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Stainless Steel Turning Inserts

CEMENTED CARBIDE TOOLS



Zhuzhou Weikeduo Cemented Carbide Co., LTD.



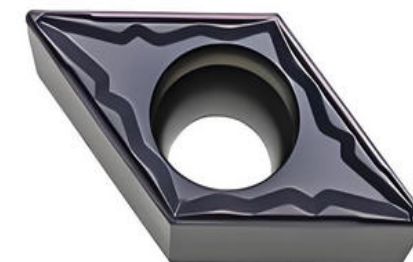
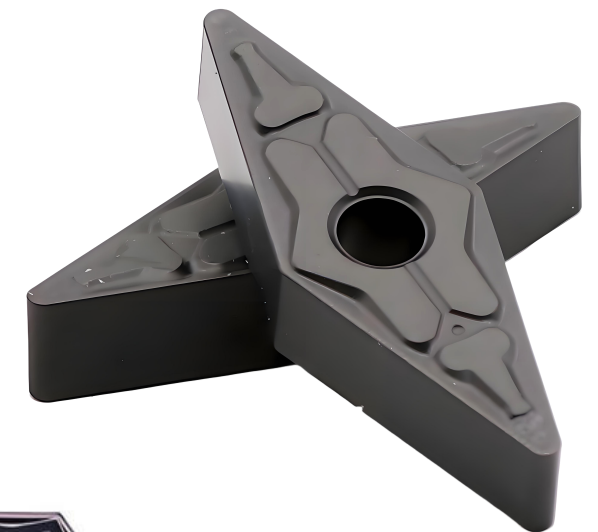
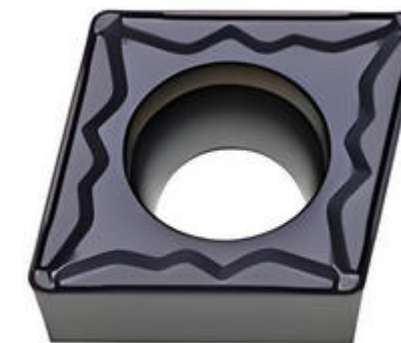
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PVD

Grade Series

VKD252P

Fine-grained carbide.
nc—TiAlN coating.

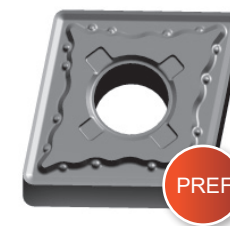
VKD254S

Ultrafine grain cemented carbide.
High temperature resistant coating.

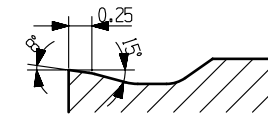
H O T

VKD402P

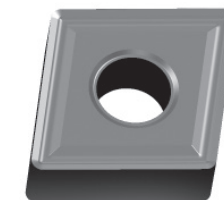
High strength substrate.
nc—TiAlN coating



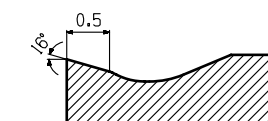
Semi-finishing ~ Roughing



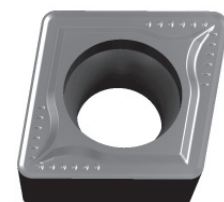
For semi-finishing and rough machining, it has a balance of strength and sharpness, and has extremely high stability regardless of continuous or intermittent working conditions.



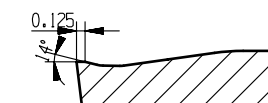
Finishing ~ Semi-finishing



It not only takes into account the strength but also enhances the sharpness of the cutting edge, and has excellent wear resistance under stable working conditions or continuous cutting.

