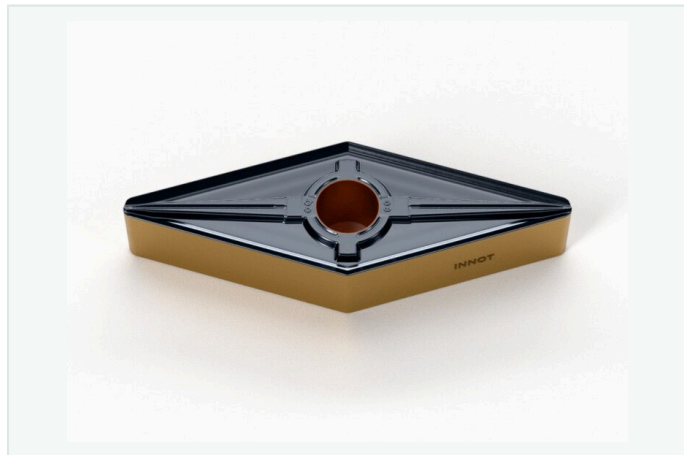


TURNING INSERTS · NEGATIVE INSERTS · VNMG - 35° RHOMBIC

VNMG-GQ

35° negative rhombic insert for finishing and semi-finishing of steels, with GQ chipbreaker and INNOT CVD grades.



KEY DATA

Product type	Turning Inserts
ISO materials	P steel
Operation	Finishing · Semi-finishing
Chipbreaker	GQ
INNOT grades	IT8105 · IT8115 ★ · IT8125 · IT8225 ★ ★ recommended
Nose radii	R0.4 · R0.8 · R1.2
Online page	innot-it.com/en/prodotto/vnmg-gq

ISO specifications

ISO	RADIUS (RE)	AVAILABLE GRADES	CHIPBREAKER
VNMG1604	0.4 - 0.8 - 1.2	IT8105 - IT8115 - IT8125 - IT8225	GQ

GQ chipbreaker data sheet

Operation	Semi-finishing
ISO material	P (non-alloy, alloy and tool steels)
Tolerance	M
Features	Chipbreaker for semi-finishing ISO P materials, suitable from finishing to semi-finishing. Excellent chip evacuation and high versatility: one solution for several passes on the same part. 35° rhombic shape: the slimmest tip in the range, for copy turning and profiling of grooves, radii and shoulders where other shapes cannot reach.

Available INNOT grades

Grade	ISO	Coating	Composition	Application
IT8105	P	CVD	TiN + MT-TiCN + Al ₂ O ₃	Tornitura di acciaio in condizioni stabili. Elevata durezza a caldo, resistenza all'usura e alla deformazione plastica.
IT8115 ★	P	CVD	TiN + MT-TiCN + Al ₂ O ₃	Continuous and lightly interrupted cuts. Finishing and semi-finishing of carbon and alloy steels.
IT8125	P	CVD	TiN + MT-TiCN + Al ₂ O ₃	Interrupted and continuous cuts on steel. The reinforced substrate limits plastic deformation at high temperature.
IT8225 ★	P	CVD	TiN + MT-TiCN + Al ₂ O ₃	First-choice grade for steel, very versatile. Multilayer coating with excellent wear resistance and toughness.

★ Recommended grade for this chipbreaker. CVD = chemical vapour deposition coating. ISO P = steels.

Recommended cutting data

External turning of steels (ISO P) - GQ chipbreaker

Recommended cutting data by material and cutting condition (stable, average, difficult).

