DIA EDGE
TOOL NEWS
2025.2 Update
B266B

CVD Coated Grade for Steel Turning

Environmentally Friendly Product

MC6100 Series

Chipbreaker Addition

Bringing the Ultimate High Speed Cutting Performance

MC6115
MC6125
MC6135
+
FP, FPH
MP
LP



MITSUBISHI MATERIALS CORPORATION

CVD Coated Grade for Steel Turning

MC6100 Series

Dramatic increase in stability and wear resistance, enabled by utilising the improved coating adhesion and crystal orientation technology.

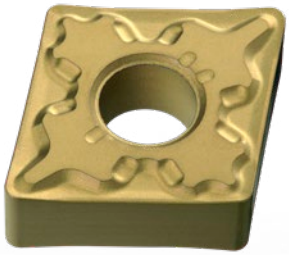
For High Speed Turning
MC6115



First Recommendation
MC6125



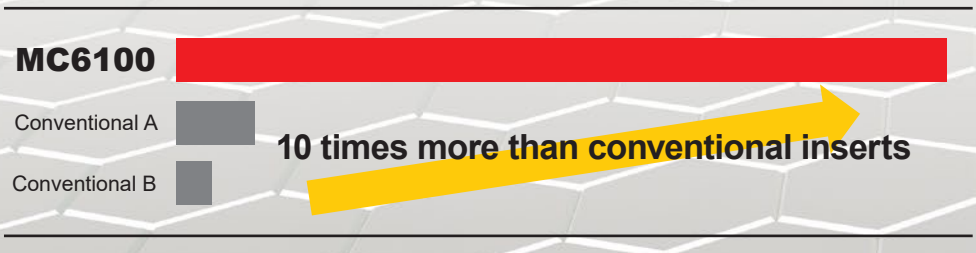
For Fracture Resistance
MC6135



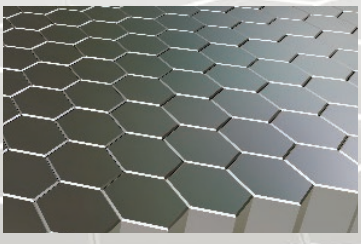
Features

"Super" Nano Texture Technology

The standard Nano Texture Technology has been improved and developed to be an industry leading standard for crystal growth of Al_2O_3 coatings. This Super Nano Texture Technology increases tool life and wear resistance due to the fine, dense crystal growth process.



The ratio of Al_2O_3 crystal grains with the same orientation



*By Image



Conventional CVD inserts

Grain size and growth direction are uneven.



Nano Texture

Uniformity of the grain size and growth direction has improved.



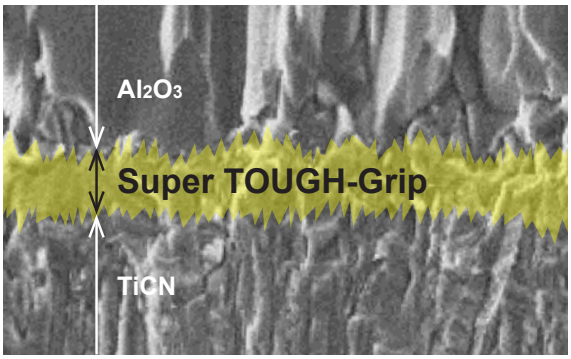
"Super" Nano Texture

Uniformity of the growth direction has drastically improved.

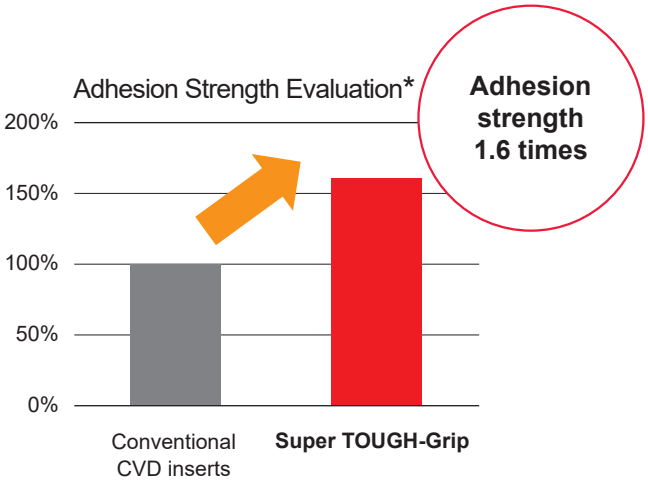
Crystal Orientation

Super TOUGH-Grip

The Super TOUGH-Grip layer has finer crystal grains that enhance the strength of the adhesion between the coating layers.



*By Image



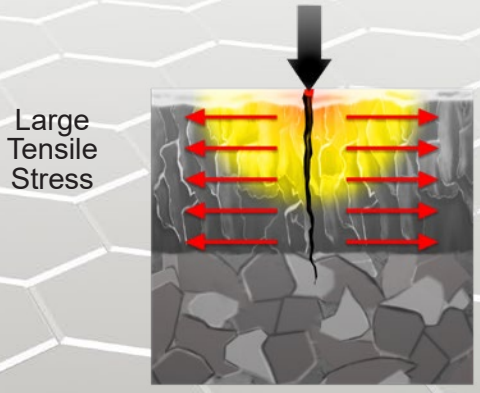
*Adhesion strength measurement is obtained from a scratch test that records the force needed to peel the coating layers.

Protection Against Sudden Fracturing

Cracks that occur during unstable machining are prevented due to the relaxing of the tensile stress in the coating. MC6100 series has an 80% reduction in coating tensile stress compared to conventional CVD inserts.

Relaxing of the Tensile Stress

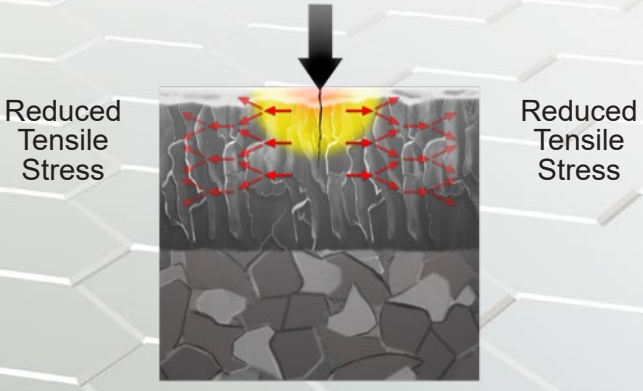
Impact Stress During Machining



Conventional CVD inserts

Cracks are generated in the surface of coatings during machining. They propagate through the coating into the substrate due to the large tensile stress in the coating structure. This creates one of the main causes of sudden insert breakage.

Impact Stress During Machining



MC6100 Series

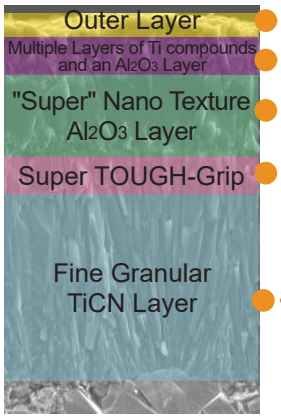
MC6100 series has a much lower level of stress than conventional CVD coatings due to the surface treatment. This divides the force of impacts during machining and protects from sudden fracturing.

CVD Coated Grade for Steel Turning

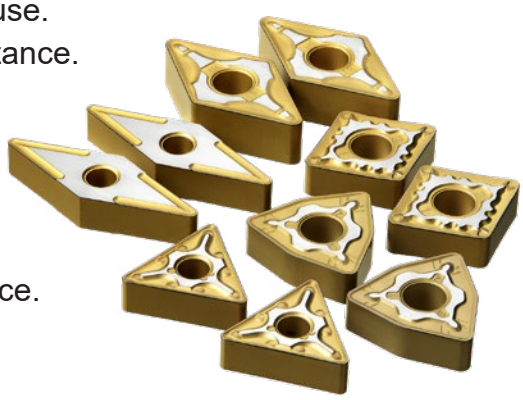
MC6125

Please refer to the last page for more information on certified environmentally friendly products.

First recommended grade for steel turning. Increasing tool life with stable performance over a wider range of applications.



- Better identification of corner use.
- Achieves excellent wear resistance.
- Outstanding wear resistance especially at high temperatures.
- Strong adhesion between the tough coating layers.
- Coating for high wear resistance.

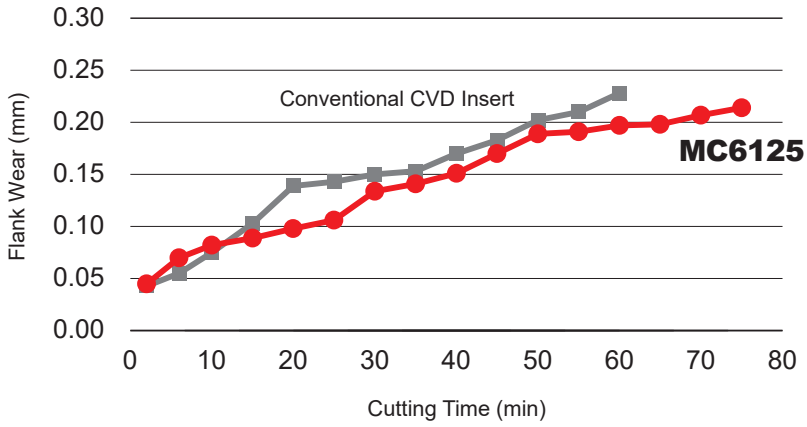


Special Smooth Surface Treatment

MC6125 uses a new surface treatment for the cutting edge for increased stability. Additionally, the seating faces also have a special smooth surface treatment that provides improved clamping stability to enable a wider range of applications.

