

aerospace turning

-2N and **-91** Geometries



PERFORMANCE FEATURES

- Inserts specifically designed for nickel based and high temperature alloys applications.
- Thin layer high hardness PVD coating for improved wear resistance.
- Suitable for dry machining.
- Ideal for semi-finishing and medium machining of aerospace components.

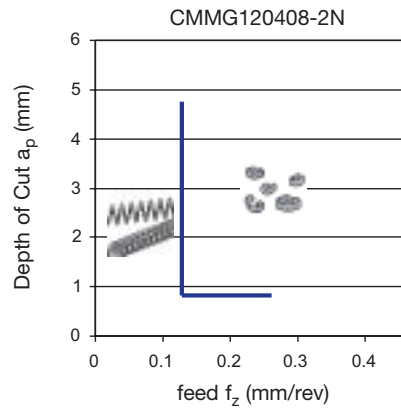




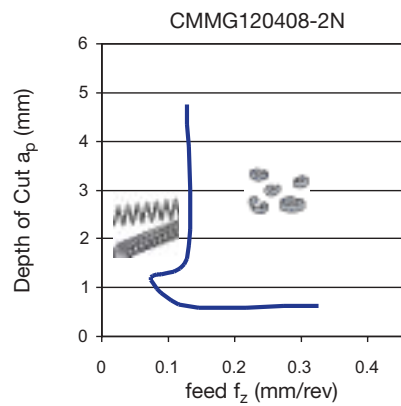
-2N Geometry

	Part Number	SP0864
CNMG	CNMG120404E-2N	027980
	CNMG120408E-2N	027981
	CNMG120412E-2N	027982
DNMG	DNMG150404E-2N	027983
	DNMG150408E-2N	027984
	DNMG150412E-2N	027985
SNMG	SNMG120408E-2N	027986
TNMG	TNMG220404E-2N	027987
	TNMG220408E-2N	027988
	TNMG220412E-2N	027989
VNMG	VNMG160404E-2N	027990
	VNMG160408E-2N	027991
WNMG	WNMG080404E-2N	027992
	WNMG080408E-2N	027993
	WNMG080412E-2N	027994

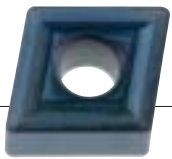
Chip Control Area



Chip control area for material:
Inconel 718 400-500 HBW
 V_c 46 m/min
Dry



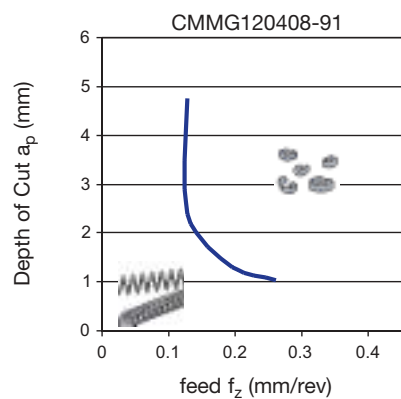
Chip control area for material:
Titanium TA6V 450HBW,
 V_c 46 m/min,
Dry



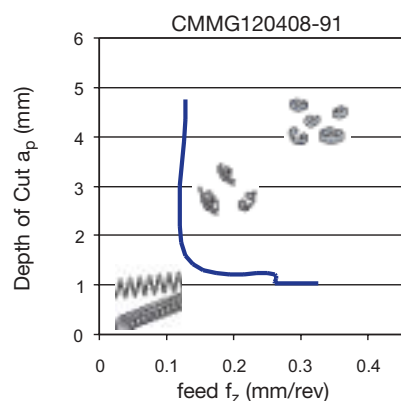
-91 Geometry

	Part Number	SP0864	SP3064
CNMG	CNMG120404E-91	027995	028004
	CNMG120408E-91	027996	028005
	CNMG120412E-91	027997	028006
DNMG	DNMG150408E-91	027998	028007
	DNMG150412E-91	027999	028008
SNMG	SNMG120408E-91	028000	028009
TNMG	TNMG160408E-91	028001	028010
	TNMG220408E-91	028002	028011
	TNMG220412E-91	028003	028012

Chip Control Area



Chip control area for material:
Inconel 718 400-500 HBW,
 V_c 46 m/min,
Dry



Chip control area for material:
Titanium TA6V 450HBW,
 V_c 46 m/min,
Dry

Technical Information


SP0864

- Micrograin carbide substrate providing high carbide density at the cutting edge.
- Single layer, TiAlN layer PVD coat with high resistance to abrasion allows dry machining.
- Lubricity properties reduces friction and aids chip flow on high temperature alloys.
- Suitable for stable conditions and finishing operations.

SP3064








- Substrate combines wear and shock resistance for roughing and medium machining.
- Suitable for larger nose radii turning (1,2mm and above).
- Single layer, TiAlN layer PVD coat with high resistance to abrasion allows dry machining.
- Lubricity properties reduces friction and aids chip flow on high temperature alloys.

Cutting Speeds

Family Material	Alloy	SP0864 Max - min HC		SP3064 Max - min HC	
		 S High Temperature Alloys	Nickel Based	57	27
Titanium Based	89		42	85	40

Star Guide

Key to Recommended Inserts

Material Designations						
	P  Unalloyed Steels	M  Stainless Steels	K  Cast Irons	S  High Temp. Alloys		
	P  Alloyed Steels	M  PH Stainless	N  Aluminium & Alloys	H  Hard Materials		

