

NPN

New Product News



POSSTURN
DOUBLE SIDED POSITIVE TURNING

New XNMV-BS Chip Breaker for Super Alloy Steel Machining



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KEY POINT

TaeguTec introduces a new BS type chip breaker to the POS-S-TURN's XNMV line dedicated to super alloy steel machining.


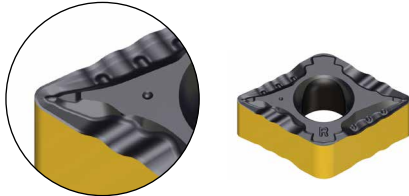

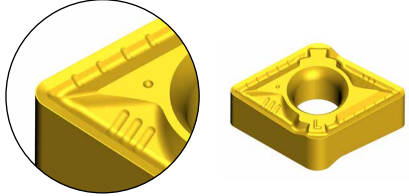
The XNMV insert dramatically improves productivity due to its deep depth of cut forward turning and high feed backward turning capabilities. The new BS chip breaker, dedicated to super alloy steel machining, expands the range of materials covered by XNMV inserts.

For further information, please contact the product manager.

Features

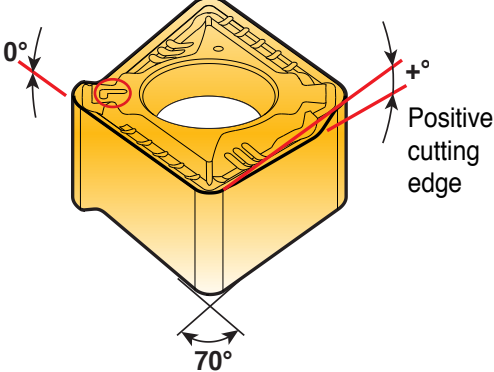

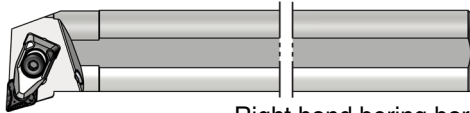
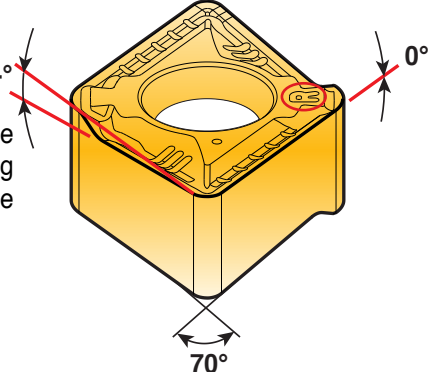

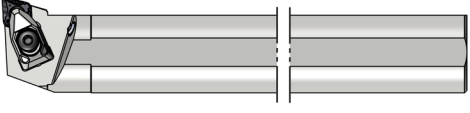
- 4-corner double-sided insert with a 70-degree corner angle
- Forward and backward turning capable cutting edges for longer tool life
- Forward turning deep depth of cut capable: maximum 4.0 mm
- High feed backward turning capable: maximum 0.8 mm/rev

XNMV insert's chip breakers

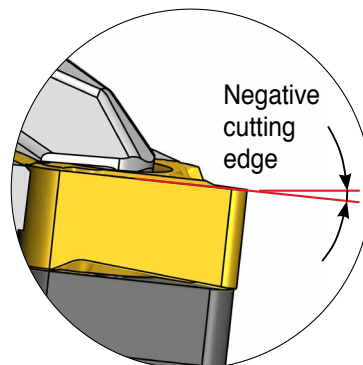
ISO	Chip breaker	
 For steel	BM	
 For super alloys	BS new	

XNMV BS insert's hand type

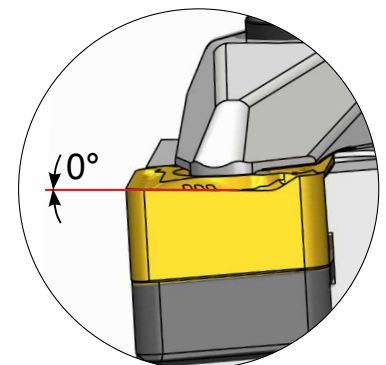
- Recommended hand type for high feed backward turning

 <p>XNMV 110508L-BS Left hand insert</p>	<p>TXJNL...1105 (-TB)</p>  <p>Left hand holder</p> <p>A- T/S/HXUNR...1105</p>  <p>Right hand boring bar</p>
 <p>XNMV 110508R-BS Right hand insert</p>	<p>TXJNR...1105 (-TB)</p>  <p>Right hand holder</p> <p>A- T/S/HXUNL...1105</p>  <p>Left hand boring bar</p>

XNMV BS cutting edge on the holder (left hand)

