DORMER PRAMET

NEW VERSATILE TURNING GRADE T9020

2023

PRAMET

1 INSTRUCTIONS

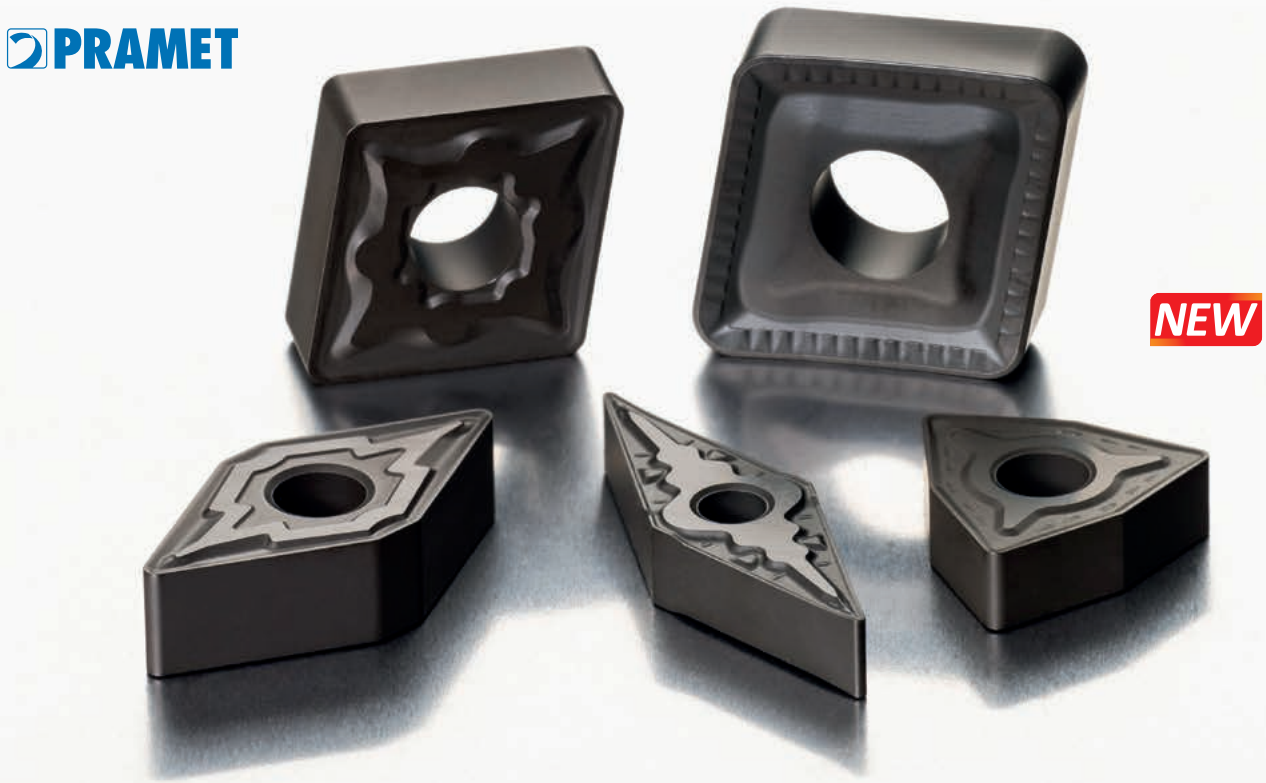
11 INSERTS

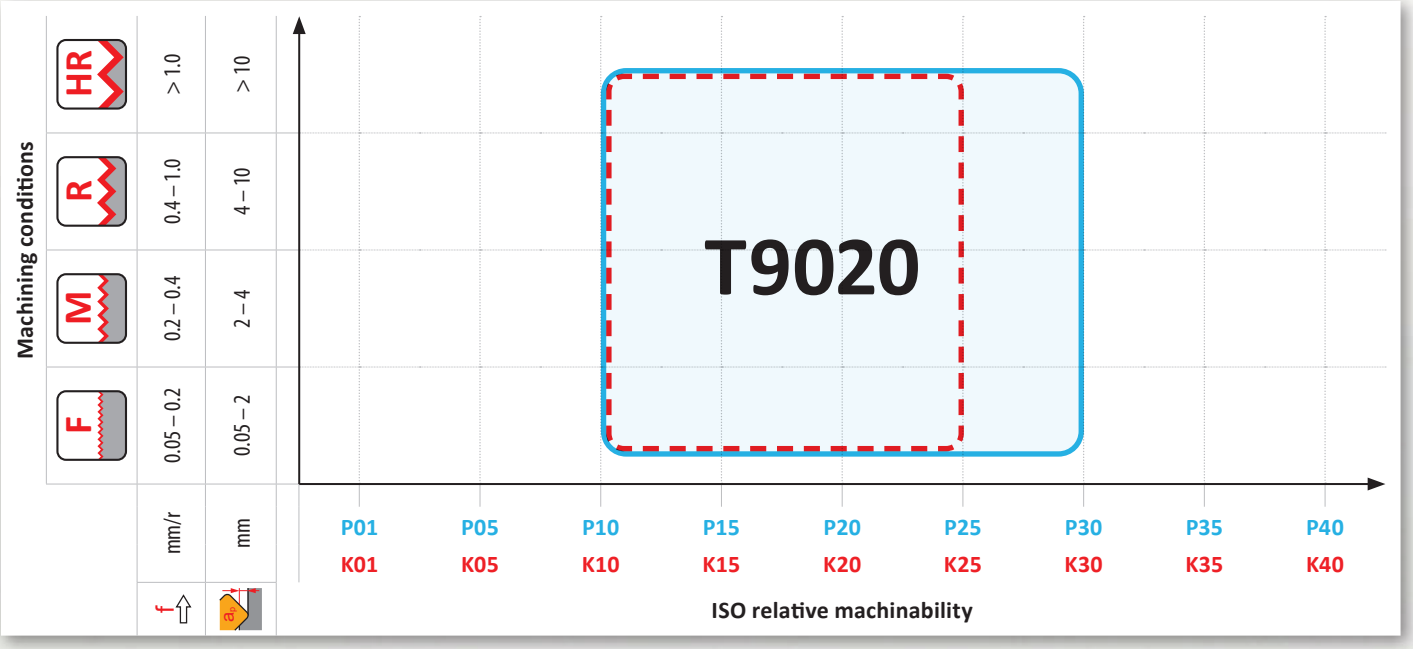
18 TECHNICAL INFORMATION

T9020 VERSATILE TURNING GRADE

INTRODUCTION

A new, cost effective turning grade, the Pramet T9020 offers a reliable and versatile solution over a multitude of other grades, resulting in cash savings by reduction of inventory. The broad application range of T9020 makes the grade suitable for both continuous and interrupted cutting in a variety of working conditions. The T9020 grade combines a hard gradient substrate and MT-CVD coating offering high levels of wear resistance, thus long tool life. The Pramet T9020 assortment range includes tailor-made geometries for steel machining covering finishing, medium and roughing operations. The grade is ideal for General machining and Automotive components.





