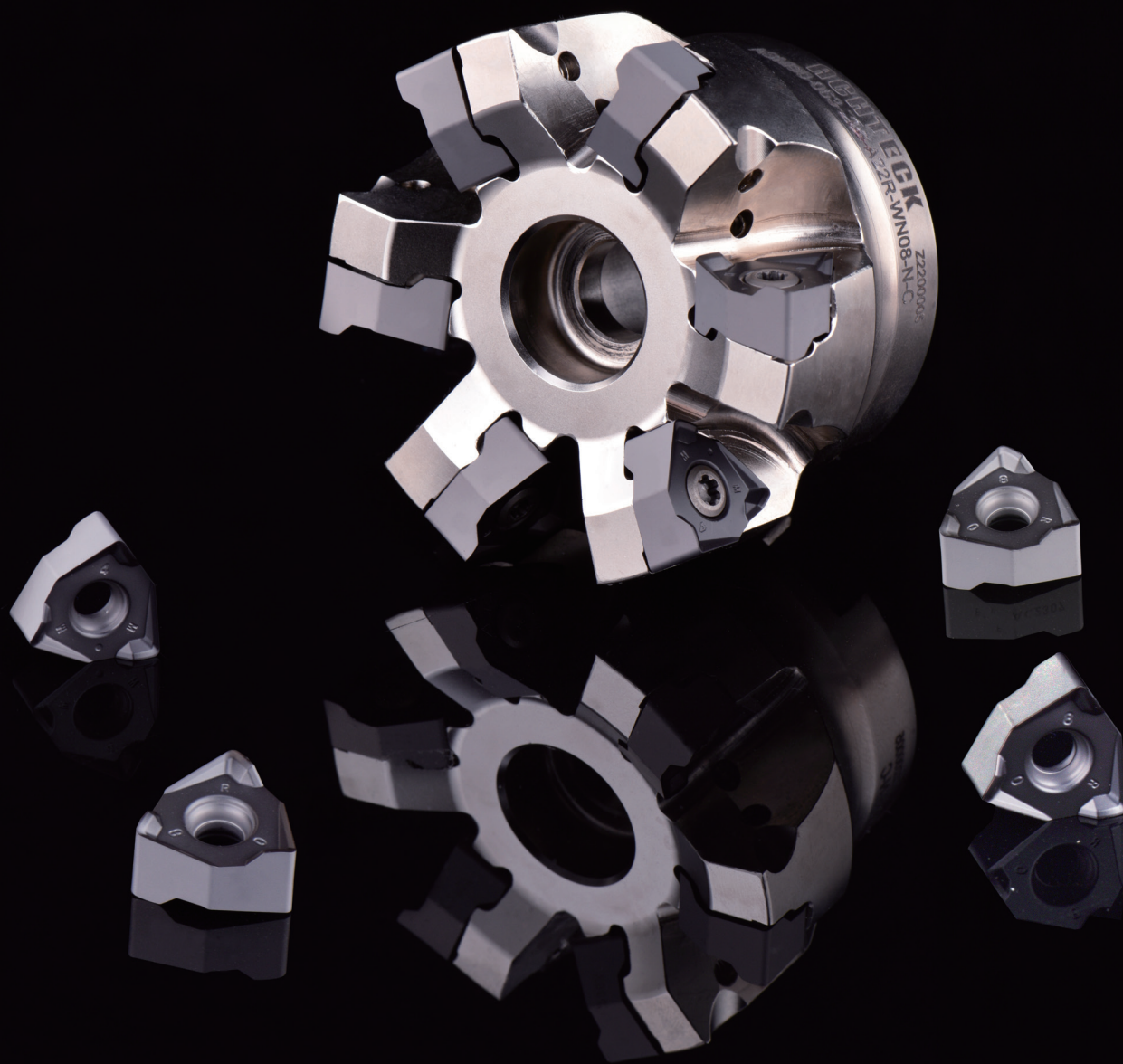


**NEW  
PRODUCT!**

**Newly added WN 08 inserts (Pressed)  
Shoulder milling cutter**





## WNMU 08 newly added pressed inserts

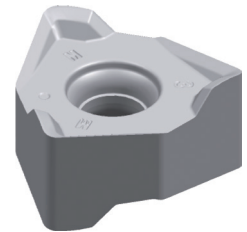
Newly added inserts of WN08 series are more economical and in M grade.

