



Dimensions (mm)			
Size	d	t	d <sub>1</sub>
06	9.525	4.76	3.81
08	12.7	4.76	5.16
13	19.05	6.35	7.93

## Trigon 80° Negative

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

Inserts	Designation	Cermets		Coated		Coated										Uncoated		Cutting Condition										
		CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	f <sub>n</sub> (mm/rev)	a <sub>p</sub> (mm)		
Medium cutting	MP	WNMG 06T304-MP																								0.10-0.40	0.40-2.80	
		06T308-MP																									0.15-0.45	0.50-3.00
		060404-MP						●	●	●				●													0.10-0.40	0.40-2.80
		060408-MP						●	●	●	●			●													0.15-0.45	0.50-3.00
		060412-MP																									0.15-0.50	0.80-3.20
		080404-MP						●	●	●				●	●	●				●	●	●					0.10-0.40	0.40-4.00
		080408-MP						●	●	●				●	●	●				●	●	●					0.15-0.45	0.50-4.50
		080412-MP						●	●	●				●	●	●				●	●						0.15-0.50	0.80-5.00
		080416-MP						●	●	●																		0.18-0.55
Medium cutting	VM	WNMG 060404-VM									●					●	●									0.10-0.45	1.00-3.50	
		060408-VM						●	●	●						●	●									0.10-0.50	1.00-4.00	
		060412-VM																									0.13-0.60	1.30-4.00
		080404-VM						●		●						●	●										0.05-0.30	0.90-5.00
		080408-VM						●	●	●	●					●	●				●		●				0.10-0.50	1.00-5.00
		080412-VM						●		●						●	●										0.10-0.50	1.00-5.00
Medium cutting	VP3	WNMG 060408-VP3																								0.60-0.38	0.40-3.50	
		060412-VP3																									0.60-0.38	0.40-3.50
		080404-VP3															●	●	●	●	●		●	●		0.10-0.45	0.50-5.00	
		080408-VP3															●	●	●	●	●		●	●		0.12-0.50	0.50-5.00	
		080412-VP3															●	●	●	●	●		●	●		0.05-0.30	0.10-3.00	
		130612-VP3																									0.20-0.40	1.00-5.00
Medium cutting	LW	WNMG 060408-LW						●	●					●												0.15-0.60	0.50-3.50	
		060412-LW																								0.20-0.70	0.80-3.50	
		080408-LW						●	●	●				●												0.15-0.60	1.00-5.00	
		080412-LW																								0.20-0.70	1.00-6.00	
General	B25	WNMG 080404-B25						●	●	●																0.17-0.45	1.00-5.00	
		080408-B25						●	●	●	●															0.23-0.60	1.50-5.00	
		080412-B25						●	●	●																0.25-0.60	2.00-5.00	
Roughing	GR	WNMG 080404-GR																								0.15-0.50	0.08-6.00	
		080408-GR						●	●	●	●															0.20-0.50	1.00-7.00	
		080412-GR						●	●	●	●															0.25-0.50	1.30-7.00	
		080416-GR																								0.25-0.60	1.80-6.00	

Cutting edge geometry A52~A61    
 Recommended chip breaker B04~B11    
 Code system B26~B27    
 ● : Stock item

Available tool holders			
Designation	Page	Designation	Page
MWLN/L	B177	WWLN/L	B168
PWLN/L	B200		