Machining S45C : Comparison of Wear Resistance

The surface treatment has improved stability and provided longer tool life.



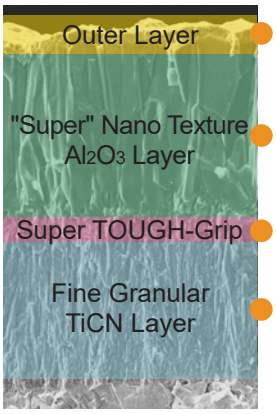
<Cutting Conditions>
Material : JIS S45C
Inserts : CNMG120408-MA
Cutting Speed : vc = 200 m/min
Feed per Rev. : f =0.3 mm/rev
Depth of Cut : ap = 1.5 mm
Cutting Mode : Wet Cutting

CVD Coated Grade for Steel Turning

MC6115

Please refer to the last page for more information on certified environmentally friendly products.

MC6115 improves high speed machining and process efficiency with a dramatic increase in resistance to wear and heat.



Better identification of corner use.

Outstanding wear resistance especially at high temperatures.

Strong adhesion between the tough coating layers.

Coating for high wear resistance.



Improved Outer Coating (Layer)

The outer layer of MC6115 restricts chip welding thereby improving the dimensional accuracy and surface roughness of components. This also enables easy recognition of whether the corner can continue machining.

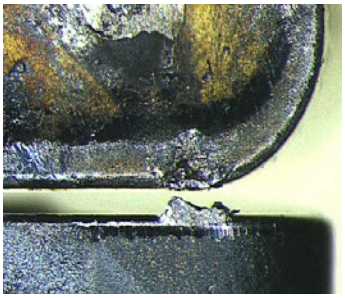
Example when machining Scr420H

When comparing the high edge strength chipbreaker MH with a conventional low resistance chipbreaker, it shows that MC6115 accomplishes both high welding and wear resistance.

After 2 Minutes Machining



MC6115 MH



Conventional CVD Insert

<Cutting Conditions>
Material : JIS SCr420H 170HB
Inserts : CNMG120408-MH
Cutting Speed : vc = 200 m/min
Feed per Rev. : f =0.3 mm/rev
Depth of Cut : ap = 1.5 mm
Cutting Mode : Dry Cutting

CVD Coated Grade for Steel Turning

MC6135 NEW

Optimal versatility for machining of continuous through to intermittent applications.

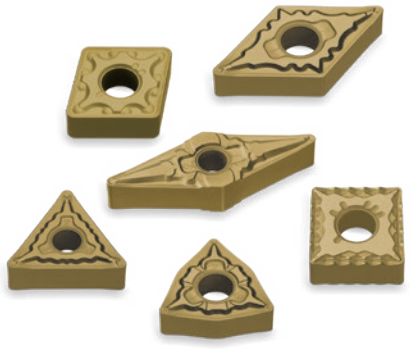


Better identification of corner use.

Outstanding wear resistance especially at high temperatures.

Strong adhesion between the tough coating layers.

Coating for high wear resistance.

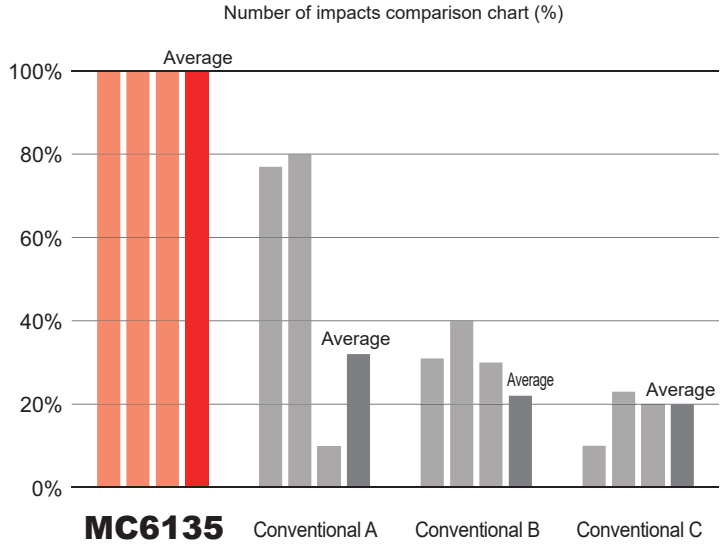


Thinner Coatings Optimised for General Purpose Machining

Industry-leading crystal orientation control technology enables thinner but still impact-resistant coatings provide improved chipping and wear resistance which is optimal for general-purpose use. (50% thinner compared to our conventional coating).

Machining SCM440 : Comparison of Toughness During Interrupted Cutting

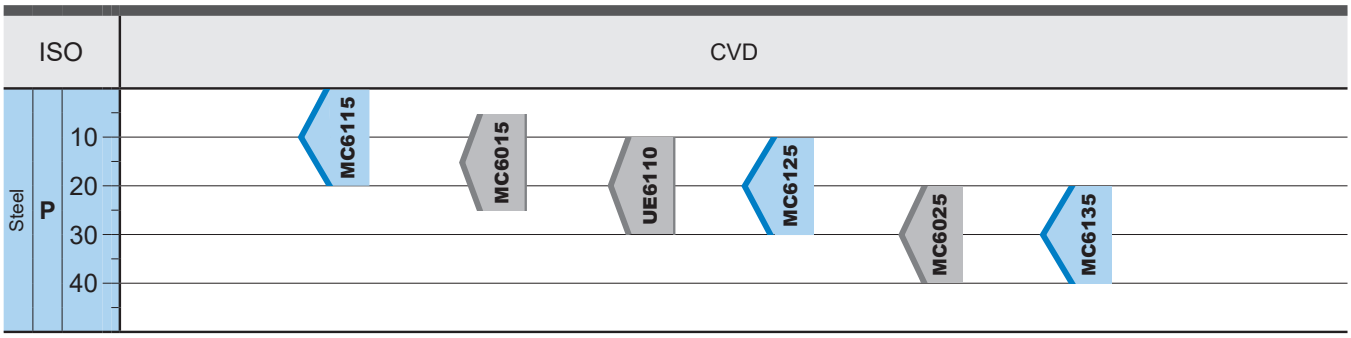
MC6135 shows high stability even during interrupted cutting and can be used over a wide area of applications.



<Cutting Conditions>
Material : JIS SCM440
Inserts : CNMG120408-◯◯
Cutting Speed : vc=200m/min
Feed per Rev. : f=0.35mm/rev
Depth of Cut : 2.5mm
Cutting Mode : Wet Cutting

Pre-set tool life limit or until damage deteriorates the performance.

Application Range



Selection Criteria

	Material	Cutting Mode	Grade
P	Steel	Continuous Cutting ↑ Low Medium ↓ High Interrupted Cutting	**MC6115**
			MC6125
			MC6135

for Low Depth of Cut and High Feed Finishing

FPH Chipbreaker

The combination of a positive land cutting edge shape and a two-stage protrusion optimises chip generation at low depths of cut, high feed conditions, thereby reducing machining times.

Main Convex

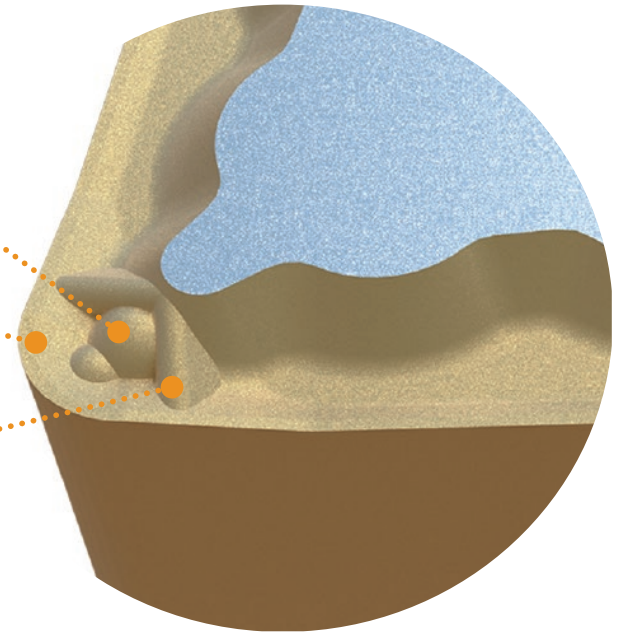
Provides consistent chip curling effect even for the thicker chips produced at high feed rates.

