

TURNING	WN		CARBIDE Negative				ISO513	HC-CVD							HW	HT						
			Size	IC	S	D1		P	JC7010	JC7020	JC8005	JC8015	JC8025	JC8035			JC9010	JC9025	JPS015	JPS030	JU6020	JU4015
THREADING			0604	9,525	4,76	3,81	M			200/380	180/360	140/300	100/240									
			0804	12,70	4,76	5,16	K	180/380	150/300					150/280	120/240	100/220	80/200		200/400			
GROOVING							N										500/1500					
							S															
MILLING	GRADE APPLICATION AREA		Stable machining, continuous cut						P													
			General machining, light interruption						M													
DRILLING			Unstable machining, interrupted cut						K													
									N													
ACCESSORIES			WNGM	060404-NSP	RE 0.4	a _p : 0.30 f _n : 0.06	0.70 0.12	1.10 0.18											●			
				060408-NSP	RE 0.8	a _p : 0.30 f _n : 0.08	0.70 0.16	1.10 0.24												●		
			WNGM	060404-NFP	RE 0.4	a _p : 0.40 f _n : 0.08	1.20 0.15	2.00 0.22			●	●							●			
				080408-NFP	RE 0.8	a _p : 0.40 f _n : 0.10	1.20 0.22	2.00 0.34			●	●	●							●		
			WNGM	060404-NFM	RE 0.4	a _p : 0.50 f _n : 0.05	1.00 0.10	1.50 0.15				▽										
				060408-NFM	RE 0.8	a _p : 0.50 f _n : 0.07	1.00 0.14	1.50 0.21				▽										
			WNGM	080404-NFM	RE 0.4	a _p : 0.50 f _n : 0.06	1.50 0.12	2.50 0.18				▽										
				080408-NFM	RE 0.8	a _p : 0.50 f _n : 0.08	1.50 0.17	2.50 0.26				▽										
			WNGM	060404-NMP	RE 0.4	a _p : 0.30 f _n : 0.05	0.70 0.10	1.10 0.15										●				
				060408-NMP	RE 0.8	a _p : 0.30 f _n : 0.07	0.70 0.15	1.10 0.23											●			
			WNGM	080404-NMP	RE 0.4	a _p : 0.40 f _n : 0.08	1.20 0.14	2.00 0.20											●			
				080408-NMP	RE 0.8	a _p : 0.40 f _n : 0.10	1.20 0.20	2.00 0.30											●			
			WNGM	060404-NUP	RE 0.4	a _p : 0.70 f _n : 0.08	1.50 0.15	2.30 0.22											●			
				060408-NUP	RE 0.8	a _p : 0.70 f _n : 0.12	1.50 0.20	2.30 0.28			○	●	●							●		
		WNGM	080404-NUP	RE 0.4	a _p : 1.00 f _n : 0.10	2.50 0.20	4.00 0.30				●	●	●		●				●			
			080408-NUP	RE 0.8	a _p : 1.00 f _n : 0.15	2.50 0.25	4.00 0.35				●	●	●		●					●		
		WNGM	060404-NMM	RE 0.4	a _p : 0.70 f _n : 0.13	1.50 0.20	2.30 0.27										○					
			060408-NMM	RE 0.8	a _p : 0.70 f _n : 0.18	1.50 0.25	2.30 0.32											●				
		WNGM	060412-NMM	RE 1.2	a _p : 0.70 f _n : 0.20	1.50 0.28	2.30 0.36															
			060416-NMM	RE 1.6	a _p : 1.00 f _n : 0.25	2.50 0.35	3.50 0.45															

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



WN	CARBIDE Negative				ISO513	HC-CVD								HC-PVD	HW	HT							
	Size	IC	S	D1		P	JC7010	JC7020	JC8005	JC8015	JC8025	JC8035	JC9010	JC9025	JPS015	JPS030	JU6020	JU4015					
<p>6 edges</p>	0604□	9.525	4.76	3.81	P			200 380	180 360	140 300	100 240							200 380					
	0604□	9.525	4.76	3.81	M						150 280	120 240	100 220	80 200				160 280					
	0804□	12.70	4.76	5.16	K	180 380	150 300											200 400					
					N													500 1500					
					S																		
				H																			
GRADE APPLICATION AREA	Stable machining, continuous cut				+																		
main application	General machining, light interruption				-																		
applicable	Unstable machining, interrupted cut				+																		

