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Inserts for Heavy-Duty Turning



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VKD154C High hardness substrate, thick TiCN and thick Al₂O₃ coating. Excellent wear resistance, suitable for heavy-duty machining under continuous working conditions.

PREF VKD254C It has both hardness and strength matrix, thick TiCN and Al₂O₃ coating. Excellent wear resistance, taking into account continuous and weak intermittent processing, and good general performance.

VKD354C High-strength substrate, thick TiCN and Al₂O₃ coating. Excellent impact resistance, suitable for strong intermittent heavy turning.

Different working conditions,
different solutions.



HLR—Light turning

The chip breaking range is wide, the cutting is light and fast, and it is suitable for continuous cutting or allowance. Smaller heavy turning.



HIR—Interrupted turning

The cutting edge is strengthened, which is highly safe and suitable for heavy turning in unstable working conditions such as intermittent turning.

PREF



HGR—General turning

The groove structure takes into account both chip control and strength requirements. Suitable for continuous and weak intermittent heavy turning.

PREF



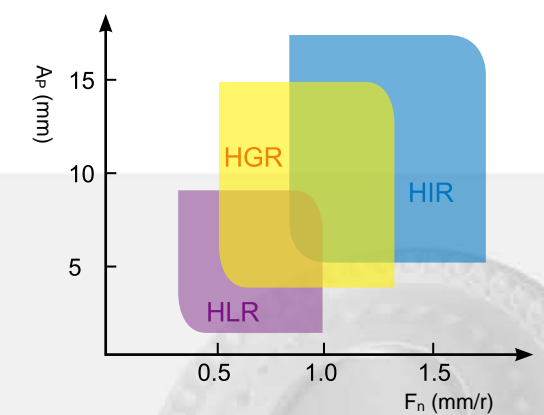
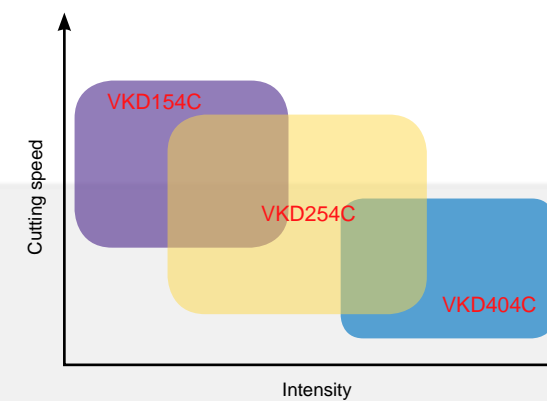
HMR—Light turning

The double-sided heavy-duty stainless steel machining geometry has good chip flow control and is suitable for

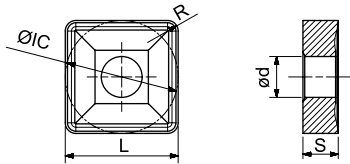


HPR - general cutting

Double-sided universal machining geometry, the structure takes into account chip control and strength requirements. It has extremely high economy under stable working conditions.

