

ISO E^{CO}TURN

Tungaloy Report No. 426S2-US

New grades and chipbreakers for this economical insert series





Latest grades and chipbreakers for improved performance in all ISO applications

GRADES & CHIPBREAKERS

T9200 SERIES (CVD)

PREMIUMTEC

- T9205** : Good wear resistance
- T9215** : First choice for machining steel
- T9225** : Grade with a good balance of wear resistance and fracture toughness

NS9530

(Cermet)

GT9530 / AT9530

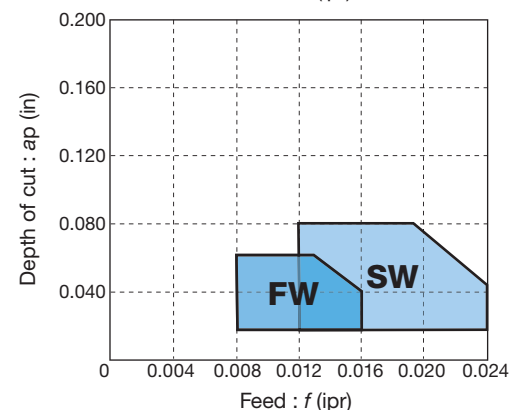
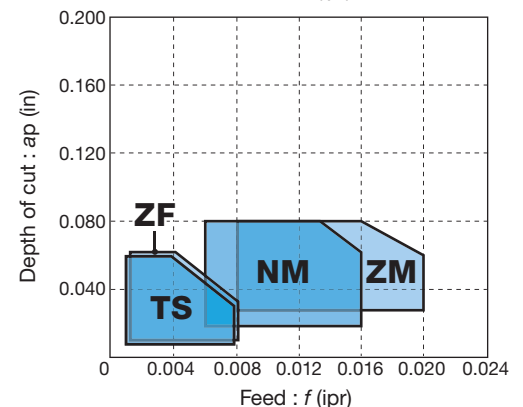
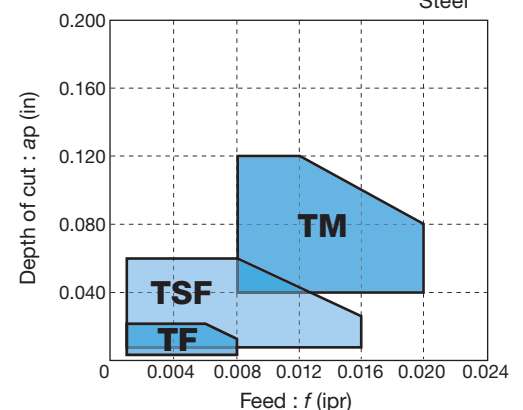
(Coated cermet)

PREMIUMTEC

- NS9530** : Suitable for finishing to medium cutting of steel
- GT9530** : Provides stable tool life and excellent surface finish for finish machining of steel at high cutting speeds
- AT9530** : Outstanding wear resistance. First choice for machining alloy steel



Steel



AH600 SERIES (PVD)

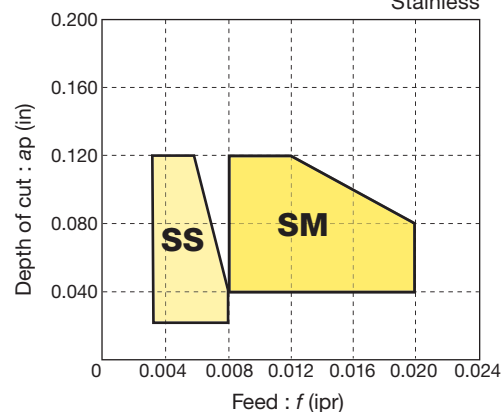
PREMIUMTEC

AH630 : Good resistance to wear and fracture in machining stainless steel at low to medium cutting speed

AH645 : High fracture resistance in machining stainless steel

M

Stainless



T6100 SERIES (CVD)

PREMIUMTEC

T6120 : Good wear resistance in continuous cutting at high speed

T6130 : High wear resistance in cutting at medium to high speed

T515 (CVD)

