

HELITURN LD

**New Descriptions for
HELITURN LD Inserts
According to New Chipformer Code Key**

HELITURN LD

ISCAR is introducing a new chipformer code key, in order to help endusers select the correct chipformer for their applications (workpiece material and turning characteristics). Each character of this key represents an applicative feature of the chipformer.

An accurate description of the chipformer helps the enduser select the most appropriate chipformer for his application, which will thus be the most productive.

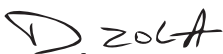
According to the above-mentioned, ISCAR has changed the chipformer designations of the HELITURN LD inserts according to its new code key.

Please note:

- The changes apply only to insert designations. Catalog numbers and chipformer geometries have not been changed.
- The designations have already been changed in the GAL system, but only new production orders will carry the new descriptions.
- Newly designated items will be provided only after the current stock will be depleted.

Attached are the new code key and a list of items with their current and new designations.

Sincerely,



David Zola
Chief Technical Officer,
Iscar Headquarters

Sincerely,



Rafi Rabouach
Product Manager,
ISO TURNING
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1. Application			
		Feed (mm/rev)	a_p (mm)
F	Finishing	0.08-0.20	0.30-1.50
M	Medium	0.15-0.45	0.70-4.50
R	Roughing	0.35-0.70	3.00-7.00
H	Heavy Roughing	0.60-1.50	6.00-20.0
T	Turn Feed	0.50-2.50	1.00-3.00

2. Chip Load	
2	For special cases
3	General recommendation for all applications
4	For special cases

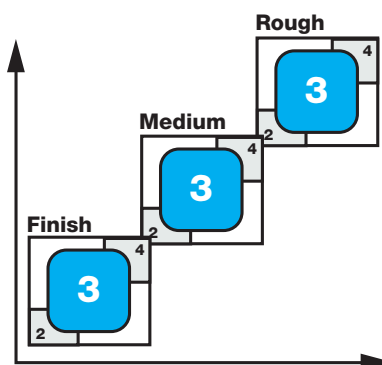
ISO Standard Designation			
CNMG	12	04	08

1	2	3	4
M	3	P	W

3. Workpiece Material Group	
P	Steel
M	Stainless Steel
K	Cast Iron
N	Non Ferrous & Aluminum
S	High Temperature Alloys

4. Wiper Geometry	
	Without wiper
W	Wiper Geometry

Chip Load	
2	For special cases
3	General recommendation for all applications
4	For special cases



In this example, **M3PW**, the insert's chipformer, should be used for the medium application range, on steel, and it has a wiper corner configuration. The initial part of the designation which represents insert shape and dimensions will remain according to the ISO identification standard.

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Item Number	Current Description	New Description
5508282	CNMM 120408-HTW IC8150	CNMM 120408-M4PW IC8150
5508077	CNMM 120408-HTW IC8250	CNMM 120408-M4PW IC8250
5519646	CNMM 120412-HTW IC8250	CNMM 120412-M4PW IC8250
5519648	CNMM 160612-HTW IC8150	CNMM 160612-M4PW IC8150
5560592	CNMM 160612-HTW IC825	CNMM 160612-M4PW IC8250
5519650	CNMM 160616-HTW IC8150	CNMM 160616-M4PW IC8150
5519651	CNMM 160616-HTW IC8250	CNMM 160616-M4PW IC8250
5510338	CNMX 090604-HTW IC8150	CNMX 090604-M3PW IC8150
5510339	CNMX 090604-HTW IC8250	CNMX 090604-M3PW IC8250
5560553	CNMX 090608-HTW IC8150	CNMX 090608-M3PW IC8150
5510341	CNMX 090608-HTW IC8250	CNMX 090608-M3PW IC8250
5507985	CNMX 120708-HTW IC807	CNMX 120708-M4PW IC807
5507915	CNMX 120708-HTW IC8150	CNMX 120708-M4PW IC8150
5507914	CNMX 120708-HTW IC8250	CNMX 120708-M4PW IC8250
5507916	CNMX 120708-HTW IC8350	CNMX 120708-M4PW IC8350
5506387	CNMX 120708-HTW IC9025	CNMX 120708-M4PW IC9025
5507026	CNMX 120708-HTW IC907	CNMX 120708-M4PW IC907
5507338	CNMX 120708-HTW IC9150	CNMX 120708-M4PW IC9150
5507339	CNMX 120708-HTW IC9250	CNMX 120708-M4PW IC9250
5507340	CNMX 120708-HTW IC9350	CNMX 120708-M4PW IC9350
5507986	CNMX 120712-HTW IC807	CNMX 120712-M4PW IC807
5507917	CNMX 120712-HTW IC8150	CNMX 120712-M4PW IC8150
5507918	CNMX 120712-HTW IC8250	CNMX 120712-M4PW IC8250
5507919	CNMX 120712-HTW IC8350	CNMX 120712-M4PW IC8350
5507027	CNMX 120712-HTW IC9025	CNMX 120712-M4PW IC9025
5507028	CNMX 120712-HTW IC907	CNMX 120712-M4PW IC907
5507341	CNMX 120712-HTW IC9150	CNMX 120712-M4PW IC9150
5507342	CNMX 120712-HTW IC9250	CNMX 120712-M4PW IC9250
5507343	CNMX 120712-HTW IC9350	CNMX 120712-M4PW IC9350
5507987	CNMX 120716-HTW IC807	CNMX 120716-M4PW IC807
5507920	CNMX 120716-HTW IC8150	CNMX 120716-M4PW IC8150
5507921	CNMX 120716-HTW IC8250	CNMX 120716-M4PW IC8250
5507761	CNMX 120716-HTW IC8350	CNMX 120716-M4PW IC8350
5507029	CNMX 120716-HTW IC9025	CNMX 120716-M4PW IC9025
5507030	CNMX 120716-HTW IC907	CNMX 120716-M4PW IC907
5507344	CNMX 120716-HTW IC9150	CNMX 120716-M4PW IC9150
5507345	CNMX 120716-HTW IC9250	CNMX 120716-M4PW IC9250
5507346	CNMX 120716-HTW IC9350	CNMX 120716-M4PW IC9350
5507505	CNMX 160712--HTW IC807	CNMX 160712--M4PW IC807
5507988	CNMX 160712--HTW IC8150	CNMX 160712--M4PW IC8150
5507989	CNMX 160712--HTW IC8250	CNMX 160712--M4PW IC8250
5507506	CNMX 160716-HTW IC807	CNMX 160716-M4PW IC807
5507990	CNMX 160716-HTW IC8150	CNMX 160716-M4PW IC8150
5507991	CNMX 160716-HTW IC8250	CNMX 160716-M4PW IC8250