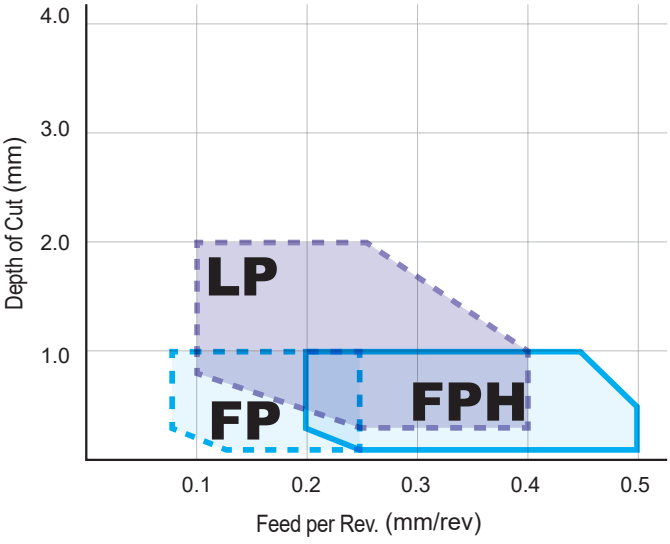
Positive Land

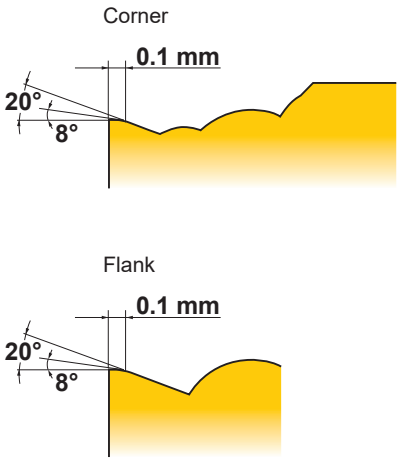
Optimum balance of sharpness and fracture resistance.

Sub Convex

Enables good chip breaking when copy turning with varying depths of cut.







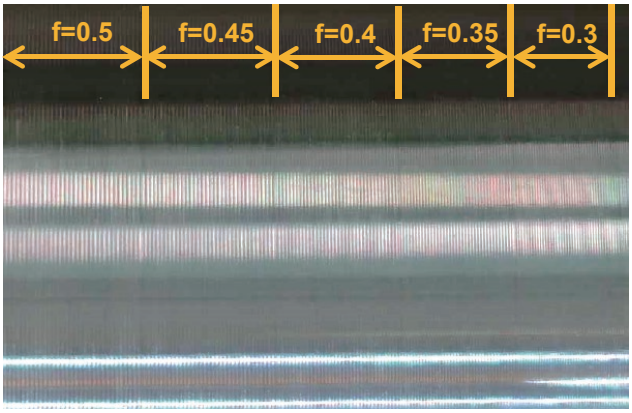
HOW TO USE

1. When using the FPH chipbreaker, keep the depth of cut to 1 mm or less and the feed rate per revolution to 0.2 mm/rev or more.
2. If the depth of cut is 1mm or more, we recommend using an LP chipbreaker.
3. If the feed rate per revolution is less than 0.2 mm/rev, we recommend an FP chipbreaker.

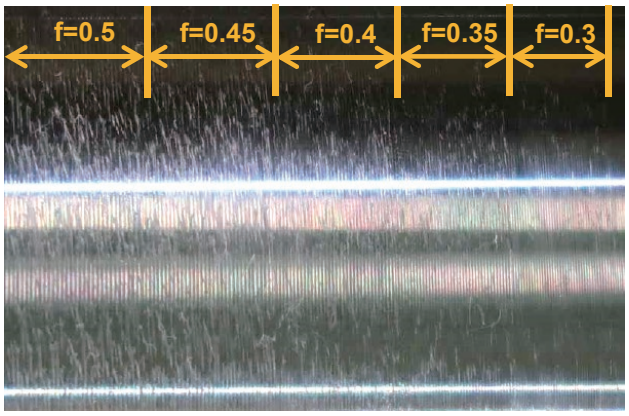
Cutting Performance

SCM440 : Comparison of Chips and Finished Surface

The FPH chipbreaker has excellent chip breaking properties, Therefore a good component surface finish can always be expected.



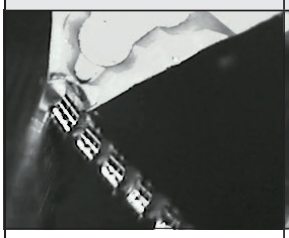
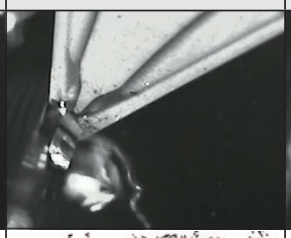
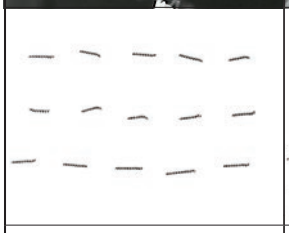
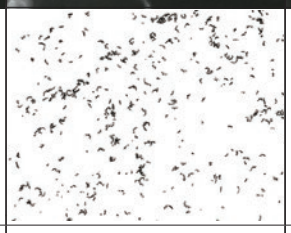
MC6135+FPH

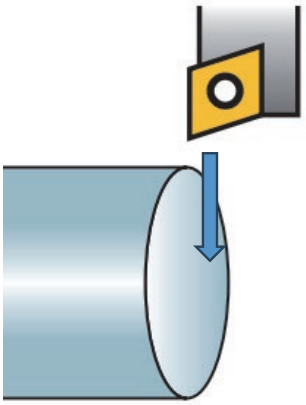


Conventional

<Cutting Conditions>
Material : JIS SCM440
Inserts : CNMG120408-◯◯ MC6125
Cutting Speed : vc=200m/min
Depth of Cut : 0.2mm
Feed per Rev. : f=The fluctuation values are shown in the image.
Cutting Mode : Wet Cutting

Chip Comparison

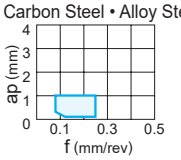
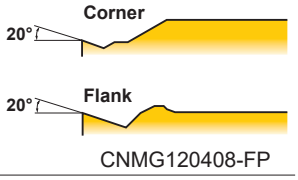
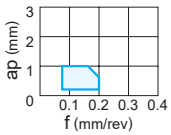
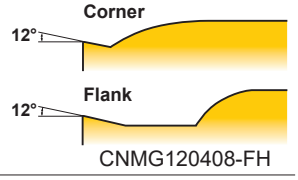
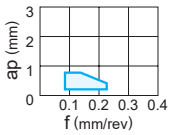
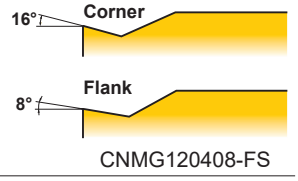
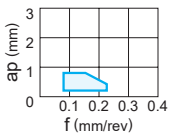
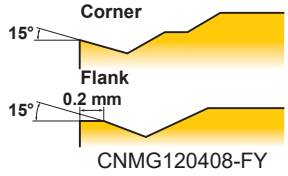
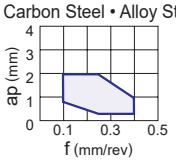
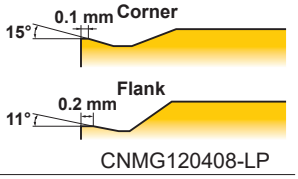
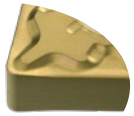
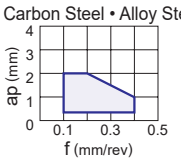
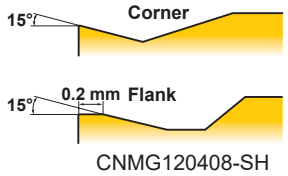
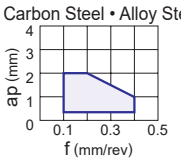
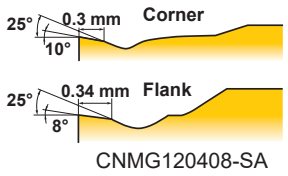
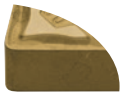
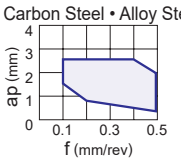
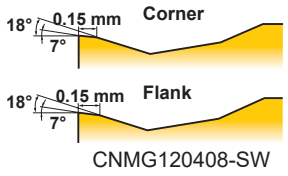
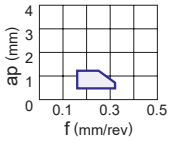
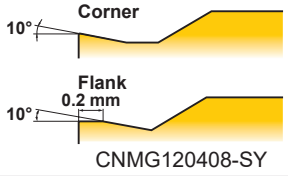
FPH	Conventional finish cutting chipbreaker	Conventional light cutting chipbreaker
		
		
Broken into pieces of ideal length.	Excessive division This is a condition where the finished surface is prone to scratches.	Long chips are being generated. There is a high risk of it wrapping around the workpiece and interrupting the machining process