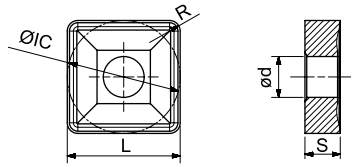


Single-sided heavy turning



Insert Shape	Model	Dimension (mm)					Grade			
		L	IC	d	S	R	VKD154C	VKD254C	VKD354C	VKD404C
	CNMM160608-HLR	16.1	15.875	6.35	6.35	0.8	★		●	○
	CNMM160612-HLR	16.1	15.875	6.35	6.35	1.2	★		●	○
	CNMM160616-HLR	16.1	15.875	6.35	6.35	1.6	★		●	○
	CNMM190612-HLR	19.3	19.05	6.35	7.94	1.2	★		●	○
	CNMM190616-HLR	19.3	19.05	6.35	7.94	1.6	★		●	○
	CNMM190624-HLR	19.3	19.05	6.35	7.94	2.4	★		●	○
	CNMM250924-HLR	25.8	25.4	9.525	9.12	2.4	★		●	○
	SNMM150608-HLR	15.875	15.875	6.35	6.35	0.8	★		●	○
	SNMM150612-HLR	15.875	15.875	6.35	6.35	1.2	★		●	○
	SNMM150616-HLR	15.875	15.875	6.35	6.35	1.6	★		●	○
	SNMM190612-HLR	19.05	19.05	6.35	7.94	1.2	★		●	○
	SNMM190616-HLR	19.05	19.05	6.35	7.94	1.6	★		●	○
	SNMM190624-HLR	19.05	19.05	6.35	7.94	2.4	★		●	○
	SNMM250724-HLR	25.4	25.4	9.12	7.94	2.4	★		●	○
	SNMM250924-HLR	25.4	25.4	9.12	9.525	2.4	★		●	○
	CNMM190612-HGR	19.3	19.05	6.35	6.35	1.2		★		○
	CNMM190616-HGR	19.3	19.05	6.35	6.35	1.6		★		○
	CNMM190624-HGR	19.3	19.05	6.35	6.35	2.4		★		○
	CNMM250724-HGR	25.8	25.4	9.12	7.94	2.4		★		○
	CNMM250924-HGR	25.8	25.4	9.12	9.525	2.4		★		○
	SNMM190612-HGR	19.05	19.05	6.35	6.35	1.2		★		○
	SNMM190616-HGR	19.05	19.05	6.35	6.35	1.6		★		○
	SNMM190624-HGR	19.05	19.05	6.35	6.35	2.4		★		○
	SNMM250724-HGR	25.4	25.4	9.12	7.94	2.4		★		○
	SNMM250924-HGR	25.4	25.4	9.12	9.525	2.4		★		○
	SNMM190624-HIR	19.3	19.05	6.35	6.35	2.4		●		★
	CNMM250724-HIR	25.8	25.4	9.12	7.94	2.4		●		★
	CNMM250924-HIR	25.8	25.4	9.12	9.525	2.4		●		★

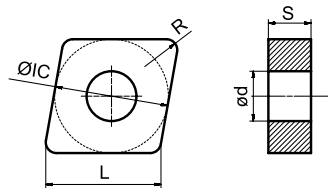
Single-sided heavy turning



Insert Shape	Model	Dimension (mm)					Grade			
		L	IC	d	S	R	VKD154C	VKD254C	VKD354C	VKD404C
	SNMM190624-HIR	19.05	19.05	6.35	6.35	2.4		●		★
	SNMM250724-HIR	25.4	25.4	9.12	7.94	2.4		●		★
	SNMM250924-HIR	25.4	25.4	9.12	9.525	2.4		●		★
	SNMM250932-HIR	25.4	25.4	9.12	9.525	3.2		●		★
	CNMM190616-HPR	19.3	19.05	6.35	7.94	1.6	★		●	
	CNMM190624-HPR	19.3	19.05	6.35	7.94	2.4	★		●	
	CNMM250724-HPR	25.8	25.4	7.94	9.12	2.4	★		●	
	CNMM250924-HPR	25.8	25.4	9.525	9.12	2.4	★		●	
	SNMM190616-HPR	19.05	19.05	6.35	7.94	1.6	★		●	
	SNMM190624-HPR	19.05	19.05	6.35	7.94	2.4	★		●	
	SNMM250724-HPR	25.4	25.4	7.94	9.12	2.4	★		●	
	SNMM250924-HPR	25.4	25.4	9.525	9.12	2.4	★		●	
	CNMM190624-HZ	19.3	19.05	6.35	7.94	2.4	★		●	
	CNMM250924-HZ	25.8	25.4	9.525	9.12	2.4	★		●	
	SNMM190624-HZ	19.05	19.05	6.35	7.94	2.4	★		●	
	SNMM250924-HZ	25.4	25.4	9.525	9.12	2.4	★		●	
	SNMM250932-HZ	25.4	25.4	9.525	9.12	3.2	★		●	