FEATURES AND BENEFITS

New hard substrate paired with specific MT-CVD coating.

WIDE APPLICATION AREA
covering ISO groups P10 – P30 and K10 – K25.

Tailor made multi-layer MT-CVD coating with new post-treatment process.

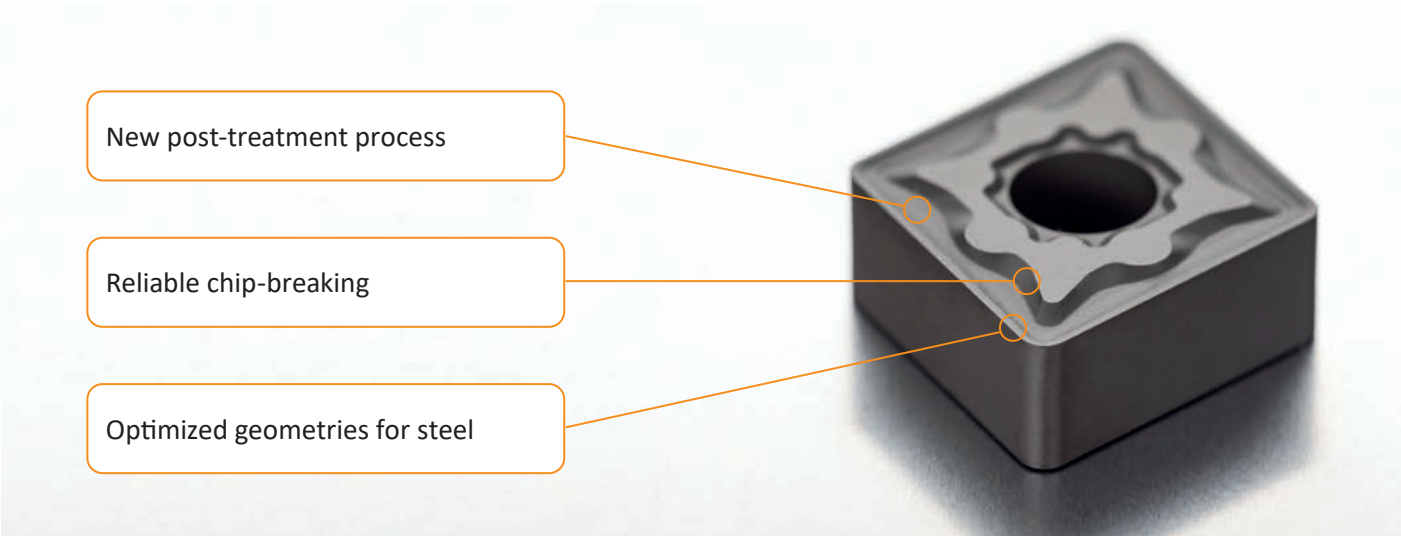
LONG TOOL LIFE
during steels and cast irons turning.

Excellent wear resistance vs. toughness ratio.

VERSATILE USAGE
in both continuous and interrupted cuts.

Simple offer of chip-breakers optimized for steel parts turning.

SIMPLE SELECTION
and reliable chip-breaking.



TECHNICAL INFORMATION

Grade identification	Area of application	Application	Feed	Cutting speed	Resistance to adverse working conditions	Coating	Colour	Substrate	Coolant benefit
T9020	P10 – P30	■				MT-CVD (Medium temperature chemical vapour deposition)		FGM (Functionally gradient material)	Recommended
	K10 – K25	◪							

Grade description:

A versatile grade with excellent wear resistance vs. toughness ratio. Reliable in wide range of cutting conditions, when suitable also in interrupted cuts. Ideal for application area ISO – P, mainly machining of carbon steel. The use of coolant is usually advisable for continuous cuts.

T9020 VERSATILE TURNING GRADE

SUCCESS STORIES – T9020

Segment: Automotive sub-contractor
Component: Gear blank
Material: Forged steel (P2.2)
Hardness: 160 – 220 HB
Coolant: Yes, water soluble
Application: Outer diameter and face turning on CNC lathe.
Previous results: With previous competitor insert, 25 workpieces were produced, with tool life at 16 min.

Dormer Pramet solution
DNMG 150608-UF:T9020

Machining data		
v_c	f_n	a_p
200	0.15	0.5

Result with T9020: A total of 35 workpieces completed, with tool life increased by 40 %!

Segment: General engineering - bearings
Component: Outer bearing
Material: SAE52100 (P3.1)
Hardness: 200 HB
Coolant: Yes, water soluble
Application: Face, outer diameter and internal diameter turning on CNC machine center.
Previous results: Using previous competitor insert, 48 workpieces were created, with surface roughness a factor in tool life.

Dormer Pramet solution
TNMG 160408-UR:T9020

Machining data		
v_c	f_n	a_p
350	0.3	1

Result with T9020: Consistent and predictable tool wear with increased tool life by 14.5 %, producing 55 workpieces!

Segment: Automotive sub-contractor
Component: Differential case
Material: Forged steel (P2.2)
Hardness: 35 HRC
Coolant: Yes, water soluble
Application: Inner diameter and face roughing on CNC lathe.
Previous results: Customer faced issues with unstable tool life. Competitor insert was set to complete 28 workpieces to avoid premature failure.

Dormer Pramet solution
CNMG 120408-UM:T9020

Machining data		
v_c	f_n	a_p
205	0.2	1.5

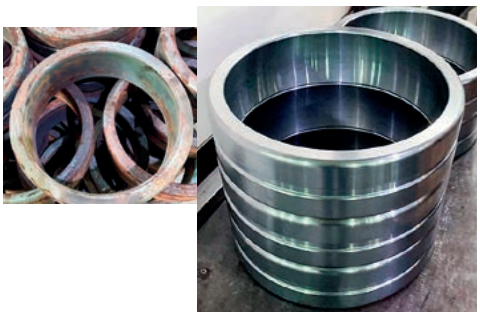
Result with T9020: Result with T9020: Uniform, consistent and predictable wear, increasing tool life by 43 %. The customer completed 40 workpieces with T9020!

v_c = cutting speed (m/min), f_n = feed per revolution (mm/r), a_p = depth of cut (mm)

SUCCESS STORIES – T9020

Segment: General machining
Component: Bearing inner ring
Material: GCr15 (P3.1)
Hardness: 150 – 170 HB
Coolant: Yes, water soluble
Application: Axial external turning and facing on horizontal CNC lathe.
Previous results: Competitor tool life produced three workpieces, with fast wear on face and flank of insert.

