

Turbine Wheel/Shaft

Shaft Material: Steel

Wheel Material: Inconell, TiAl Alloy

ISO TURN

1 DNMG... IC8250

- Double-sided insert
- Positive rake for low cutting forces
- High toughness

Cutting conditions

$V_c = 180 \text{ m/min}$ (590 sfm)

$f = 0.25 \text{ mm/rev}$ (0.0098 inch/rev)

ISO TURN

2 VCMT... IC8250

- Moderated chipbreaker
- Precisely ground insert
- Excellent repeatability

Cutting conditions

$V_c = 180 \text{ m/min}$ (590 sfm)

$f = 0.1 \text{ mm/rev}$ (0.0039 inch/rev)

PENTACUT-24

PARTING GROOVING LINE

3 PENTA 24... IC908

- 5 cutting edges (economical)
- Precise profile
- Durable insert design
- Pressed chipbreaker for effective chip control

Cutting conditions

$V_c = 160 \text{ m/min}$ (525 sfm)

$f = 0.08 \text{ mm/rev}$ (0.0031 inch/rev)

High Pressure Rough Turn

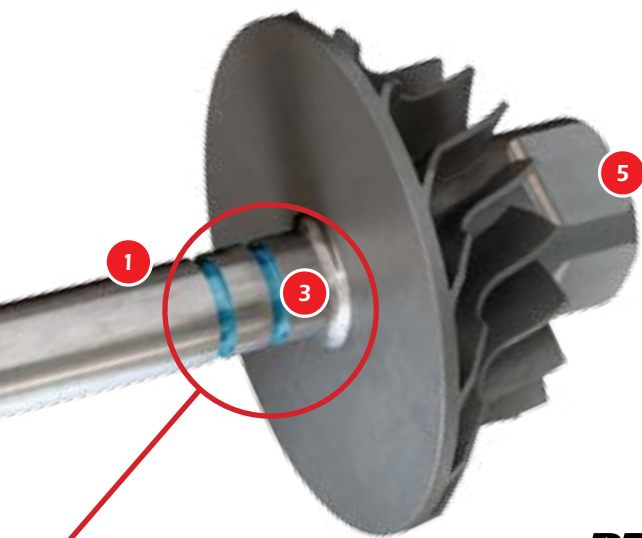
- High pressure coolant directed right to the cutting edge
- Shiftable telescopic coolant tube for easy and fast insert replacement
- Quick change lever lock mechanism

High Pressure Finish Turn

- High pressure coolant directed right to the cutting edge
- Shiftable telescopic coolant tube for easy and fast insert replacement
- Quick change lever lock mechanism

Slot - Groove-Turn

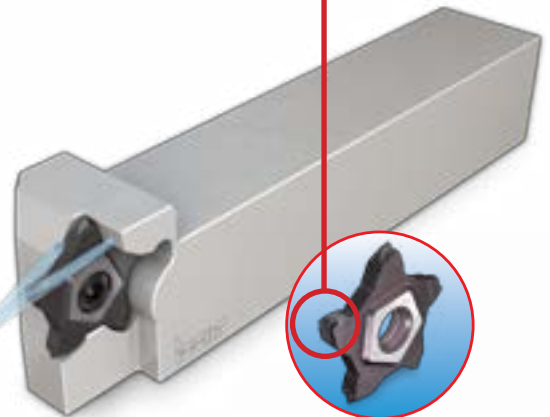
- Excellent surface finish
- High grooving repeatability
- High pressure coolant for chip evacuation and longer tool life



PENTACUT
THREADING LINE
PENTA 24... IC908

- 5 cutting corners
- High cutting speed
- Unique pressed chipformer
- Wide range of threading types

Cutting conditions
Vc=15 m/min (50 sfm)
f=Pitch



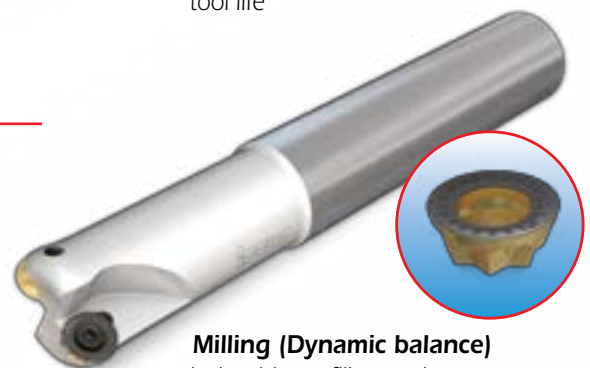
High Pressure Threading

- Extreme accuracy
- Excellent surface finish
- High pressure coolant for effective chip control and longer tool life

ISCARMILL
RXCR 07...- IC808

- Low cutting forces
- High stability cutting
- Moderated chipbreaker

Cutting conditions
Vc=35 m/min (115 sfm)
fz=0.1 mm/t (0.0039 inch/t)



Milling (Dynamic balance)

- Indexable profiling tool
- High material removal rate