

ISCAR has Widened Its Line of ISO Turning Inserts with Additional New Sizes, Geometries and Chipbreakers

New designs have been added to the Line for finishing applications. The new SF and SM chipformers are recommended, as well as the new ground Cermet inserts designated IC30N, having small corner radii of 0.2mm and 0.4 mm.

For medium and semi-rough machining, the ISCAR Line now covers most industrial requirements.

Roughing applications are now easier with the new NR chip deflectors available on □ NMG inserts. This double sided-insert covers the full range of applications that the single-sided □ NMM-type inserts performed, but with more cutting edges and a lower price per edge for comparable performance.

The unique QNMG inserts are recommended for medium to high volume applications. ISCAR has expanded their range to include 0.4 mm and 1.2 mm corner radii and the NF chipformer.

For heat resistant alloys, stainless and hardened steel, ISCAR inserts, designated IC507, are manufactured with a new Sub-Micron substrate and TiCN-PVD coating. For stainless steel applications, the NF, PP, TF and SM chipformers with their positive rake angles are recommended. A fine surface quality in finishing applications may be achieved with the ground CNGG inserts, utilizing their sharp cutting edges.

Machining cast iron is no longer a problem. ISCAR's new grade IC9007 is made with a new Sub-Micron substrate for high toughness, good fracture resistance, and a medium temperature coating, a MT-CVD Al_2O_3 -TiN combination. IC9007 is recommended for gray and nodular cast iron at low to medium cutting speeds. ISCAR has added the popular 0.8 mm and 1.2 mm corner radii for applications at medium feeds and medium depths of cut.



Finishing Applications

Cat. No.	Designation	New Grade	Vc(m/min)			
			Steel	Stainless Steel	f(mm/rev)	ap(mm)
5503028	CCGT 060202	IC30N	200-290	150-280	0.10-0.20	0.5-2.0
5503029	CCGT 060204	IC30N	200-290	150-280	0.10-0.20	0.5-2.0
5504090	CNMG 120404-SF	IC570	200-280	150-260	.004-0.25	0.3-3.0
5503025	DCGT 070202	IC30N	200-290	150-280	0.08-0.20	0.5-2.0
5503026	DCGT 070204	IC20N	200-290	150-280	0.13-0.25	0.5-2.5
5504093	DNMG 110404-SF	IC530N	200-300	150-280	0.06-0.25	0.5-3.0
5504532	SCMT 09T308-SM	IC9025	250-300	100-300	0.10-0.30	0.5-3.0
5504533	SCMT 09308-SM	IC3028	50-200	50-180	0.10-0.30	0.5-3.0
5504541	TNMG 1600408-SF	IC570	200-280	150-260	0.06-0.30	1.0-3.0
5504542	TNMG 160408-SF	IC9025	150-350	100-300	0.06-.030	1.0-3.0
5503792	VNMG 12T302-SF	IC570	200-280	150-260	0.03-0.20	0.3-2.0

Medium machining and Semi-Roughing

Cat. No.	Designation	New Grade	Vc(m/min)			f(mm/rev)	ap(mm)
			Steel	Stainless Steel	Cast Iron		
5503993	CNMG 090304-TF	IC9025	150-300	100-250	-	0.12-0.03	1.0-3.0
5503994	CNMG 090304-TF	IC9015	200-350	-	140-300	0.12-0.03	1.0-3.0
5504077	TNMG 270612-GN	IC9025	150-300	100-250	-	0.18-0.45	2.0-6.0
5504543	RCMT 1204M0-14S*	IC9015	200-350	-	140-300	0.30-0.50	1.50-6.0