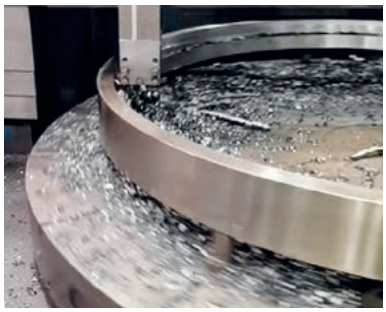
Dormer Pramet solution		
WNMG 080412-RP:T9020		
Machining data		
v_c	f_n	a_p
205 – 230	0.27	1 – 2



Result with T9020: Keeping the same cutting conditions, a total of eight workpieces were produced, increasing tool life by 166 %!

Segment: Energy generation
Component: Gear ring (diameter 3.1 m)
Material: 42CrMo (P3.2)
Hardness: 280 HB
Coolant: No
Application: Axial boring and facing on big vertical CNC lathe.
Previous results: Cutting depth had to be divided in two passes, competitor's tool life was unstable with one cut.

Dormer Pramet solution		
CNMG 190616-RP:T9020		
Machining data		
v_c	f_n	a_p
77	0.4 – 0.7	12 – 17



Result with T9020: Our insert completed the required depth of cut in one pass, resulting in increased productivity by 40 % and tool life by 50 %!

Segment: Energy generation
Component: Gear bearing ring
Material: 42CrMo (P3.2)
Hardness: 270 HB
Coolant: No
Application: Roughing of end face on big vertical CNC lathe.
Previous results: Competitor insert delivered a tool life of 63 min, when machining by fn = 0.63 mm/r.

Dormer Pramet solution		
CNMM190624E-HR:T9020		
Machining data		
v_c	f_n	a_p
60	0.9	7 – 8

Result with T9020: Consistent and slower tool wear, helping to increase feed rate and tool life to 90 min, resulting in greater productivity by 43 %!

v_c = cutting speed (m/min), f_n = feed per revolution (mm/r), a_p = depth of cut (mm)

P / K

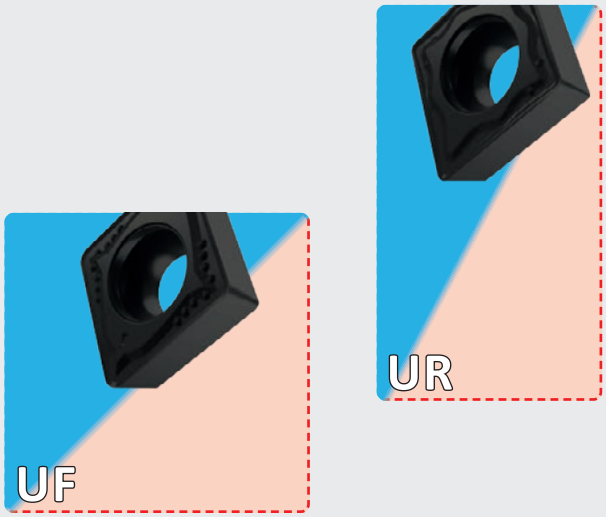
1st choice (ISO-P)
Possible use (ISO-P)
Possible use (ISO-K)

Very unstable working conditions

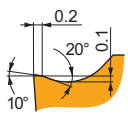
Unstable working conditions

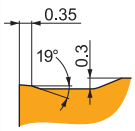
Stable working conditions

Thin -walled and slim workpieces



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev		0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm		2 – 4 mm	4 – 10 mm	> 10 mm

UF		Designed for finish to semi-rough machining, steels and stainless steels, potentially cast irons and non ferrous materials, continuous and moderately interrupted cuts.

UR		Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts.

P / K

Very unstable working conditions

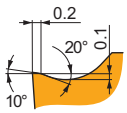
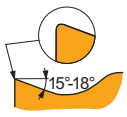
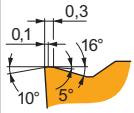
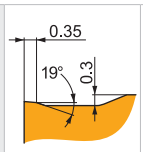
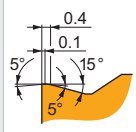
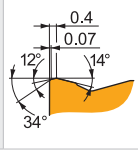
Unstable working conditions

Stable working conditions

Thin -walled and slim workpieces

1st choice (ISO-P)
Possible use (ISO-P)
Possible use (ISO-K)

	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev		0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm		2 – 4 mm	4 – 10 mm	> 10 mm

UF		Designed for finish to semi-rough machining, steels and stainless steels, potentially cast irons and non ferrous materials, continuous and moderately interrupted cuts.
SI		Positive geometry for fine finish to semi-rough machining, steels, stainless steels and cast irons and potentially non ferrous materials, continuous cuts.
UM		Designed for finish and semi-rough machining, cast irons, potentially steels and hard materials, continuous and interrupted cuts.
UR		Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts.
RP		Designed for semi-rough and rough machining, cast irons, potentially steel and hard materials, continuous and interrupted cuts.
UH		Designed for semi-rough and rough machining, steels, stainless steels and cast irons, potentially super alloys, continuous and interrupted cuts.

ISO INSERTS POSITIVE – NAVIGATOR

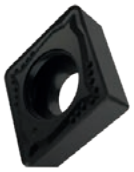
CCMT	DCMT	TCMT	VBMT
11	13	14	16

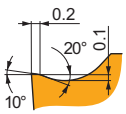
ICONS OVERVIEW

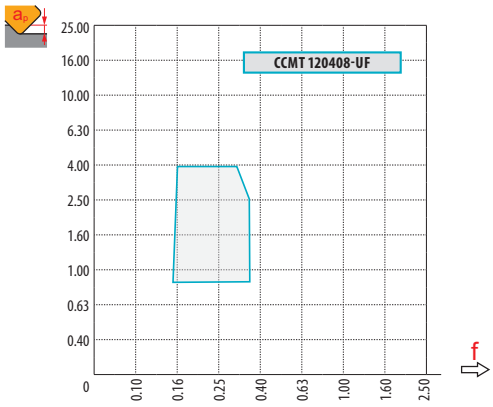
a_p	Depth of cut (mm)		Very high cutting speed, excellent system rigidity (stable working conditions)		Medium cutting speed, system rigidity limited (slightly interrupted cut)
f	Feed (mm/rev)		High cutting speed, high system rigidity (stable working conditions)		Low cutting speed, low system rigidity (interrupted cut)
	Grade		High cutting speed, system rigidity slightly limited (depth of cut changing)		Very low cutting speed, very low system rigidity (very unstable working conditions)

GEOMETRY OF POSITIVE INSERTS – CLAMPING DESIGNATION ISO S

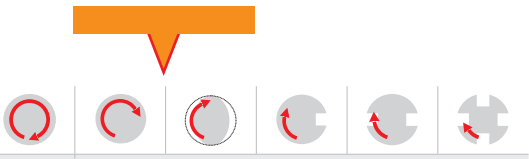
UF





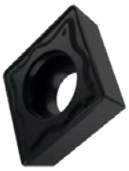


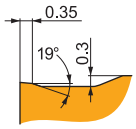
P	M	K	N	S	H
■		◪			
f	0.08 – 0.35				
a_p	0.2 – 4.0				