★Mainly grade brands are in stock ● Optional grades ○ Made to Order

Double-sided heavy turning



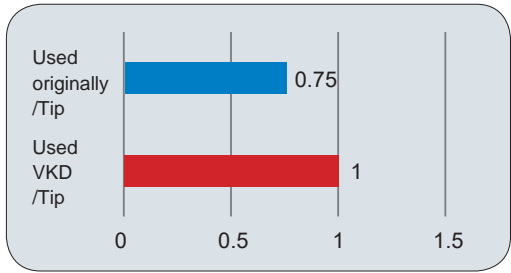
Insert Shape	Model	Dimension (mm)					Grade			
		L	IC	d	S	R	VKD154C	VKD254C	VKD354C	VKD404C
	CNMG160608-HGR	16.1	15.875	6.35	6.35	0.8	★		●	
	CNMG160612-HGR	16.1	15.875	6.35	6.35	1.2	★		●	
	CNMG160616-HGR	16.1	15.875	6.35	6.35	1.6	★		●	
	CNMG190612-HGR	19.3	19.05	6.35	6.35	1.2	★		●	
	CNMG190616-HGR	19.3	19.05	6.35	6.35	1.6	★		●	
	CNMG190624-HGR	19.3	19.05	6.35	6.35	2.4	★		●	
	CNMG250924-HGR	25.8	25.4	9.12	9.525	2.4	★		●	
	SNMG160612-HGR	15.875	15.875	6.35	6.35	1.2	★		●	
	SNMG160616-HGR	15.875	15.875	6.35	6.35	1.6	★		●	
	SNMG190612-HGR	19.05	19.05	6.35	6.35	1.2	★		●	
	SNMG190616-HGR	19.05	19.05	6.35	6.35	1.6	★		●	
	SNMG190624-HGR	19.05	19.05	6.35	6.35	2.4	★		●	
	SNMG250724-HGR	25.4	25.4	9.12	7.94	2.4	★		●	
	SNMG250924-HGR	25.4	25.4	9.12	9.525	2.4	★		●	
	CNMG160608-HMR	16.1	15.875	6.35	6.35	0.8		★		●
	CNMG160612-HMR	16.1	15.875	6.35	6.35	1.2		★		●
	CNMG160616-HMR	16.1	15.875	6.35	6.35	1.6		★		●
	CNMG190612-HMR	19.3	19.05	6.35	6.35	1.2		★		●
	CNMG190616-HMR	19.3	19.05	6.35	6.35	1.6		★		●
	CNMG190624-HMR	19.3	19.05	6.35	6.35	2.4		★		●
	CNMG250924-HMR	25.8	25.4	9.12	9.525	2.4		★		●
	SNMG160612-HMR	15.875	15.875	6.35	6.35	1.2		★		●
	SNMG160616-HMR	15.875	15.875	6.35	6.35	1.6		★		●
	SNMG190612-HMR	19.05	19.05	6.35	6.35	1.2		★		●
	SNMG190616-HMR	19.05	19.05	6.35	6.35	1.6		★		●
	SNMG190624-HMR	19.05	19.05	6.35	6.35	2.4		★		●
	SNMG250724-HMR	25.4	25.4	9.12	7.94	2.4		★		●
	SNMG250924-HMR	25.4	25.4	9.12	9.525	2.4		★		●

★ Mainly grade brands are in stock ● Optional grades ○ Made to Order

(Work piece)

Wind turbine main shaft

- Work piece material: alloy steel
- Lathe type: Horizontal CNC lathe
- insert: VKD254C SNMM250924-HGR
- Compare insert: A well-known manufacturer

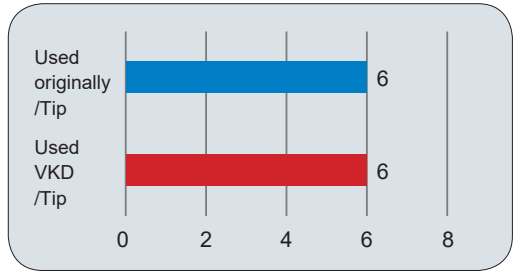


- Processing content: Outer circle
- Insert change criteria: Surface processing quality, excessive wear of inserts.
- Cooling type: None
- Cutting parameters: Vc=80-120m/min Fn=0.9mm/r Ap=5~10mm

(Work piece)

Slewing bearing

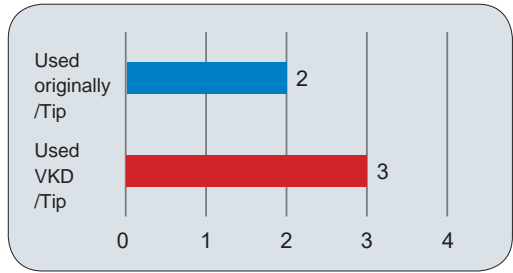
- Work piece material: 40CrNiMo
- Lathe type: CNC Lathe
- insert: VKD254C CNMG190616-HGR
- Compare insert: A well-known manufacturer
- Processing content: Outer circle
- Insert change criteria: Surface processing quality, excessive wear of inserts.
- Cooling type: Dry Cut
- Cutting parameters: Vc=80-120m/min Fn=0.63mm/r Ap=2~8mm

