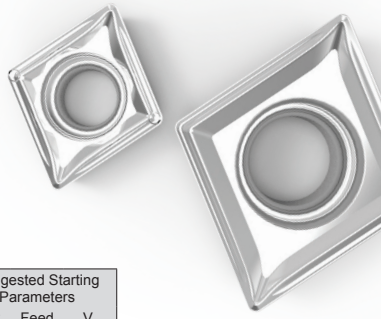
NEW PRODUCT RELEASE

POSITIVE TURNING INSERTS FOR ALUMINIUM

LT 05

LAMINA TECHNOLOGIES ADDS TWO NEW POSITIVE GEOMETRIES TO ITS ALUMINIUM TURNING LINE.

- ISO STANDARD POSITIVE INSERTS
- IMPROVED CHIP CONTROL AND CHIP EVACUATION
- POSITIVE INSERTS WITH 2 CUTTING EDGES
- UNIQUE COATING DEDICATED TO ALUMINIUM
- ALL INSERTS FIT INTO STANDARD TOOL HOLDERS AND BORING BARS



CCGT 060204 - CATALOG # T0004162

Material Group		Gr. N°	VDI Group	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters DOC	Feed	V_c
S	Ti Based Alloys	10	37	T 40	-	0.30	1.00	0.12	0.19	0.20	30	40	0.90	0.12	35
			36	TiAl 6 V4	-	0.30	1.00	0.09	0.15	0.24	40	60	0.90	0.13	45
NF	AL (<8%Si)	15	21, 22, 23, 24	4% < Si < 8%	100 HB	0.30	2.50	0.10	0.29	1.02	250	600	1.50	0.23	300
				Si < 4%	60 HB	0.30	2.50	0.12	0.33	1.28	400	1'200	1.50	0.23	400
	Copper Alloys	16	26, 27, 28	CuZn30	100HB	0.30	2.50	0.10	0.29	1.02	150	800	1.50	0.23	250
	Non Metallic	17	29	Fiber Plastics	-	0.30	2.50	0.10	0.19	1.02	70	500	1.20	0.15	150
			-	Graphite	-	0.30	2.50	0.10	0.19	1.02	100	200	1.20	0.15	150
			30	Hard Rubber	-	0.30	2.50	0.10	0.19	1.02	80	300	1.20	0.15	150

CCGT 09T304 - CATALOG # T0004162

Material Group		Gr. N°	VDI Group	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters DOC	Feed	V_c
S	Ti Based Alloys	10	37	T 40	-	0.30	1.80	0.20	0.20	0.24	30	40	0.90	0.12	35
			36	TiAl 6 V4	-	0.30	1.80	0.09	0.16	0.28	40	60	0.90	0.13	45
NF	AL (<8%Si)	15	21, 22, 23, 24	4% < Si < 8%	100 HB	0.30	4.50	0.10	0.30	1.20	250	600	1.50	0.23	300
				Si < 4%	60 HB	0.30	4.50	0.12	0.35	1.50	400	1'200	1.50	0.23	400
	Copper Alloys	16	26, 27, 28	CuZn30	100HB	0.30	4.50	0.10	0.30	1.20	150	800	1.50	0.23	250
	Non Metallic	17	29	Fiber Plastics	-	0.30	4.50	0.10	0.20	1.20	70	500	1.20	0.15	150
			-	Graphite	-	0.30	4.50	0.10	0.20	1.20	100	200	1.20	0.15	150
			30	Hard Rubber	-	0.30	4.50	0.10	0.20	1.20	80	300	1.20	0.15	150