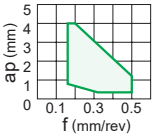
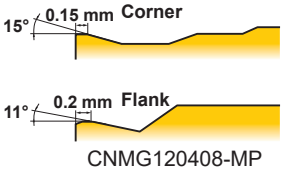
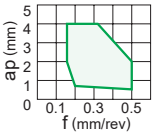
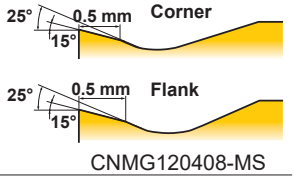
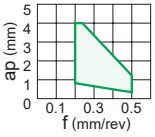
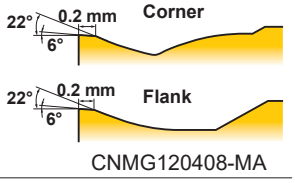
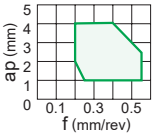
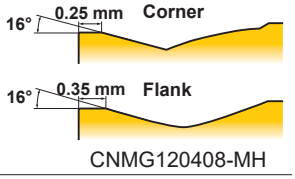
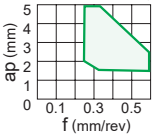
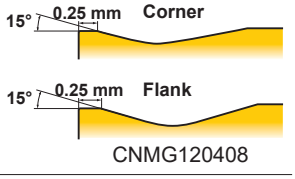
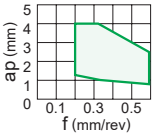
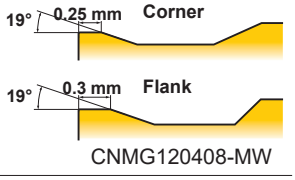
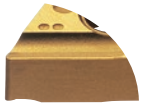
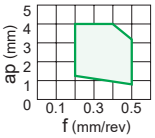
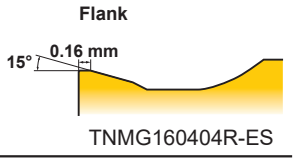
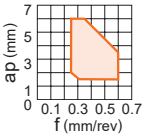
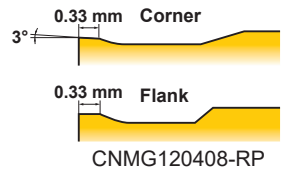
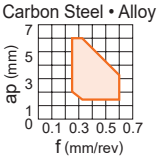
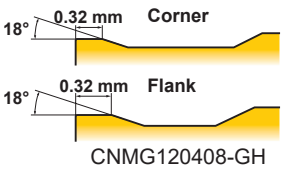


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Inserts : DNMG150408-◯◯
Cutting Speed : vc=200m/min
Depth of Cut : 0.2mm
Feed per Rev. : f=0.3mm/rev
Cutting Mode : Dry Cutting

Chipbreaker System for Steel Turning

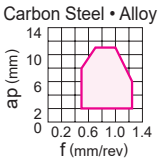
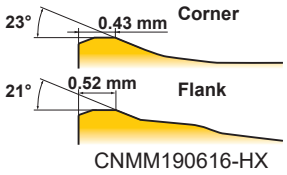
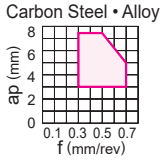
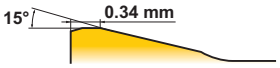
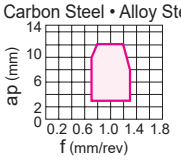
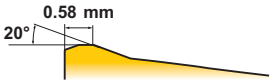
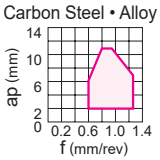
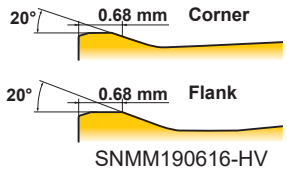
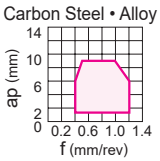
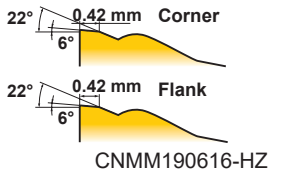
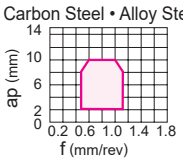
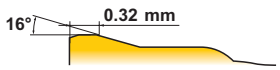
Negative Inserts

Application	Tolerance	Chipbreaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	M	**FP** 	**First recommendation for finishing carbon steel and alloy steel** Controls chip clogging during high-feed cutting and prevents chips of soft workpiece materials from running onto their surfaces. Large rake angle suppress chatter, vibration and deformation when machining low rigidity workpieces.	Carbon Steel • Alloy Steel   CNMG120408-FP
		FH 	**Alternative chipbreaker for finishing carbon steel and alloy steel** Stable chip control even at small depths of cut.	Carbon Steel • Alloy Steel   CNMG120408-FH
		FS 	**Alternative chipbreaker for finishing mild steel** Stable chip control even at small depths of cut. Sharp edge gives best performance.	Mild Steel   CNMG120408-FS
		FY 	**First recommendation for finishing mild steel** Effectively controls adhesive chips. Suitable for mild steel finishing.	Mild Steel   CNMG120408-FY
Light Cutting	M	**LP** 	**First recommendation for light cutting of carbon steel and alloy steel** Stable chip control in the light cutting area. The curved edge allows smooth chip discharge.	Carbon Steel • Alloy Steel   CNMG120408-LP
		SH 	**Alternative chipbreaker for light cutting of carbon steel and alloy steel** Can be used at low depth of cuts and high feed rates. The curved edge allows smooth chip discharge. Recommended for workpieces in the 160—250HB range.	Carbon Steel • Alloy Steel   CNMG120408-SH
		SA 	**Alternative chipbreaker for light cutting of carbon steel and alloy steel** Superior chip control at small depth of cuts. Covers copying and back turning with wavy edge. Recommended for workpieces in the 200—300HB range.	Carbon Steel • Alloy Steel   CNMG120408-SA
		SW 	**Wiper insert for light cutting of carbon steel, alloy steel, stainless steel and cast iron** In comparison to conventional chipbreakers, the surface finish is maintained even if the feed per revolution is doubled. Wiper design for increased productivity and improved surface finish.	Carbon Steel • Alloy Steel   CNMG120408-SW
		SY 	**First recommendation for light cutting of mild steel** Effectively controls adhesive chips. Suitable for light cutting of mild steel.	Mild Steel   CNMG120408-SY

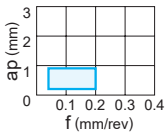
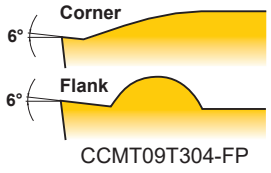
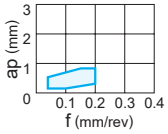
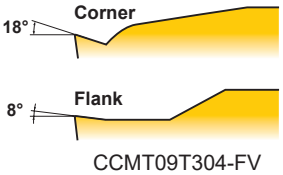
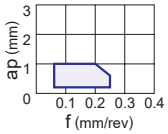
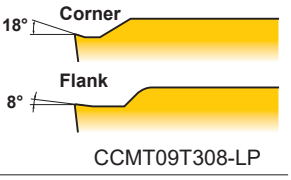
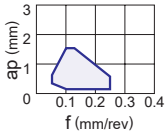
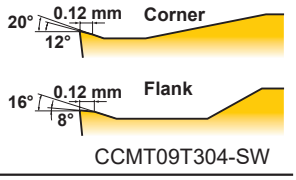
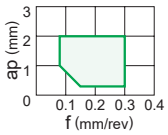
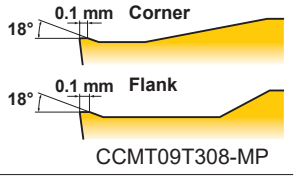
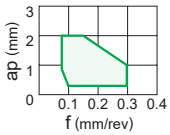
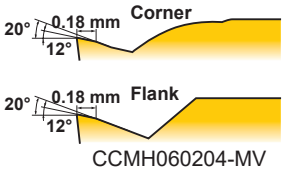
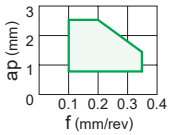
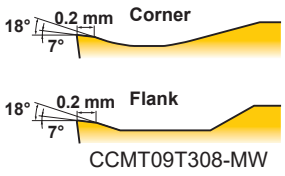
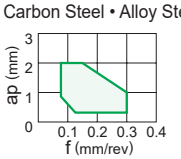
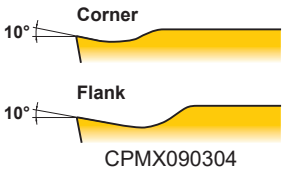
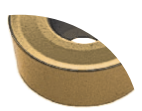
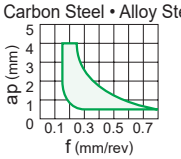
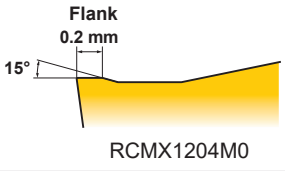
Application	Tolerance	Chipbreaker Name and Picture	Features	Cross Section Geometry
Medium Cutting	M	**MP** 	**First recommendation for medium cutting of carbon steel and alloy steel** Suitable for medium to light cutting. Chipbreaker geometry appropriate for copying and back turning. Cutting edge geometry for an optimum balance of sharpness and fracture resistance.	Carbon Steel • Alloy Steel   CNMG120408-MP
		MS 	**Alternative chipbreaker for medium cutting** The sharp edge gives best performance. Flat top chipbreaker shape offers high edge strength. Applicable to grades other than MP9005, MP9015, MP9025, MT9015	Carbon Steel • Alloy Steel   CNMG120408-MS
		MA 	**Multi-Assist chipbreaker for medium cutting of carbon steel and alloy steel** Ideal for general cutting applications. Positive land provides sharp cutting action.	Carbon Steel • Alloy Steel   CNMG120408-MA
		MH 	**Alternative chipbreaker for medium cutting of carbon steel and alloy steel** Flat land offers high edge strength. Good chip control enabled by a suitable chip pocket.	Carbon Steel • Alloy Steel   CNMG120408-MH
		Standard 	**Alternative chipbreaker for medium cutting of carbon steel and alloy steel** Flat land offers high edge strength. Flat top chipbreaker shape offers high edge strength.	Carbon Steel • Alloy Steel   CNMG120408
		MW 	**Wiper insert for medium cutting of carbon steel, alloy steel, stainless steel and cast iron** The wiper allows up to two times higher feed. A wide chip pocket prevents chip jamming.	Carbon Steel • Alloy Steel   CNMG120408-MW
		R/L-ES 	**Alternative chipbreaker for medium cutting of stainless steel** Good balance of edge strength and sharpness. Right- or left-hand chipbreaker for unidirectional chip control.	Stainless Steel   TNMG160404R-ES
Rough Cutting	M	**RP** 	**First recommendation for rough cutting of carbon steel and alloy steel** For interrupted cuts and removing scale. Good balance of cutting edge strength and low cutting resistance because of suitable rake angle.	Carbon Steel • Alloy Steel   CNMG120408-RP
		GH 	**Alternative chipbreaker for rough cutting of carbon steel, alloy steel and cast iron** For interrupted cuts and removing scale. A combination of wide land and a large chip pocket allows high feed rates.	Carbon Steel • Alloy Steel   CNMG120408-GH

