

TURNING	DN	CARBIDE Negative				ISO513	HC-CVD								HC-PVD		HW	HT					
		Size	IC	S	D1	P	JC7010	JC7020	JC8005	JC8015	JC8025	JC8035	JC9010	JC9025	JPS015	JPS025	JP9015	JP9030	JU6020	JU4015			
		MICRO DN	7.00	3.18	3.60	M			200 380	180 360	140 300	100 240			80 220	60 180				200 380			
		1104□□	9.525	4.76	3.81	K	180 380	150 300					150 280	120 240		80 160	60 120	100 220	80 200		160 280		
		1506□□	12.70	6.35	5.16	N														500 1500			
						S										40 80							
					H																		
	GRADE APPLICATION AREA	Stable machining, continuous cut				+	-	+	-	+	-	+	-	+	-	+	-	+	-	+	-	+	
	<div style="width: 10px; height: 10px; background-color: orange; display: inline-block;"></div> main application	General machining, light interruption				-	+	-	+	-	+	-	+	-	+	-	+	-	+	-	+		
	<div style="width: 10px; height: 10px; background-color: lightorange; display: inline-block;"></div> applicable	Unstable machining, interrupted cut				+	-	+	-	+	-	+	-	+	-	+	-	+	-	+	-		

FINISHING	GB P M		MICRO	DN.R04-GB%/L	RE 0.4	a_p	0.20	0.50	0.80															
				f_n	0.05	0.10	0.15								▽									
		NSP P	DNMG 110404-NSP 110408-NSP	RE 0.4 RE 0.8																				
				DNMG 150604-NSP 150608-NSP	RE 0.4 RE 0.8																			
		NFP P	DNMG 110408-NFP	RE 0.8																				
				DNMG 110404-NFM 110408-NFM	RE 0.4 RE 0.8																			
	NFM M	DNMG 150604-NFM 150608-NFM	RE 0.4 RE 0.8																					
		GM P M	MICRO DN.R04-GM DN.R08-GM	RE 0.4 RE 0.8																				
	SS M	MICRO DN.R02-SS DN.R04-SS	RE 0.2 RE 0.4																					
	NMU P M	DNMG 150604%-NMU 150608%-NMU	RE 0.4 RE 0.8																					

