

TAC Inserts, Negative

2

TAC Inserts

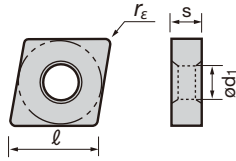
C
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Y
R
K
H

Rhombic, with hole

80° Negative



CN □ □



CNMG 12 04 04 - □ □

Cutting edge length (l) Thickness (s) Corner radius (r_ε) Chipbreaker symbol

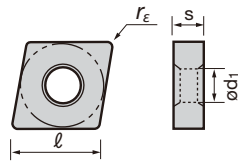
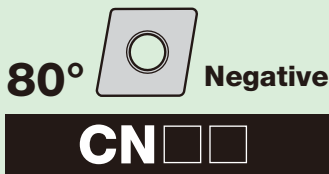
CN □ □	0903 □ □	1204 □ □	1606 □ □	1906 □ □	2509 □ □
ød1 (mm)	3.81	5.16	6.35	7.93	9.12

Application	Chipbreaker Appearance (Cross section)	f - a _p	Insert Cat. No.	Stocked grades												Applicable toolholders (pages)								
				Coated										Coated cermet	Cermet		Un-coated							
				T9105	T9115	T9125	T9135	T9005	T9015	T9025	T9035	T6020	T6030	T5105	T5115		T5125	GH110	GT730	GT530	NS730	NS520	NS530	TH10
Precision finishing	TF (M)		CNMG120404-TF *CNMG120408-TF																●	▲	●		TAC External Toolholders (4-14, 4-15, 4-44, 4-46, 4-80) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53) J-series (Only l = 09) (8-17)	
	01 (G)		CNGG090302-01 CNGG090304-01 CNGG090308-01 CNGG120402-01 CNGG120404-01 *CNGG120408-01															●			▲			
	C (G)		CNGG120404R-C CNGG120404L-C *CNGG120408R-C CNGG120408L-C																	▲		●		
	TSF (M)		CNMG120404-TSF *CNMG120408-TSF CNMG120412-TSF	●	●	●	▲	▲	●	●									●	●				
	TS (M)		CNMG120404-TS *CNMG120408-TS CNMG120412-TS						▲	▲	▲	▲	▲						▲			▲		▲

Note: Chipbreaker cross sections are of * marked inserts.

- : Stocked items.
- ▲ : Will be replaced by new products.
- ★ : Available from 2011.

Rhombic, with hole



CNMG 12 04 04 -

Cutting edge length (l) Thickness (s) Corner radius (r_ϵ) Chipbreaker symbol

CN	0903	1204	1606	1906	2509
ød1 (mm)	3.81	5.16	6.35	7.93	9.12

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Application	Chipbreaker Appearance (Cross section)	$f - a_p$	Insert Cat. No.	Stocked grades											Applicable toolholders (pages)									
				Coated							Coated cermet		Cermets											
				T9115	T9125	T9005	T9015	T9025	T9035	T6020	T6030	T5105	T5115	T5125		GH330	GT720	GT730	GT530	NS730	NS520	NS530		
Finishing	SS (M)		CNMG120404-SS *CNMG120408-SS CNMG120412-SS																				TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)	
	CF (M)		CNMG120404-CF CNMG120408-CF *CNMG120412-CF																					
	ZF (M)		CNMG120404-ZF *CNMG120408-ZF CNMG120412-ZF	●●	▲▲										●▲	●▲								
	NS (M)		CNMG120404-NS *CNMG120408-NS		●▲	▲																▲		
	AFW (M)		CNMG120404-AFW *CNMG120408-AFW	●●	●▲	▲									●							▲		TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)

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TAC Inserts, Negative

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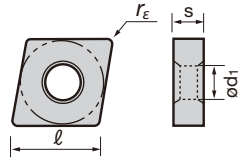
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Rhombic, with hole