Chipbreaker System for Steel Turning

Negative Inserts

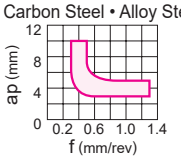
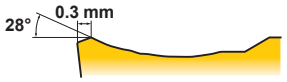
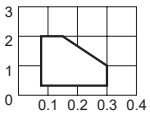
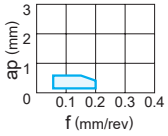
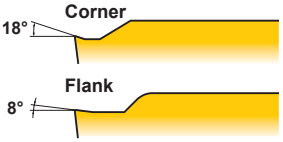
Application	Tolerance	Chipbreaker Name and Picture	Features	Cross Section Geometry
Heavy Cutting	M	**HX** 	**First recommendation for heavy cutting of carbon steel and alloy steel** Covers the medium range of the heavy cutting region. Owing to the straight edge and chamfer, it gives a balance of sharpness and strength. Variable land and a wavy chipbreaker for good chip control.	  CNMM190616-HX
		HL 	**First recommendation for heavy cutting** **Alternative chipbreaker for heavy cutting of carbon steel and alloy steel** Low resistance due to narrow flat land. Achieves high chip breaking ability.	  CNMM190616-HL
		HR 	**Alternative chipbreaker for heavy cutting of carbon steel and alloy steel** High cutting edge strength. Excellent chip discharge even with high feed and high depth of cut.	  CNMM250924-HR
		HV 	**Alternative chipbreaker for heavy cutting of carbon steel and alloy steel** Covers the upper end of the heavy cutting area. Wide land and large chamfer offer high edge strength. A wide chipbreaker prevents chip jamming.	  SNMM190616-HV
		HZ 	**Alternative chipbreaker for heavy cutting of carbon steel and alloy steel** Covers the lower end of the heavy cutting area. Low cutting resistance due to positive land and curved edge. Teardrop dots improve chip control without increasing cutting resistance.	  CNMM190616-HZ
		HM 	**Alternative chipbreaker for heavy cutting of carbon steel and alloy steel and stainless steel** Flat land provides outstanding balance between cutting edge strength and sharpness.	  CNMM190616-HM

Positive Inserts

Application	Tolerance	Chipbreaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	M	**FP** 	**First recommendation for finishing carbon steel, alloy steel and mild steel** Chipbreaker protrusion at the corner tip controls chips even at small depths of cut. Maintains the edge strength at the corner and prevents sudden fractures.	Carbon Steel • Alloy Steel   CCMT09T304-FP
		FV 	**Alternative chipbreaker for finishing carbon steel, alloy steel, mild steel and stainless steel** Suitable for low depths of cut and low feed rates. Sharp cutting edge and low resistance design achieves excellent cutting performance.	Carbon Steel • Alloy Steel   CCMT09T304-FV
Light Cutting	M	**LP** 	**First recommendation for light cutting of carbon steel, alloy steel and mild steel** Sharp cutting edge due to a large rake angle. Prevents welding of the insert and controls white turbidity of the surface finish. Chipbreaker protrusion suitable for depth of cut area achieves a wide range of chip control.	Carbon Steel • Alloy Steel   CCMT09T308-LP
		SW 	**Wiper insert for light cutting of carbon steel, alloy steel, mild steel and stainless steel** In comparison to conventional chipbreakers, the surface finish is maintained even if the feed per revolution is doubled. Positive land improves sharpness.	Carbon Steel • Alloy Steel   CCMT09T304-SW
Medium Cutting	M	**MP** 	**First recommendation for medium cutting of carbon steel, alloy steel and mild steel** Good balance of wear resistance and fracture resistance because of the flat land cutting edge. A wide chip pocket controls increases of cutting resistance and reduces vibration and chip jamming even at large depths of cut.	Carbon Steel • Alloy Steel   CCMT09T308-MP
		MV 	**Alternative chipbreaker for medium cutting of carbon steel, alloy steel, mild steel and stainless steel** A positive insert and the large rake angle achieve sharp cutting edge performance. The double chipbreaker and round shape in the rake face achieves a wide range of effective chip discharge.	Carbon Steel • Alloy Steel   CCMH060204-MV
		MW 	**Wiper insert for medium cutting of carbon steel, alloy steel, mild steel and stainless steel** The wiper allows up to two times higher feed. A wide chip pocket prevents chip jamming.	Carbon Steel • Alloy Steel   CCMT09T308-MW
		Standard 	**Alternative chipbreaker for medium cutting of carbon steel, alloy steel and stainless steel** Standard, general purpose chipbreaker.	Carbon Steel • Alloy Steel   CPMX090304
		Standard 	**Alternative chipbreaker for medium cutting of carbon steel, alloy steel, mild steel, stainless steel and cast iron** Balance of edge strength and sharpness due to a combination of a flat land and large rake angle.	Carbon Steel • Alloy Steel   RCMX1204M0

Chipbreaker System for Steel Turning

Positive Inserts

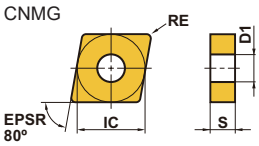
Application	Tolerance	Chipbreaker Name and Picture	Features	Cross Section Geometry
Heavy Cutting	M	**RR** 	**Chipbreaker for heavy cutting of carbon steel and alloy steel** A wide groove chipbreaker prevents chips from jamming at large depths of cut. Small dimples improve chip control at small depths of cut.	Carbon Steel • Alloy Steel   RCMX2006M0-RR
Strong Cutting Edge	M	**Flat Top** 	**Chipbreaker for Heavy cutting** Flat top. Most effective for unstable machining due to its high edge strength.	  SPMW120308
Finish Cutting	M	**SVX** 	**Alternative chipbreaker for light cutting of carbon steel and alloy steel** Chip control is improved by having a chipbreaker geometry suitable for copying.	Carbon Steel • Alloy Steel   XCMT150304-SVX

● : Inventory maintained in Japan.
(10 inserts in one case)

MC6100 Series

Negative Inserts (With Hole)

M Class



Finish	Finish	Finish	Finish	Finish	Light
FPH	FP	FH	FS	FY	LP
					
Light	**Light**	**Light**	**Light**	**Medium**	**Medium**
SH	SA	SW	SY	MP	MS
		 (Wiper)			

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CNMG120404-FPH	F	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-FPH	F	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-FPH	F	●	●	●	12.7	4.76	1.2	5.16
CNMG120402-FP	F	●	●	●	12.7	4.76	0.2	5.16
CNMG120404-FP	F	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-FP	F	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-FP	F	●	●	●	12.7	4.76	1.2	5.16
CNMG120402-FH	F	●	●	●	12.7	4.76	0.2	5.16
CNMG120404-FH	F	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-FH	F	●	●		12.7	4.76	0.8	5.16
CNMG120404-FS	F		●	●	12.7	4.76	0.4	5.16
CNMG120404-FY	F	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-FY	F	●	●	●	12.7	4.76	0.8	5.16
CNMG120404-LP	L	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-LP	L	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-LP	L	●	●	●	12.7	4.76	1.2	5.16
CNMG09T304-SH	L	●	●		9.525	3.97	0.4	3.81
CNMG09T308-SH	L	●	●		9.525	3.97	0.8	3.81
CNMG120404-SH	L	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-SH	L	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-SH	L	●	●	●	12.7	4.76	1.2	5.16
CNMG120404-SA	L	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-SA	L	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-SA	L	●	●	●	12.7	4.76	1.2	5.16
CNMG120404-SW	L	●	●		12.7	4.76	0.4	5.16
CNMG120408-SW	L	●	●		12.7	4.76	0.8	5.16
CNMG120412-SW	L	●	●		12.7	4.76	1.2	5.16
CNMG120404-SY	L	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-SY	L	●	●	●	12.7	4.76	0.8	5.16