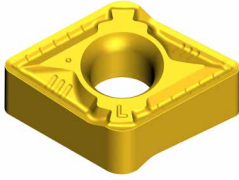
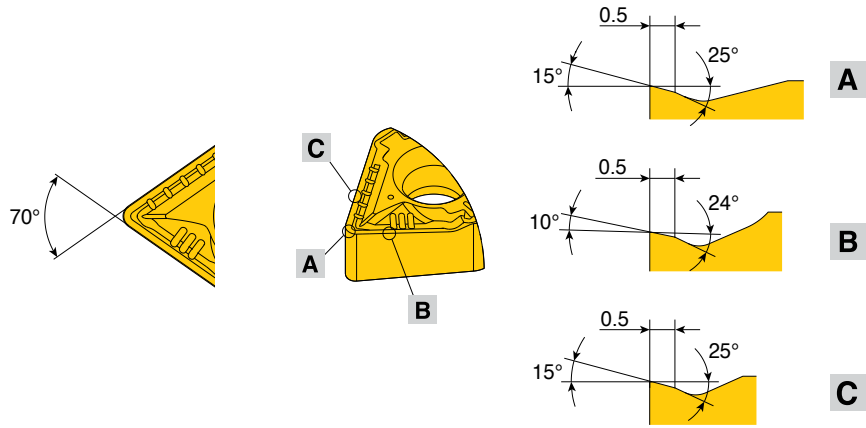


Cutting edge for forward turning

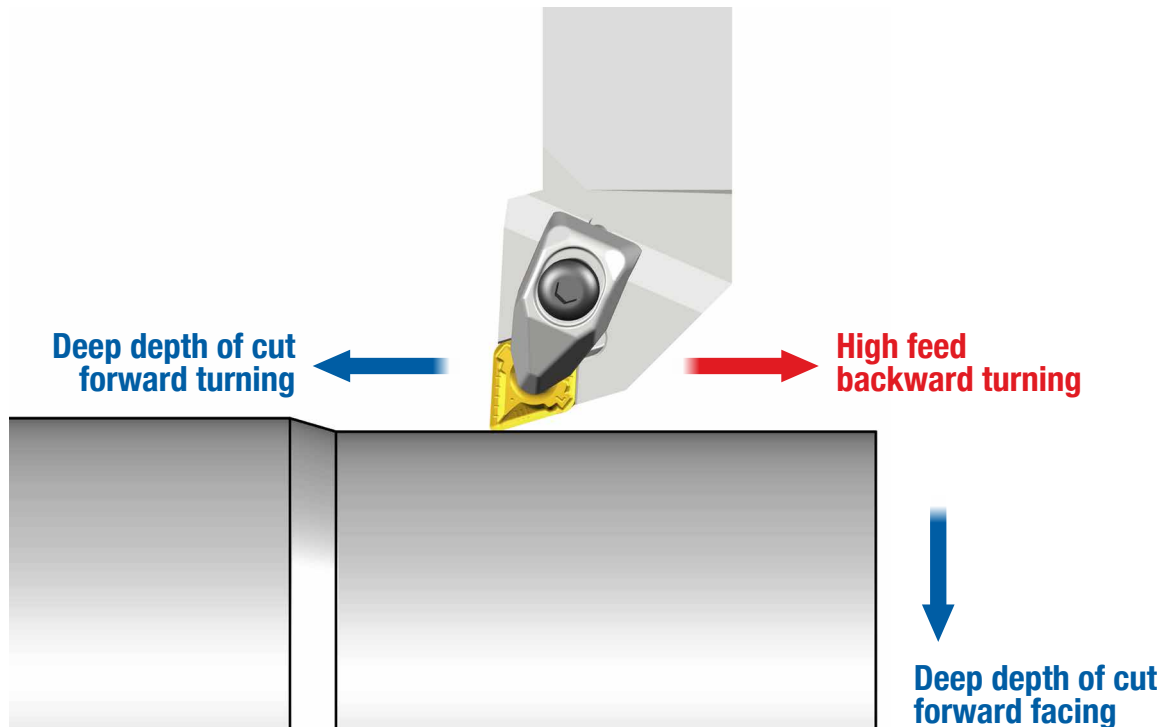


Cutting edge for backward turning and forward facing

XNMV BS insert geometry

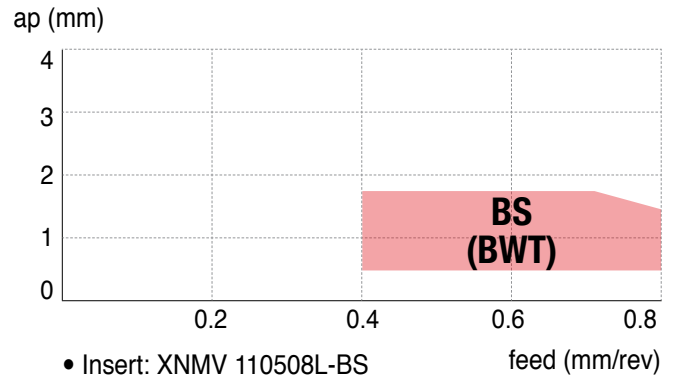
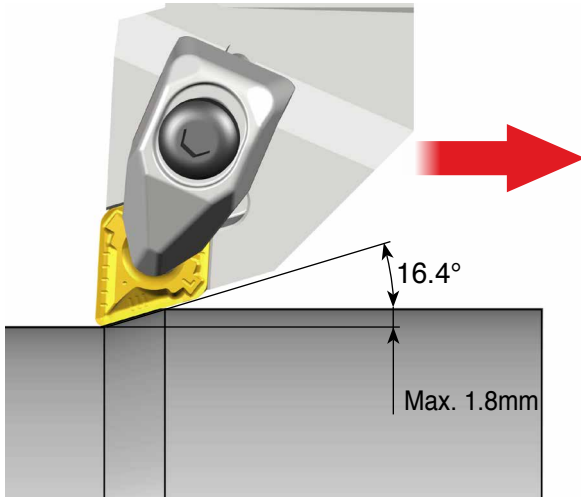
Chip breaker	Geometry
 <p>BS: For super alloys (Left hand insert)</p>	