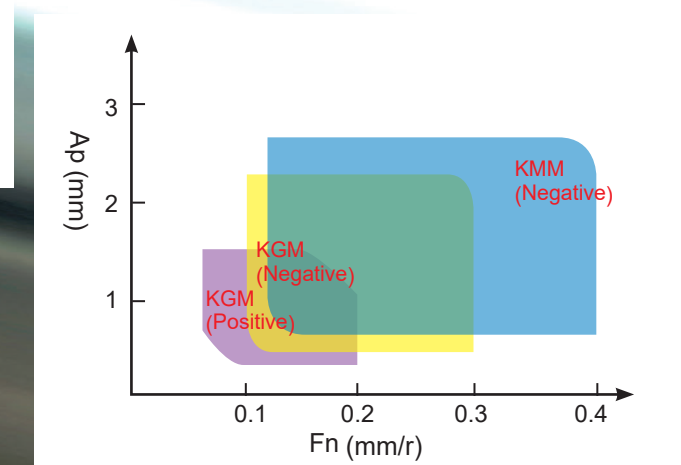
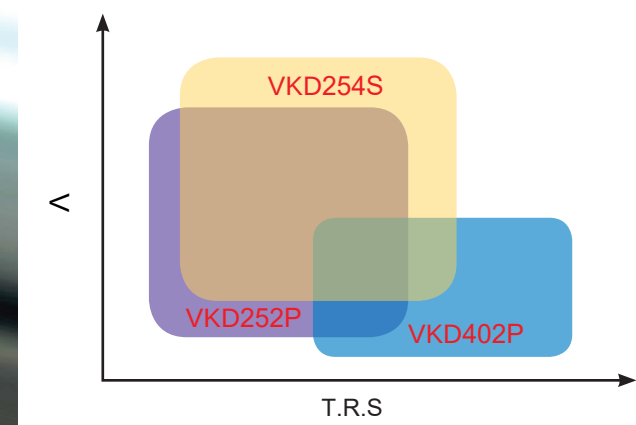


General turning

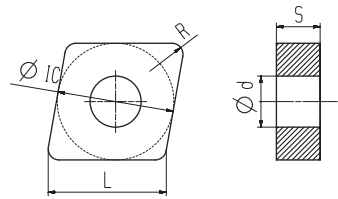


The universal positive-angle geometry of stainless steel, the blade edge and groove width are specially designed to meet the chip breaking requirements of continuous machining and the strength requirements of intermittent machining.

The coating surface has been specially post-treated to significantly reduce the friction coefficient



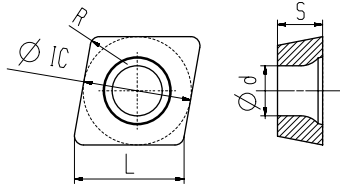
Negative



Insert Shape	Model	(Dimension)mm					Grade					
		L	IC	d	S	R	VKD152P	VKD252P	VKD254S	VKD402P	VKD251U	VKD401U
	CNMG120404-KMM	12.9	12.7	5.16	4.76	0.4		●	★			○
	CNMG120408-KMM	12.9	12.7	5.16	4.76	0.8		●	★			○
	CNMG120412-KMM	12.9	12.7	5.16	4.76	1.2		●	★			○
	CNMG120404-KGM	12.9	12.7	5.16	4.76	0.4		●				○
	CNMG120408-KGM	12.9	12.7	5.16	4.76	0.8		●				○
	CNMG120412-KGM	12.9	12.7	5.16	4.76	1.2		●				○
	WNMG080404-KMM	8.7	12.7	5.16	4.76	0.4		●	★			○
	WNMG080408-KMM	8.7	12.7	5.16	4.76	0.8		●	★			○
	WNMG080412-KMM	8.7	12.7	5.16	4.76	1.2		●	★			○
	WNMG080404-KGM	8.7	12.7	5.16	4.76	0.4		●				○
	WNMG080408-KGM	8.7	12.7	5.16	4.76	0.8		●				○
	WNMG080412-KGM	8.7	12.7	5.16	4.76	1.2		●				○
	DNMG150604-KMM	15.5	12.7	5.16	4.76	0.4		●	★			○
	DNMG150608-KMM	15.5	12.7	5.16	4.76	0.8		●	★			○
	DNMG150612-KMM	15.5	12.7	5.16	4.76	1.2		●	★			○
	DNMG150604-KGM	15.5	12.7	5.16	4.76	0.4		●				○
	DNMG150608-KGM	15.5	12.7	5.16	4.76	0.8		●				○
	DNMG150612-KGM	15.5	12.7	5.16	4.76	1.2		●				○
	TNMG160404-KMM	16.5	9.525	3.81	4.76	0.4		●	★			○
	TNMG160408-KMM	16.5	9.525	3.81	4.76	0.8		●	★			○
	TNMG160412-KMM	16.5	9.525	3.81	4.76	1.2		●	★			○
	TNMG160404-KGM	16.5	9.525	3.81	4.76	0.4		●				○
	TNMG160408-KGM	16.5	9.525	3.81	4.76	0.8		●				○
	TNMG160412-KGM	16.5	9.525	3.81	4.76	1.2		●				○