80° Negative



CN



CNMG 12 04 04 -

Cutting edge length (l) Thickness (s) Corner radius (rε) Chipbreaker symbol

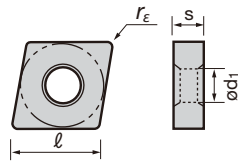
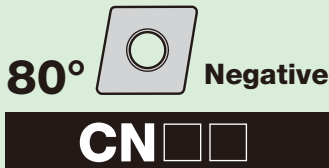
CN	0903	1204	1606	1906	2509
od1 (mm)	3.81	5.16	6.35	7.93	9.12

Application	Chipbreaker Appearance (Cross section)	f - ap	Insert Cat. No.	Stocked grades											Applicable toolholders (pages)			
				Coated						Coated cermet		Cermets		Uncoated				
				T9115	T9125	T9005	T9015	T9025	T9035	T6020	T6030	GH330	GT720	GT730	NS730	NS530	TH10	
Finishing	11 (M)		CNMG120404-11 *CNMG120408-11														●	TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)
Finishing of mild steels	17 (M)		CNMG120404-17 *CNMG120408-17 CNMG120412-17				▲	▲								▲		
							▲	▲								▲		
High feed, small depth of cutting	ASW (M)		*CNMG120408-ASW CNMG120412-ASW	●	●	●	▲	▲								▲		TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)
				●	●	●	▲	▲								●		
High feed	AS (M)		CNMG120404-AS *CNMG120408-AS CNMG120412-AS		●	▲	▲	●								▲		TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)
					●	▲	▲	●								▲		
Boring (Double sided chipbreaker)	CB (M)		CNMG090304-CB *CNMG090308-CB				▲									▲		TAC External Toolholders (4-14, 4-80) TAC Internal Toolholders (5-29, 5-52) J-series (Only l = 09) (8-17)
							▲							●				

Note: Chipbreaker cross sections are of * marked inserts.

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Rhombic, with hole



CNMG 12 04 04 -

Cutting edge length (l) Thickness (s) Corner radius (r_ϵ) Chipbreaker symbol

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ød1 (mm)	3.81	5.16	6.35	7.93	9.12

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Application	Chipbreaker	$f - a_p$	Insert Cat. No.	Stocked grades										Applicable toolholders (pages)				
				Coated						Coated cermet		Cermet						
				T9105	T9115	T9125	T9135	T9005	T9015	T9025	T9035	T6020	T6030		GT730	GT530	NS530	
Finishing to medium cutting	ZM (M)		* CNMG120408-ZM	●	●				▲	▲			●	▲				TAC External Toolholders (4-14, 4-15, 4-44, 4-46, 4-80) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53) J-series (Only l = 09) (8-17)
			CNMG120412-ZM	●	●				▲	▲			●	▲				
			CNMG120416-ZM	●	●				▲	▲								
Finishing to medium cutting	27 (M)		CNMG120404-27						▲	▲					▲			
			* CNMG120408-27						▲	▲	●				▲			
			CNMG120412-27						▲	▲								
Medium cutting	NM (M)		CNMG120408-NM	●	●			●	▲	▲					▲			
			* CNMG120412-NM	●	●			●	▲	▲								
Medium cutting	TM (M)		CNMG090304-TM	●	●				▲	▲								
			CNMG090308-TM	●	●				▲	▲								
			CNMG120404-TM	★	●	★	●	●	▲	▲	●	●						
			* CNMG120408-TM	★	●	★	●	●	▲	▲	●	●						
			CNMG120412-TM	●	●	★	●	●	▲	▲	●	●						
			CNMG120416-TM	●	●				▲	▲	●	●						
			CNMG160612-TM	★	●				▲	▲								
Medium cutting	SM (M)		CNMG120404-SM								●	●						
			* CNMG120408-SM								●	●						
			CNMG120412-SM								●	●						

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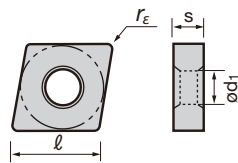
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Rhombic, with hole