XNMV BS cutting conditions



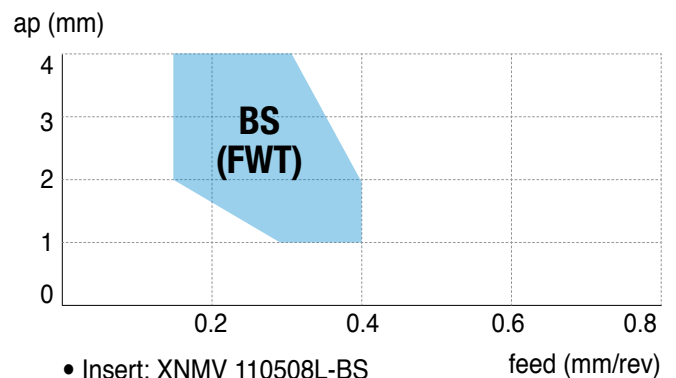
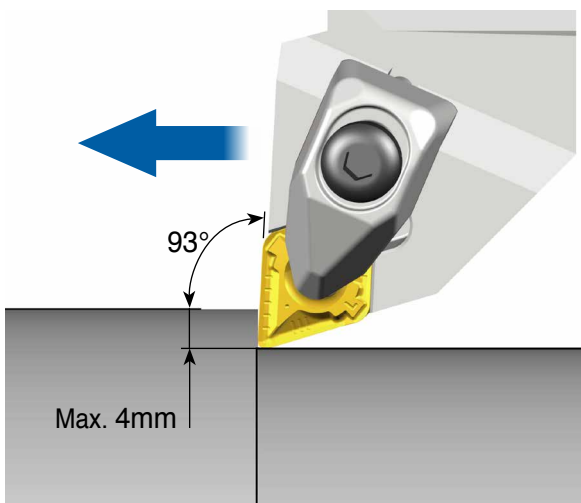
	Backward turning	Forward turning	Forward facing
feed (mm/rev)	0.6 (0.4 - 0.8)	0.28 (0.15 - 0.4)	0.28 (0.15 - 0.4)
ap (mm)	1.2 (0.5 - 1.8)	2.5 (1.0 - 4.0)	2.5 (1.0 - 4.0)

XNMV BS's **Backward turning** chip control range



- Insert: XNMV 110508L-BS
- Cutting speed (V): 30m/min
- Workpiece: INCONEL 718 (HB340~360)

XNMV BS's **Forward turning** chip control range

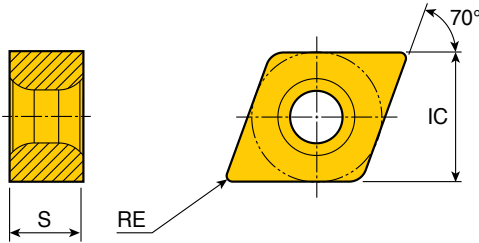


- Insert: XNMV 110508L-BS
- Cutting speed (V): 30m/min
- Workpiece: INCONEL 718 (HB340~360)

XNMV



Negative 70° rhombic inserts



Size	Dimension (mm)		
	IC	S	RE
11	11.11	5.56	0.8

Insert	Designation	Backward turning		Forward turning		CVD coated				PVD coated	
		ap (mm)	feed (mm/rev)	ap (mm)	feed (mm/rev)	TT7005B	TT7015B	TT8115B	TT8125B	TT3010	TT3020
	XNMV 110508L-BM	0.5-1.8	0.5-0.8	0.5-3.5	0.10-0.40			•	•		
	110508R-BM	0.5-1.8	0.5-0.8	0.5-3.5	0.10-0.40						
	XNMV 110508L-BS new	0.5-1.8	0.4-0.8	1.0-4.0	0.15-0.40			•	•	•	•
	110508R-BS new	0.5-1.8	0.4-0.8	1.0-4.0	0.15-0.40			•	•	•	•

- ▶ Apply L insert to L holder and R boring bar
- ▶ Apply R insert to R holder and L boring bar

•: Standard items