Insert Shape	Model	(Dimension)mm					Grade					
		L	IC	d	S	R	VKD152P	VKD252P	VKD254S	VKD402P	VKD251U	VKD401U
	SNMG120408-KMM	12.7	12.7	5.16	4.76	0.8		●				○
	SNMG120412-KMM	12.7	12.7	5.16	4.76	1.2		●				○
	SNMG120408-KGM	12.7	12.7	5.16	4.76	0.8			★			○
	SNMG120412-KGM	12.7	12.7	5.16	4.76	1.2			★			○
	VNMG160404-KMM	16.6	9.525	3.81	4.76	0.4		●				○
	VNMG160408-KMM	16.6	9.525	3.81	4.76	0.8		●				○
	VNMG160412-KMM	16.6	9.525	3.81	4.76	1.2		●				○
	VNMG160404-KGM	16.6	9.525	3.81	4.76	0.4			★			○
	VNMG160408-KGM	16.6	9.525	3.81	4.76	0.8			★			○
	VNMG160412-KGM	16.6	9.525	3.81	4.76	1.2			★			○

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



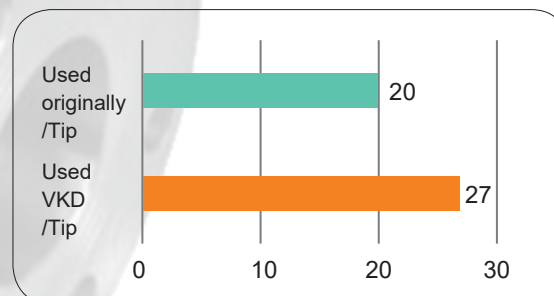
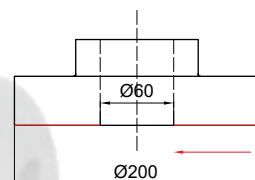
Positive

Insert Shape	Model	(Dimension)mm					Grade					
		L	IC	d	S	R	VKD152P	VKD252P	VKD254S	VKD402P	VKD251U	VKD401U
	CCMT060202-KGM	6.4	6.35	2.8	2.38	0.2		●			●	○
	CCMT060204-KGM	6.4	6.35	2.8	2.38	0.4		●			●	○
	CCMT060208-KGM	6.4	6.35	2.8	2.38	0.8		●			●	○
	CCMT09T304-KGM	9.7	9.525	4.4	3.97	0.4		●			●	○
	CCMT09T308-KGM	9.7	9.525	4.4	3.97	0.8		●			●	○
	TCMT110202-KGM	11	6.35	2.8	2.38	0.2		●			●	○
	TCMT110204-KGM	11	6.35	2.8	2.38	0.4		●			●	○
	TCMT110208-KGM	11	6.35	2.8	2.38	0.8		●			●	○