PREMIUMTEC

T515 : Good wear resistance even in high speed machining

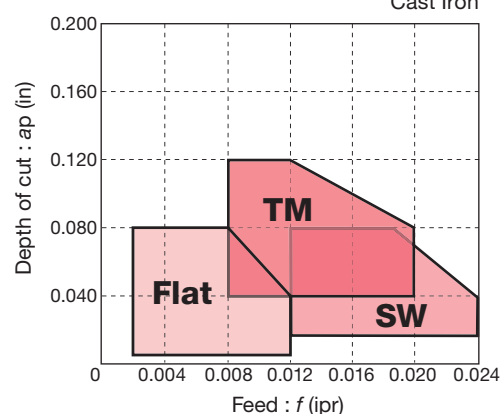
T5100 SERIES (CVD)

PREMIUMTEC

T5115 : Stable machining in a wide range of applications from continuous to interrupted cutting

K

Cast Iron



AH8000 SERIES (PVD)

PREMIUMTEC

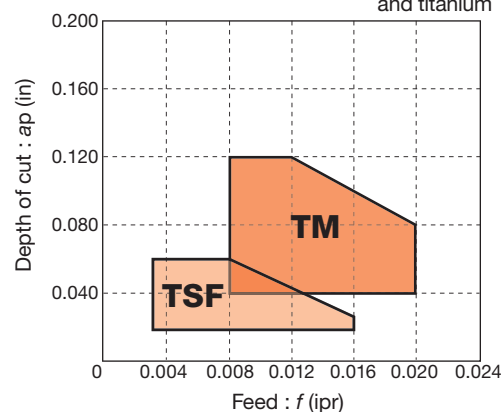
AH8015 : Strong resistance to wear and built up edge

M

Stainless

S

Superalloys and titanium



AH120 (PVD)

PREMIUMTEC

AH120 : Suitable for machining steel, stainless steel, cast iron and heat resistant alloys under general cutting conditions

P

Steel

M

Stainless

K

Cast Iron

S

Superalloys and titanium

Insert NEGATIVE TYPE

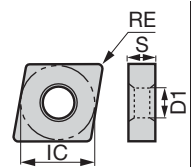
- : Continuous cutting
- ◐ : Light interrupted cutting
- ✱ : Heavy interrupted cutting

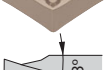
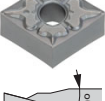
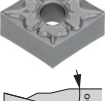
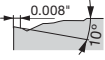
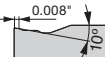
CN



**Rhombic, 80°
with hole**

P	Steel	●	●	✱	◐	✱	✱	✱	◐				●	●	●	●		
M	Stainless		●	●		●	◐	◐	✱	◐	◐							
K	Cast iron	●	●	●					◐	◐	◐	●	●	●	●	●		
N	Non-ferrous																	
S	Superalloys								◐	◐	◐							
H	Hard materials																	



Application	Chipbreaker			Designation		Coated										Coated cermet		Cermet	Dimension (in)			
	Inch		Metric	T9205	T9215	T9225	T6120	T6130	AH630	AH645	AH120	AH8015	T515	T5115	GT9530	AT9530	NS9530	RE	IC	S	D1	
Precision finishing	TF	CNMG 330.5E TF	CNMG090402E-TF	●	●													●	0.008	0.375	0.187	0.150
		CNMG 331E TF	CNMG090404E-TF	●	●													●	0.016	0.375	0.187	0.150
		CNMG 332E TF	CNMG090408E-TF	●	●													●	0.031	0.375	0.187	0.150
																						
Finishing	TSF	CNMG 330.5E TSF	CNMG090402E-TSF	●	●						●	●			●			●	0.008	0.375	0.187	0.150
		CNMG 331E TSF	CNMG090404E-TSF	●	●						●	●			●	●		●	0.016	0.375	0.187	0.150
		CNMG 332E TSF	CNMG090408E-TSF	●	●						●	●			●	●		●	0.031	0.375	0.187	0.150
																						
	TS	CNMG 330.5E TS	CNMG090402E-TS												●			●	0.008	0.375	0.187	0.150
		CNMG 331E TS	CNMG090404E-TS												●			●	0.016	0.375	0.187	0.150
Finishing (wiper)		CNMG 332E TS	CNMG090408E-TS											●			●	0.031	0.375	0.187	0.150	
																						
