

ARNO[®]

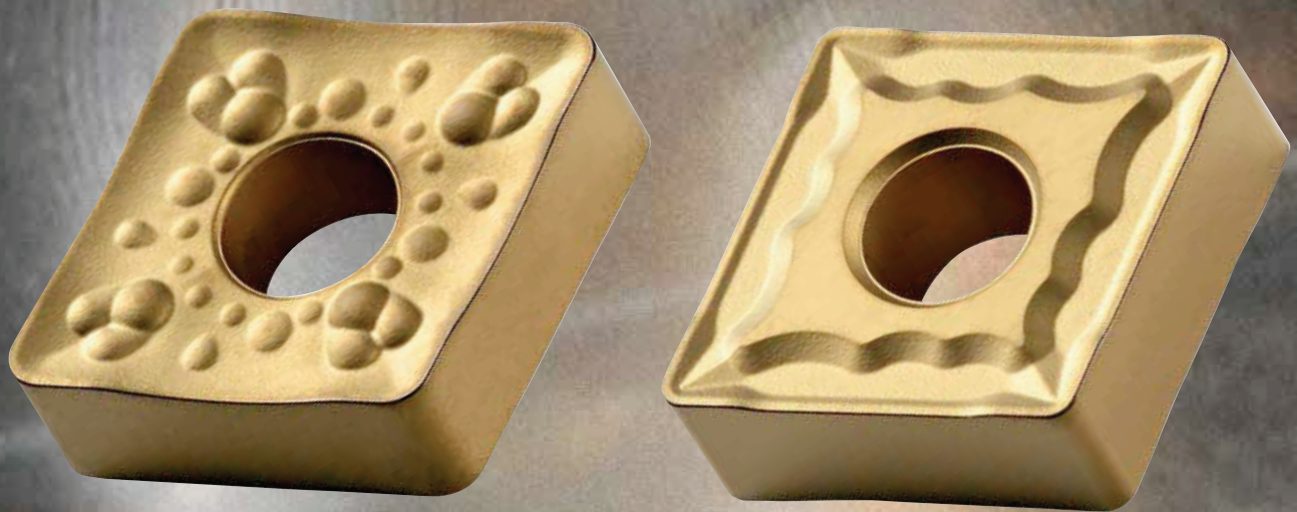
WERKZEUGE

We have a passion for precision.

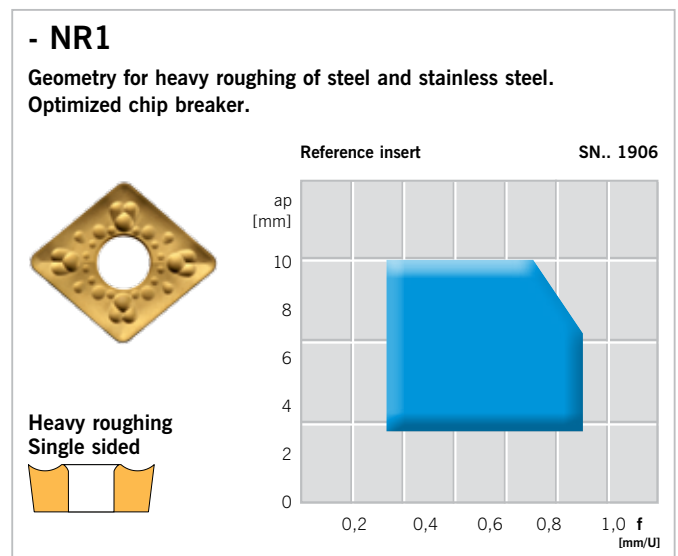
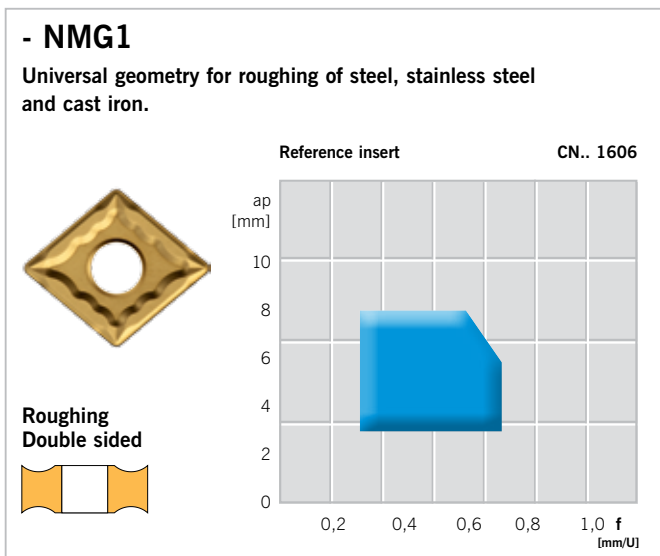
CARBIDE - INDEXABLE INSERTS

Product expansion - Turning

- Geometries: -NMG1, -NR1
- For roughing
- Larger corner radius
- Higher cutting speeds
- Grades AP2335 / AP2420 for steel machining
Grade AM5130 for exotic materials and stainless steel



Geometry description



Grade description

Coated

AM5130

PVD-multilayer coating

Universal grade for medium machining of stainless steel, alloyed steel and exotic materials.