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

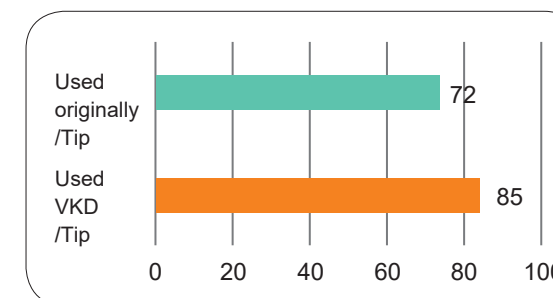
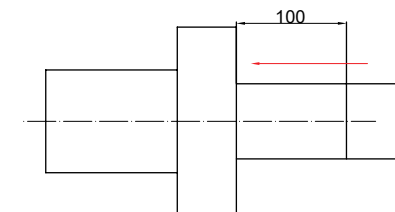
Work piece: Flange

- Work piece material: 316L
- Lathe type: CNC Lathe
- insert: VKD254S WNMG080408-KGM
- Processing content: Turning end face
- Insert change criteria: Surface processing quality, excessive wear of inserts.
- Cooling type: wet cut
- Cutting parameters:
Vc=120-200m/min Fn=0.25mm/r Ap=1~2mm



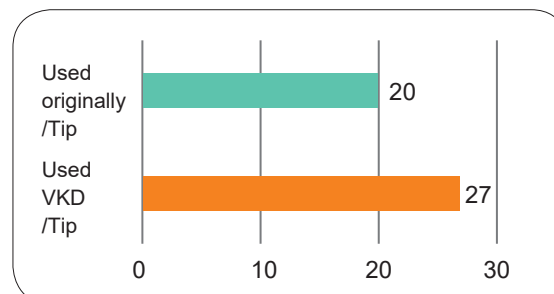
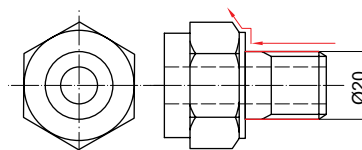
Work piece: Bearings

- Work piece material: 316L
- Lathe type: CNC Lathe
- insert: KM254S CNMG120408-KGM
- Processing content: Outer circle
- Insert change criteria: Surface processing quality, excessive wear of inserts.
- Cooling type: wet cut
- Cutting parameters:
Vc=100-140m/min Fn=0.25mm/r Ap=1~1.54mm



Work piece: Connectors

- Work piece material: 316L
- Lathe type: CNC Lathe
- insert: VKD252P WNMG080408-KMM
- Processing content: Outer circle and shoulder
- Insert change criteria: Surface processing quality, excessive wear of inserts.
- Cooling type: wet cut
- Cutting parameters:
Vc=80-120m/min Fn=0.3mm/r Ap=0.7~1.5mm



Recommended turning speed (Vc: m/min)

	Continuous	Light Intermittent	Intermittent
Austenitic type	180(120-240)	150(80-220)	120(70-160)
ferrite type	190(130-250)	160(90-230)	130(80-170)
martensite type	190(130-250)	160(90-230)	----

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

	Continuous ~ Light Intermittent		Intermittent
	VKD254S	VKD252P	VKD402P
KMM	Ap: 0.5~3.5 Fn: 0.12~0.35	----	----
KGM(Negative)	Ap: 0.5~3.5 Fn: 0.15~0.4	Ap: 0.5~3.5 Fn: 0.15~0.35	Ap: 0.5~2.5 Fn: 0.15~0.3
KGM(Positive)	Ap: 0.2~2 Fn: 0.08~0.25	Ap: 0.2~2 Fn: 0.08~0.2	Ap: 0.2~2 Fn: 0.08~0.2

Work piece: Connectors

- Work piece material: 304
- Lathe type: CNC Lathe
- insert: VKD252P CCMT09T308-KGM
- Processing content: Inner hole
- Insert change criteria: Surface processing quality, excessive wear of inserts.
- Cooling type: wet cut
- Cutting parameters:
Vc=80-120m/min Fn=0.15mm/r Ap=0.3~1mm

