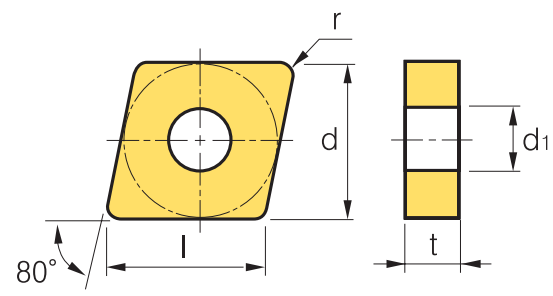
CN○○

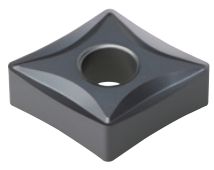
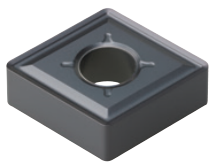
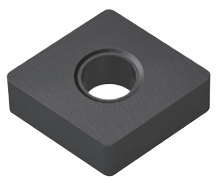
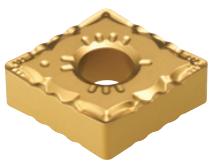
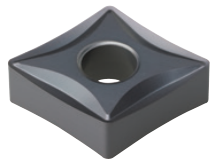
Rhombic 80° Negative



Dimensions (mm)			
Size	d	t	d_1
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			Cermet			Coated		Coated															Uncoated	
			CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05
Workpiece	Steel	P	●	⬌	⬍	●	⬌	●	⬌	⬌	⬍	⬍	●	●	⬌		⬍								
	Stainless steel	M									⬌	⬌			●	⬌	⬍	⬌	⬍		●	⬌	⬌		
	Cast iron	K	●	⬌	⬍	●	⬌	⬌				⬌	⬌	⬌										●	⬌
	Non-ferrous metal	N																						●	⬌
	Heat resistant alloy, Titanium alloy	S										●				●	●	⬌	⬍	●	●	⬌		●	⬌
	Hardened steel	H																			⬌	⬍		●	⬌

Machining types
- ● Continuous cutting
- ⬌ General cutting
- ⬍ Interrupted cutting

Inserts		Designation		Cutting Condition	
				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

● : Stock item