



CA45 FOR CAST IRON

New CVD Coated Carbide for Cast Iron

- CA4515: First choice for stability.
- CA4505: High-speed and efficient cutting.



Neue CVD Hartmetall Sorte für Guss

- CA4515: Erste Wahl für Stabilität.
- CA4505: Hochgeschwindigkeitsbearbeitung und wirtschaftliches Zerspanen.












Nouvelle CVD carbure revêtues pour fonte


- CA4515: 1 choix pour un usinage stable.
- CA4505: Pour usinage à haute vitesse.

Nuovo rivestimento CVD per metallo duro per la ghisa

- CA4515: Prima scelta per stabilità.
- CA4505: Alta velocità ed efficienza.






Standard Items (negative)





Insert	Description	Dimension (mm)				CVD Coated Carbide				
		I.C.	Thickness	Hole	Corner-R(r _e)	CA4505	CA4515			
	CNMG 120408WQ 120412WQ	12.70	4.76	5.16	0.8 1.2	● ●	● ●			
	CNMG 120404 120408 120412 120416	12.70	4.76	5.16	0.4 0.8 1.2 1.6	● ● ● ●	● ● ● ●			
	CNMG 160612 160616				15.875	6.35	6.35	1.2 1.6	● ●	● ●
	CNMG 190608 190612 190616				19.05	6.35	7.94	0.8 1.2 1.6	● ● ●	● ● ●
	CNMG 120404C 120408C 120412C 120416C	12.70	4.76	5.16	0.4 0.8 1.2 1.6	● ● ● ●	● ● ● ●			
	CNMG 160612C				15.875	6.35	6.35	1.2	●	●
	CNMG 120408ZS 120412ZS	12.70	4.76	5.16	0.8 1.2	● ●	● ●			
	CNMG 120408GC 120412GC	12.70	4.76	5.16	0.8 1.2	● ●	● ●			
	CNMA 120404 120408 120412 120416	12.70	4.76	5.16	0.4 0.8 1.2 1.6	● ● ● ●	● ● ● ●			
	DNMG 150404 150408 150412				12.70	4.76	5.16	0.4 0.8 1.2	● ● ●	● ● ●
	DNMG 150604 150608 150612							12.70	6.35	5.16
	DNMG 150404C 150408C 150412C				12.70	4.76	5.16	0.4 0.8 1.2	● ● ●	● ● ●
DNMG 150604C 150608C 150612C	12.70	6.35	5.16	0.4 0.8 1.2				● ● ●	● ● ●	
	DNMG 150408ZS 150412ZS	12.70	4.76	5.16	0.8 1.2	● ●	● ●			
	DNMG 150608ZS 150612ZS				12.70	6.35	5.16	0.8 1.2	● ●	● ●
	DNMG 150408GC 150412GC	12.70	4.76	5.16	0.8 1.2	● ●	● ●			
	DNMG 150608GC 150612GC				12.70	6.35	5.16	0.8 1.2	● ●	● ●
	DNMA 150404 150408	12.70	4.76	5.16	0.4 0.8	● ●	● ●			
	DNMA 150604 150608				12.70	6.35	5.16	0.4 0.8	● ●	● ●
	RNMG 120400	12.70	4.76	5.16	-		●			
	RNMG 150600	15.875	6.35	6.35	-		●			
	SNMG 090308	9.525	3.18	3.81	0.8		●			
	SNMG 120404 120408 120412 120416 120420	12.70	4.76	5.16	0.4 0.8 1.2 1.6 2.0	● ● ● ● ●	● ● ● ● ●			
	SNMG 120408C 120412C				12.70	4.76	5.16	0.8 1.2	● ●	● ●
	SNMG 120408ZS 120412ZS							12.70	4.76	5.16

