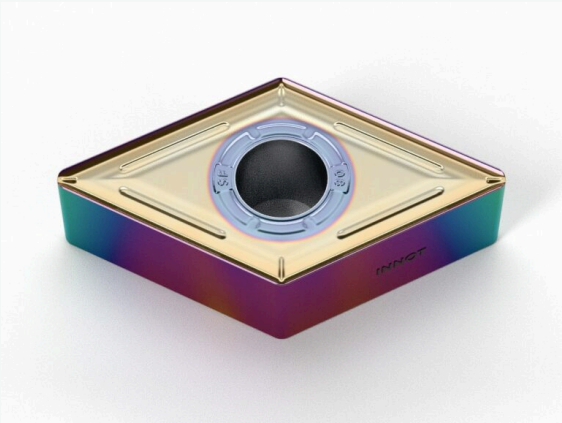
TURNING INSERTS · NEGATIVE INSERTS · DNMG - 55° RHOMBIC

DNMG-SF

55° negative insert for finishing superalloys and titanium, with SF chipbreaker and INNOT PVD grades.



KEY DATA	
Product type	Turning Inserts
ISO materials	S superalloys
Operation	Finishing
Chipbreaker	**SF**
INNOT grades	IT7115 · **IT9205** ★ · **IT9215** ★ ★ recommended
Nose radii	R0.4 · R0.8
Online page	innot-it.com/en/prodotto/dnmg-sf

ISO specifications

ISO	RADIUS (RE)	AVAILABLE GRADES	CHIPBREAKER
DNMG1504	0.4 - 0.8	IT7115 - IT9205 - IT9215	SF
DNMG1506	0.4 - 0.8	IT7115 - IT9205 - IT9215	SF

SF chipbreaker data sheet

Operation	Finishing
ISO material	S (heat-resistant superalloys and titanium alloys)
Tolerance	M
Features	Rompitruciolo per la finitura di superleghe resistenti al calore e leghe di titanio. Il raggio di punta dal disegno speciale e il tagliente affilato riducono le forze di taglio e le vibrazioni dell'utensile, per una superficie liscia e una buona evacuazione del truciolo. Forma rombica 55°: punta più snella rispetto all'80°, ideale per profilatura, copiatura e torniture di contorni con accesso agli spallamenti.

Available INNOT grades

Grade	ISO	Coating	Composition	Application
IT7115	**M · S**	**PVD**	AlTiSiN + TiSiN	Sub-micron grain substrate with nano-gradient coating: excellent wear and oxidation resistance, great stability. Suitable for titanium alloys and superalloys.
IT9205 ★	**S**	**PVD**	AlTiN + TiSiN + AlCrN	Highly wear-resistant grade for superalloys. Uniform sub-micron hard phase and alloying elements for greater reliability; excellent thermal stability and oxidation resistance.
IT9215 ★	**S**	**PVD**	AlTiN + TiSiN + AlCrN	Universal grade for turning superalloys. Greater toughness and reliability; the multilayer structure limits cracks and protects the coating from flaking and chipping.

★ Recommended grade for this chipbreaker. PVD = physical vapour deposition coating. ISO S = superalloys and titanium. ISO M = stainless steels.

Recommended cutting data

External turning of superalloys (ISO S)

Heat-resistant superalloys (Inconel 718 and similar). Recommended cutting data for the SF chipbreaker.

Condition	Grade	Vc (m/min)	fn (mm/rev)	ap (mm)
Stable	IT9205	40 – 80	0.02 – 0.20	0.20 – 1.80
Stable	IT9215	30 – 70	0.02 – 0.20	0.20 – 1.80
Average	IT9205	40 – 80	0.02 – 0.20	0.20 – 1.80
Average	IT9215	30 – 70	0.02 – 0.20	0.20 – 1.80
Difficult	IT9205	40 – 80	0.02 – 0.20	0.20 – 1.80
Difficult	IT9215	30 – 70	0.02 – 0.20	0.20 – 1.80

IT9205 permette velocità di taglio più alte; IT9215 offre maggiore tenacità. Partire dal valore minimo di Vc e aumentare in base all'usura. Usare sempre refrigerante abbondante.

Internal turning (boring) of superalloys (ISO S)

Starting values for internal turning with a boring bar, derived from this insert's external turning data: cutting speed −15%, feed −20%, maximum depth of cut −40%. Negative inserts are mounted on boring bars for bores from about Ø 25 mm upwards (Ø 32–40 mm for the larger sizes).

Condition	Grade	Vc (m/min)	fn (mm/rev)	ap (mm)
Stable	IT9205	35 – 70	0.02 – 0.16	0.20 – 1.10
Stable	IT9215	25 – 60	0.02 – 0.16	0.20 – 1.10
Average	IT9205	35 – 70	0.02 – 0.16	0.20 – 1.10
Average	IT9215	25 – 60	0.02 – 0.16	0.20 – 1.10
Difficult	IT9205	35 – 70	0.02 – 0.16	0.20 – 1.10
Difficult	IT9215	25 – 60	0.02 – 0.16	0.20 – 1.10

With a boring bar overhang above 3 times the diameter (steel bar) or 5 times (carbide or anti-vibration bar), reduce speed and feed further. Use the bar's internal coolant to clear the chips.

Application case: nickel-iron superalloy

Part	Main steam valve
Material	Nickel-iron-based superalloy (Incoloy 901 type)
Operation	External turning, emulsion
Insert	CNMG120408-SM · IT9215
Vc	41.7 m/min
fn	0.2 mm/rev
ap	2.5 mm
Result	Usura uniforme, durata +30% rispetto all'inserto precedente

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Cutting data are indicative starting values: adjust them to machine, clamping, tool overhang and workpiece material. Data and images may change without notice.