CN □ □



CNMG 12 04 04 - □ □

Cutting edge length (l) Thickness (s) Corner radius (r_ϵ) Chipbreaker symbol

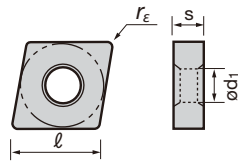
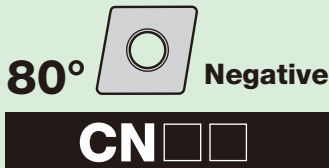
CN □ □	0903 □ □	1204 □ □	1606 □ □	1906 □ □	2509 □ □
ød1 (mm)	3.81	5.16	6.35	7.93	9.12

Application	Chipbreaker Appearance (Cross section)	$f - a_p$	Insert Cat. No.	Stocked grades											Applicable toolholders (pages)								
				Coated										Coated cermet		Cermets		Uncoated					
				T9115	T9125	T9005	T9015	T9025	T9035	T5105	T5115	T5125	AH110	AH120		GT720	GT730	NS730	NS520	NS530	TH10		
Medium cutting	All-round (M)			CNMG090304	●	●	●	▲	▲							●		●	▲			TAC External Toolholders (4-14, 4-15, 4-44, 4-46, 4-80) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53) J-series (Only $l = 09$) (8-17)	
				CNMG090308	●	●	●	▲	▲						●		●	▲					
				CNMG120404	●	●	●	▲	▲	●	●	●	●	●	●	●		●	▲	●			
				*CNMG120408	●	●	●	▲	▲	●	●	●	●	●	●	●		●	▲	▲	●		
				CNMG120412	●	●	●	▲	▲	●	●	●	●	●	●	●		●	▲	▲	●		
				CNMG120416	●	●	●	▲	▲	●	●	●	●	●	●	●		●			●		
				CNMG160608	●	●	●	▲	▲	●	●	●	●	●	●	●		●			●		
				CNMG160612	●	●	●	▲	▲	●	●	●	●	●	●	●		●			●		
				CNMG160616	●	●	●	▲	▲	●	●	●	●	●	●	●		●			●		
				CNMG190608	●	●	●	▲	▲	●								●			●		
				CNMG190612	●	●	●	▲	▲	●	●	●	●	●	●	●		●			●		
				CNMG190616	●	●	●	▲	▲	●	●	●	●	●	●	●		●			●		
	CM (M)			CNMG120404-CM							●	●	●										
				CNMG120408-CM							●	●	●										
				*CNMG120412-CM							●	●	●										
				CNMG160608-CM							●	●	●										
				CNMG160612-CM							●	●	●										
	DM (M)			CNMG120404-DM		●	▲	▲	●														
				*CNMG120408-DM	●	●	●	▲	▲	●													
				CNMG120412-DM	●	●	●	▲	▲	●													
				CNMG120416-DM		●	▲	▲	●														

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Cutting edge length (l) Thickness (s) Corner radius (r_ϵ) Chipbreaker symbol

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ød1 (mm)	3.81	5.16	6.35	7.93	9.12

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TAC Inserts

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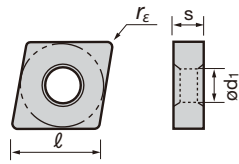
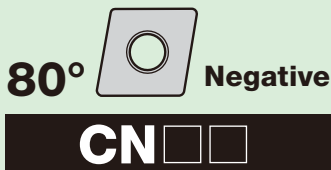
Application	Chipbreaker Appearance (Cross section)	$f - a_p$	Insert Cat. No.	Stocked grades										Applicable toolholders (pages)						
				Coated						Coated cermet	Cermets		Uncoated							
				T9005	T9015	T9025	T9035	T6020	T6030	T5105	T5115	AH110	AH905		GH330	GT720	NS520	NS530	TH10	
Medium cutting	HMM (M) 		CNMG120404-HMM *CNMG120408-HMM CNMG120412-HMM CNMG160608-HMM CNMG160612-HMM CNMG160616-HMM																TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)	
	33 (M) 		CNMG120404-33 *CNMG120408-33 CNMG120412-33 CNMG120416-33 CNMG160612-33 CNMG160616-33 CNMG190612-33 CNMG190616-33	●	●	●	●													
	37 (M) 		CNMG120404-37 *CNMG120408-37 CNMG120412-37	●											▲				●	
	38 (M) 		CNMG120404-38 *CNMG120408-38	●															●	

