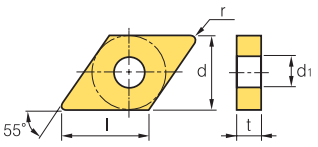
DN ○○

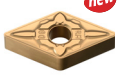
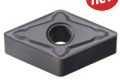
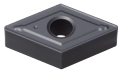
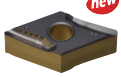
Rhombic 55° Negative



Dimensions (mm)			
Size	d	t	d1
15	12.7	4.76~6.35	5.16

Workpiece			CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05
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	CN2000	CN2500	Coated CC1500	CC2500	Coated NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	Uncoated H01	H05	Cutting Condition fn (mm/rev)	ap (mm)
Roughing	RM new 	DNMG	150404-RM														●	●	●				●				0.10~0.50	2.00~6.00
			150408-RM													●	●	●	●				●				0.15~0.55	2.00~6.00
			150412-RM													●	●	●	●				●				0.20~0.60	2.00~6.00
			150416-RM																								0.25~0.70	2.00~6.00
			150604-RM														●	●	●				●	●			0.10~0.50	2.00~6.00
			150608-RM													●	●	●				●		●			0.15~0.55	2.00~6.00
			150612-RM													●	●	●									0.20~0.60	2.00~6.00
			150616-RM																								0.25~0.70	2.00~6.00
Roughing	VP4 new 	DNMG	150408-VP4																								0.15~0.35	1.00~4.00
			150412-VP4																								0.20~0.40	1.00~4.00
			150608-VP4																				●				0.15~0.35	1.00~4.00
			150612-VP4																				●				0.20~0.40	1.00~4.00
Roughing	VR 	DNMG	150408-VR																								0.25~0.55	1.20~7.00
			150412-VR																								0.30~0.60	1.50~7.00
			150608-VR																								0.25~0.55	1.20~7.00
			150612-VR																								0.30~0.60	1.50~7.00
Finishing	SR new  [Shaft]	DNMX	150404R-SR																								0.10~0.40	0.70~4.50
			150408R-SR																								0.12~0.45	1.00~4.50
			150604R-SR																								0.10~0.40	0.70~4.50
			150608R-SR																								0.12~0.45	1.00~4.50
			150404L-SR																								0.10~0.40	0.70~4.50
			150408L-SR																								0.12~0.45	1.00~4.50
			150604L-SR																								0.10~0.40	0.70~4.50
			150608L-SR																								0.12~0.45	1.00~4.50
Medium cutting	SH [Shaft]	DNMX	150404R-SH																								0.15~0.30	1.00~4.00
			150408R-SH																								0.15~0.50	1.50~5.00
			150604R-SH						●		●																0.15~0.30	1.00~4.00
			150608R-SH						●		●																0.15~0.50	1.50~5.00
			150404L-SH																								0.15~0.30	1.00~4.00
			150408L-SH																								0.15~0.50	1.50~5.00
			150604L-SH						●		●																0.15~0.30	1.00~4.00
			150608L-SH						●		●																0.15~0.50	1.50~5.00

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