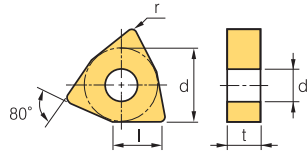


# WN

## Trigon 80° Negative



Dimensions (mm)			
Size	d	t	d <sub>1</sub>
06	9.525	4.76	3.81
08	12.7	4.76	5.16
10	15.875	6.35	6.35
13	19.05	6.35	7.93

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

Inserts	Designation	Cermet		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)		
Roughing 	WNMG 060408-RK																									0.10~0.40	1.00~3.50	
	060412-RK																										0.23~0.40	1.50~5.00
	080404-RK												●														0.23~0.50	1.50~6.00
	080408-RK											●	●														0.23~0.53	1.50~6.00
	080412-RK											●	●														0.28~0.53	1.80~6.00
	080416-RK												●														0.25~0.60	2.00~6.00
Roughing 	WNMG 060404-RM														●	●										0.10~0.50	1.50~3.00	
	060408-RM														●	●										0.15~0.55	1.50~3.00	
	060412-RM														●	●										0.20~0.60	1.50~3.00	
	080404-RM																●	●								0.10~0.50	2.00~4.00	
	080408-RM													●	●	●	●					●	●	●		0.15~0.55	2.00~4.00	
	080412-RM													●	●	●	●					●				0.20~0.60	2.00~4.00	
Roughing 	WNMG 080408-VP4																					●			0.15~0.35	1.00~4.00		
	080412-VP4																					●			0.20~0.40	1.00~4.00		
Roughing 	WNMG 060408-VR																									0.20~0.40	1.00~6.00	
	080404-VR																									0.20~0.50	0.80~7.00	
	080408-VR																									0.25~0.55	1.20~7.00	
	080412-VR																									0.30~0.60	1.50~7.00	
	080416-VR																									0.40~0.60	1.50~4.00	
Medium to roughing 	WNMM 100608-B25											●														0.30~0.80	3.00~8.00	
	130612-B25																									0.40~0.90	4.00~10.00	
Finishing 	WNMX 080404R-SR																									0.10~0.35	0.70~3.00	
	080408R-SR																									0.12~0.40	1.00~3.00	
	080404L-SR																									0.10~0.35	0.70~3.00	
	080408L-SR																									0.12~0.40	1.00~3.00	
Medium cutting 	WNMX 080404R-SH																									0.15~0.30	1.00~4.00	
	080408R-SH																									0.15~0.50	1.50~5.00	
	080404L-SH																									0.15~0.30	1.00~4.00	
	080408L-SH																									0.15~0.50	1.50~5.00	

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

Available tool holders			
Designation	Page	Designation	Page
MWLNRL	B177	WWLNRL	B168
PWLNRL	B200		