Finishing	FW	CNMG 331E FW	CNMG090404E-FW	●	●	●									●			●	0.016	0.375	0.187	0.150
		CNMG 332E FW	CNMG090408E-FW	●	●	●									●			●	0.031	0.375	0.187	0.150
			* Wiper																			
Finishing	ZF	CNMG 331E ZF	CNMG090404E-ZF	●	●														0.016	0.375	0.187	0.150
		CNMG 332E ZF	CNMG090408E-ZF	●	●														0.031	0.375	0.187	0.150
																						
Finishing to medium cutting (wiper)	SW	CNMG 332E SW	CNMG090408E-SW	●	●	●							●						0.031	0.375	0.187	0.150
		CNMG 333E SW	CNMG090412E-SW	●	●	●							●						0.047	0.375	0.187	0.150
			* Wiper																			

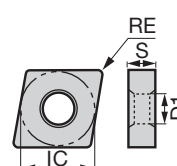
* Please contact our sales representative for your inquiries about the program adjustment when using SW/FW for machining of radius shape or taper machining.

- : New product
- : Line up

- : Continuous cutting
- ◐ : Light interrupted cutting
- ⊕ : Heavy interrupted cutting



**Rhombic, 80°
with hole**

[illegible][illegible]

● : New product
● : Line up

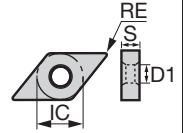
Insert NEGATIVE TYPE

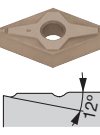
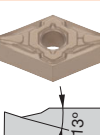
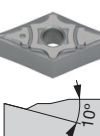
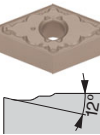
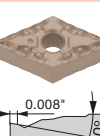
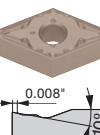
- : Continuous cutting
- ◐ : Light interrupted cutting
- ✱ : Heavy interrupted cutting

DN

 **Rhombic, 55° with hole**

P	Steel	●	●	✱	◐	✱	✱	✱	◐					●	●	●	●		
M	Stainless		●	●		●	◐	◐	✱	◐	◐								
K	Cast iron	●	●	●					◐	◐	◐		●	●	●	●	●		
N	Non-ferrous																		
S	Superalloys								◐	◐	◐								
H	Hard materials																		



Application	Chipbreaker			Designation		Coated										Coated cermet		Cermet	Dimension (in)			
	Inch		Metric		T9205	T9215	T9225	T6120	T6130	AH630	AH645	AH120	AH8015	T515	T5115	GT9530	AT9530	NS9530	RE	IC	S	D1
Precision finishing		TF	DNMG 330.5E TF	DNMG110402E-TF	●	●												●	0.008	0.375	0.187	0.150
		DNMG 331E TF	DNMG110404E-TF	●	●													●	0.016	0.375	0.187	0.150
		DNMG 332E TF	DNMG110408E-TF	●	●													●	0.031	0.375	0.187	0.150
Finishing		TSF	DNMG 330.5E TSF	DNMG110402E-TSF	●	●						●	●				●	●	0.008	0.375	0.187	0.150
		DNMG 331E TSF	DNMG110404E-TSF	●	●							●	●				●	●	0.016	0.375	0.187	0.150
		DNMG 332E TSF	DNMG110408E-TSF	●	●							●	●				●	●	0.031	0.375	0.187	0.150
		DNMG 333E TSF	DNMG110412E-TSF	●	●							●	●				●	●	0.047	0.375	0.187	0.150
		TS	DNMG 330.5E TS	DNMG110402E-TS													●	●	0.008	0.375	0.187	0.150
		DNMG 331E TS	DNMG110404E-TS														●	●	0.016	0.375	0.187	0.150
		DNMG 332E TS	DNMG110408E-TS														●	●	0.031	0.375	0.187	0.150
Finishing (wiper)		FW	DNMG 331E FW	DNMG110404E-FW	●														0.016	0.375	0.187	0.150
		DNMG 332E FW	DNMG110408E-FW	●															0.031	0.375	0.187	0.150
			* Wiper																			
Finishing		ZF	DNMG 331E ZF	DNMG110404E-ZF	●	●													0.016	0.375	0.187	0.150
		DNMG 332E ZF	DNMG110408E-ZF	●	●														0.031	0.375	0.187	0.150
Finishing to medium cutting (wiper)		SW	DNMG 332E SW	DNMG110408E-SW	●														0.031	0.375	0.187	0.150
		DNMG 333E SW	DNMG110412E-SW	●															0.047	0.375	0.187	0.150
			* Wiper																			

* Please contact our sales representative for your inquiries about the program adjustment when using SW/FW for machining of radius shape or taper machining.