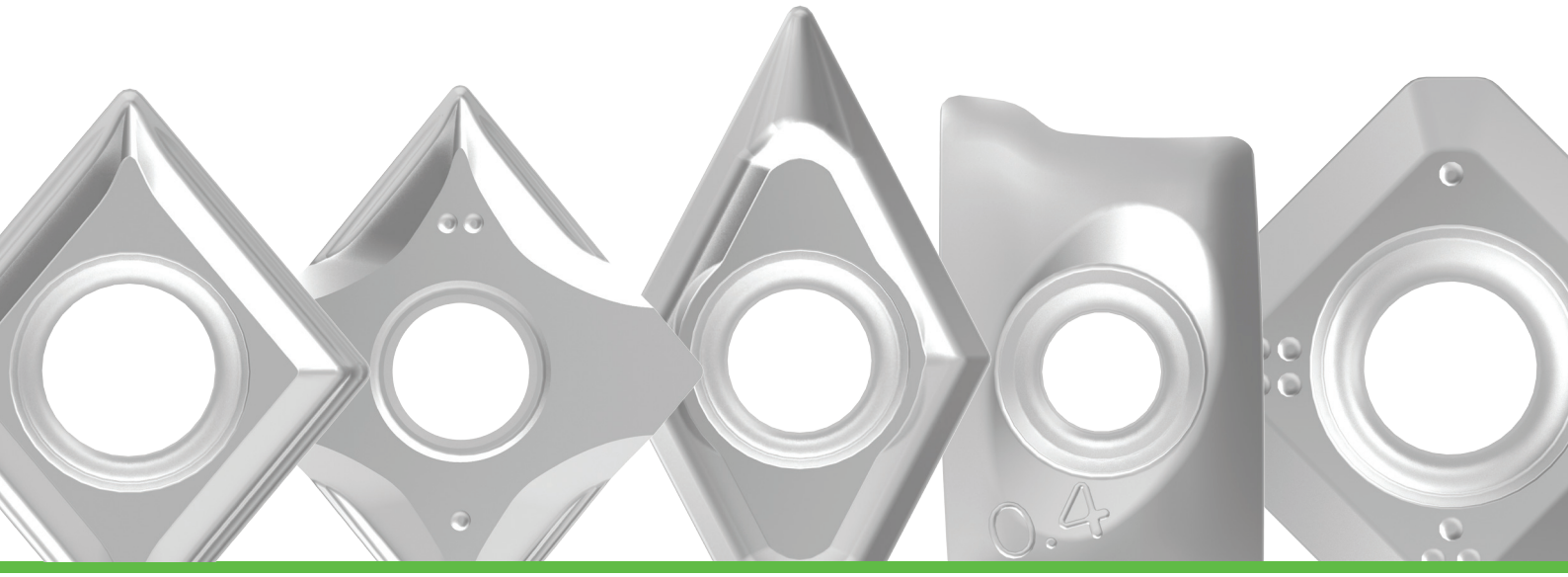
DCGT 11T304 - CATALOG # T0006164

Material Group		Gr. N°	VDI Group	Material Examples	Hardness	DOC [mm] min	DOC [mm] max	Feed [mm/rev] min	Feed [mm/rev] max	Amax [mm²]	V_c [m/min] min	V_c [m/min] max	Suggested Starting Parameters DOC	Feed	V_c
S	Ti Based Alloys	10	37	T 40	-	0.30	1.80	0.12	0.20	0.24	30	40	1.40	0.12	35
			36	TiAl 6 V4	-	0.30	1.80	0.09	0.16	0.28	40	60	1.40	0.13	45
NF	AL (<8%Si)	15	21, 22, 23, 24	4% < Si < 8%	100 HB	0.30	4.50	0.10	0.30	1.20	250	600	2.30	0.23	300
				Si < 4%	60 HB	0.30	4.50	0.12	0.35	1.50	400	1'200	2.30	0.23	400
	Copper Alloys	16	26, 27, 28	CuZn30	100HB	0.30	4.50	0.10	0.30	1.20	150	800	2.30	0.23	250
	Non Metallic	17	29	Fiber Plastics	-	0.30	4.50	0.10	0.20	1.20	70	500	1.80	0.15	150
			-	Graphite	-	0.30	4.50	0.10	0.20	1.20	100	200	1.80	0.15	150
			30	Hard Rubber	-	0.30	4.50	0.10	0.20	1.20	80	300	1.80	0.15	150

SEE OUR CATALOG OR CONTACT US FOR MORE INFORMATION ON OUR FULL LINE OF ALUMINIUM INSERTS FOR TURNING AND MILLING

ALUMINIUM TURNING AND MILLING

LT 05



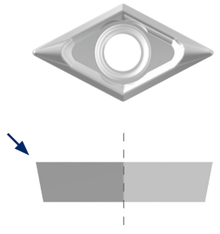
LAMINA TECHNOLOGIES

ALU TURNING

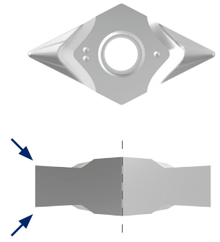
UNIQUE COATING AND CHIPBREAKER DESIGN DEDICATED TO TURNING ALUMINIUM

ISO standard positive chipbreaker geometries for aluminium turning operations.

- Improved chip control and chip evacuation
- Standard 2 cutting edges and
- Economical 4 cutting edges
- All inserts use standard tool holders and boring bars



STANDARD POSITIVE INSERTS
_CGT



LAMINA 4 EDGE ALTERNATIVE
_NGG

ALU MILLING

OPTIMIZED GEOMETRIES AND UNIQUE COATING IDEAL FOR MILLING ALUMINIUM

Highly positive inserts with a unique coating. Ideal for 90° shoulder milling and 45° face milling of aluminium.

Suitable for roughing to finishing, slotting and face milling operations.

- Extended tool life
- No edge build up in low silicon aluminium
- Improved wear resistance for high silicon aluminium

LT 05 DEDICATED ALUMINIUM GRADE

See our catalog or contact us for our full range of inserts available in our advanced LT 05 aluminium grade.

- Dedicated for aluminum and other non-ferrous materials
- Suitable for titanium
- Low friction
- High resistance to built up edge
- Extremely long tool life

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