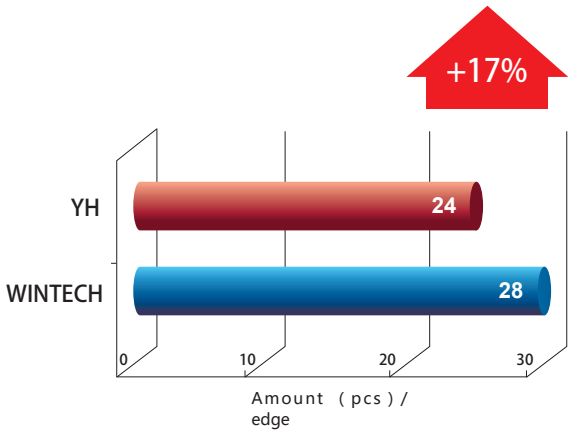
Steel Turning Inserts Case Studies
QM Geometry + A1225 Grade

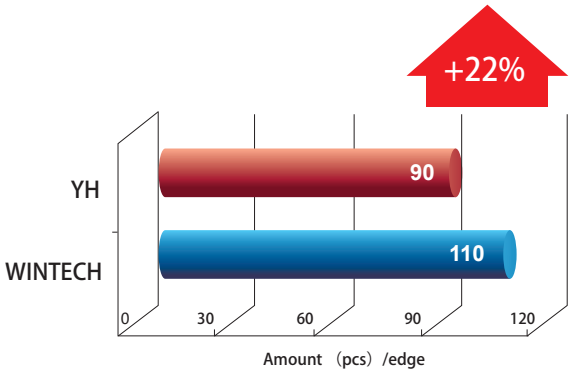
Case 1

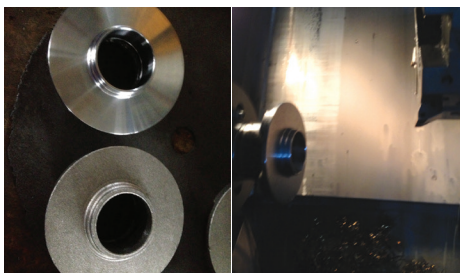
Workpiece Material	55#（HB180-220）
Processing Way	Longitudinal and Face Roughing, Wet
Cutting Parameters	Vc=100m/min, f=0.3mm/r, ap=1.5mm
Inserts	WNMG0804012-QM-A1225



Case 2

Workpiece Material	S55C (HB180-220)
Processing Way	Longitudinal and Face Semi-finishing,Wet
Cutting Parameters	Vc=500m/min, f=0.2mm/r, ap=1mm
Inserts	WNMG080408-QM-A1225

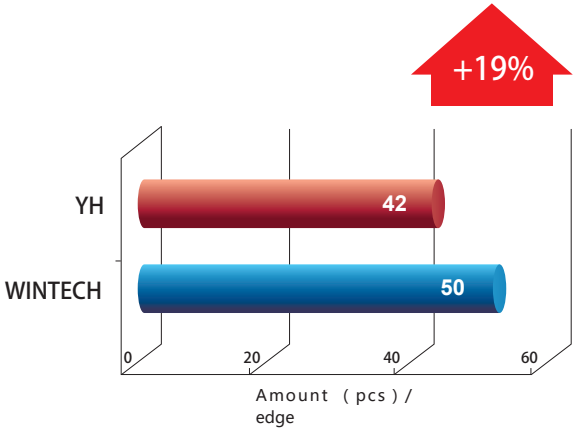




Steel Turning Inserts Case Studies
QH Geometry + A1225 Grade

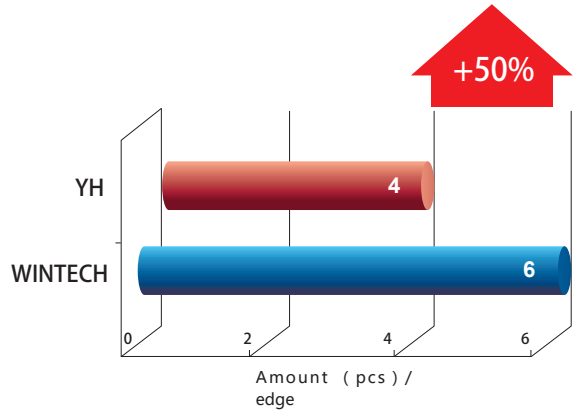
Case 1

Workpiece Material	Cr13（HB200-220）
Processing Way	Ongitudinal Heavy Cutting, Wet
Cutting Parameters	Vc =114 m/min, f = 0.6 mm/r, ap = 7 mm
Inserts	SNMM250924-QH-A1225



Case 2

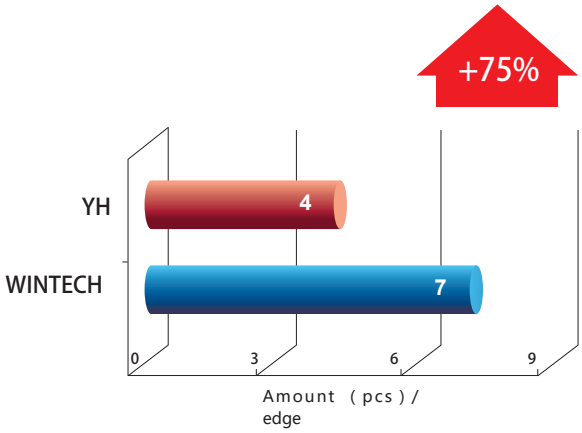
Workpiece Material	35CrMo（HB230-260）
Processing Way	Ongitudinal Heavy Cutting, Wet
Cutting Parameters	Vc=80m/min, f=0.6mm/r, ap=6mm
Inserts	CNMM250924-QH-A1225



Steel Turning Inserts Case Studies
QR Geometry + A1225 Grade

Case 1

Workpiece Material	40Cr（HB174-229）
Processing Way	Longitudinal and Face Roughing, Wet
Cutting Parameters	Vc=271m/min, f=0.25mm/r, ap=2mm
Inserts	CNMG120408-QR-A1225



Case 2

Workpiece Material	20CrMnTi（HB159-201）
Processing Way	Longitudinal and Face Roughing, Wet
Cutting Parameters	Vc=200m/min, f=0.2mm/r, ap=5mm
Inserts	WNMG080408-QR-A1225