Insert	Description	Dimension (mm)				CVD Coated Carbide						
		I.C.	Thickness	Hole	Corner-R(r _e)	CA4505	CA4515					
	SNMG 120408GC 120412GC	12.70	4.76	5.16	0.8 1.2	● ●	● ●					
	SNMA 120404 120408 120412 120416 120420				12.70	4.76	5.16	0.4 0.8 1.2 1.6 2.0	● ● ● ● ●	● ● ● ● ●		
SNMN 120408 120412	12.70	4.76	5.16	0.8 1.2				● ●	● ●			
TNMG 160404 160408 160412 160416 160420				9.525				4.76	3.81	0.4 0.8 1.2 1.6 2.0	● ● ● ● ●	● ● ● ● ●
TNMG 220404 220408 220412	12.70	4.76	5.16							0.4 0.8 1.2	● ● ●	● ● ●
TNMG 160404C 160408C 160412C				9.525				4.76	3.81	0.4 0.8 1.2	● ● ●	● ● ●
TNMG 160408ZS 160412ZS	9.525	4.76	3.81		0.8 1.2	● ●	● ●					
TNMG 160408GC 160412GC				9.525	4.76	3.81	0.8 1.2	● ●	● ●			
TNMA 160404 160408 160412 160416 160420	9.525	4.76	3.81				0.4 0.8 1.2 1.6 2.0	● ● ● ● ●	● ● ● ● ●			
VNMG 160404 160408				9.525	4.76	3.81	0.4 0.8	● ●	● ●			
WNMG 080404 080408 080412							12.70	4.76	3.81	0.4 0.8 1.2	● ● ●	● ● ●
WNMG 080404C 080408C 080412C				12.70	4.76	3.81				0.4 0.8 1.2	● ● ●	● ● ●
WNMG 080408ZS 080412ZS										12.70	4.76	3.81
WNMG 080408GC 080412GC	12.70	4.76	3.81	0.8 1.2	● ●	● ●						
WNMA 080408 080412				12.70	4.76	3.81	0.8 1.2	● ●	● ●			

● : Standard Item

Standard Items (positive)

Insert	Description	Dimension (mm)					CVD Coated Carbide	
		I.C.	Thickness	Hole	Corner-R(r)	Relief Angle	CA4505	CA4515
	CCMT 060204GK	6.35	2.38	2.8	0.4	7°		●
	CCMT 09T304GK	9.525	3.97	4.4	0.4	7°		●
	CCMT 120404GK 120408GK	12.70	4.76	5.5	0.8	7°		●
	CCMT 09T308	9.525	3.97	4.4	0.8	7°	●	●
	CPMH 080204 080208	7.94	2.38	3.5	0.8	11°		●
	CPMH 090304 090308	9.525	3.18	4.5	0.8	11°	●	●
	DCMT 070204GK 070208GK	6.35	2.38	2.8	0.8	7°		●
	DCMT 11T304GK 11T308GK	9.525	3.97	4.4	0.8	7°		●
	DCMT 11T308	9.525	3.97	4.4	0.8	7°		●
	RCMX 1204M0	12.0	4.76	4.2	-	7°	●	●

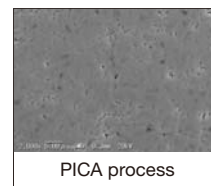
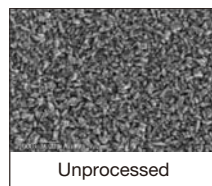
Insert	Description	Dimension (mm)					CVD Coated Carbide	
		I.C.	Thickness	Hole	Corner-R(r)	Relief Angle	CA4505	CA4515
	SPMN 120304 120308	12.70	3.18	-	0.4	11°	●	●
	0.8							
	SPMN 120408 120412	12.70	4.76	-	0.8	11°	●	●
					1.2			
	TCMT 110204HQ 110208HQ	6.35	2.38	2.8	0.4	7°	●	●
	0.8							
	TCMT 16T308HQ 16T312HQ	9.525	3.97	4.4	0.8	7°	●	●
	1.2							
	TPMT 110304HQ 110308HQ	6.35	3.18	3.3	0.4	11°	●	●
					0.8			
TPMT 160304HQ 160408HQ	9.525	3.18	4.4	0.4	11°	●	●	
				0.8				
	TPMR 110304 110308	6.35	3.18	-	0.4	11°	●	●
	0.8							
	TPMR 160304 160308	9.525	3.18	-	0.4	11°	●	●
0.8								
	TPMN 110304 110308	6.35	3.18	-	0.4	11°	●	●
	0.8							
	TPMN 160304 160308	9.525	3.18	-	0.4	11°	●	●
					0.8			
TPMN 160312	9.525	3.18	-	1.2	11°	●	●	