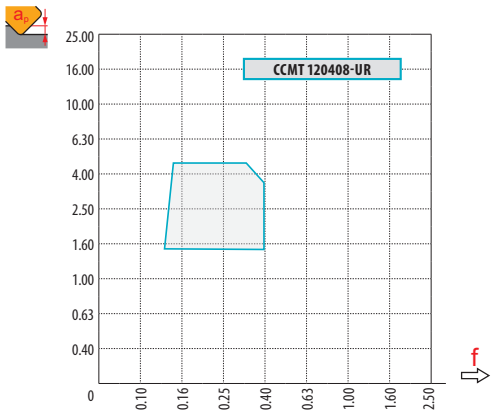


? CCMT, DCMT, TCMT, VBMT

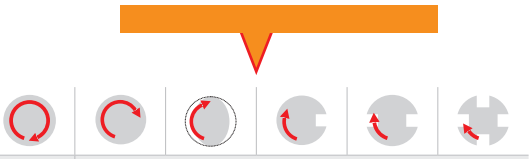
UR







P	M	K	N	S	H
■		◪			
f	0.15 – 0.40				
a_p	1.0 – 4.5				



? CCMT, TCMT

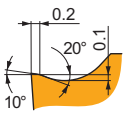
ISO INSERTS NEGATIVE – NAVIGATOR

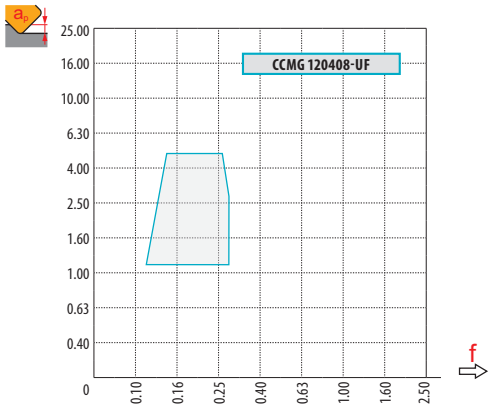
CNMG	CNMM	DNMG	SNMG	TNMG
11	12	13	14	15

VNMG	WNMG
16	17

GEOMETRY OF NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

UF



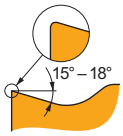


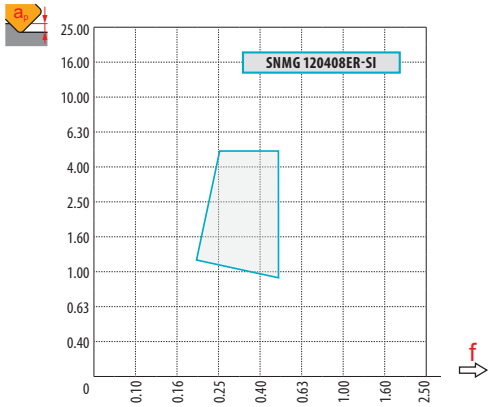
P	M	K	N	S	H
■		◪			

f	0.10 – 0.45
a_p	0.5 – 3.0

CNMG, DNMG, TNMG, VNMG, WNMG

SI





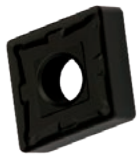
P	M	K	N	S	H
■					

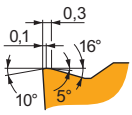
f	0.20 – 0.50
a_p	0.8 – 5.0

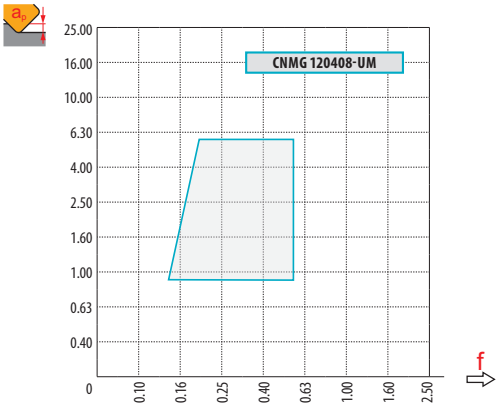
SNMG

GEOMETRY OF NEGATIVE INSERTS – CLAMPING DESIGNATION ISO P, M, D

UM





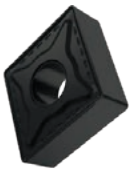


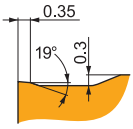
P	M	K	N	S	H
■		◪			

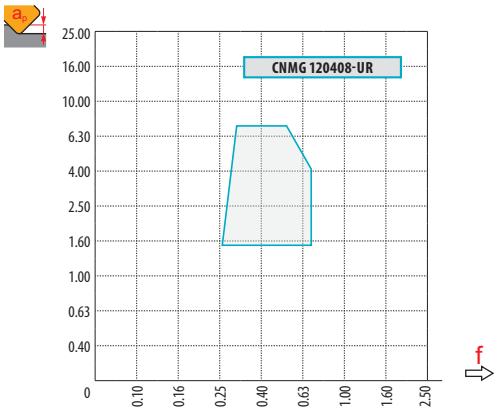
f	0.17 – 0.80
a_p	0.8 – 6.0

CNMG, DNMG, TNMG, VNMG, WNMG

UR





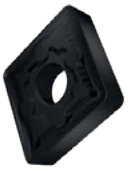


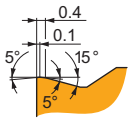
P	M	K	N	S	H
■		◪			

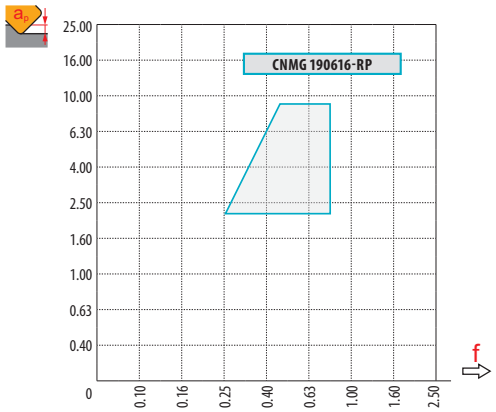
f	0.25 – 0.80
a_p	1.0 – 8.0

CNMG, DNMG, TNMG, WNMG

RP





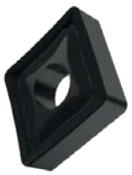


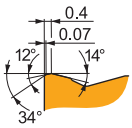
P	M	K	N	S	H
■		◪			

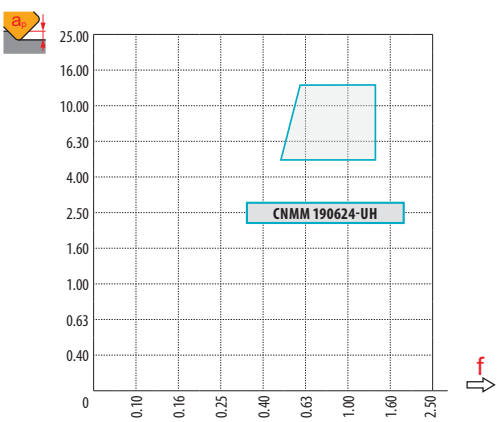
f	0.25 – 0.70
a_p	2.0 – 9.0

CNMG, DNMG, TNMG, WNMG

UH







P	M	K	N	S	H
■		◪			

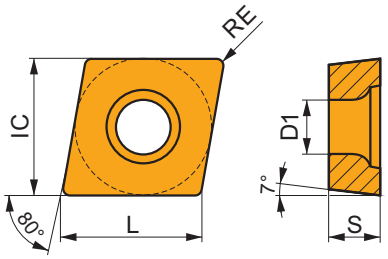
f	0.50 – 1.40
a_p	5.0 – 13.3

CNMM

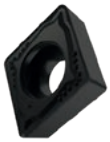
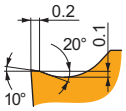
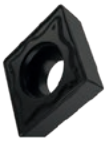
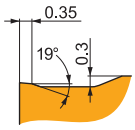
CCMT

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



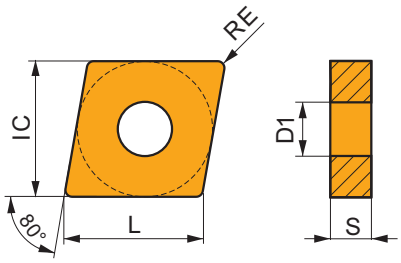
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
			UF geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
CCMT 09T308-UF	T9020	0.8	270	0.20	1.2	–	–	–	255	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 120408-UF	T9020	0.8	260	0.20	1.7	–	–	–	245	0.20	1.7	–	–	–	–	–	–	–	–	–
																				
			UR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
CCMT 120408-UR	T9020	0.8	220	0.30	2.7	–	–	–	205	0.30	2.7	–	–	–	–	–	–	–	–	–

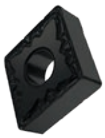
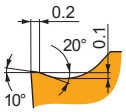
CNMG

PRAMET

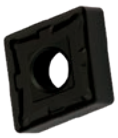
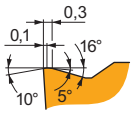
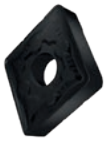
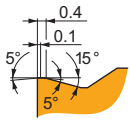
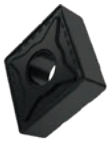
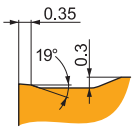
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.880	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
			UF geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
CNMG 120404-UF	T9020	0.4	240	0.20	2.1	–	–	–	225	0.20	2.1	–	–	–	–	–	–	–	–	–
