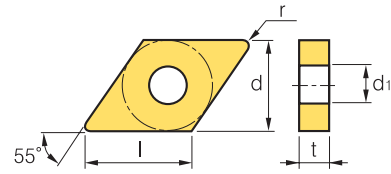


B Turning Insert (Negative)

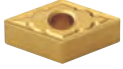





DN○○



Rhombic **55° Negative**



Workpiece	Steel	P	●	●	●	●	●	●	●	●	●	●	●	●	●	●	Machining types	● Continuous cutting ● General cutting ● Interrupted cutting
	Stainless steel	Yellow	●	●	●	●	●	●	●	●	●	●	●	●	●	●		
Cast iron	Green	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●		
Non-ferrous metal	Blue	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●		
Heat resistant alloy, Titanium alloy	Orange	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●		
Hardened steel	Grey	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●		

Inserts	Designation	Coated											Cermet	Coated	Uncoated	Dimensions (mm)					Cutting Condition		Available tool holders								
		NC3010	NC3120	NC3220	NC3030	NC9020	NC9025	NC5330	PC8110	PC5300	PC9030	NC6205	NC6210	NC315K	CN1000	CN2000	CN20	CC105	CC115	U20	H01	G10	l	d	t	r	d ₁	fn (mm/rev)	a _p (mm)	Designation	Page
 Medium Roughing	150404-GS																					15.1	12.7	4.76	0.4	5.16	0.07-0.40	1.00-5.00	MDJNR/L	B107	
	150408-GS																						14.7	12.7	4.76	0.8	5.16	0.10-0.50	1.00-5.00	MDNPN	B107
	150412-GS																						14.4	12.7	4.76	1.2	5.16	0.13-0.65	1.00-5.00	MDQNR/L	B108
	150604-GS					●			●	●													15.1	12.7	6.35	0.4	5.16	0.07-0.40	1.00-5.00	MDUNR/L	B132
	150608-GS						●		●	●	●												14.7	12.7	6.35	0.8	5.16	0.10-0.50	1.00-5.00	PDJNR/L	B96, 150
	150612-GS						●		●	●	●												14.4	12.7	6.35	1.2	5.16	0.10-0.65	1.00-5.00	PDNNR/L	B96
 Medium to finishing	150404-HA																					15.1	12.7	4.76	0.4	5.16	0.05-0.30	0.80-3.50	MDJNR/L	B107	
	150408-HA																						14.7	12.7	4.76	0.8	5.16	0.10-0.40	0.80-3.50	MDNPN	B107
	150604-HA																						15.1	12.7	6.35	0.4	5.16	0.05-0.30	0.80-3.50	MDQNR/L	B108
	150608-HA																						14.7	12.7	6.35	0.8	5.16	0.10-0.40	0.80-3.50	MDUNR/L	B132
 Medium to finishing	150404-HC																					15.1	12.7	4.76	0.4	5.16	0.05-0.30	0.05-3.50	MDJNR/L	B107	
	150408-HC																						14.7	12.7	4.76	0.8	5.16	0.08-0.40	0.80-4.00	MDNPN	B107
	150412-HC																						14.4	12.7	4.76	1.2	5.16	0.13-0.50	0.90-4.00	MDQNR/L	B108
	150604-HC																						15.1	12.7	6.35	0.4	5.16	0.05-0.30	0.80-4.00	MDUNR/L	B132
	150608-HC																						14.7	12.7	6.35	0.8	5.16	0.08-0.40	0.80-4.00	PDJNR/L	B96, 150
	150612-HC																						14.4	12.7	6.35	1.2	5.16	0.13-0.50	0.90-4.00	PDNNR/L	B96
 Roughing	150408-HR																					14.7	12.7	4.76	0.8	5.16	0.20-0.50	1.00-7.00	MDJNR/L	B107	
	150412-HR																						14.4	12.7	4.76	1.2	5.16	0.25-0.70	1.30-7.00	MDNPN	B107
	150416-HR																						14.0	12.7	4.76	1.6	5.16	0.30-0.75	1.80-7.00	MDQNR/L	B108
	150608-HR																						14.7	12.7	6.35	0.8	5.16	0.20-0.50	1.00-7.00	MDUNR/L	B132
	150612-HR																						14.4	12.7	6.35	1.2	5.16	0.25-0.70	1.30-7.00	PDJNR/L	B96, 150
	150616-HR																						14.0	12.7	6.35	1.6	5.16	0.20-0.75	1.80-7.00	PDNNR/L	B96
	190612-HR																						18.1	15.875	6.35	1.2	7.93	0.20-0.75	1.80-8.00	PDSNR/L	B128
 Medium	110404-HS																					11.2	9.525	4.76	0.4	3.81	0.05-0.35	0.80-2.50	MDJNR/L	B107	
	110408-HS																						10.8	9.525	4.76	0.8	3.81	0.10-0.40	1.00-2.50	MDNPN	B107
	150404-HS																						15.1	12.7	4.76	0.4	5.16	0.05-0.35	0.80-4.00	MDQNR/L	B108
	150408-HS																						14.7	12.7	4.76	0.8	5.16	0.10-0.40	1.00-4.00	MDUNR/L	B132
	150412-HS																						14.4	12.7	4.76	1.2	5.16	0.13-0.55	1.00-4.50	PDJNR/L	B96, 150
	150604-HS																						15.1	12.7	6.35	0.4	5.16	0.05-0.35	0.80-4.00	PDNNR/L	B96
	150608-HS																						14.7	12.7	6.35	0.8	5.16	0.10-0.40	1.00-4.50	PDSNR/L	B128
	150612-HS																						14.4	12.7	6.35	1.2	5.16	0.10-0.55	1.00-4.50	PDUNR/L	B129
 Medium (Wiper)	150408-LW																					14.7	12.7	4.76	0.8	5.16	0.15-0.50	0.70-4.50	MDJNR/L	B107	
	150412-LW																						14.4	12.7	4.76	1.2	5.16	0.20-0.60	1.00-5.00	MDNPN	B107
	150608-LW																						14.7	12.7	6.35	0.8	5.16	0.15-0.50	0.70-4.50	MDQNR/L	B108
	150612-LW																						14.4	12.7	6.35	1.2	5.16	0.20-0.60	1.00-5.00	MDUNR/L	B132