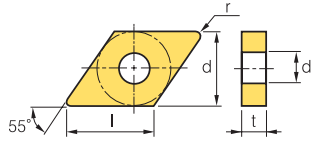


B Turning Insert (Negative)

DN

Rhombic **55° Negative**



Dimensions (mm)			
Size	d	t	d ₁
15	12.7	4.76~6.35	5.16

Workpiece	Material Compatibility												Machining types					
	Steel	P	M	K	N	S	H	●	●	●	●	●	●	●	●	●	●	●
Steel	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Stainless steel	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Cast iron	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Non-ferrous metal	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Heat resistant alloy, Titanium alloy	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Hardened steel	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Inserts	Designation	Cermets		Coated										Uncoated		Cutting Condition												
		CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	fn (mm/rev)	ap (mm)		
Roughing 	DNMG	150404-RM													●	●	●									0.10~0.50	2.00~6.00	
		150408-RM														●	●	●									0.15~0.55	2.00~6.00
		150412-RM														●	●	●									0.20~0.60	2.00~6.00
		150416-RM														●	●	●									0.25~0.70	2.00~6.00
		150604-RM														●	●	●									0.10~0.50	2.00~6.00
		150608-RM														●	●	●				●		●			0.15~0.55	2.00~6.00
		150612-RM														●	●	●									0.20~0.60	2.00~6.00
		150616-RM														●	●	●									0.25~0.70	2.00~6.00
Roughing 	DNMG	150408-VP4																								0.15~0.35	1.00~4.00	
		150412-VP4																								0.20~0.40	1.00~4.00	
		150608-VP4																					●			0.15~0.35	1.00~4.00	
		150612-VP4																					●			0.20~0.40	1.00~4.00	
Roughing 	DNMG	150408-VR																								0.25~0.55	1.20~7.00	
		150412-VR																								0.30~0.60	1.50~7.00	
		150608-VR																								0.25~0.55	1.20~7.00	
		150612-VR																								0.30~0.60	1.50~7.00	
Finishing 	DNMX	150404R-SR																								0.10~0.40	0.70~4.50	
		150408R-SR																									0.12~0.45	1.00~4.50
		150604R-SR																									0.10~0.40	0.70~4.50
		150608R-SR																									0.12~0.45	1.00~4.50
		150404L-SR																									0.10~0.40	0.70~4.50
		150408L-SR																									0.12~0.45	1.00~4.50
		150604L-SR																									0.10~0.40	0.70~4.50
		150608L-SR																									0.12~0.45	1.00~4.50
Medium cutting 	DNMX	150404R-SH																								0.15~0.30	1.00~4.00	
		150408R-SH																									0.15~0.50	1.50~5.00
		150604R-SH						●	●																		0.15~0.30	1.00~4.00
		150608R-SH						●	●																		0.15~0.50	1.50~5.00
		150404L-SH																									0.15~0.30	1.00~4.00
		150408L-SH																									0.15~0.50	1.50~5.00
		150604L-SH							●	●																	0.15~0.30	1.00~4.00
		150608L-SH							●	●																	0.15~0.50	1.50~5.00

Cutting edge geometry A52~A61 Recommended chip breaker B04~B11 Code system B26~B27 ● : Stock item

Available tool holders			
Designation	Page	Designation	Page
MCKNR/L	B171	MCRNR/L	B172
MCLNR/L	B171	PCBNR/L	B159
MCMNN	B171	PCLNR/L	B160