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Rhombic, with hole



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TAC Inserts

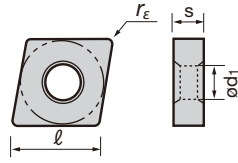
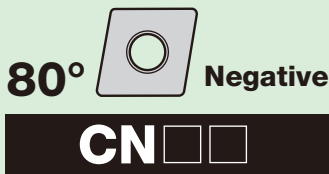
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Application	Chipbreaker	Appearance (Cross section)	Insert Cat. No.	Stocked grades											Applicable toolholders (pages)								
				Coated							Coated cermet	Cermet	Un-coated										
				T9115	T9125	T9005	T9015	T9025	T9035	T6020	T6030	T5105	T5115	T5125		AH120	GH110	GH330	GT720	GT730	NS530	TH10	KS20
Medium cutting	SA (M)		CNMG120404-SA *CNMG120408-SA CNMG120412-SA CNMG190612-SA CNMG190616-SA																				TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)
	S (M)		CNMG120404R-S CNMG120404L-S *CNMG120408R-S CNMG120408L-S	●	●	▲	●													▲			
	P (G)		CNGG120404R-P CNGG120404L-P *CNGG120408R-P CNGG120408L-P																				
	THS (M)		CNMG190612-THS *CNMG190616-THS CNMG190624-THS CNMG250924-THS	★	★																		TAC External Toolholders (4-14, 4-15)
	TH (M)		*CNMG120408-TH CNMG120412-TH CNMG120416-TH CNMG160612-TH CNMG160616-TH CNMG190612-TH CNMG190616-TH	●	●	▲	▲	●	●														TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)
	CH (M)		CNMG120404-CH CNMG120408-CH *CNMG120412-CH CNMG160612-CH CNMG160616-CH CNMG190612-CH CNMG190616-CH																				

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Rhombic, with hole



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Cutting edge length (l) Thickness (s) Corner radius (r_ε) Chipbreaker symbol

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ød1 (mm)	3.81	5.16	6.35	7.93	9.12

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TRS			CNMM120408-TRS				●	●		●		●			TAC External Toolholders (4-14, 4-15, 4-44, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)																																																																																																																																																																																																																																																																																																																													
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			CNMM250924-TRS				●	●		●		●				TR (M)			CNMM120408-TR				●	●						TAC External Toolholders (4-14, 4-15) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)	*CNMM120412-TR				●	●						CNMM160612-TR				●	●						CNMM190612-TR				●	●						CNMM190616-TR				●	●						CNMM250724-TR				●	●						CNMM250924-TR				●	●						TUS (M)			CNMM190608-TUS	★	★									TAC External Toolholders (4-14, 4-15, 4-46) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)	*CNMM190612-TUS	★	★									CNMM190616-TUS	★	★									CNMM190624-TUS	★	★									CNMM190632-TUS	★	★									CNMM250916-TUS	★	★									CNMM250924-TUS	★	★									CNMM250932-TUS	★	★									TU (M)			CNMM190612-TU			●	●	●						*CNMM190616-TU			●	●	●					CNMM190624-TU			●	●	●					CNMM250724-TU			●	●	●					CNMM250924-TU			●	●	●					57 (M)			CNMM120404-57				●	●						*CNMM120408-57				●	●					CNMM120412-57				●	●					CNMM160608-57				●	●					CNMM160612-57				●	●					CNMM160616-57				●	●					CNMM190612-57				●	●					CNMM190616-57				●	●					CNMM190624-57				●	●
TR (M)			CNMM120408-TR				●	●						TAC External Toolholders (4-14, 4-15) TAC Internal Toolholders (5-29, 5-36, 5-52, 5-53)																																																																																																																																																																																																																																																																																																																														
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Note: Chipbreaker cross sections are of * marked inserts.

- : Stocked items.
- ▲ : Will be replaced by new products.
- ★ : Available from 2011.