

SN	CARBIDE Negative				ISO513	HC-CVD								HC-PVD	HW	HT					
	Size	IC	S	D1		JC7010	JC7020	JC8005	JC8015	JC8025	JC8035	JC9010	JC9025	JP9015	JP9030	JU6020					JU4015
					<b>P</b>			200 380	180 360	140 300	100 240										
	0903□	9.525	3.18	3.81	<b>M</b>						150 280	120 240	100 220	80 200		200 380					
	1204□	12.70	4.76	5.16	<b>K</b>	180 380	150 300									160 280					
	1906□	19.05	6.35	7.94	<b>N</b>											500 1500					
	2509□	25.40	9.52	8.80	<b>S</b>																
						<b>H</b>															
GRADE APPLICATION AREA	Stable machining, continuous cut																				
main application	General machining, light interruption																				
applicable	Unstable machining, interrupted cut																				
FINISHING	NSP <b>P</b>		SNMG	120404-NSP	RE 0.4	a <sub>p</sub> 0.40 f <sub>n</sub> 0.08	1.20 0.15	2.00 0.22													
				120408-NSP	RE 0.8	a <sub>p</sub> 0.40 f <sub>n</sub> 0.10	1.20 0.22	2.00 0.34													
	NFP <b>P</b>		SNMG	120404-NFP	RE 0.4	a <sub>p</sub> 0.50 f <sub>n</sub> 0.06	1.50 0.12	2.50 0.18			▽	▽									
				120408-NFP	RE 0.8	a <sub>p</sub> 0.50 f <sub>n</sub> 0.08	1.50 0.17	2.50 0.26			▽										
	NFM <b>M</b>		SNMG	120404-NFM	RE 0.4	a <sub>p</sub> 0.40 f <sub>n</sub> 0.08	1.20 0.14	2.00 0.20						●							
				120408-NFM	RE 0.8	a <sub>p</sub> 0.40 f <sub>n</sub> 0.10	1.20 0.20	2.00 0.30							●						
MEDIUM	NMP <b>P</b>		SNMG	120404-NMP	RE 0.4	a <sub>p</sub> 1.50 f <sub>n</sub> 0.12	2.50 0.20	3.50 0.28			●	●									
				120408-NMP	RE 0.8	a <sub>p</sub> 1.50 f <sub>n</sub> 0.16	2.50 0.25	3.50 0.34			●	●									
				120412-NMP	RE 1.2	a <sub>p</sub> 1.50 f <sub>n</sub> 0.20	2.50 0.30	3.50 0.40			●	●									
				120416-NMP	RE 1.6	a <sub>p</sub> 1.50 f <sub>n</sub> 0.25	2.50 0.35	3.50 0.45			○	○									
	NUP <b>P</b>		SNMG	120404-NUP	RE 0.4	a <sub>p</sub> 1.00 f <sub>n</sub> 0.10	2.50 0.20	4.00 0.30			○	○									
				120408-NUP	RE 0.8	a <sub>p</sub> 1.00 f <sub>n</sub> 0.15	2.50 0.25	4.00 0.35			○	●									
				120412-NUP	RE 1.2	a <sub>p</sub> 1.00 f <sub>n</sub> 0.18	2.50 0.30	4.00 0.42			○	●									
				120416-NUP	RE 1.6	a <sub>p</sub> 1.00 f <sub>n</sub> 0.20	2.50 0.35	4.00 0.50			○	○									
NMU <b>P</b>		SNMG	120408%-NMU	RE 0.8	a <sub>p</sub> 1.00 f <sub>n</sub> 0.20	2.50 0.30	4.00 0.40			○											
NMM <b>M</b>		SNMG	120404-NMM	RE 0.4	a <sub>p</sub> 1.00 f <sub>n</sub> 0.15	2.50 0.25	4.00 0.35						●	○							
			120408-NMM	RE 0.8	a <sub>p</sub> 1.00 f <sub>n</sub> 0.20	2.50 0.30	4.00 0.40							●	○						
			120412-NMM	RE 1.2	a <sub>p</sub> 1.00 f <sub>n</sub> 0.25	2.50 0.35	4.00 0.45							○	○						
			120416-NMM	RE 1.6	a <sub>p</sub> 1.00 f <sub>n</sub> 0.30	2.50 0.40	4.00 0.50							○	○						