It has negative trigon design with 6 cutting edges to reduce the machining cost effectively.

There are three geometries (MM3, MM4, MR2), combined Achteck new coating and substrate technology, can achieve better performance and longer tool life.

## WNMU 08 insert introduction

- Negative insert with 6 cutting edges, highly economical.
- Different insert corner radius options: R0.8, 1.2, 1.6 for different applications.
- Different insert geometry, suitable for different applications.
- Various cutter coupling: arbor, cylindrical shank, and weldon shank.
- Various pitches: coarse, close and extra-close pitch for wide application.

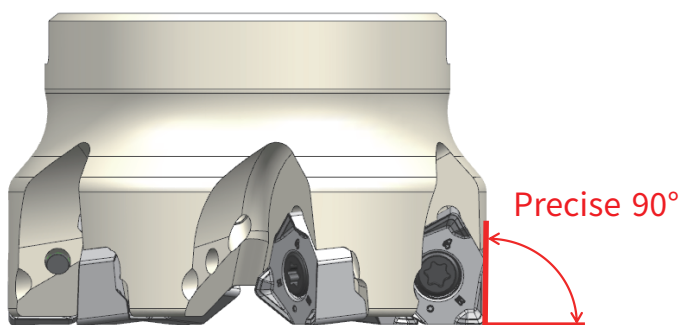


## WNMU08 product features and benefits

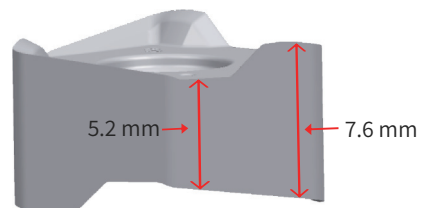
WNMU08 product features	Customer benefits
Negative shoulder milling cutter with 6 cutting edge insert Various nose radius: R0.8, R1.2, R1.6 Various geometry design The insert is with positive axial angle, has a good chip evacuation	Lower tool cost More various applications
New PVD coating technology High wear resistance and good heat resistance Good thermal crack resistance	New WNMU 08 and grade AP251K to achieve: Longer tool life Better stability in machining process Higher cutting data and production efficiency
New ultra-fine and even carbide substrate offers high hardness, high strength and good thermal crack resistance	
New technology of post coating process to reduce the surface friction	
Various tool bodies Various tool coupling Different pitches	Suitable for various machining conditions Suitable for various machines Suitable for various materials



- WNMU 08 insert introduction

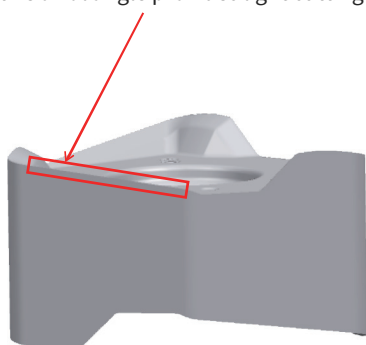


The thickest: 7.6 mm; The thinnest: 5.2 mm

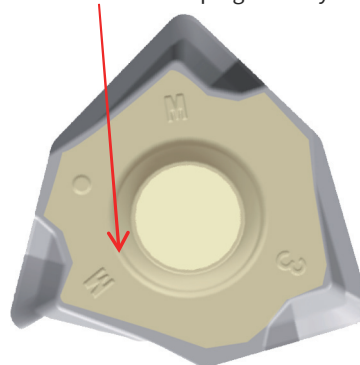


Strong insert design

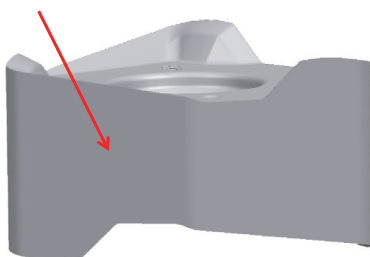
Positive axial angle provides light cutting and good chip evacuation.