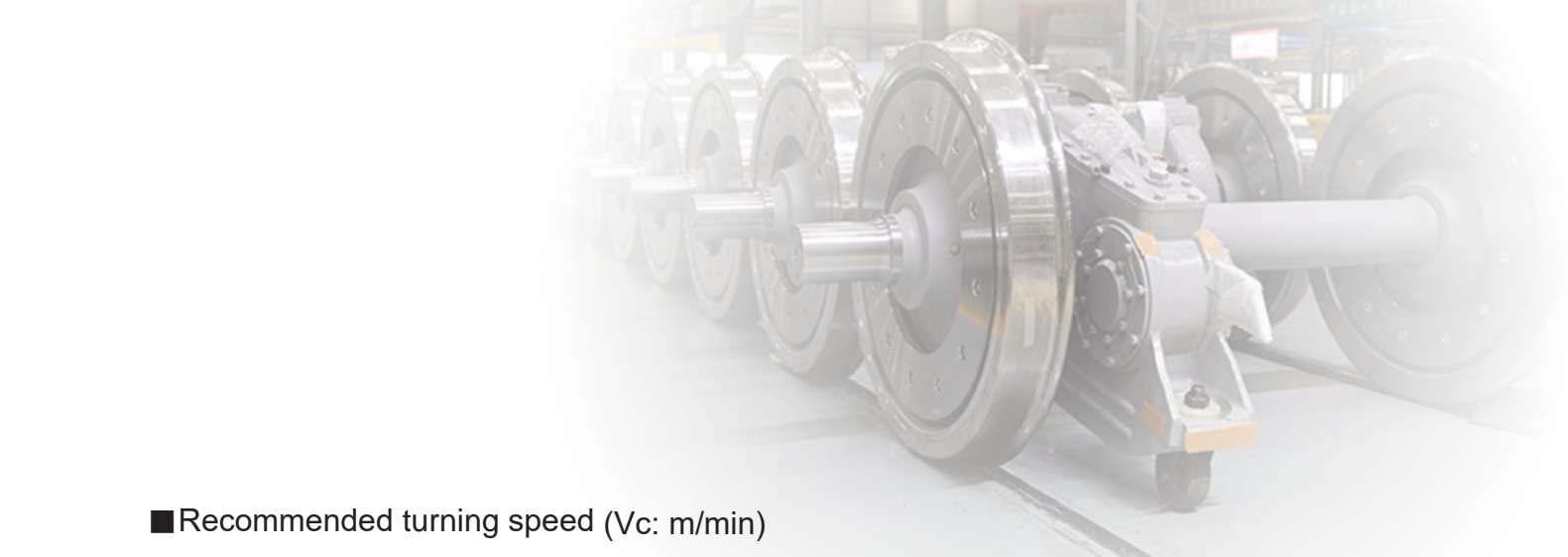


(Work piece)

Oil tubular joint

- Work piece material: 40CrNiMo
- Lathe type: CNC Lathe
- insert: VKD404C CNMM250924-HIR
- Compare insert: A well-known manufacturer
- Processing content: Outer circle and end face
- Insert change criteria: Surface processing quality, excessive wear of inserts.
- Cooling type: Dry Cut
- Cutting parameters: Vc=80-120m/min Fn=1.3mm/r Ap=8~15mm





■ Recommended turning speed (Vc: m/min)

	Continuous ~ Intermittent		Big intermittent
	VKD154C	VKD254C	VKD404C
	160(100-220)	140(80-200)	120(70-150)

■ Recommended turning depth and feed(Ap: mm Fn: mm/r)

	Continuous ○	Light Intermittent ◡	Intermittent ⚙	Big intermittent ⚙
HLR (Single)	Ap: 2~8 Fn: 0.3~1.0	Ap: 2~8 Fn: 0.3~0.6	----	----
HGR (Single)	----	Ap: 4~15 Fn: 0.5~1.3	Ap: 4~10 Fn: 0.5~0.9	----
HIR (Single)	----	----	Ap: 5~20 Fn: 0.7~1.5	Ap: 5~15 Fn: 0.7~1.0
HPR (Single)	AP:4-12 Fn: 0.35-1.3	AP:4-12 Fn: 0.35-1.0		
HZ (Single)	AP:4-15 Fn: 0.5-1.	AP:4-15 Fn: 0.5-1.1		
HGR (Double)	Ap: 4~12 Fn: 0.5~1.0	Ap: 4~8 Fn: 0.5~1.0	----	----
HMR (Double)	Ap: 2~8 Fn: 0.3~1.0	Ap: 2~8 Fn: 0.3~0.6	----	----

