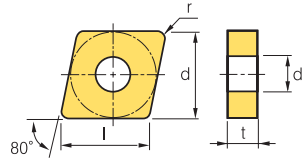


B Turning Insert (Negative)

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

	Inserts	Designation	Cermets		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	f _n (mm/rev)	a _p (mm)				
Finishing	VP1	CNGG 120402-VP1 120404-VP1 120408-VP1																										0.01~0.10	0.10~1.00		
																													0.05~0.15	0.10~1.50	
																														0.07~0.20	0.10~1.50
Medium cutting	VP3	CNGG 120404-VP3 120408-VP3 120412-VP3																											0.05~0.30	0.10~3.00	
																													0.10~0.40	0.50~4.50	
																														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 120408-VB 120412-VB																											0.15~0.35	0.30~2.00	
																													0.15~0.45	0.50~2.00	
																														0.20~0.50	0.50~2.00
Finishing	VF	CNMG 090304-VF 090308-VF 120404-VF 120408-VF 120412-VF																											0.07~0.30	0.50~1.50	
																														0.10~0.30	0.50~1.50
																														0.07~0.30	0.50~1.50
																														0.10~0.40	0.50~1.50
																															0.10~0.50
Finishing	VP1	CNMG 120404-VP1 120408-VP1																											0.05~0.15	0.10~1.50	
																													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