Roughing Applications

Cat. No.	Designation	New Grade	Vc(m/min) Steel	Vc(m/min) Stainless Steel	Vac(m/min)		f(mm/rev)	ap(mm)
					Cast Iron			
5504558	CNMG 190616-NR	IC9015	200-300	-	140-250	0.30-0.80	3.0-10.0	
5504557	CNMG 190616-NR	IC9025	150-200	100-220	-	0.30-0.80	3.0-10.0	
5504561	DNMG 150616-NR	IC9015	200-300	-	140-250	0.25-0.60	2.0-6.0	
5504562	DNMG 150616-NR	IC9025	150-200	100-220	-	0.25-0.60	2.0-6.0	
5504559	SNMG 190616-NR	IC9025	150-250	100-220	-	0.28-1.00	2.0-10.0	
5508348	WNMG 080412-NR	IC9025	150-250	100-200	-	0.25-0.60	2.0-6.0	
5508358	WNMG 080412-NR	IC9015	200-300	-	140-250	0.25-0.60	2.0-6.0	
5508338	WNMG 080412-NR	IC520M	120-200	100-250	120-200	0.25-0.60	2.0-6.0	

New QNMG Geometries

Cat. No.	Designation	New Grade	Vc(m/min) Steel	Vc(m/min) Stainless Steel	Vac(m/min)		f(mm/rev)	ap(mm)
					Cast Iron			
5504433	QNMG 120404-TF	IC9025	150-300	100-250	-	0.12-0.35	1.0-4.0	
5504435	QNMG 120404-TF	IC9028	50-180	80-150	-	0.12-0.35	1.0-4.0	
5504434	QNMG 120404-TF	IC9015	200-350	-	140-300	0.12-0.35	1.0-4.0	
5504734	QNMG 120412-TF	IC9015	200-350	-	140-300	0.15-0.40	1.5-4.5	
5508308	QNMG 120408-NF	IC9015	250-400	-	140-350	0.08-0.25	0.8-3.0	



IC507 Items

Cat. No.	Designation	New Grade	Vc(m/min)	Vc(m/min)	Vac(m/min)	f(mm/rev)	ap(mm)
			Steel	Stainless Steel	Cast Iron		
5504537	CNMG 120404-TF	IC507	30-60	180-300	30-40	0.14-0.30	1.0-4.0
5504600	CNMG 120412-PP	IC507	30-60	180-300	30-40	0.18-0.40	1.5-4.0
5504725	CNMG 190612-NR	IC507	30-60	180-300	30-40	0.30-0.60	2.0-8.0
5504540	CNMG 120401-SF	IC507	30-60	180-300	30-40	0.03-0.15	0.2-1.5
5506288	CNMG 120402-SF	IC507	30-60	180-300	30-40	0.03-0.25	0.3-2.0
5504536	DNMG 11T308-SM	IC507	30-60	180-300	30-40	0.08-0.30	0.5-2.5
5504736	DNMG 150-408-TF	IC507	30-60	180-300	30-40	0.14-0.30	1.0-3.5
5504746	WNMG 06T308-PP	IC507	30-60	180-300	30-40	0.14-0.30	1.0-3.0
5504539	WNMG 080412-TF	IC507	30-60	180-300	30-40	0.15-0.40	1.5-4.5
5504265	VNMG 12T304-NF	IC507	30-60	180-300	30-40	0.07-0.30	0.8-2.0
5504737	VNMG 160408-TF	IC507	30-60	180-300	30-40	0.13-0.36	1.0-3.5

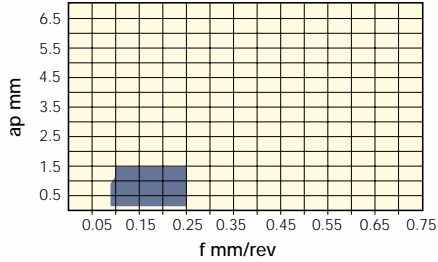
IC9007 Items

Cat. No.	Designation	New Grade	Vc(m/min)	f(mm/rev)	ap(mm)
			Cast Iron		
5504729	CNMG 120408	IC9007	100-280	Max. 0.50	1.0-4.0
5504731	CNMG 120412	IC9007	100-280	Max. 0.50	1.5-4.0
5504730	CNMG 120408-GN	IC9007	100-280	0.16-0.45	1.0-4.5
5504732	CNMG 120412-GN	IC9007	100-280	Max. 0.50	1.5-5.0
5506728	TNMG 160408	IC9007	100-280	0.22-0.50	1.0-4.0
5504726	WNMG 080412	IC9007	100-280	Max. 0.30	1.5-4.0
5504727	WNMG 080412-GN	IC9007	100-280	0.22-0.50	1.5-4.5
5504733	SNMG 120412	IC9007	100-280	0.30-0.50	1.5-5.0

