

EM CHIPBREAKER

For turning in stainless steel
and exotic alloys

Insert Styles:

CNMG
DNMG
SNMG
TNMG
VNMG
WNMG

Grades:

TT9215
TT9225
TT9235
TT5030
TT9080

Feed Rates:

.005~.024 ipr (0.13~0.60 mm/rev)

Cutting Depths:

.020~.315 inches (0.5~8.0 mm)

Applications:

- General purpose & medium turning applications in stainless steel and exotic alloys
- Medium machining operations where lower cutting forces are needed



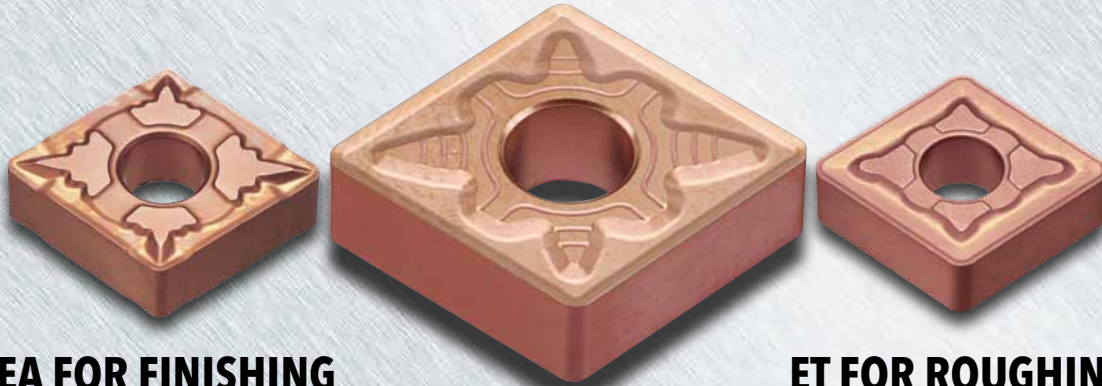
Ingersoll previously introduced two new chipbreakers for machining stainless steels and exotic materials: The EA chipbreaker for finish to semi-finish operations in low depths of cut, and the ET chipbreaker for rough machining of these materials. The new EM chipbreaker is designed for medium applications where customers desire a single insert that encompasses many of the same features offered by the EA and ET.

The EM chipbreaker features a sharp land that reduces machining load during medium machining applications, while simultaneously reducing build up material on the cutting edge. The design also includes a broad boss face that dissipates heat on the upper side of the chipbreaker, improving the surface contact ratio while maximizing tool life. The result is an insert that provides stable performance in difficult to machine materials over a wide range of feed rates and cutting depths.

TOTURN™

NEW

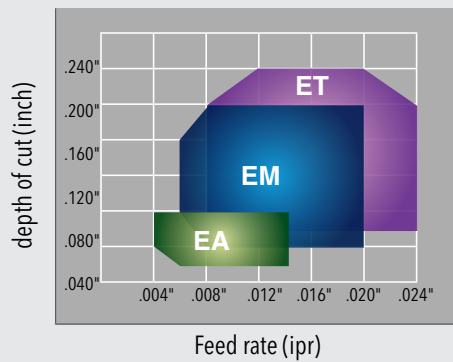
EM FOR MEDIUM



EA FOR FINISHING

ET FOR ROUGHING

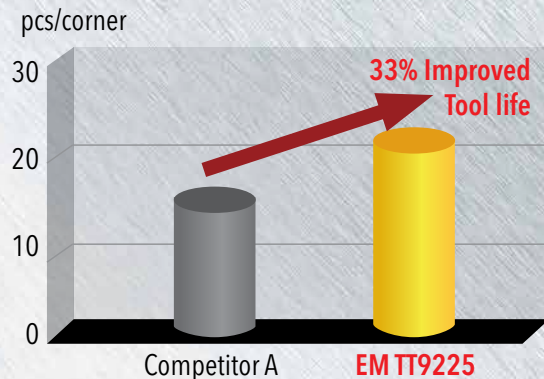
Chip Control Range



Insert : CNMG 432
Cutting speed: 400 sfm
Material: 304 Stainless steels

TEST REPORT

TEST RESULTS		
Component	Axle	
Material	Stainless steel	
Cutting speed (V)	540 sfm	
Feed Rate(f)	.010 ipr	
Depth of cut (ap)	.080"	
Machining Method	External / Wet machining	
Tool life		
Competitor A	WNMG 432	15pcs/corner
Ingersoll	WNMG 432 EM TT9225	20pcs/corner