Material	Condition	Vc (m/min) by grade	fn (mm/rev)	ap (mm)
Structural steels ≤ 180 HB (S235, C45...)	Stable	IT8105: 230 - 400 IT8115: 215 - 360 IT8125: 190 - 355 IT8225: 205 - 375	0.14 - 0.50	1.00 - 5.00
Structural steels ≤ 180 HB (S235, C45...)	Average	IT8105: 230 - 400 IT8115: 215 - 360 IT8125: 190 - 355 IT8225: 205 - 375	0.14 - 0.45	1.00 - 5.00
Structural steels ≤ 180 HB (S235, C45...)	Difficult	IT8125: 190 - 355 IT8225: 205 - 375	0.14 - 0.40	1.00 - 5.00
Carbon and alloy steels 180 - 280 HB (41Cr4, 42CrMo4...)	Stable	IT8105: 230 - 400 IT8115: 215 - 360 IT8125: 190 - 355 IT8225: 205 - 375	0.14 - 0.50	1.00 - 5.00
Carbon and alloy steels 180 - 280 HB (41Cr4, 42CrMo4...)	Average	IT8105: 230 - 400 IT8115: 215 - 360 IT8125: 190 - 355 IT8225: 205 - 375	0.14 - 0.45	1.00 - 5.00
Carbon and alloy steels 180 - 280 HB (41Cr4, 42CrMo4...)	Difficult	IT8125: 190 - 355 IT8225: 205 - 375	0.14 - 0.40	1.00 - 5.00
Quenched and tempered steels ≥ 280 HB	Stable	IT8105: 220 - 400 IT8115: 205 - 380	0.20 - 0.60	0.90 - 4.00
Quenched and tempered steels ≥ 280 HB	Average	IT8105: 220 - 380 IT8115: 205 - 360	0.20 - 0.55	0.90 - 4.00

Guide values for the GQ chipbreaker. Conditions not shown are not recommended for that material.

Internal turning (boring) of steels (ISO P) - GQ chipbreaker

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).

Material	Condition	Vc (m/min) by grade	fn (mm/rev)	ap (mm)
Structural steels ≤ 180 HB (S235, C45...)	Stable	IT8105: 195 - 340 IT8115: 185 - 305 IT8125: 160 - 300 IT8225: 175 - 320	0.11 - 0.40	1.00 - 3.00
Structural steels ≤ 180 HB (S235, C45...)	Average	IT8105: 195 - 340 IT8115: 185 - 305 IT8125: 160 - 300 IT8225: 175 - 320	0.11 - 0.36	1.00 - 3.00
Structural steels ≤ 180 HB (S235, C45...)	Difficult	IT8125: 160 - 300 IT8225: 175 - 320	0.11 - 0.32	1.00 - 3.00
Carbon and alloy steels 180 - 280 HB (41Cr4, 42CrMo4...)	Stable	IT8105: 195 - 340 IT8115: 185 - 305 IT8125: 160 - 300 IT8225: 175 - 320	0.11 - 0.40	1.00 - 3.00
Carbon and alloy steels 180 - 280 HB (41Cr4, 42CrMo4...)	Average	IT8105: 195 - 340 IT8115: 185 - 305 IT8125: 160 - 300 IT8225: 175 - 320	0.11 - 0.36	1.00 - 3.00

Material	Condition	Vc (m/min) by grade	fn (mm/rev)	ap (mm)
Carbon and alloy steels 180 - 280 HB (41Cr4, 42CrMo4...)	Difficult	IT8125: 160 - 300 IT8225: 175 - 320	0.11 - 0.32	1.00 - 3.00
Quenched and tempered steels $\geq$ 280 HB	Stable	IT8105: 185 - 340 IT8115: 175 - 325	0.16 - 0.48	0.90 - 2.40
Quenched and tempered steels $\geq$ 280 HB	Average	IT8105: 185 - 325 IT8115: 175 - 305	0.16 - 0.44	0.90 - 2.40

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.

Profondità di passata e misura dell'inserto. The table shows the chipbreaker range (ap up to 5 mm), valid for all negative shapes. The 35° shape has the slimmest tip in the range: with VNMG1604 (16.6 mm cutting edge) keep the depth of cut within about 1/4 of the edge, i.e. about 4 mm. For deeper cuts choose a stronger shape (55° DNMG or 80° CNMG).

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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.