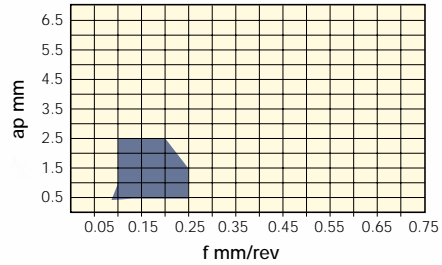


Chip Breaking Range

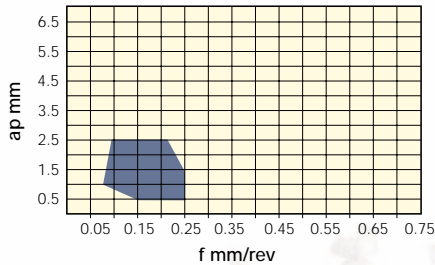
CCGT 060202



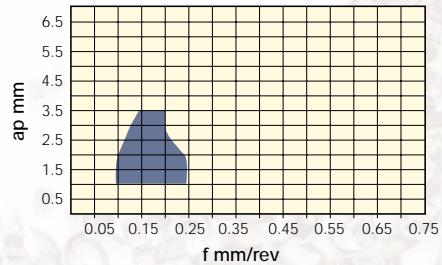
DCGT 070202



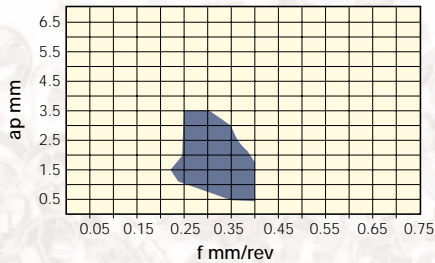
DCGT 070204



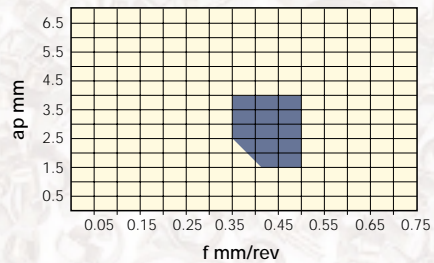
***DCMT 11T308-SM**



SCMT 09T308-SM

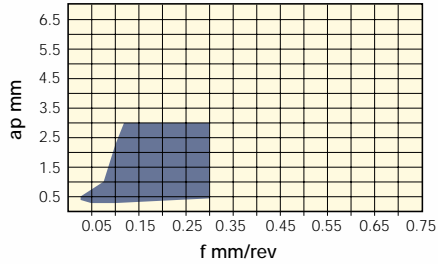


RCMT 1204M0-14S

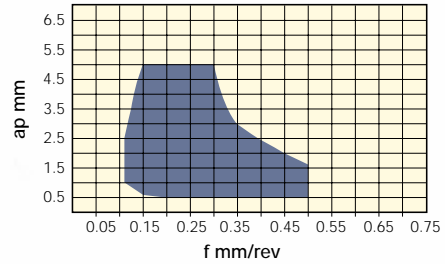


Chip Breaking Range

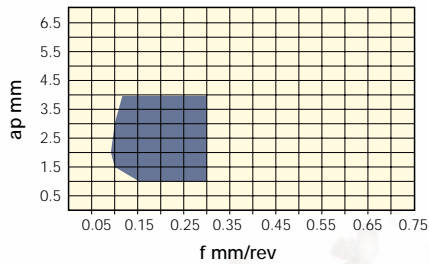
VNMG 12T302-SF



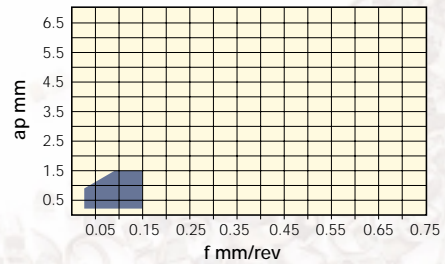
WNMG 080404-TF