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion



DN	CARBIDE Negative				ISO513	HC-CVD								HC-PVD		HW	HT					
	Size	IC	S	D1		JC7010	JC7020	JC8005	JC8015	JC8025	JC8035	JC9010	JC9025	JPS015	JPS025					JPS015	JPS030	JU6020
					P			200 380	180 360	140 300	100 240			80 220	60 180			200 380				
	MICRO DN	7.00	3.18	3.60	M						150 280	120 240	80 160	60 120	100 220	80 200		160 280				
	1104 □□	9.525	4.76	3.81	K	180 380	150 300							80 170				200 400				
	1506 □□	12.70	6.35	5.16	N												500 1500					
					S								40 80									
				H																		
GRADE APPLICATION AREA	Stable machining, continuous cut				+																	
main application	General machining, light interruption				-																	
applicable	Unstable machining, interrupted cut				+																	
MEDIUM	NMP P	DNMG 110404-NMP	RE 0.4	a _p 1.00 f _n 0.10	1.50 0.15	2.00 0.20																
			RE 0.8	a _p 1.00 f _n 0.15	1.50 0.20	2.00 0.25	●															
		DNMG 150604-NMP	RE 0.4	a _p 1.50 f _n 0.12	2.50 0.20	3.50 0.28																
			RE 0.8	a _p 1.50 f _n 0.16	2.50 0.25	3.50 0.34																
		DNMG 150612-NMP	RE 1.2	a _p 1.50 f _n 0.20	2.50 0.30	3.50 0.40																
			RE 1.6	a _p 1.50 f _n 0.25	2.50 0.35	3.50 0.45																
	NUP P M	DNMG 110404-NUP	RE 0.4	a _p 0.70 f _n 0.08	1.50 0.15	2.30 0.22														●		
			RE 0.8	a _p 0.70 f _n 0.12	1.50 0.20	2.30 0.28														●		
			RE 1.2	a _p 0.70 f _n 0.15	1.50 0.25	2.30 0.35															●	
		DNMG 150604-NUP	RE 0.4	a _p 1.00 f _n 0.10	2.50 0.20	4.00 0.30			●	●	●				●						●	
			RE 0.8	a _p 1.00 f _n 0.15	2.50 0.25	4.00 0.35			●	●	●				●						●	
			RE 1.2	a _p 1.00 f _n 0.18	2.50 0.30	4.00 0.42			●	●	●				●						●	
	NMM M	DNMG 110404-NMM	RE 0.4	a _p 0.70 f _n 0.13	1.50 0.20	2.30 0.27														○		
			RE 0.8	a _p 0.70 f _n 0.18	1.50 0.25	2.30 0.32														●		
		DNMG 150604-NMM	RE 0.4	a _p 1.00 f _n 0.15	2.50 0.25	4.00 0.35															●	
			RE 0.8	a _p 1.00 f _n 0.20	2.50 0.30	4.00 0.40															●	
		DNMG 150612-NMM	RE 1.2	a _p 1.00 f _n 0.25	2.50 0.35	4.00 0.45															●	
	NMK K	DNMG 150604-NMK	RE 0.4	a _p 0.50 f _n 0.10	2.00 0.20	3.50 0.30	●	○														
			RE 0.8	a _p 0.50 f _n 0.15	2.00 0.25	3.50 0.35	●	○														
		DNMG 150612-NMK	RE 1.2	a _p 0.50 f _n 0.20	2.00 0.30	3.50 0.40	○	○														
	NMN N	DNMG 150604-NMN	RE 0.4	a _p 0.50 f _n 0.10	2.00 0.20	3.50 0.30														●		
			RE 0.8	a _p 0.50 f _n 0.15	2.00 0.25	3.50 0.35														●		

● stock standard, ○ non-standard stock



- TURNING
- THREADING
- GROOVING
- MILLING
- DRILLING
- ACCESSORIES

TURNING		CARBIDE Negative				ISO513	HC-CVD								HC-PVD		HW	HT					
		Size	IC	S	D1		P	JC7010	JC7020	JC8005	JC8015	JC8025	JC8035	JC9010	JC9025	JPS015	JPS025	JP9015	JP9030	JU6020	JU4015		
		MICRO DN	7.00	3.18	3.60		M			200 380	180 360	140 300	100 240	150 280	120 240	80 220	60 180	100 220	80 200		200 380	160 380	
		1104□	9.525	4.76	3.81	K	180 380	150 300						80 170					200 400				
		1506□	12.70	6.35	5.16	N													500 1500				
						S								40 80									
						H																	
THREADING	GRADE APPLICATION AREA	Stable machining, continuous cut				+ Hardness - Toughness 																	
	main application	General machining, light interruption																					
	applicable	Unstable machining, interrupted cut																					
ROUGHING		DNMG	150608-NRP	RE 0.8	a_p 2.00 f_n 0.25	4.00 0.35	6.00 0.45																
			150612-NRP	RE 1.2	a_p 2.00 f_n 0.30	4.00 0.40	6.00 0.50																
			150616-NRP	RE 1.6	a_p 2.00 f_n 0.35	4.00 0.45	6.00 0.55																
		DNMG	150612-NTP	RE 1.2	a_p 3.00 f_n 0.35	5.00 0.45	7.00 0.55																
MILLING		DNMG	150608-NRK	RE 0.8	a_p 1.50 f_n 0.20	4.00 0.30	6.50 0.40	●	○														
			150612-NRK	RE 1.2	a_p 1.50 f_n 0.25	4.00 0.35	6.50 0.45	●	○														
DRILLING		DNMA	150608	RE 0.8	a_p 2.00 f_n 0.25	4.00 0.35	6.00 0.45	●	○														
			150612	RE 1.2	a_p 2.00 f_n 0.35	4.00 0.45	6.00 0.55	●	○														

● stock standard, ○ non-standard stock, ▽ stock exhaustion