● : Standard Item

New Coating Technology Neue Beschichtungstechnologie Nouvelle technologie de revêtement Nuova tecnologia di rivestimento

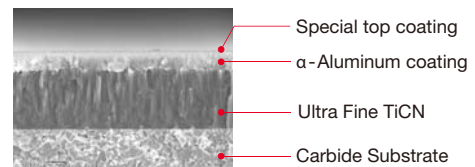
Special top coating and surface finish Spezielle Beschichtung und Oberflächenbehandlung Haut niveau de revêtement et de finition spécial Speciale rivestimento superiore e finitura superficiale

The innovative surface treatment prevents adhesion.
Die innovative Oberflächenbehandlung vermindert Adhäsion.
L'innovation du traitement de surface empêche l'adhésion.
Il trattamento superficiale innovativo impedisce l'adesione.

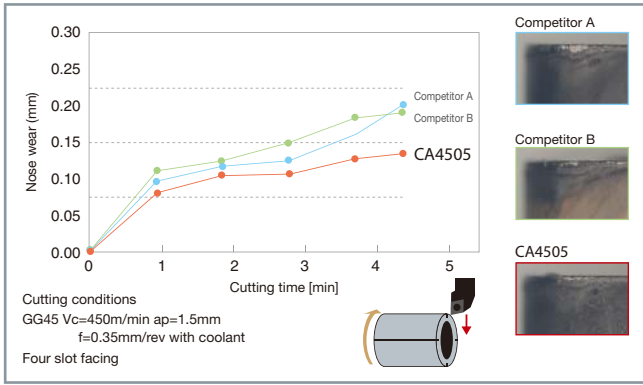


New special coating structure Neue spezielle Beschichtungsstruktur Nouveau revêtement à structure spéciale Nuova struttura di rivestimento di speciale

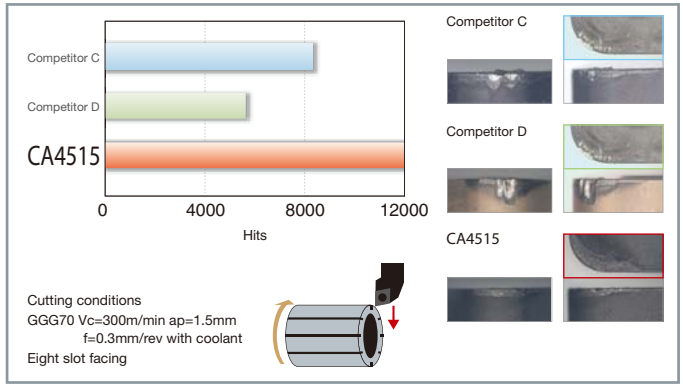
Improved resistance to delamination (coating peeling) and chipping resistance.
Verbesserte Haftungseigenschaften der Beschichtung und verbesserte Kantenschlagfestigkeit.
Meilleure résistance à la délamination (peeling revêtement) et à la résistance écaillage.
Migliore resistenza alla delaminazione (peeling rivestimento) e resistenza alla scheggiatura.



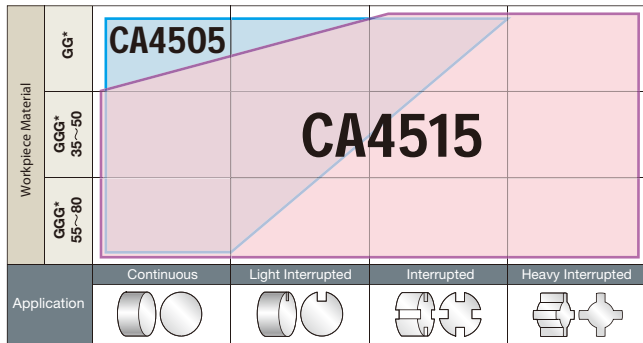
Wear Resistance Comparison (Nodular Cast Iron)