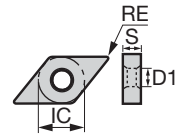
- : New product
- : Line up

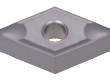
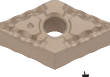
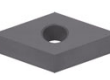
Insert NEGATIVE TYPE

- : Continuous cutting
- ◐ : Light interrupted cutting
- ✱ : Heavy interrupted cutting

DN

Rhombic, 55°
with hole



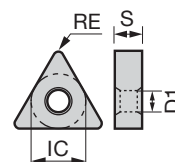
Application	Chipbreaker			Designation		Coated										Coated cermet		Cermet	Dimension (in)				
						T9205	T9215	T9225	T6120	T6130	AH630	AH645	AH120	AH8015	T515	T5115	GT9530	AT9530	NS9530	RE	IC	S	D1
	Inch	Metric																					
Finishing	SS	DNMG 331E SS	DNMG110404E-SS							●	●									0.016	0.375	0.187	0.150
		DNMG 332E SS	DNMG110408E-SS							●	●									0.031	0.375	0.187	0.150
																							
Medium cutting	TM	DNMG 331E TM	DNMG110404E-TM	●	●							●	●							0.016	0.375	0.187	0.150
		DNMG 332E TM	DNMG110408E-TM	●	●							●	●							0.031	0.375	0.187	0.150
		DNMG 333E TM	DNMG110412E-TM	●	●							●	●							0.047	0.375	0.187	0.150
Finishing to medium cutting	ZM	DNMG 332E ZM	DNMG110408E-ZM	●	●															0.031	0.375	0.187	0.150
		DNMG 333E ZM	DNMG110412E-ZM	●	●															0.047	0.375	0.187	0.150
																							
Medium cutting	SM	DNMG 331E SM	DNMG110404E-SM			●	●	●												0.016	0.375	0.187	0.150
		DNMG 332E SM	DNMG110408E-SM			●	●	●												0.031	0.375	0.187	0.150
																							
Finishing to medium cutting	-	DNMA 331E	DNMA110404E											●						0.016	0.375	0.187	0.150
		DNMA 332E	DNMA110408E											●						0.031	0.375	0.187	0.150
		DNMA 333E	DNMA110412E											●						0.047	0.375	0.187	0.150

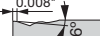
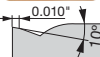
- : New product
- : Line up

- : Continuous cutting
- ◐ : Light interrupted cutting
- ⊕ : Heavy interrupted cutting



**Triangular, 60°
with hole**

[illegible]

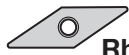
Application	Chipbreaker			Designation			Coated								Coated cermet		Cermet	Dimension (in)			
							T9205	T9215	T9225	T6120	T6130	AH630	AH645	AH120	AH8015	T515	T5115	GT9530	AT9530	NS9530	RE
	Inch	Metric																			
Finishing	SS	TNMG 231E SS	TNMG110404E-SS						●	●								0.016	0.250	0.187	0.089
		TNMG 232E SS	TNMG110408E-SS						●	●								0.031	0.250	0.187	0.089
																					
Medium cutting	TM	TNMG 231E TM	TNMG110404E-TM	●	●													0.016	0.250	0.187	0.089
		TNMG 232E TM	TNMG110408E-TM	●	●													0.031	0.250	0.187	0.089
		TNMG 233E TM	TNMG110412E-TM	●	●													0.047	0.250	0.187	0.089
																					
	SM	TNMG 231E SM	TNMG110404E-SM				●	●	●									0.016	0.250	0.187	0.089
Finishing to medium cutting		TNMG 232E SM	TNMG110408E-SM				●	●	●									0.031	0.250	0.187	0.089
																					
	-	TNMA 231E	TNMA110404E									●						0.016	0.250	0.187	0.089
		TNMA 232E	TNMA110408E									●						0.031	0.250	0.187	0.089
		TNMA 233E	TNMA110412E									●						0.047	0.250	0.187	0.089

● : Line up

Insert NEGATIVE TYPE

- : Continuous cutting
- ◐ : Light interrupted cutting
- ✱ : Heavy interrupted cutting