Big mounting surface provides better insert clamping stability.

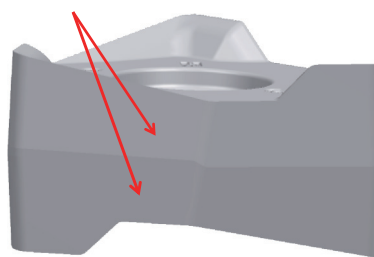


**Single flank surface**



New product: WNM(G)U 0806..insert

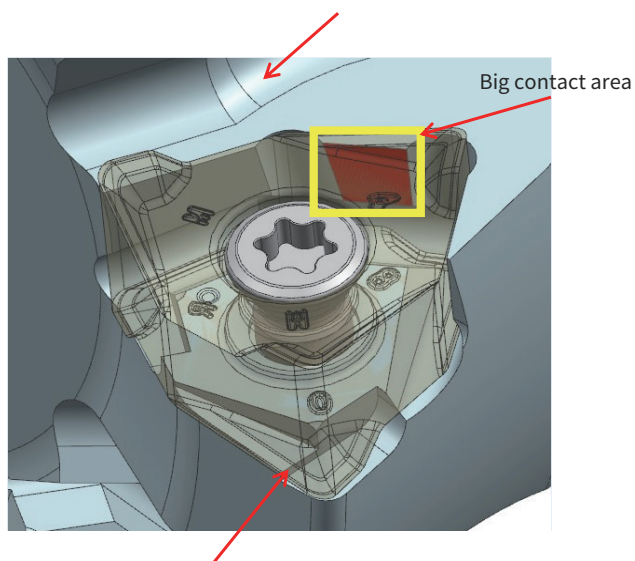
**Double flank surface**



Old product: WNGU 0806..insert

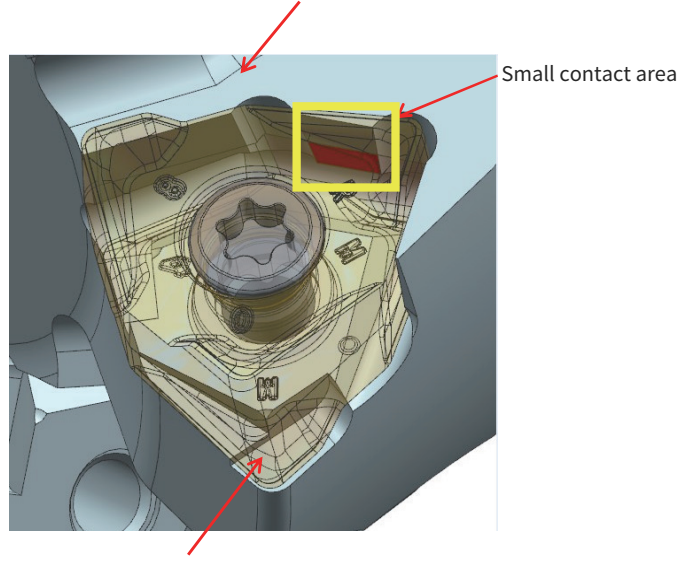
## WNMU 08 tool body introduction

New tool body: ASM90-063-Z06-A22R-WN08-N-C



New insert: WNM(G)U 0806..insert

New tool body: ASM90-063-Z06-A22R-WN08-N-C

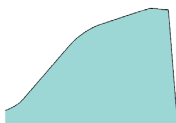

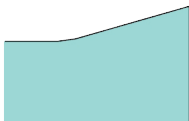


Old insert: WNGU 0806..insert

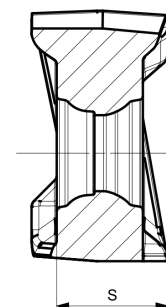
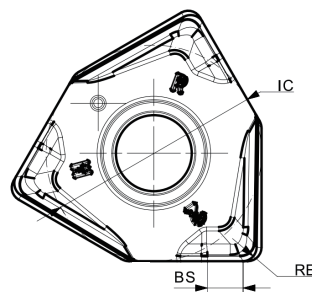
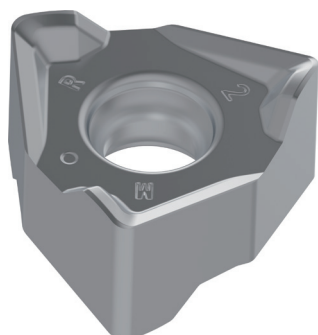
Note:

1. Old insert can be used in the new tool body (marked with "-N").
2. Tool diameter will be 0.5mm less when old inserts are mounted on the new tool body.
3. New insert can't be mounted on the old tool body.

## WNMU 08 geometry introduction

Chip breaker	Cutting edge shape	Application
<b>MR2</b> Strong type		<ul style="list-style-type: none"> <li>Suitable for poor machining conditions</li> <li>High cutting edge reliability</li> <li>High feeding speed</li> </ul>