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CNMG120404-MP	M	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-MP	M	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-MP	M	●	●	●	12.7	4.76	1.2	5.16
CNMG120416-MP	M	●	●	●	12.7	4.76	1.6	5.16
CNMG160608-MP	M	●	●	●	15.875	6.35	0.8	6.35
CNMG160612-MP	M	●	●	●	15.875	6.35	1.2	6.35
CNMG160616-MP	M	●	●	●	15.875	6.35	1.6	6.35
CNMG090308-MS	M	●	●		9.525	3.18	0.8	3.81
CNMG09T308-MS	M	●	●		9.525	3.97	0.8	3.81
CNMG120404-MS	M	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-MS	M	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-MS	M	●	●		12.7	4.76	1.2	5.16

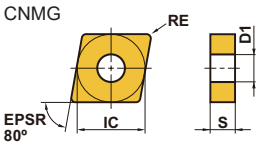
● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class

Medium	Medium	Medium	Medium	Rough	Rough
MA	MH	Standard	MW	RP	GH
			 (Wiper)		



(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CNMG120404-MA	M	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-MA	M	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-MA	M	●	●	●	12.7	4.76	1.2	5.16
CNMG120416-MA	M	●	●	●	12.7	4.76	1.6	5.16
CNMG160608-MA	M	●	●	●	15.875	6.35	0.8	6.35
CNMG160612-MA	M	●	●	●	15.875	6.35	1.2	6.35
CNMG160616-MA	M	●	●	●	15.875	6.35	1.6	6.35
CNMG190612-MA	M	●	●	●	19.05	6.35	1.2	7.93
CNMG190616-MA	M	●	●	●	19.05	6.35	1.6	7.93
CNMG120404-MH	M	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-MH	M	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-MH	M	●	●	●	12.7	4.76	1.2	5.16
CNMG120416-MH	M	●	●	●	12.7	4.76	1.6	5.16
CNMG160608-MH	M	●	●		15.875	6.35	0.8	6.35
CNMG160612-MH	M	●	●	●	15.875	6.35	1.2	6.35
CNMG160616-MH	M	●	●		15.875	6.35	1.6	6.35
CNMG190612-MH	M	●	●	●	19.05	6.35	1.2	7.93
CNMG190616-MH	M	●	●	●	19.05	6.35	1.6	7.93
CNMG090308	M	●	●		9.525	3.18	0.8	3.81
CNMG09T304	M	●	●	●	9.525	3.97	0.4	3.81
CNMG09T308	M	●	●	●	9.525	3.97	0.8	3.81
CNMG120404	M	●	●	●	12.7	4.76	0.4	5.16
CNMG120408	M	●	●	●	12.7	4.76	0.8	5.16
CNMG120412	M	●	●	●	12.7	4.76	1.2	5.16
CNMG120416	M	●	●	●	12.7	4.76	1.6	5.16
CNMG160608	M	●	●	●	15.875	6.35	0.8	6.35
CNMG160612	M	●	●	●	15.875	6.35	1.2	6.35
CNMG160616	M	●	●	●	15.875	6.35	1.6	6.35
CNMG190608	M	●	●	●	19.05	6.35	0.8	7.93
CNMG190612	M	●	●	●	19.05	6.35	1.2	7.93
CNMG190616	M	●	●	●	19.05	6.35	1.6	7.93
CNMG120408-MW	M	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-MW	M	●	●	●	12.7	4.76	1.2	5.16

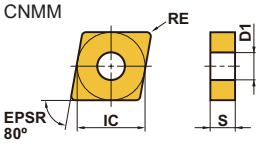
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CNMG120408-RP	R	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-RP	R	●	●	●	12.7	4.76	1.2	5.16
CNMG120416-RP	R	●	●	●	12.7	4.76	1.6	5.16
CNMG160612-RP	R	●	●	●	15.875	6.35	1.2	6.35
CNMG160616-RP	R	●	●	●	15.875	6.35	1.6	6.35
CNMG190612-RP	R	●	●	●	19.05	6.35	1.2	7.93
CNMG190616-RP	R	●	●	●	19.05	6.35	1.6	7.93
CNMG120408-GH	R	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-GH	R	●	●	●	12.7	4.76	1.2	5.16
CNMG120416-GH	R	●	●		12.7	4.76	1.6	5.16
CNMG160612-GH	R	●	●	●	15.875	6.35	1.2	6.35
CNMG160616-GH	R	●	●		15.875	6.35	1.6	6.35
CNMG190612-GH	R	●	●	●	19.05	6.35	1.2	7.93
CNMG190616-GH	R	●	●	●	19.05	6.35	1.6	7.93

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

Heavy	Heavy	Heavy	Heavy	Heavy	Heavy
HX	HL	HR	HV	HZ	HM
					

CNMM



(mm)

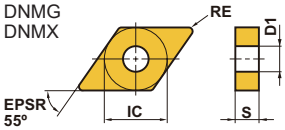
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CNMM120408-HX	H		●	●	12.7	4.76	0.8	5.16
CNMM120412-HX	H		●	●	12.7	4.76	1.2	5.16
CNMM160612-HX	H		●	●	15.875	6.35	1.2	6.35
CNMM160616-HX	H		●	●	15.875	6.35	1.6	6.35
CNMM190612-HX	H	●	●	●	19.05	6.35	1.2	7.93
CNMM190616-HX	H	●	●	●	19.05	6.35	1.6	7.93
CNMM190624-HX	H	●	●	●	19.05	6.35	2.4	7.93
CNMM250924-HX	H	●	●	●	25.4	9.52	2.4	9.12
CNMM120408-HL	H		●	●	12.7	4.76	0.8	5.16
CNMM120412-HL	H		●	●	12.7	4.76	1.2	5.16
CNMM120416-HL	H			●	12.7	4.76	1.6	5.16
CNMM160612-HL	H		●	●	15.875	6.35	1.2	6.35
CNMM160616-HL	H		●	●	15.875	6.35	1.6	6.35
CNMM190612-HL	H		●	●	19.05	6.35	1.2	7.93
CNMM190616-HL	H		●	●	19.05	6.35	1.6	7.93
CNMM190624-HL	H		●	●	19.05	6.35	2.4	7.93
CNMM250924-HR	H	●	●	●	25.4	9.52	2.4	9.12
CNMM190616-HV	H	●	●	●	19.05	6.35	1.6	7.93
CNMM190624-HV	H	●	●	●	19.05	6.35	2.4	7.93
CNMM250924-HV	H	●	●	●	25.4	9.52	2.4	9.12
CNMM120408-HZ	H	●	●	●	12.7	4.76	0.8	5.16
CNMM120412-HZ	H	●	●	●	12.7	4.76	1.2	5.16
CNMM120416-HZ	H			●	12.7	4.76	1.6	5.16
CNMM160612-HZ	H	●	●	●	15.875	6.35	1.2	6.35
CNMM160616-HZ	H	●	●	●	15.875	6.35	1.6	6.35
CNMM190612-HZ	H	●	●	●	19.05	6.35	1.2	7.93
CNMM190616-HZ	H	●	●	●	19.05	6.35	1.6	7.93
CNMM160612-HM	H		●	●	15.875	6.35	1.2	6.35
CNMM160616-HM	H		●	●	15.875	6.35	1.6	6.35
CNMM190612-HM	H		●	●	19.05	6.35	1.2	7.93
CNMM190616-HM	H		●	●	19.05	6.35	1.6	7.93
CNMM190624-HM	H		●	●	19.05	6.35	2.4	7.93
CNMM250924-HM	H	●	●	●	25.4	9.52	2.4	9.12

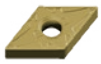
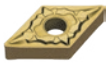
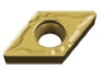
● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class



Finish	Finish	Finish	Finish	Finish	Light
FPH	FP	FH	FS	FY	LP
					
Light	**Light**	**Light**	**Light**	**Medium**	**Medium**
SH	SA	SW	SY	MP	MS
					
		(Wiper)			

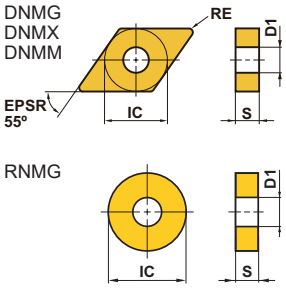
(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
DNMG150404-FPH	F	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-FPH	F	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-FPH	F	●	●	●	12.7	4.76	1.2	5.16
DNMG150604-FPH	F	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-FPH	F	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-FPH	F	●	●	●	12.7	6.35	1.2	5.16
DNMG150402-FP	F	●	●	●	12.7	4.76	0.2	5.16
DNMG150404-FP	F	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-FP	F	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-FP	F	●	●	●	12.7	4.76	1.2	5.16
DNMG150602-FP	F	●	●	●	12.7	6.35	0.2	5.16
DNMG150604-FP	F	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-FP	F	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-FP	F	●	●	●	12.7	6.35	1.2	5.16
DNMG150402-FH	F	●	●	●	12.7	4.76	0.2	5.16
DNMG150404-FH	F	●	●		12.7	4.76	0.4	5.16
DNMG150408-FH	F	●	●		12.7	4.76	0.8	5.16
DNMG150602-FH	F	●	●	●	12.7	6.35	0.2	5.16
DNMG150604-FH	F	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-FH	F	●	●	●	12.7	6.35	0.8	5.16
DNMG150408-FS	F		●	●	12.7	4.76	0.8	5.16
DNMG150404-FY	F	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-FY	F	●	●	●	12.7	4.76	0.8	5.16
DNMG150608-FY	F	●	●	●	12.7	6.35	0.8	5.16
DNMG110404-LP	L	●	●	●	9.525	4.76	0.4	3.81
DNMG110408-LP	L	●	●	●	9.525	4.76	0.8	3.81
DNMG150404-LP	L	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-LP	L	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-LP	L	●	●	●	12.7	4.76	1.2	5.16
DNMG150604-LP	L	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-LP	L	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-LP	L	●	●	●	12.7	6.35	1.2	5.16