CNMG 120408-UF	T9020	0.8	285	0.20	2.1	–	–	–	270	0.20	2.1	–	–	–	–	–	–	–	–	–

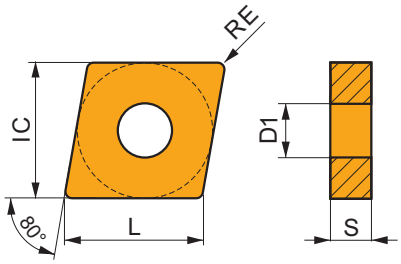
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			UM geometry for finish to semi-rough machining and continuous to interrupted cuts.																	
CNMG 120404-UM	T9020	0.4	220	0.20	2.1	–	–	–	205	0.20	2.1	–	–	–	–	–	–	–	–	–
CNMG 120408-UM	T9020	0.8	210	0.32	2.1	–	–	–	195	0.32	2.1	–	–	–	–	–	–	–	–	–
CNMG 120412-UM	T9020	1.2	205	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	–	–	–
CNMG 160608-UM	T9020	0.8	200	0.32	3.6	–	–	–	190	0.32	3.6	–	–	–	–	–	–	–	–	–
			RP geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
CNMG 120408-RP	T9020	0.8	180	0.40	4.0	–	–	–	170	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412-RP	T9020	1.2	185	0.45	4.0	–	–	–	175	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 160608-RP	T9020	0.8	175	0.40	5.5	–	–	–	165	0.40	5.5	–	–	–	–	–	–	–	–	–
CNMG 160612-RP	T9020	1.2	175	0.45	5.5	–	–	–	165	0.45	5.5	–	–	–	–	–	–	–	–	–
CNMG 190608-RP	T9020	0.8	170	0.40	7.0	–	–	–	160	0.40	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612-RP	T9020	1.2	175	0.45	7.0	–	–	–	165	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616-RP	T9020	1.6	170	0.50	7.0	–	–	–	160	0.50	7.0	–	–	–	–	–	–	–	–	–
			UR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
CNMG 120408-UR	T9020	0.8	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412-UR	T9020	1.2	210	0.45	4.0	–	–	–	195	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 160608-UR	T9020	0.8	200	0.40	6.0	–	–	–	190	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612-UR	T9020	1.2	200	0.45	6.0	–	–	–	190	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 190608-UR	T9020	0.8	195	0.40	7.5	–	–	–	185	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612-UR	T9020	1.2	195	0.45	7.5	–	–	–	185	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616-UR	T9020	1.6	195	0.50	7.5	–	–	–	185	0.50	7.5	–	–	–	–	–	–	–	–	–

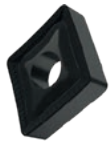
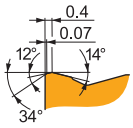
CNMM

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.30	6.35

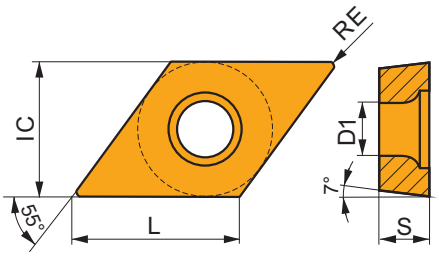


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

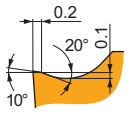
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			UH geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																	
CNMM 190624-UH	T9020	2.4	155	0.65	10.0	–	–	–	145	0.65	10.0	–	–	–	–	–	–	–	–	–

DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97

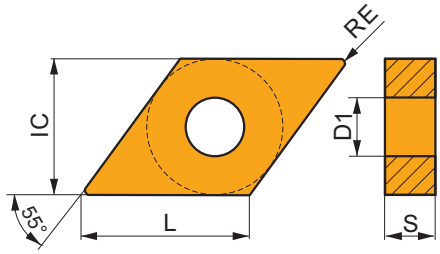


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

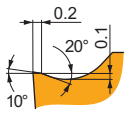
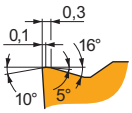
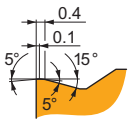
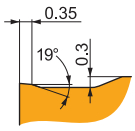
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			UF geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
DCMT 11T308-UF	T9020	0.8	240	0.17	0.8	–	–	–	225	0.17	0.8	–	–	–	–	–	–	–	–	–

DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



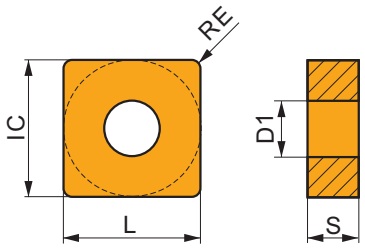
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			UF geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
DNMG 150604-UF	T9020	0.4	195	0.20	1.7	–	–	–	185	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608-UF	T9020	0.8	230	0.20	1.7	–	–	–	215	0.20	1.7	–	–	–	–	–	–	–	–	–
			UM geometry for finish to semi-rough machining and continuous to interrupted cuts.																	
DNMG 150608-UM	T9020	0.8	175	0.30	1.9	–	–	–	165	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150612-UM	T9020	1.2	165	0.40	1.9	–	–	–	155	0.40	1.9	–	–	–	–	–	–	–	–	–
			RP geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
DNMG 150612-RP	T9020	1.2	160	0.40	3.0	–	–	–	150	0.40	3.0	–	–	–	–	–	–	–	–	–
			UR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
DNMG 150612-UR	T9020	1.2	180	0.40	3.0	–	–	–	170	0.40	3.0	–	–	–	–	–	–	–	–	–

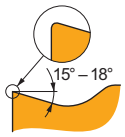
SNMG

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



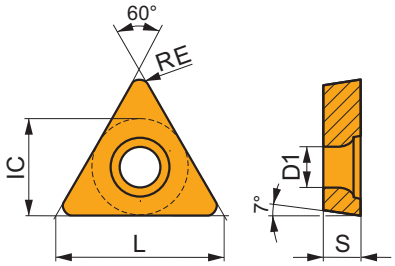
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			E																	
			ER-SI geometry with positive right-handed design for fine-finish to semi-rough machining, and continuous cuts.																	
SNMG 120408ER-SI	T9020	0.8	270	0.35	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

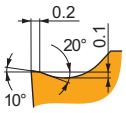
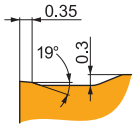
TCMT

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



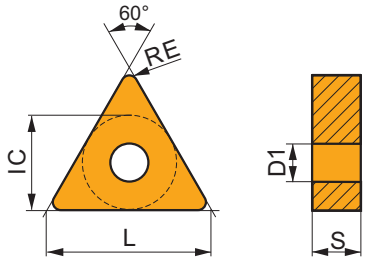
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			1 E																	
			UF geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
TCMT 110204-UF	T9020	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308-UF	T9020	0.8	235	0.17	1.7	–	–	–	220	0.17	1.7	–	–	–	–	–	–	–	–	–
			1 S																	
			UR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
TCMT 16T308-UR	T9020	0.8	200	0.27	1.9	–	–	–	190	0.27	1.9	–	–	–	–	–	–	–	–	–

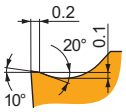
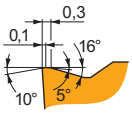
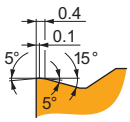
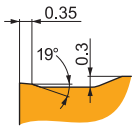
TNMG

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



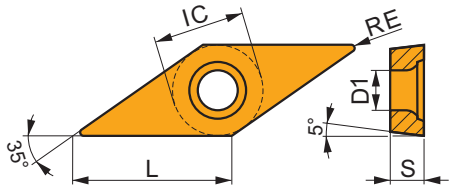
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			UF geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
TNMG 160404-UF	T9020	0.4	205	0.20	1.7	–	–	–	190	0.20	1.7	–	–	–	–	–	–	–	–	–
TNMG 160408-UF	T9020	0.8	245	0.20	1.7	–	–	–	230	0.20	1.7	–	–	–	–	–	–	–	–	–
			UM geometry for finish to semi-rough machining and continuous to interrupted cuts.																	
TNMG 160404-UM	T9020	0.4	190	0.20	1.6	–	–	–	180	0.20	1.6	–	–	–	–	–	–	–	–	–
TNMG 160408-UM	T9020	0.8	190	0.30	1.6	–	–	–	180	0.30	1.6	–	–	–	–	–	–	–	–	–
			RP geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
TNMG 160408-RP	T9020	0.8	160	0.40	3.0	–	–	–	150	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412-RP	T9020	1.2	170	0.40	3.0	–	–	–	160	0.40	3.0	–	–	–	–	–	–	–	–	–
			UR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
TNMG 160408-UR	T9020	0.8	185	0.40	3.0	–	–	–	175	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412-UR	T9020	1.2	195	0.40	3.0	–	–	–	185	0.40	3.0	–	–	–	–	–	–	–	–	–

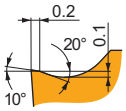
VBMT

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



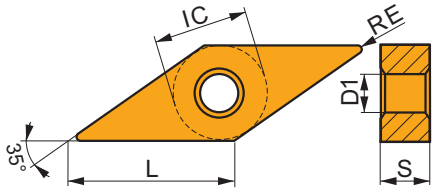
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
UF geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.																				
VBMT 160408-UF	T9020	0.8	215	0.17	1.2	–	–	–	200	0.17	1.2	–	–	–	–	–	–	–	–	–

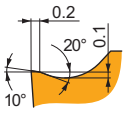
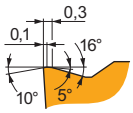
VNMG

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

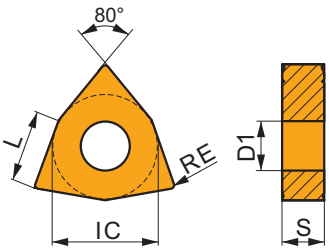


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

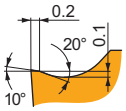
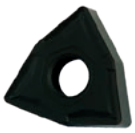
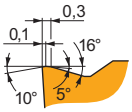
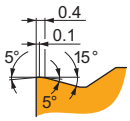
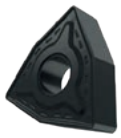
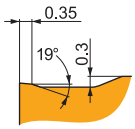
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
UF geometry with positive design for finish to semi-rough machining and continuous to slightly interrupted cuts.																				
VNMG 160404-UF	T9020	0.4	175	0.20	1.2	–	–	–	165	0.20	1.2	–	–	–	–	–	–	–	–	–
VNMG 160408-UF	T9020	0.8	205	0.20	1.4	–	–	–	190	0.20	1.4	–	–	–	–	–	–	–	–	–
																				
UM geometry for finish to semi-rough machining and continuous to interrupted cuts.																				
VNMG 160404-UM	T9020	0.4	160	0.20	1.2	–	–	–	150	0.20	1.2	–	–	–	–	–	–	–	–	–
VNMG 160408-UM	T9020	0.8	155	0.30	1.4	–	–	–	145	0.30	1.4	–	–	–	–	–	–	–	–	–

WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
UF geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.																				
WNMG 080404-UF	T9020	0.4	255	0.20	1.2	–	–	–	240	0.20	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408-UF	T9020	0.8	290	0.20	1.9	–	–	–	275	0.20	1.9	–	–	–	–	–	–	–	–	–
																				
UM geometry for finish to semi-rough machining and continuous to interrupted cuts.																				
WNMG 080404-UM	T9020	0.4	220	0.20	2.1	–	–	–	205	0.20	2.1	–	–	–	–	–	–	–	–	–
WNMG 080408-UM	T9020	0.8	210	0.32	2.1	–	–	–	195	0.32	2.1	–	–	–	–	–	–	–	–	–
WNMG 080412-UM	T9020	1.2	205	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	–	–	–
																				
RP geometry for semi-rough to rough machining, and continuous to interrupted cuts.																				
WNMG 080408-RP	T9020	0.8	185	0.40	3.5	–	–	–	175	0.40	3.5	–	–	–	–	–	–	–	–	–
WNMG 080412-RP	T9020	1.2	185	0.45	3.5	–	–	–	175	0.45	3.5	–	–	–	–	–	–	–	–	–
																				
UR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																				
WNMG 080408-UR	T9020	0.8	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080412-UR	T9020	1.2	210	0.45	4.0	–	–	–	195	0.45	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416-UR	T9020	1.6	210	0.50	4.0	–	–	–	195	0.50	4.0	–	–	–	–	–	–	–	–	–

DORMER PRAMET

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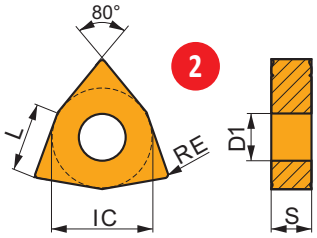
TECHNICAL INFORMATION

1 WNMG

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
4	5		1 S 6																	
			UF geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts. 10																	
WNMG 080404-UF	T9020	0.4	255	0.20	1.2	–	–	–	240	0.20	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408-UF	T9020	0.8	290	0.20	1.9	–	–	–	275	0.20	1.9	–	–	–	–	–	–	–	–	–
			P																	
			UM geometry for finish to semi-rough machining and continuous to interrupted cuts.																	
WNMG 080404-UM	T9020	0.4	220	0.20	2.1	–	–	–	205	0.20	2.1	–	–	–	–	–	–	–	–	–
WNMG 7 08-UM	8	9	210	0.32	2.1	–	11	–	195	0.32	2.1	–	–	–	–	–	–	–	–	–
WNMG 080412-UM	T9020	1.2	205	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	–	–	–
			P																	
			RP geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
WNMG 080408-RP	T9020	0.8	185	0.40	3.5	–	–	–	175	0.40	3.5	–	–	–	–	–	–	–	–	–
WNMG 080412-RP	T9020	1.2	185	0.45	3.5	–	–	–	175	0.45	3.5	–	–	–	–	–	–	–	–	–
			1 S																	

WNMG 080408-RP:T9020 Use full insert specification code when ordering!

Grade

Include colon

ISO insert code

Typical page with turning inserts displayed – specific page details will differ.

TURNING INSERTS – PAGE OVERVIEW

Pos.	Description
1	Designation of insert
2	Schematic drawing of insert
3	Table with insert sizes (mm)
4	Picture of representative insert
5	Profile of main cutting edge
6	Icons – specific features and cutting edge type

Pos.	Description
7	ISO insert code
8	Grade
9	Insert radii (mm)
10	Geometry description
11	Application area of insert

TURNING HOLDERS – ICONS OVERVIEW

GENERAL ICONS

■	Primary use
◪	Possible use

●	Suitable for stable working conditions
◐	Suitable for unstable working conditions
✖	Suitable for very unstable working conditions

FEATURES

1	First choice
	For short chipping materials
	For tough materials (long chipping)

	Heavy working conditions
	Large overhang
	Thin-walled and slim workpieces

E	Rounded edge
S	Rounded edge with facet
P	Rounded edge with double facet

Correction factors for specific type of operation C_{VcO}

X.V	FF			F			M			R			HR		
a_p	0.5			1.5			2.5			5.0			12.0		
	I	II	III	I	II	III	I	II	III	I	II	III	I	II	III
f	0.05	0.08	0.10	0.10	0.15	0.20	0.20	0.30	0.40	0.40	0.60	0.80	0.80	1.00	1.30
Finishing chip-breaker **UF**	–	–	1.20	1.05	1.00	1.05	1.00	0.90	–	–	–	–	–	–	–
Medium chip-breakers **UM, SI**	–	–	–	–	–	1.15	1.10	1.00	0.95	0.85	–	–	–	–	–
Roughing chip-breakers **UR, RP**	–	–	–	–	–	–	–	–	1.25	1.10	1.00	0.95	0.65	–	–
Heavy roughing chip-breaker **UH** (for 45 min durability)	–	–	–	–	–	–	–	–	–	1.25	1.20	1.15	1.05	1.00	0.95

Correction factors for required durability C_{VcT}

minutes	10	15	20	30	45	60
General machining operations (fine finishing up to roughing)	1.13	1.00	0.93	0.84	0.76	0.71
Heavy machining operations (heavy roughing)	–	–	–	1.10	1.00	0.93

Additional correction factors C_{VcA}

Machining environment	C_{VcA}
Condition of the work-material (hard skin due to forging or casting)	0.70
Internal turning	0.75
Parting and grooving (radial)	0.88
Face grooving	0.80
Interrupted cut	0.80
Unstable machining conditions	0.85
Common machining conditions	1.00
Stable machining conditions	1.20

Resulting corrected cutting speed v_{cC}

$$v_{cC} = v_c \times k_{vG} \times C_{VcO} \times C_{VcT} \times C_{VcA}$$

k_{vG} – coefficient of used material
v_c – starting speed from catalogue page

WORKPIECE MATERIAL GROUPS (WMG)