AP2335

CVD-multilayer coating

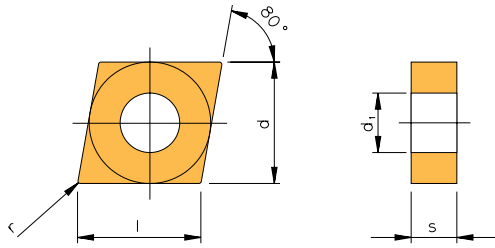
Grade for cutting steel. Extremely tough grade for interrupted cuts and unfavorable machining conditions in roughing applications.

AP2420

CVD-multilayer coating

Latest technology carbide grade with aluminium oxide coating for steel turning. The effect of polishing of the cutting edge makes the aluminium oxide coating smooth and free cutting. This minimises the friction and reduces the insert wear. Furthermore the already tough grade is cobalt enhanced around the cutting edges to make them even stronger when rough turning. The TiN coating on top is ideal for identifying wear. Improve your tool life using grade AP2420.

CN..



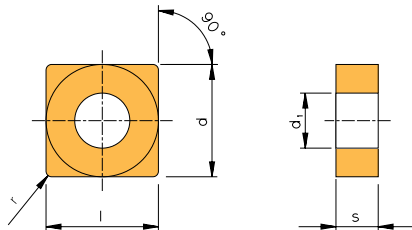
Description	l	d	s	d ₁	r	PG	grades coated		
							AM5130	AP2335	AP2420
CNMG 160612EN-NMG1	16,10	15,875	6,35	6,35	1,2	2	●	●	●
CNMG 160616EN-NMG1	16,10	15,875	6,35	6,35	1,6	2	●	●	●
CNMG 190612EN-NMG1	19,30	19,050	6,35	7,94	1,2	2	●	●	●
CNMG 190616EN-NMG1	19,30	19,050	6,35	7,94	1,6	2	●	●	
CNMM 160612EN-NR1	16,10	15,875	6,35	6,35	1,2	2		●	●
CNMM 160616EN-NR1	16,10	15,875	6,35	6,35	1,6	2	●	●	●
CNMM 190612EN-NR1	19,30	19,050	6,35	7,94	1,2	2	●	●	●
CNMM 190616EN-NR1	19,30	19,050	6,35	7,94	1,6	2		●	

Other grades may be available, please contact your local ARNO representative.

● Main application
○ Secondary application

P		●	●
M	●		
K			
N			
S	●		
H			

SN..



Description	l	d	s	d ₁	r	PG	grades coated		
							AM5130	AP2335	AP2420
SNMG 150612EN-NMG1	15,875	15,875	6,35	6,35	1,2	2	●	●	
SNMG 150616EN-NMG1	15,875	15,875	6,35	6,35	1,6	2	●	●	●
SNMG 190612EN-NMG1	19,050	19,050	6,35	7,94	1,2	2	●	●	
SNMG 190616EN-NMG1	19,050	19,050	6,35	7,94	1,6	2	●	●	●
SNMM 150612EN-NR1	15,875	15,875	6,35	6,35	1,2	2	●	●	●
SNMM 150616EN-NR1	15,875	15,875	6,35	6,35	1,6	2	●	●	●
SNMM 190612EN-NR1	19,050	19,050	6,35	7,94	1,2	2	●	●	●
SNMM 190616EN-NR1	19,050	19,050	6,35	7,94	1,6	2	●	●	

Other grades may be available, please contact your local ARNO representative.

● Main application
○ Secondary application

P		●	●
M	●		
K			
N			
S	●		
H			

ISO	Material	Tensile strength (N/mm ²)	Cutting speed V _c [m/min]		
			coated		
			AP2335	AP2420	AM5130
P	Unalloyed steel and cast steel	< 0,15 % C/hardened and tempered	350	180 - 270	250 - 350
		0,15 – 0,45 % C/hardened and tempered	650	170 - 230	210 - 300
		> 0,45 % C/tempered	1000	160 - 210	180 - 230
	Low alloyed steel and cast steel	annealed	600	160 - 220	180 - 270
		hardened and tempered	900	140 - 180	160 - 220
			1200	100 - 160	100 - 200
	High alloyed steel	annealed	700	130 - 180	130 - 200
	High alloyed steel and cast steel	hardened and tempered	1100	70 - 120	70 - 140
	Stainless steel	ferritic, annealed	700		
	Cast steel	martensitic, hardened and tempered	1000		
M	Stainless steel and cast steel	ferritic/martensitic, annealed	450 - 600		80 - 150
		martensitic/austenitic, chilled	600 - 900		40 - 120
S	High temperature resistant alloys	Fe-alloyed, annealed	700		20 - 50
		Fe-alloyed, hardened	950		20 - 50
		Ni- or Co-Basis, annealed	800		15 - 40
		Ni- or Co-Basis, casting	1100		15 - 40
		Ni- or Co-Basis, based hardened	1200		15 - 40
	Titanium alloys, high strength	Pure titanium	500 - 700		80 - 170
	Alpha+Beta-alloys	hardened	700 - 1000		80 - 170

The data given is only approximate values.
It can be necessary to adjust this data to the individual machining operation.



For further information please ask for our complete catalogue.

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