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
DNMG110404-SH	L	●	●		9.525	4.76	0.4	3.81
DNMG110408-SH	L	●	●		9.525	4.76	0.8	3.81
DNMG150404-SH	L	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-SH	L	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-SH	L	●	●	●	12.7	4.76	1.2	5.16
DNMG150604-SH	L	●	●		12.7	6.35	0.4	5.16
DNMG150608-SH	L	●	●		12.7	6.35	0.8	5.16
DNMG150612-SH	L	●	●		12.7	6.35	1.2	5.16
DNMG150404-SA	L	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-SA	L	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-SA	L	●	●	●	12.7	4.76	1.2	5.16
DNMG150604-SA	L	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-SA	L	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-SA	L	●	●	●	12.7	6.35	1.2	5.16
DNMX110404-SW	L	●	●		9.525	4.76	0.4	3.81
DNMX110408-SW	L	●	●		9.525	4.76	0.8	3.81
DNMX150404-SW	L	●	●		12.7	4.76	0.4	5.16
DNMX150408-SW	L	●	●		12.7	4.76	0.8	5.16
DNMX150412-SW	L	●	●		12.7	4.76	1.2	5.16
DNMX150604-SW	L	●	●		12.7	6.35	0.4	5.16
DNMX150608-SW	L	●	●		12.7	6.35	0.8	5.16
DNMX150612-SW	L	●	●		12.7	6.35	1.2	5.16
DNMG150404-SY	L	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-SY	L	●	●	●	12.7	4.76	0.8	5.16
DNMG150608-SY	L	●	●	●	12.7	6.35	0.8	5.16
DNMG150404-MP	M	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-MP	M	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-MP	M	●	●	●	12.7	4.76	1.2	5.16
DNMG150416-MP	M	●	●	●	12.7	4.76	1.6	5.16
DNMG150604-MP	M	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-MP	M	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-MP	M	●	●	●	12.7	6.35	1.2	5.16
DNMG150616-MP	M	●	●	●	12.7	6.35	1.6	5.16
DNMG110408-MS	M	●	●		9.525	4.76	0.8	3.81
DNMG150404-MS	M	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-MS	M	●	●		12.7	4.76	0.8	5.16
DNMG150412-MS	M	●	●		12.7	4.76	1.2	5.16
DNMG150604-MS	M	●	●		12.7	6.35	0.4	5.16
DNMG150608-MS	M	●	●		12.7	6.35	0.8	5.16
DNMG150612-MS	M	●	●		12.7	6.35	1.2	5.16

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)



Medium	Medium	Medium	Medium	Rough
MA	MH	Standard	MW	RP
			(Wiper)	
Rough	**Heavy**	**Heavy**		**Medium**
GH	HL	HZ		Standard

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
DNMG110404-MA	M	●	●	●	9.525	4.76	0.4	3.81
DNMG110408-MA	M	●	●	●	9.525	4.76	0.8	3.81
DNMG110412-MA	M	●	●	●	9.525	4.76	1.2	3.81
DNMG150404-MA	M	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-MA	M	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-MA	M	●	●	●	12.7	4.76	1.2	5.16
DNMG150604-MA	M	●	●	●	12.7	6.35	0.4	5.16
DNMG150608-MA	M	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-MA	M	●	●	●	12.7	6.35	1.2	5.16
DNMG150616-MA		●	●		12.7	6.35	1.6	5.16
DNMG150404-MH	M	●	●	●	12.7	4.76	0.4	5.16
DNMG150408-MH	M	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-MH	M	●	●	●	12.7	4.76	1.2	5.16
DNMG150604-MH	M	●	●		12.7	6.35	0.4	5.16
DNMG150608-MH	M	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-MH	M	●	●	●	12.7	6.35	1.2	5.16
DNMG110408	M	●	●		9.525	4.76	0.8	3.81
DNMG150404	M	●	●	●	12.7	4.76	0.4	5.16
DNMG150408	M	●	●	●	12.7	4.76	0.8	5.16
DNMG150412	M	●	●	●	12.7	4.76	1.2	5.16
DNMG150416	M	●	●	●	12.7	4.76	1.6	5.16
DNMG150604	M	●	●	●	12.7	6.35	0.4	5.16
DNMG150608	M	●	●	●	12.7	6.35	0.8	5.16
DNMG150612	M	●	●	●	12.7	6.35	1.2	5.16
DNMG150616	M	●	●	●	12.7	6.35	1.6	5.16
DNMX150408-MW	M	●	●		12.7	4.76	0.8	5.16
DNMX150412-MW	M	●	●		12.7	4.76	1.2	5.16
DNMX150608-MW	M	●	●		12.7	6.35	0.8	5.16
DNMX150612-MW	M	●	●		12.7	6.35	1.2	5.16
DNMG150408-RP	R	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-RP	R	●	●	●	12.7	4.76	1.2	5.16
DNMG150416-RP	R	●	●	●	12.7	4.76	1.6	5.16
DNMG150608-RP	R	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-RP	R	●	●	●	12.7	6.35	1.2	5.16
DNMG150616-RP	R	●	●	●	12.7	6.35	1.6	5.16
DNMG150408-GH	R	●	●	●	12.7	4.76	0.8	5.16
DNMG150412-GH	R	●	●	●	12.7	4.76	1.2	5.16
DNMG150608-GH	R	●	●	●	12.7	6.35	0.8	5.16
DNMG150612-GH	R	●	●	●	12.7	6.35	1.2	5.16

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
DNMM150408-HL	H		●	●	12.7	4.76	0.8	5.16
DNMM150412-HL	H		●	●	12.7	4.76	1.2	5.16
DNMM150608-HL	H		●	●	12.7	6.35	0.8	5.16
DNMM150612-HL	H		●	●	12.7	6.35	1.2	5.16
DNMM150408-HZ	H	●	●	●	12.7	4.76	0.8	5.16
DNMM150412-HZ	H	●	●	●	12.7	4.76	1.2	5.16
DNMM150608-HZ	H	●	●	●	12.7	6.35	0.8	5.16
DNMM150612-HZ	H	●	●	●	12.7	6.35	1.2	5.16

● = NEW

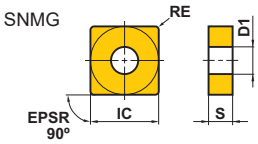
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
RNMG120400	M	●	●	●	12.0	4.76	-	5.16

● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class



Finish	Finish	Light	Light	Light	Light
FP	FH	LP	SH	SA	SY
					
Medium	**Medium**	**Medium**	**Medium**	**Medium**	
MP	MS	MA	MH	Standard	
					

(mm)

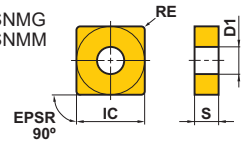
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
SNMG120404-FP	F	●	●	●	12.7	4.76	0.4	5.16
SNMG120408-FP	F	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-FP	F	●	●	●	12.7	4.76	1.2	5.16
SNMG120404-FH	F	●	●		12.7	4.76	0.4	5.16
SNMG120408-FH	F	●	●		12.7	4.76	0.8	5.16
SNMG120404-LP	L	●	●	●	12.7	4.76	0.4	5.16
SNMG120408-LP	L	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-LP	L	●	●	●	12.7	4.76	1.2	5.16
SNMG120404-SH	L	●	●		12.7	4.76	0.4	5.16
SNMG120408-SH	L	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-SH	L	●	●	●	12.7	4.76	1.2	5.16
SNMG120404-SA	L	●	●		12.7	4.76	0.4	5.16
SNMG120408-SA	L	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-SA	L	●	●	●	12.7	4.76	1.2	5.16
SNMG120408-SY	L	●	●	●	12.7	4.76	0.8	5.16
SNMG120404-MP	M	●	●	●	12.7	4.76	0.4	5.16
SNMG120408-MP	M	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-MP	M	●	●	●	12.7	4.76	1.2	5.16
SNMG120404-MS	M	●	●		12.7	4.76	0.4	5.16
SNMG120408-MS	M	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-MS	M	●	●		12.7	4.76	1.2	5.16
SNMG120404-MA	M	●	●	●	12.7	4.76	0.4	5.16
SNMG120408-MA	M	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-MA	M	●	●	●	12.7	4.76	1.2	5.16
SNMG150608-MA	M	●	●	●	15.875	6.35	0.8	6.35
SNMG150612-MA	M	●	●	●	15.875	6.35	1.2	6.35
SNMG150616-MA	M	●	●	●	15.875	6.35	1.6	6.35
SNMG190612-MA	M	●	●	●	19.05	6.35	1.2	7.93
SNMG190616-MA	M	●	●	●	19.05	6.35	1.6	7.93
SNMG120408-MH	M	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-MH	M	●	●	●	12.7	4.76	1.2	5.16
SNMG190612-MH	M	●	●	●	19.05	6.35	1.2	7.93
SNMG190616-MH	M	●	●	●	19.05	6.35	1.6	7.93

