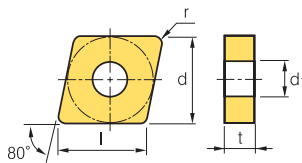


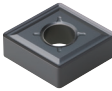
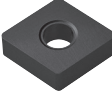
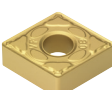
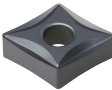
Turning Insert (Negative)

CN ○ ○



Dimensions (mm)			
Size	d	t	d _i
09	9.525	3.18	3.81
12	12.7	4.76	5.16
16	15.875	6.35	6.35
19	19.05	6.35	7.93

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

Inserts		Designation	Cermet			Coated		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)	
Finishing	VP1 	CNGG	120402-VP1																		●					0.01~0.10	0.10~1.00	
			120404-VP1																			●				0.05~0.15	0.10~1.50	
			120408-VP1																								0.07~0.20	0.10~1.50
Medium cutting	VP3 	CNGG	120404-VP3																	●	●	●		●		0.05~0.30	0.10~3.00	
			120408-VP3																	●	●	●		●		0.10~0.40	0.50~4.50	
			120412-VP3																		●	●	●		●		0.12~0.50	0.50~5.00
Roughing		CNMA	090308																							0.10~0.30	0.50~3.00	
			120404											●										●		0.15~0.60	1.00~5.00	
			120408										●	●										●		0.15~0.60	1.00~6.00	
			120412										●	●												0.15~0.70	1.50~6.00	
			120416										●	●												0.20~0.80	2.00~6.00	
			160608																							0.15~0.70	2.00~6.00	
			160612											●												0.15~0.70	2.00~6.00	
			160616											●												0.15~0.70	2.00~6.00	
			190608											●												0.15~0.70	2.00~10.00	
			190612											●												0.15~0.70	2.00~10.00	
			190616											●	●											0.20~1.00	3.00~10.00	
Finishing	VB 	CNMG	120404-VB	●		●	●	●	●		●															0.15~0.35	0.30~2.00	
			120408-VB	●		●	●	●	●		●															0.15~0.45	0.50~2.00	
			120412-VB						●		●															0.20~0.50	0.50~2.00	
Finishing	VF 	CNMG	090304-VF						●	●																0.07~0.30	0.50~1.50	
			090308-VF																							0.10~0.30	0.50~1.50	
			120404-VF						●			●														0.07~0.30	0.50~1.50	
			120408-VF								●															0.10~0.40	0.50~1.50	
			120412-VF																						0.10~0.50	0.60~1.50		
Finishing	VP1 	CNMG	120404-VP1																●	●			●		0.05~0.15	0.10~1.50		
			120408-VP1																	●	●			●		0.07~0.20	0.10~1.50	

 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