QNGM 120408-NF

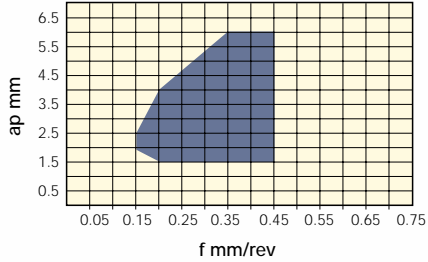


CNGG 120401-SF

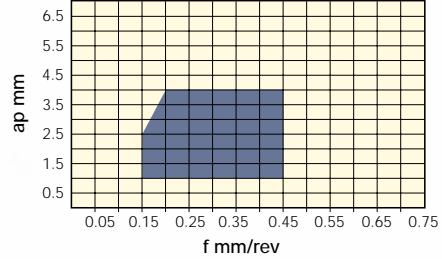


Chip Breaking Range

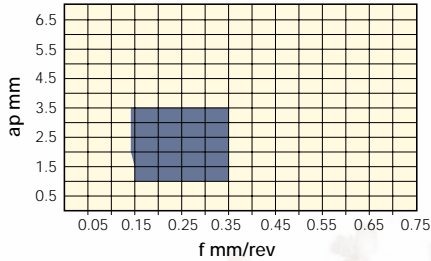
TNMG 270612-GN



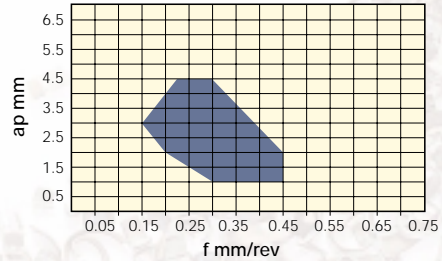
CNMG 120404-TF



VNMG 160408-TF

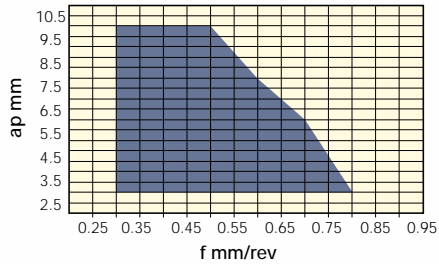


WNMG 06T308-PP

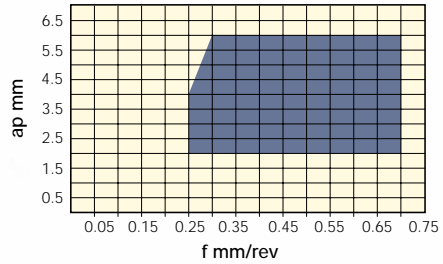


Chip Breaking Range

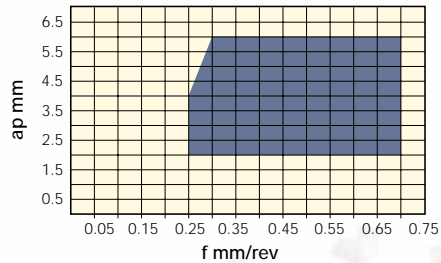
CNMG 190616-NR



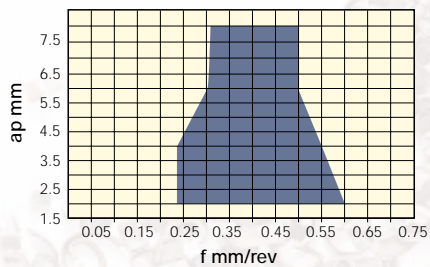
DNMG 150616-NR



DNMG 150616-NR



WNMG 080412-NR



SNMG 190616-NR