MEDIUM	NMM M	WNMG	080404-NMM	RE 0.4	a _p 1.00 f _n 0.15	2.50 0.25	4.00 0.35												▽		
			080408-NMM	RE 0.8	a _p 1.00 f _n 0.20	2.50 0.30	4.00 0.40												▽		
			080412-NMM	RE 1.2	a _p 1.00 f _n 0.25	2.50 0.35	4.00 0.45														
	NMK K	WNMG	080404-NMK	RE 0.4	a _p 0.50 f _n 0.10	2.00 0.20	3.50 0.30	●	○												
			080408-NMK	RE 0.8	a _p 0.50 f _n 0.15	2.00 0.25	3.50 0.35	●	●												
			080412-NMK	RE 1.2	a _p 0.50 f _n 0.20	2.00 0.30	3.50 0.40	●	●												
	NWU P K	WNMG	080408-NWU	RE 0.8	a _p 0.80 f _n 0.20	2.00 0.40	3.20 0.60	●			●										
			080412-NWU	RE 1.2	a _p 0.80 f _n 0.25	2.00 0.45	3.20 0.65	●				●									
	NMN N	WNGG	060404-NMN	RE 0.4	a _p 0.30 f _n 0.08	1.00 0.15	1.70 0.22												●		
			060408-NMN	RE 0.8	a _p 0.30 f _n 0.10	1.00 0.20	1.70 0.30													●	
		WNGG	080404-NMN	RE 0.4	a _p 0.50 f _n 0.10	2.00 0.20	3.50 0.30													●	
			080408-NMN	RE 0.8	a _p 0.50 f _n 0.15	2.00 0.25	3.50 0.35													●	
			080412-NMN	RE 1.2	a _p 0.50 f _n 0.20	2.00 0.30	3.50 0.40													●	

ROUGHING	NRP P	WNMG	080408-NRP	RE 0.8	a _p 2.00 f _n 0.25	4.00 0.35	6.00 0.45													
			080412-NRP	RE 1.2	a _p 2.00 f _n 0.30	4.00 0.40	6.00 0.50				●	●	●	●						
			080416-NRP	RE 1.6	a _p 2.00 f _n 0.35	4.00 0.45	6.00 0.55					●	●	●						
	NTP P	WNMG	080408-NTP	RE 0.8	a _p 3.00 f _n 0.30	5.00 0.40	7.00 0.50													

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



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

TURNING	WN	CARBIDE Negative				ISO513	HC-CVD								HC-PVD	HW	HT	
		Size	IC	S	D1		JC7010	JC7020	JC8005	JC8015	JC8025	JC8035	JC9010	JC9025				JP9015
THREADING						P			200 380	180 360	140 300	100 240					200 380	
		0604□	9.525	4.76	3.81	M						150 280	120 240	100 220	80 200		160 280	
		0804□	12.70	4.76	5.16	K	180 380	150 300									200 400	
						N										500 1500		
GROOVING		WNMG 060408-NRK	RE 0.8	a _p 1.00 f _n 0.15	2.00 0.25	3.00 0.35	●	●										
		WNMG 080408-NRK	RE 0.8	a _p 1.50 f _n 0.20	4.00 0.30	6.50 0.40	●	●										
		080412-NRK	RE 1.2	a _p 1.50 f _n 0.25	4.00 0.35	6.50 0.45	●	●										
MILLING		WNMA 080408	RE 0.8	a _p 2.00 f _n 0.25	4.00 0.35	6.00 0.45	●	○										
		080412	RE 1.2	a _p 2.00 f _n 0.35	4.00 0.45	6.00 0.55	●	○										
		080416	RE 1.6	a _p 2.00 f _n 0.45	4.00 0.55	6.00 0.65	●	○										

● stock standard, ○ non-standard stock