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



TURNING

THREADING

GROOVING

MILLING

DRILLING

ACCESSORIES

TURNING	SN	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
								180 380	150 300	200 380	180 360	140 300	100 240	150 280				120 240	100 220	80 200	500 1500	200 380
		0903□	9.525	3.18	3.81	M																
		1204□	12.70	4.76	5.16	K																
		1906□	19.05	6.35	7.94	N																
		2509□	25.40	9.52	8.80	S																
						H																
THREADING	GRADE APPLICATION AREA	Stable machining, continuous cut																				
		main application																				
		applicable																				
MEDIUM	NMM <b>M</b>		SNMG 190612-NMM	RE 1.2	a <sub>p</sub> : 3.00 f <sub>n</sub> : 0.35	6.00 0.45	9.00 0.55															
			190616-NMM	RE 1.6	a <sub>p</sub> : 3.00 f <sub>n</sub> : 0.40	6.00 0.50	9.00 0.60															
	NMK <b>K</b>		SNMG 120408-NMK	RE 0.8	a <sub>p</sub> : 0.50 f <sub>n</sub> : 0.15	2.00 0.25	3.50 0.35	●	○													
			120412-NMK	RE 1.2	a <sub>p</sub> : 0.50 f <sub>n</sub> : 0.20	2.00 0.30	3.50 0.40	●	○													
	NMN <b>N</b>		SNGG 120404-NMN	RE 0.4	a <sub>p</sub> : 0.50 f <sub>n</sub> : 0.10	2.00 0.20	3.50 0.30															
			120408-NMN	RE 0.8	a <sub>p</sub> : 0.50 f <sub>n</sub> : 0.15	2.00 0.25	3.50 0.35															
120412-NMN			RE 1.2	a <sub>p</sub> : 0.50 f <sub>n</sub> : 0.20	2.00 0.30	3.50 0.40																
ROUGHING	NRP <b>P</b>		SNMG 120408-NRP	RE 0.8	a <sub>p</sub> : 2.00 f <sub>n</sub> : 0.25	4.00 0.35	6.00 0.45															
			120412-NRP	RE 1.2	a <sub>p</sub> : 2.00 f <sub>n</sub> : 0.30	4.00 0.40	6.00 0.50															
			120416-NRP	RE 1.6	a <sub>p</sub> : 2.00 f <sub>n</sub> : 0.35	4.00 0.45	6.00 0.55															
			SNMG 190612-NRP	RE 1.2	a <sub>p</sub> : 6.00 f <sub>n</sub> : 0.40	8.00 0.55	10.0 0.70															
			190616-NRP	RE 1.6	a <sub>p</sub> : 6.00 f <sub>n</sub> : 0.45	8.00 0.60	10.0 0.75															
			190624-NRP	RE 2.4	a <sub>p</sub> : 6.00 f <sub>n</sub> : 0.50	8.00 0.65	10.0 0.80															
			SNMG 120408-NTP	RE 0.8	a <sub>p</sub> : 3.00 f <sub>n</sub> : 0.30	5.00 0.40	7.00 0.50															
NRK <b>K</b>		SNMG 120408-NRK	RE 0.8	a <sub>p</sub> : 1.50 f <sub>n</sub> : 0.20	4.00 0.30	6.50 0.40	●	○														
		120412-NRK	RE 1.2	a <sub>p</sub> : 1.50 f <sub>n</sub> : 0.25	4.00 0.35	6.50 0.45	●	○														
		120416-NRK	RE 1.6	a <sub>p</sub> : 1.50 f <sub>n</sub> : 0.30	4.00 0.40	6.50 0.50	●	●														
		SNMG 190612-NRK	RE 1.2	a <sub>p</sub> : 5.00 f <sub>n</sub> : 0.45	8.00 0.60	11.0 0.75	○	○														
		190616-NRK	RE 1.6	a <sub>p</sub> : 5.00 f <sub>n</sub> : 0.50	8.00 0.65	11.0 0.80	○	○														

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



SN	CARBIDE Negative				ISO513	HC-CVD								HC-PVD	HW	HT	
	Size	IC	S	D1		JC7010	JC7020	JC8005	JC8015	JC8025	JC8035	JC9010	JC9025	JP9015	JP9030	JU6020	JU4015
<p>8 edges</p>					<b>P</b>			200 380	180 360	140 300	100 240						200 380
	<b>0903</b>	9.525	3.18	3.81	<b>M</b>						150 280	120 240	100 220	80 200			160 280
	<b>1204</b>	12.70	4.76	5.16	<b>K</b>	180 380	150 300										200 400
	<b>1906</b>	19.05	6.35	7.94	<b>N</b>											500 1500	
	<b>2509</b>	25.40	9.52	8.80	<b>S</b>												
GRADE APPLICATION AREA	Stable machining, continuous cut				<b>H</b>												
main application	General machining, light interruption																
applicable	Unstable machining, interrupted cut																
<b>ROUGHING</b> <b>Flat <span style="color:red">K</span></b> 	SNMA 090308	RE 0.8	a <sub>p</sub> 1.00 f <sub>n</sub> 0.22	<b>2.00</b> <b>0.30</b>	3.00 0.38	○											
	SNMA 120408	RE 0.8	a <sub>p</sub> 2.00 f <sub>n</sub> 0.25	<b>4.00</b> <b>0.35</b>	6.00 0.45	● ○											
	120412	RE 1.2	a <sub>p</sub> 2.00 f <sub>n</sub> 0.35	<b>4.00</b> <b>0.45</b>	6.00 0.55	● ○											
	120416	RE 1.6	a <sub>p</sub> 2.00 f <sub>n</sub> 0.45	<b>4.00</b> <b>0.55</b>	6.00 0.65	● ○											
<b>HEAVY ROUGHING</b> <b>MRP <span style="color:blue">P</span></b> <p>4 edges, single side</p>	SNMM 190616-MRP	RE 1.6	a <sub>p</sub> 6.00 f <sub>n</sub> 0.60	<b>9.00</b> <b>0.75</b>	12.0 0.90				○ ○								
	190624-MRP	RE 2.4	a <sub>p</sub> 6.00 f <sub>n</sub> 0.65	<b>9.00</b> <b>0.80</b>	12.0 0.95				● ●								
	SNMM 250924-MRP	RE 2.4	a <sub>p</sub> 8.00 f <sub>n</sub> 0.70	<b>12.0</b> <b>0.85</b>	16.0 1.00				● ●								

● stock standard, ○ non-standard stock

TURNING

THREADING

GROOVING

MILLING

DRILLING

ACCESSORIES