<b>MM4</b> General type		<ul style="list-style-type: none"> <li>Suitable for medium machining conditions</li> <li>Good geometry choice for general machining</li> </ul>
<b>MM3</b> Easy cutting type		<ul style="list-style-type: none"> <li>Suitable for good machining condition and finishing</li> <li>Low cutting force (used in low power machine)</li> </ul>

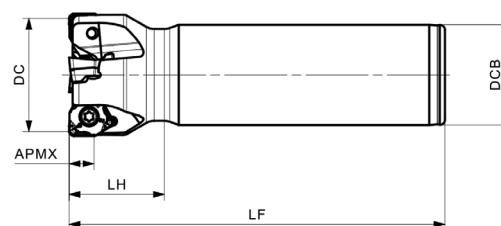
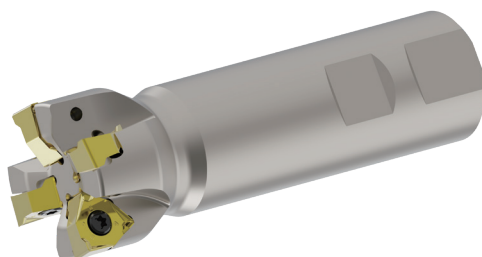
## WNMU 0806..Insert





Product code	Dimension(mm)				Grade				
	IC	S	RE	BS	AP251U	AP351M	AP403M	AC301K	AP251K
WNMU 080608R-MR2	12.5	6.60	0.8	2.3	●	●	●	▲	●
WNMU 080608R-MM4	12.5	6.58	0.8	2.3	●	●	●	▲	●
WNMU 080608R-MM3	12.5	6.58	0.8	2.3	●	●	●	▲	●
WNMU 080612R-MR2	12.5	6.47	1.2	1.19	●	●		▲	●
WNMU 080612R-MM4	12.5	6.47	1.2	1.18	●	●	●		●
WNMU 080616R-MR2	12.5	6.50	1.6	0.81	●		●		
WNMU 080616R-MM4	12.5	6.50	1.6	0.8	●		●		

● Stocked ▲ Stocked at present will be replaced in the future

## ASM90-WN08-N Cutter

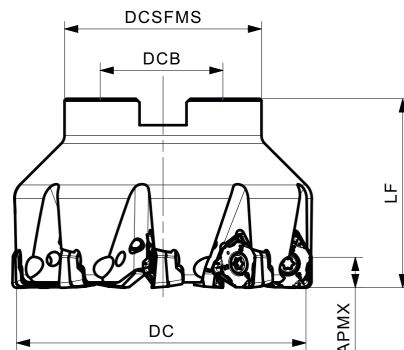
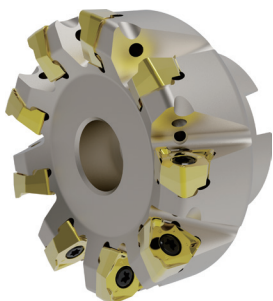