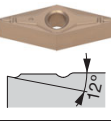
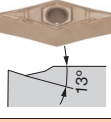
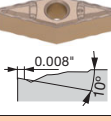
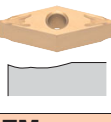
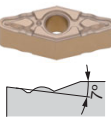
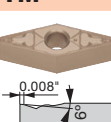
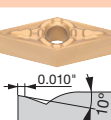
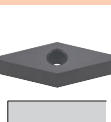
VN



Rhombic, 35°
with hole

P	Steel
M	Stainless
K	Cast iron
N	Non-ferrous
S	Superalloys
H	Hard materials



Application	Chipbreaker	Designation		Coated										Coated cermet		Cermet		Dimension (in)			
				T9205	T9215	T9225	T6120	T6130	AH630	AH645	AH120	AH8015	T515	T5115	GT9530	AT9530	NS9530	RE	IC	S	D1
		Inch	Metric																		
Precision finishing		TF	VNMG 2.330.5E	VNMG120402E-TF	●	●										●	0.008	0.281	0.187	0.150	
			VNMG 2.331E TF	VNMG120404E-TF	●	●										●	0.016	0.281	0.187	0.150	
			VNMG 2.332E TF	VNMG120408E-TF	●	●										●	0.031	0.281	0.187	0.150	
Finishing		TSF	VNMG 2.330.5E TSF	VNMG120402E-TSF	●	●								●	●	●	0.008	0.281	0.187	0.150	
			VNMG 2.331E TSF	VNMG120404E-TSF	●	●								●	●	●	0.016	0.281	0.187	0.150	
			VNMG 2.332E TSF	VNMG120408E-TSF	●	●								●	●	●	0.031	0.281	0.187	0.150	
		ZF	VNMG 2.331E ZF	VNMG120404E-ZF	●	●											0.016	0.281	0.187	0.150	
			VNMG 2.332E ZF	VNMG120408E-ZF	●	●											0.031	0.281	0.187	0.150	
	SS	VNMG 2.331E SS	VNMG120404E-SS			●	●	●	●							0.016	0.281	0.187	0.150		
		VNMG 2.332E SS	VNMG120408E-SS			●	●	●	●							0.031	0.281	0.187	0.150		
Finishing to medium cutting		ZM	VNMG 2.332E ZM	VNMG120408E-ZM	●	●										0.031	0.281	0.187	0.150		
			VNMG 2.333E ZM	VNMG120412E-ZM	●	●										0.047	0.281	0.187	0.150		
Medium cutting		TM	VNMG 2.331E TM	VNMG120404E-TM	●	●										0.016	0.281	0.187	0.150		
			VNMG 2.332E TM	VNMG120408E-TM	●	●										0.031	0.281	0.187	0.150		
			VNMG 2.333E TM	VNMG120412E-TM	●	●										0.047	0.281	0.187	0.150		
		SM	VNMG 2.331E SM	VNMG120404E-SM			●	●	●	●						0.016	0.281	0.187	0.150		
		VNMG 2.332E SM	VNMG120408E-SM			●	●	●	●						0.031	0.281	0.187	0.150			
Finishing to medium cutting		-	VNMA 2.331E	VNMA120404E								●				0.016	0.281	0.187	0.150		
			VNMA 2.332E	VNMA120408E								●				0.031	0.281	0.187	0.150		

- : New product
- : Line up

Insert NEGATIVE TYPE

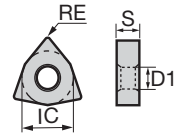
- : Continuous cutting
- ◐ : Light interrupted cutting
- ✱ : Heavy interrupted cutting

WN



**Trigon, 80°
with hole**

P	Steel
M	Stainless
K	Cast iron
N	Non-ferrous
S	Superalloys
H	Hard materials



Application	Chipbreaker		
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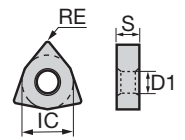
* Please contact our sales representative for your inquiries about the program adjustment when using SW/FW for machining of radius shape or taper machining.

- : New product
- : Line up

- : Continuous cutting
- ◐ : Light interrupted cutting
- ⊕ : Heavy interrupted cutting

**Trigon, 80°
with hole**

P	Steel
M	Stainless
K	Cast iron
N	Non-ferrous
S	Superalloys
H	Hard materials



- : New product
- : Line up



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