■ CNMG EM



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT9215	TT9225	TT9235	TT5030	TT9080
NEW CNMG 431 EM	CNMG 120404 EM	.004-.018	.020-.200		●	●	●	●	●
CNMG 432 EM	CNMG 120408 EM	.005-.020	.020-.200		●	●	●	●	●
CNMG 433 EM	CNMG 120412 EM	.006-.022	.020-.200		●	●	●	●	●
CNMG 434 EM	CNMG 120416 EM	.007-.024	.020-.200		●	●	●	●	●
CNMG 542 EM	CNMG 160608 EM	.005-.020	.020-.250		●	●	●	●	●
CNMG 543 EM	CNMG 160612 EM	.006-.022	.020-.250		●	●	●	●	●
CNMG 544 EM	CNMG 160616 EM	.007-.024	.020-.250		●	●	●	●	●
CNMG 642 EM	CNMG 190608 EM	.005-.020	.020-.315		●	●	●	●	●
CNMG 643 EM	CNMG 190612 EM	.006-.022	.020-.315		●	●	●	●	●
CNMG 644 EM	CNMG 190616 EM	.007-.024	.020-.315		●	●	●	●	●

■ DNMG EM



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT9215	TT9225	TT9235	TT5030	TT9080
DNMG 332 EM	DNMG 110408 EM*	.005-.020	.020-.160		●	●	●	●	●
DNMG 432 EM	DNMG 150408 EM	.005-.020	.020-.200		●	●	●	●	●
DNMG 442 EM	DNMG 150608 EM	.005-.020	.020-.200		●	●	●	●	●
DNMG 433 EM	DNMG 150412 EM	.006-.022	.020-.200		●	●	●	●	●
DNMG 443 EM	DNMG 150612 EM	.006-.022	.020-.200		●	●	●	●	●

*Insert is screw held

■ SNMG EM



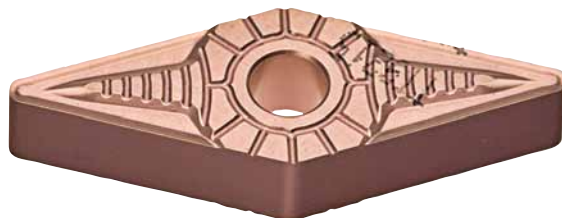
ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT9215	TT9225	TT9235	TT5030	TT9080
SNMG 432 EM	SNMG 120408 EM	.005-.020	.031-.200		●	●	●	●	●
SNMG 433 EM	SNMG 120412 EM	.006-.022	.031-.200		●	●	●	●	●
SNMG 543 EM	SNMG 150612 EM	.006-.022	.031-.250		●	●	●	●	●
SNMG 544 EM	SNMG 150616 EM	.007-.024	.031-.250		●	●	●	●	●
SNMG 643 EM	SNMG 190612 EM	.006-.022	.031-.315		●	●	●	●	●
SNMG 644 EM	SNMG 190616 EM	.007-.024	.031-.315		●	●	●	●	●

■ TNMG EM



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT9215	TT9225	TT9235	TT5080	TT9080
TNMG 332 EM	TNMG 160408 EM	.005-.020	.031-.180		●	●	●	●	●
TNMG 333 EM	TNMG 160412 EM	.006-.022	.031-.180		●	●	●	●	●
TNMG 432 EM	TNMG 220408 EM	.005-.020	.031-.240		●	●	●	●	●
TNMG 433 EM	TNMG 220412 EM	.006-.022	.031-.240		●	●	●	●	●

VNMG EM



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT9215	TT9225	TT9235	TT5030	TT9080
VNMG 332 EM	VNMG 160408 EM	.050-.020	.031-.140		●	●	●		●

WNMG EM



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT9215	TT9225	TT9235	TT5030	TT9080
WNMG 332 EM	WNMG 060408 EM	.005-.020	.031-.120		●	●	●	●	●
WNMG 333 EM	WNMG 060412 EM	.006-.022	.031-.120		●	●	●	●	●
WNMG 431 EM	WNMG 080404 EM	.004-.018	.031-.160		●	●	●	●	
WNMG 432 EM	WNMG 080408 EM	.005-.020	.031-.160		●	●	●	●	●
WNMG 433 EM	WNMG 080412 EM	.005-.022	.031-.160		●	●	●	●	●

Availability

In stock

Price

Available in the GAL system