# CANELA
# NEW TURNING LINE

***Available in TN15, TN20, TN30 and TN35***

## -FC *Chipbreaker*

FC chipbreaker is engineered for light finishing operations at high speeds in the 0,08 mm to 0,3 mm feed range at depths of cut between (0,2 to 2,5 mm).
Main application area:
Cutting depth (Ap): 0,2 - 2,5 mm
Feed (f): 0,08 - 0,3 mm

| Reference | TN15 | TN30 |
|---|---|---|
| CNMG 090304-FC | ● | |
| CNMG 090308-FC | ● | |
| CNMG 120404-FC | ● | ● |
| DNMG 150604-FC | ● | |
| TNMG 160404-FC | ● | ● |
| WNMG 080404-FC | ● | ● |

## -FMC *Chipbreaker*

Finishing chipbreaker with differential profile which reduces the contact zone and so improves thermal diffusion.
Main application area:
Cutting depth (Ap): 0,5 - 2,5 mm
Feed (f): 0,05 - 0,25 mm

| Reference | TN15 | TN30 |
|---|---|---|
| CNMG 120404-FMC | ● | |
| DNMG 150604-FMC | ● | |
| SNMG 120404-FMC | ● | |
| TNMG 160404-FMC | ● | |
| WNMG 080404-FMC | ● | |

## -MC *Chipbreaker*

MC chipbreaker provides a positive rake angle with land for high edge strength in medium duty applications on a wide range of materials. Recommended for general purpose use on all types of steel and stainless steels.
Main application area:
Cutting depth (Ap): 1,0 - 3,5 mm
Feed (f): 0,15 - 0,35 mm

| Reference | TN15 | TN30 | TN35 |
|---|---|---|---|
| CNMG 120408-MC | ● | ● | ● |
| DNMG 150608-MC | ● | ● | ● |
| TNMG 160408-MC | ● | ● | ● |
| WNMG 060404-MC | ● | | ● |
| WNMG 060408-MC | ● | | ● |
| WNMG 080408-MC | ● | ● | ● |

## -MFC *Chipbreaker*

MFC chipbreaker provides excellent chip control with low cutting forces and free cutting action over a broad range of light duty applications. Recommended for light duty use on carbon alloys.
Main application area:
Cutting depth (Ap): 0,5 - 4,0 mm
Feed (f): 0,15 - 0,5 mm

| Reference | TN15 | TN30 |
|---|---|---|
| CNMG 120408-MFC | ● | ● |
| DNMG 150608-MFC | ● | ● |
| TNMG 160408-MFC | ● | ● |
| WNMG 080408-MFC | ● | |

## -MHC *Chipbreaker*

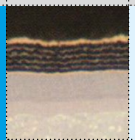
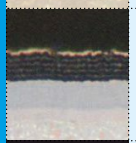
Alternative chipbreaker for medium cutting of general steel and alloy steel. First recommendation for medium-heavy cutting of mild steel.
Main application area:
Cutting depth (Ap): 0,5 - 5,0 mm
Feed (f): 0,4 - 0,8 mm

| Reference | TN15 | TN20 | TN30 |
|---|---|---|---|
| CNMG 120408-MHC | ● | | ● |
| CNMG 120412-MHC | | ● | |
| DNMG 150608-MHC | | ● | ● |
| DNMG 150612-MHC | | | ● |
| TNMG 160408-MHC | | ● | ● |
| TNMG 160412-MHC | | | ● |
| WNMG 080408-MHC | | ● | ● |
| WNMG 080412-MHC | | ● | |

## -RC *Chipbreaker*

The RC chipbreaker is suitable for high feed rates and depths of cut that normally require single-sided inserts. The chipbreaker has a wide negative T land, which gives high edge strength.
Main application area:
Cutting depth (Ap): 1,5 - 5 mm
Feed (f): 0,3 - 0,5 mm

| Reference | TN15 | TN20 | TN30 |
|---|---|---|---|
| CNMG 120408-RC | ● | | ● |
| CNMG 120412-RC | ● | | ● |
| SNMG 120412-RC | | | ● |

| Material | | Grade | Definition |
|---|---|---|---|
| **P** Steel |  | ***TN15*** | Wear resistant finishing to intermediate grade suitable for many applications on steel, cast iron, stainless steel and high temperature alloys. It is generally used at higher speeds where deformation may be a problem. The multi-layer coating includes TiCN and aluminium oxide. |
| |  | ***TN20*** | General purpose wear resistant grade. It has enriched substrate which has exceptionally good deformation as well as fracture resistance. The multi-layer coating includes aluminium oxide to add additional heat and wear resistance. It is used to machine steel and stainless steel at lower speeds than TN15. |
| |  | ***TN30*** | General purpose wear resistant turning grade. The multi-layer coating includes aluminium oxide to add additional heat and wear resistance. It is used to machine steel at lower speeds thanTN15. This turning grade is for demanding metal removal operations, including cutting through scale at low speeds through heavy interruption, and problem machining of stainless steel at low speed and poor rigidity. |
| **M** Stainless |  | ***TN35*** | New coated grade developed to machine stainless steel and heat-resistance alloys. This grade is only used in combination with the MC chipbreaker. First choice for stainless steel applications. |

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