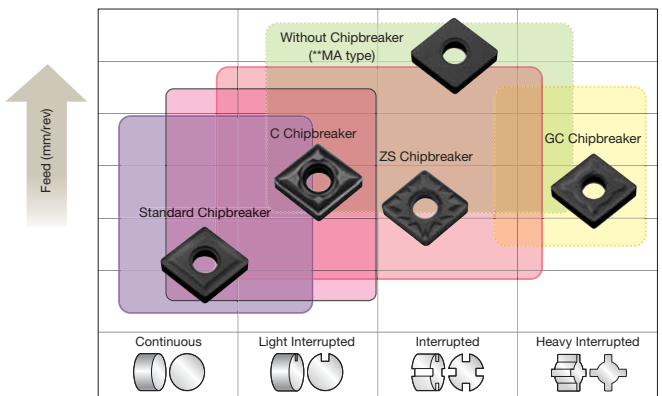
Fracture Resistance Comparison (Nodular Cast Iron)



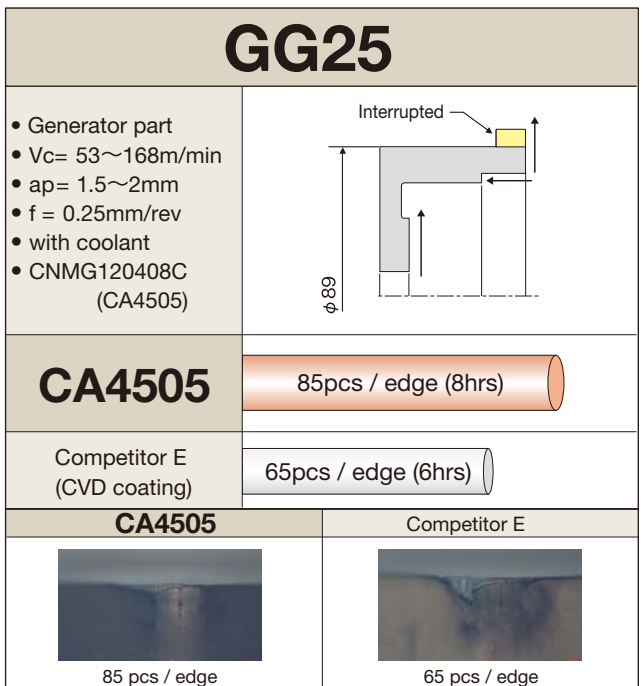
Application Maps for Cast Iron Cutting



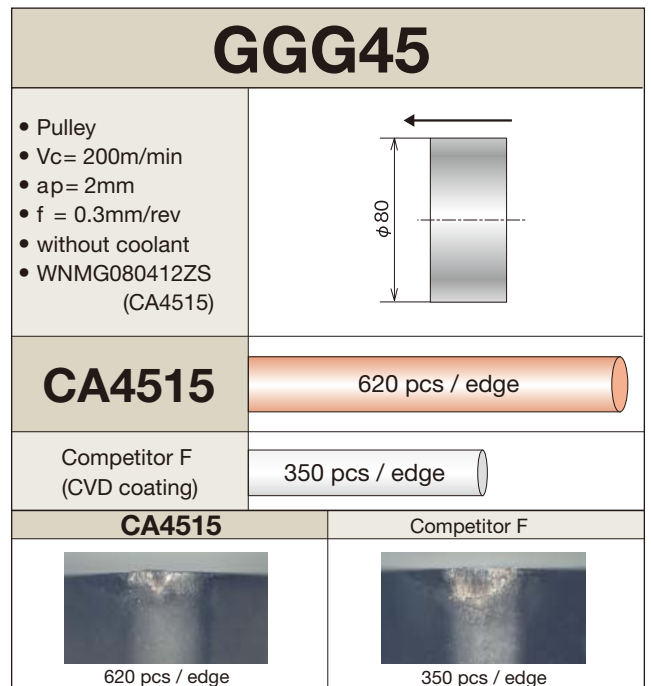
Chipbreaker Selection (Negative Insert)



Case Studies



Evaluation by the user



Evaluation by the user

THE NEW VALUE FRONTIER



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