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5560566	TNMX 160604-HTW	IC8150	TNMX 160604-M3PW	IC8150
5560567	TNMX 160604-HTW	IC8250	TNMX 160604-M3PW	IC8250
5560568	TNMX 160608-HTW	IC8150	TNMX 160608-M3PW	IC8150
5560569	TNMX 160608-HTW	IC8250	TNMX 160608-M3PW	IC8250
5567452	TNMX 220708-HTW	IC8150	TNMX 220708-M4PW	IC8150
5567453	TNMX 220708-HTW	IC8250	TNMX 220708-M4PW	IC8250
5567454	TNMX 220712-HTW	IC8150	TNMX 220712-M4PW	IC8150
5567455	TNMX 220712-HTW	IC8250	TNMX 220712-M4PW	IC8250
5567456	TNMX 220716-HTW	IC8150	TNMX 220716-M4PW	IC8150
5567457	TNMX 220716-HTW	IC8250	TNMX 220716-M4PW	IC8250
5509287	WNMM 080408-HTW	IC8150	WNMM 080408-M4PW	IC8150
5509286	WNMM 080408-HTW	IC8250	WNMM 080408-M4PW	IC8250
5519654	WNMM 080412-HTW	IC8150	WNMM 080412-M4PW	IC8150
5519655	WNMM 080412-HTW	IC8250	WNMM 080412-M4PW	IC8250
5510360	WNMX 060604-HTW	IC8150	WNMX 060604-M3PW	IC8150
5510361	WNMX 060604-HTW	IC8250	WNMX 060604-M3PW	IC8250
5507992	WNMX 060608-HTW	IC807	WNMX 060608-M3PW	IC807
5507993	WNMX 060608-HTW	IC8150	WNMX 060608-M3PW	IC8150
5507686	WNMX 060608-HTW	IC8250	WNMX 060608-M3PW	IC8250
5507994	WNMX 080708-HTW	IC807	WNMX 080708-M4PW	IC807
5507995	WNMX 080708-HTW	IC8150	WNMX 080708-M4PW	IC8150
5507685	WNMX 080708-HTW	IC8250	WNMX 080708-M4PW	IC8250
5508504	WNMX 080712-HTW	IC8150	WNMX 080712-M4PW	IC8150
5508506	WNMX 080712-HTW	IC8250	WNMX 080712-M4PW	IC8250
5508505	WNMX 080716-HTW	IC8150	WNMX 080716-M4PW	IC8150
5508507	WNMX 080716-HTW	IC8250	WNMX 080716-M4PW	IC8250
5509374	DNMX 150608-HT	IC6015	DNMX 150608-M3P	IC6015
5509933	DNMX 150608-HT	IC6025	DNMX 150608-M3P	IC6025
5510113	DNMX 150608-HT	IC806	DNMX 150608-M3P	IC806
5507996	DNMX 150608-HT	IC807	DNMX 150608-M3P	IC807
5507504	DNMX 150608-HT	IC8150	DNMX 150608-M3P	IC8150
5507997	DNMX 150608-HT	IC8250	DNMX 150608-M3P	IC8250
5509375	DNMX 150612-HT	IC6015	DNMX 150612-M3P	IC6015
5509934	DNMX 150612-HT	IC6025	DNMX 150612-M3P	IC6025
5510114	DNMX 150612-HT	IC806	DNMX 150612-M3P	IC806
5508538	DNMX 150612-HT	IC807	DNMX 150612-M3P	IC807
5508536	DNMX 150612-HT	IC8150	DNMX 150612-M3P	IC8150
5508537	DNMX 150612-HT	IC8250	DNMX 150612-M3P	IC8250
5508820	DNMX 150612-HT	IC8350	DNMX 150612-M3P	IC8350
5509269	DNMX 150616-HT	IC8250	DNMX 150616-M3P	IC8250
5509268	DNMX 150616-HT	IC8350	DNMX 150616-M3P	IC8350