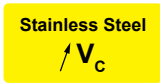


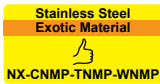
Lamina Technologies Machining Recommendations

In order to obtain the best productivity using Lamina Technologies cutting tools, we have included some relevant comments and tips.

Each comment is represented by an icon and the relevant icons appear for each insert.



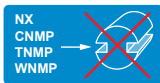
In machining stainless steel, please verify and respect the cutting speed recommended for the insert as there is a tendency to machine at speeds that are too low.



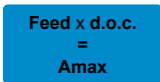
In machining stainless steel or exotic materials, P geometry inserts (CNMP, TNMP, WNMP) and NX chipbreakers are recommended as first choice.



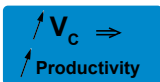
In machining exotic materials, it is important to verify cutting conditions of the specific insert.



P geometry inserts (CNMP, TNMP, WNMP) and NX chipbreakers are not recommended when machining with interrupted cut.



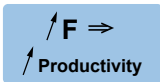
It is important to verify and respect A_{max} , which is the maximum chip section. Feed x d.o.c. must be lower than the number noted as A_{max} .



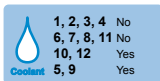
To increase machining productivity, it is recommended to increase speed (V_c) while respecting chip size calculation.



Appropriate for boring operations.



To increase machining productivity, it is recommended to increase speed (V_c) while respecting chip size calculation.



When milling materials from groups 1, 2, 3, 4, 6, 7, 8 and 11, coolant is not recommended. When machining materials from groups 5, 9, 10 and 12, it is recommended to use coolant.