ISO group		Subgroup		WMG (Work Material Group)		k_{vG}
P	**Steel and cast steel** (steels with alloy content ≤ 10 % and a hardness of < 45 HRC)	P1	Free machining steel (carbon steels with increased machinability)	P1.1	Free machining sulfurized carbon steel with a hardness of < 240 HB	1.33
				P1.2	Free machining sulfurized and phosphorized carbon steel with a hardness of < 180 HB	1.49
				P1.3	Free machining sulfurized/phosphorized and leaded carbon steel with a hardness of < 180 HB	1.53
		P2	Plain carbon steel (steels comprised of mainly iron and carbon)	P2.1	Plain low carbon steel containing < 0.25 % C with a hardness of < 180 HB	1.14
				P2.2	Plain medium carbon steel containing < 0.55 %C with a hardness of < 240 HB	1.00
				P2.3	Plain high carbon steel containing > 0.55 % C, with a hardness of < 300 HB	0.89
		P3	Alloy steel (carbon steels with an alloying content ≤ 10 %)	P3.1	Alloy steel with a hardness of < 180 HB	0.92
				P3.2	Alloy steel with a hardness of 180 – 260 HB	0.74
				P3.3	Alloy steel with a hardness of 260 – 360 HB	0.63
		P4	Tool steel (special alloy steel for tools, dies and molds)	P4.1	Tool steel with a hardness of < 26 HRC	0.55
				P4.2	Tool steel with a hardness of 26 – 39 HRC	0.47
				P4.3	Tool steel with a hardness of 39 – 45 HRC	0.38
K	**Cast Iron** (castings of iron and carbon alloys with > 2 % carbon content)	K1	Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	K1.1	Gray iron, ferritic or ferritic-pearlitic with a hardness of < 180 HB	1.35
				K1.2	Gray iron, ferritic-pearlitic or pearlitic with a hardness of 180 – 240 HB	1.00
				K1.3	Gray iron, pearlitic with a hardness of 240 – 280 HB	0.75
		K2	Malleable iron (GTS/GTW) (heat-treated iron-carbon castings with a graphite-free microstructure)	K2.1	Malleable iron, ferritic with a hardness of < 160 HB	1.39
				K2.2	Malleable iron, ferritic or pearlitic with a hardness of 160 – 200 HB	1.13
				K2.3	Malleable iron, pearlitic with a hardness of 200 – 240 HB	0.90
		K3	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microsturcture)	K3.1	Ductile (nodular/spheriodal) iron, ferritic with a hardness of < 180 HB	1.23
				K3.2	Ductile (nodular/spheriodal) iron, ferritic or pearlitic with a hardness of 180 – 220 HB	0.94
				K3.3	Ductile (nodular/spheriodal) iron, pearlitic with a hardness of 220 – 260 HB	0.76
		K4	Austenitic or austempered ductile iron (Ni-Resist/ADI) (iron-carbon alloy castings with an austenitic or ausferrite microstructure)	K4.1	Austenitic cast iron with a hardness of < 180 HB	1.14
				K4.2	Austenitic cast iron with a hardness of 180 – 240 HB	0.86
				K4.3	Austempered ductile iron with a hardness of 240 – 280 HB	0.63
				K4.4	Austempered ductile iron with a hardness of 280 – 320 HB	0.54
				K4.5	Austempered ductile iron with a hardness of 320 – 360 HB	0.45
		K5	Compacted graphite iron (CGI) (iron-carbon castings with a vermicular graphite structure)	K5.1	Vermicular, compacted graphite iron with a hardness of < 180 HB	1.29
				K5.2	Vermicular, compacted graphite iron with a hardness of 180 – 220 HB	0.97
				K5.3	Vermicular, compacted graphite iron with a hardness of 220 – 260 HB	0.75

NOTES

SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

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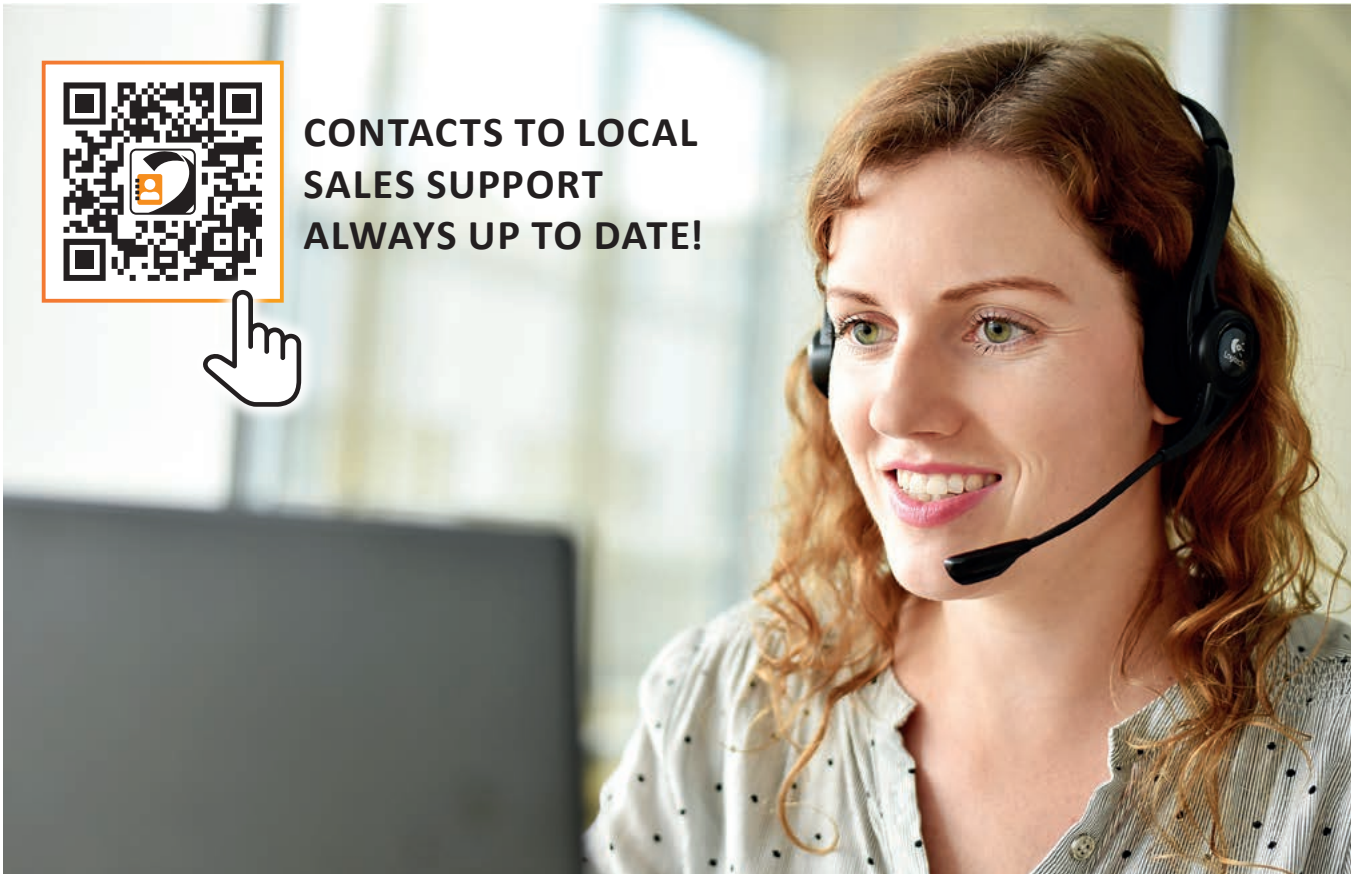

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