Cutter	DC	DCB	LF	LH	APMX	Coolant	Z	Insert
ASM90-040-Z03-W32R-WN08-N-C	40	32	120	35	7		3	WNMU 0806
ASM90-040-Z04-W32R-WN08-N-C	40	32	120	35	7		4	





● **ASM90-WN08-N Cutter**



Cutter	DC	DCB	LF	DCSFMS	APMX	Coolant	Z	Insert
ASM90-050-Z04-A22R-WN08-N-C	50	22	40	42	7		4	WNMU 0806
ASM90-050-Z05-A22R-WN08-N-C	50	22	40	42	7		5	
ASM90-063-Z04-A22R-WN08-N-C	63	22	40	48	7		4	
ASM90-063-Z06-A22R-WN08-N-C	63	22	40	48	7		6	
ASM90-063-Z07-A22R-WN08-N-C	63	22	40	48	7		7	
ASM90-080-Z05-A27R-WN08-N-C	80	27	50	62	7		5	
ASM90-080-Z07-A27R-WN08-N-C	80	27	50	62	7		7	
ASM90-080-Z09-A27R-WN08-N-C	80	27	50	62	7		9	
ASM90-100-Z06-A32R-WN08-N-C	100	32	50	80	7		6	
ASM90-100-Z08-A32R-WN08-N-C	100	32	50	80	7		8	
ASM90-100-Z11-A32R-WN08-N-C	100	32	50	80	7		11	
ASM90-125-Z07-A40R-WN08-N-C	125	40	63	87	7		7	
ASM90-125-Z11-A40R-WN08-N-C	125	40	63	87	7		11	
ASM90-125-Z13-A40R-WN08-N-C	125	40	63	87	7		13	
ASM90-160-Z08-A40R-WN08-N	160	40	63	107	7		8	
ASM90-160-Z12-A40R-WN08-N	160	40	63	107	7		12	
ASM90-200-Z14-A60R-WN08-N	200	60	63	140	7		14	
ASM90-250-Z16-A60R-WN08-N	250	60	63	180	7		16	

Size(mm)	Cutter spare parts		
Cutter diameter	Screw	Wrench	Torque
φ40-250			3.5Nm
	SP040112	DT-TP15	



## ASM90-WN08-N Success Stories

Workpiece: Axle case

Material: Nodular cast iron

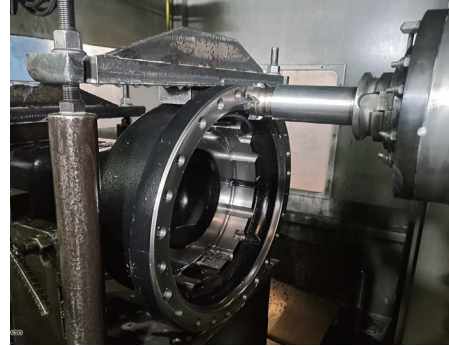
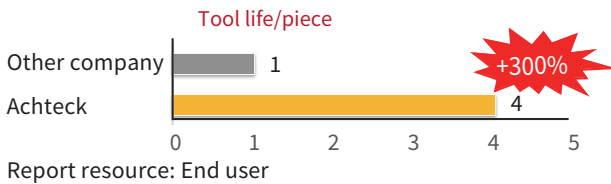
Insert: WNMU 080608R-MM4 AP251K

Cutter: ASM90-063-Z06-A22R-WN08-N-C

Operation: Milling big round surface

Cutting parameter:  $V_c=178$  m/min,  $a_p=2$  mm,  $a_e=38$  mm,  $f_z=0.2$  mm

Coolant: Wet cutting



Workpiece: Part of agricultural machine

Material: Grey cast iron

Insert: WNMU 080608R-MM4 AP251K

Cutter: ASM90-063-Z06-A22R-WN08-N-C

Operation: Milling installation slot

Cutting parameter:  $V_c=280$  m/min,  $a_p=2-3$  mm,  $a_e=50$  mm,  $f_z=0.2$  mm

Coolant: Wet

