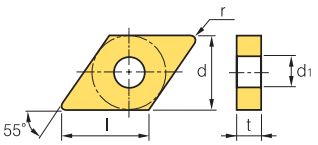
DN○○

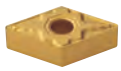
Rhombic 55° Negative



Dimensions (mm)			
Size	d	t	d_1
11	9.525	3.18~4.76	3.81
15	12.7	4.76~6.35	5.16

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		Cermet CN1500	Cermet CN2500	Coated CC1500	Coated CC2500	Coated NC3215P	NC3225P	NC3215	NC3225	NC3120	NC3030	NC3235	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC8105	PC8110	PC8115	PC9030	Uncoated H01	Uncoated H05	Cutting Condition fn (mm/rev)	Cutting Condition ap (mm)
Medium to finishing	CP new	DNMG	110404-CP																								0.08~0.30	0.40~3.00
			110408-CP																								0.10~0.30	0.40~3.00
			110504-CP																								0.08~0.30	0.40~3.00
			110508-CP																								0.10~0.30	0.40~3.00
			150404-CP					●	●																		0.10~0.35	0.50~3.50
			150408-CP					●	●																		0.12~0.35	0.50~3.50
			150412-CP					●	●																		0.13~0.35	0.80~3.50
			150604-CP					●	●																		0.10~0.35	0.50~3.50
			150608-CP					●	●																		0.12~0.35	0.50~3.50
			150612-CP					●	●																		0.13~0.35	0.80~3.50
Medium to finishing	VC	DNMG	150404-VC							●	●																0.10~0.35	0.30~2.00
			150408-VC							●	●				●												0.15~0.40	0.50~3.00
			150412-VC							●	●																0.15~0.45	0.50~3.00
			150604-VC							●	●																0.10~0.35	0.30~2.00
			150608-VC							●	●				●												0.15~0.40	0.50~3.00
			150612-VC							●	●																0.15~0.45	0.50~3.00
Medium cutting	HM 	DNMG	110404-HM										●											●			0.05~0.50	0.80~4.00
			110408-HM																					●			0.10~0.50	1.00~4.00
			150404-HM								●																0.05~0.30	0.90~5.00
			150408-HM									●															0.10~0.50	1.00~5.00
			150604-HM									●	●				●							●			0.05~0.30	0.90~5.00
			150608-HM								●	●	●											●			0.10~0.50	1.00~5.00
			150612-HM										●														0.18~0.50	1.00~5.00
Medium cutting	MP new	DNMG	110404-MP							●	●				●				●	●							0.10~0.40	0.40~3.80
			110408-MP							●	●				●				●	●							0.15~0.40	0.50~4.00
			110412-MP																								0.15~0.50	0.80~4.20
			110504-MP																								0.10~0.40	0.40~3.80
			110508-MP																								0.15~0.40	0.50~4.00
			110512-MP																								0.15~0.50	0.80~4.20
			150404-MP							●	●				●			●	●	●		●					0.10~0.40	0.40~4.00
			150408-MP							●	●				●			●	●	●	●	●					0.15~0.45	0.50~4.50
			150412-MP							●	●				●			●				●					0.15~0.50	0.80~5.00
			150416-MP																								0.15~0.50	0.85~5.00
			150604-MP							●	●				●	●		●	●	●	●	●					0.10~0.40	0.40~4.00
			150608-MP							●	●				●	●		●	●	●	●	●					0.15~0.45	0.50~4.50
			150612-MP							●	●				●			●	●	●	●	●					0.15~0.50	0.80~5.00
			150616-MP																								0.15~0.55	0.85~5.00

Cutting edge geometry A52~A61 Recommended chip breaker B04~B14 Code system B34~B35

● : Stock item

Available tool holders			
Designation	Page	Designation	Page
MCKNR/L	B183	MCRNR/L	B184
MCLNR/L	B183	PCBNR/L	B172
MCMNN	B183	PCLNR/L	B173