


**CNMG 120408, Grade: SP4019**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 250184 SP4019 |
| GTIN         |               |
| Item class   | 28A           |

**Description**

CNMG 120408 SP4019 Grade: SP4019  
 Chip breaker: 3J  
 Cutting depth  $a_p$ : 1 - 4 mm  
 Feed  $f$ : 0.15 - 0.4 mm/rev.  
 Cutting speed  $v_c$  main application: 120 - 300 m/min  
 Cutting speed  $v_c$  secondary application: 40 - 110 m/min

**Technical description**

|   |                    |
|---|--------------------|
| Chip breaker                              | 3J                 |
| Cutting speed $v_c$ secondary application | 40 - 110 m/min     |
| Feed $f$                                  | 0.15 - 0.4 mm/rev. |
| Cutting speed $v_c$ main application      | 120 - 300 m/min    |
| Corner radius                             | 0.8 mm             |
| Secondary application                     | S                  |
| Main application                          | M                  |

|                               |                              |
|-------------------------------|------------------------------|
| Cutting conditions            | continuous                   |
| Cutting depth $a_p$           | 1 - 4 mm                     |
| Grade                         | SP4019                       |
| Finishing/roughing assignment | Semi-roughing                |
| Tool material                 | Carbide                      |
| ISO code indexable insert     | CNMG 120408                  |
| Number of changes/inserts     | 4                            |
| Type of product               | Indexable insert for turning |