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
SNMG090304	M	●	●	●	9.525	3.18	0.4	3.81
SNMG090308	M	●	●	●	9.525	3.18	0.8	3.81
SNMG120404	M	●	●	●	12.7	4.76	0.4	5.16
SNMG120408	M	●	●	●	12.7	4.76	0.8	5.16
SNMG120412	M	●	●	●	12.7	4.76	1.2	5.16
SNMG120416	M	●	●	●	12.7	4.76	1.6	5.16
SNMG120420	M	●	●	●	12.7	4.76	2.0	5.16
SNMG150612	M	●	●	●	15.875	6.35	1.2	6.35
SNMG150616	M	●	●	●	15.875	6.35	1.6	6.35
SNMG190612	M	●	●	●	19.05	6.35	1.2	7.93
SNMG190616	M	●	●	●	19.05	6.35	1.6	7.93

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

SNMG
SNMM



Rough	Rough				
RP	GH				
					
Heavy	**Heavy**	**Heavy**	**Heavy**	**Heavy**	**Heavy**
HX	HL	HR	HV	HZ	HM
					

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
SNMG120408-RP	R	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-RP	R	●	●	●	12.7	4.76	1.2	5.16
SNMG120416-RP	R	●	●	●	12.7	4.76	1.6	5.16
SNMG150612-RP	R	●	●	●	15.875	6.35	1.2	6.35
SNMG150616-RP	R	●	●	●	15.875	6.35	1.6	6.35
SNMG190612-RP	R	●	●	●	19.05	6.35	1.2	7.93
SNMG190616-RP	R	●	●	●	19.05	6.35	1.6	7.93
SNMG120408-GH	R	●	●	●	12.7	4.76	0.8	5.16
SNMG120412-GH	R	●	●	●	12.7	4.76	1.2	5.16
SNMG120416-GH	R	●	●		12.7	4.76	1.6	5.16
SNMG150612-GH	R	●	●		15.875	6.35	1.2	6.35
SNMG150616-GH	R	●	●		15.875	6.35	1.6	6.35
SNMG190612-GH	R	●	●		19.05	6.35	1.2	7.93
SNMG190616-GH	R	●	●		19.05	6.35	1.6	7.93
SNMM120408-HX	H		●	●	12.7	4.76	0.8	5.16
SNMM120412-HX	H		●	●	12.7	4.76	1.2	5.16
SNMM150612-HX	H		●	●	15.875	6.35	1.2	6.35
SNMM190612-HX	H	●	●	●	19.05	6.35	1.2	7.93
SNMM190616-HX	H	●	●	●	19.05	6.35	1.6	7.93
SNMM190624-HX	H	●	●	●	19.05	6.35	2.4	7.93
SNMM250724-HX	H	●	●	●	25.4	7.94	2.4	9.12
SNMM250924-HX	H	●	●	●	25.4	9.52	2.4	9.12
SNMM120408-HL	H		●	●	12.7	4.76	0.8	5.16
SNMM120412-HL	H		●	●	12.7	4.76	1.2	5.16
SNMM150612-HL	H		●	●	15.875	6.35	1.2	6.35
SNMM190612-HL	H		●	●	19.05	6.35	1.2	7.93
SNMM190616-HL	H		●	●	19.05	6.35	1.6	7.93
SNMM190624-HL	H		●	●	19.05	6.35	2.4	7.93
SNMM250724-HR	H	●	●	●	25.4	7.94	2.4	9.12
SNMM250924-HR	H	●	●	●	25.4	9.52	2.4	9.12
SNMM190616-HV	H	●	●	●	19.05	6.35	1.6	7.93
SNMM190624-HV	H	●	●	●	19.05	6.35	2.4	7.93
SNMM250724-HV	H	●	●	●	25.4	7.94	2.4	9.12
SNMM250924-HV	H	●	●	●	25.4	9.52	2.4	9.12

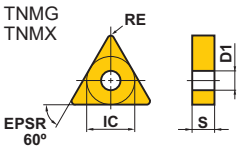
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
SNMM120408-HZ	H	●	●	●	12.7	4.76	0.8	5.16
SNMM120412-HZ	H	●	●	●	12.7	4.76	1.2	5.16
SNMM150612-HZ	H	●	●	●	15.875	6.35	1.2	6.35
SNMM190612-HZ	H	●	●	●	19.05	6.35	1.2	7.93
SNMM190616-HZ	H	●	●	●	19.05	6.35	1.6	7.93
SNMM150612-HM	H		●	●	15.875	6.35	1.2	6.35
SNMM190612-HM	H		●	●	19.05	6.35	1.2	7.93
SNMM190616-HM	H		●	●	19.05	6.35	1.6	7.93
SNMM190624-HM	H		●	●	19.05	6.35	2.4	7.93
SNMM250724-HM	H	●	●	●	25.4	7.94	2.4	9.12
SNMM250924-HM	H	●	●	●	25.4	9.52	2.4	9.12

● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class



Finish	Finish	Finish	Finish	Finish	Light
FPH	FP	FH	FS	FY	LP
					
Light	**Light**	**Light**	**Light**	**Medium**	**Medium**
SH	SA	SW	SY	MP	MS
		 (Wiper)			

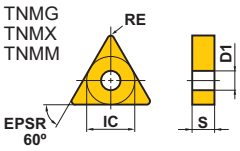
(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TNMG160404-FPH	F	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-FPH	F	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-FPH	F	●	●	●	9.525	4.76	1.2	3.81
TNMG160402-FP	F	●	●	●	9.525	4.76	0.2	3.81
TNMG160404-FP	F	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-FP	F	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-FP	F	●	●	●	9.525	4.76	1.2	3.81
TNMG160402-FH	F	●	●	●	9.525	4.76	0.2	3.81
TNMG160404-FH	F	●	●		9.525	4.76	0.4	3.81
TNMG160408-FH	F	●	●	●	9.525	4.76	0.8	3.81
TNMG160404-FS	F		●	●	9.525	4.76	0.4	3.81
TNMG160408-FS	F		●	●	9.525	4.76	0.8	3.81
TNMG160404-FY	F	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-FY	F	●	●	●	9.525	4.76	0.8	3.81
TNMG160404-LP	L	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-LP	L	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-LP	L	●	●	●	9.525	4.76	1.2	3.81
TNMG220408-LP	L	●	●	●	12.7	4.76	0.8	5.16
TNMG220412-LP	L	●	●	●	12.7	4.76	1.2	5.16
TNMG160404-SH	L	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-SH	L	●	●	●	9.525	4.76	0.8	3.81
TNMG220408-SH	L	●	●		12.7	4.76	0.8	5.16
TNMG160404-SA	L	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-SA	L	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-SA	L	●	●	●	9.525	4.76	1.2	3.81
TNMG220408-SA	L	●	●	●	12.7	4.76	0.8	5.16
TNMG220412-SA	L	●	●		12.7	4.76	1.2	5.16
TNMX160404-SW	L	●	●		9.525	4.76	0.4	3.81
TNMX160408-SW	L	●	●		9.525	4.76	0.8	3.81
TNMG160404-SY	L	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-SY	L	●	●	●	9.525	4.76	0.8	3.81

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TNMG160404-MP	M	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-MP	M	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-MP	M	●	●	●	9.525	4.76	1.2	3.81
TNMG220408-MP	M	●	●	●	12.7	4.76	0.8	5.16
TNMG220412-MP	M	●	●	●	12.7	4.76	1.2	5.16
TNMG160404-MS	M	●	●		9.525	4.76	0.4	3.81
TNMG160408-MS	M	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-MS	M	●	●		9.525	4.76	1.2	3.81
TNMG220408-MS	M	●	●		12.7	4.76	0.8	5.16

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)



Medium	Medium	Medium	Medium	Medium
MA	MH	Standard	MW	ES
			 (Wiper)	
Rough	**Rough**	**Heavy**	**Heavy**	
RP	GH	HL	HZ	
				

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TNMG160404-MA	M	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-MA	M	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-MA	M	●	●	●	9.525	4.76	1.2	3.81
TNMG220408-MA	M	●	●	●	12.7	4.76	0.8	5.16
TNMG220412-MA	M	●	●	●	12.7	4.76	1.2	5.16
TNMG270608-MA	M	●	●	●	15.875	6.35	0.8	6.35
TNMG270612-MA	M	●	●	●	15.875	6.35	1.2	6.35
TNMG160404-MH	M	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-MH	M	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-MH	M	●	●	●	9.525	4.76	1.2	3.81
TNMG220408-MH	M	●	●	●	12.7	4.76	0.8	5.16
TNMG220412-MH	M	●	●	●	12.7	4.76	1.2	5.16
TNMG110304	M	●	●	●	6.35	3.18	0.4	2.26
TNMG110308	M	●	●	●	6.35	3.18	0.8	2.26
TNMG160304	M	●	●	●	9.525	3.18	0.4	3.81
TNMG160308	M	●	●	●	9.525	3.18	0.8	3.81
TNMG160404	M	●	●	●	9.525	4.76	0.4	3.81
TNMG160408	M	●	●	●	9.525	4.76	0.8	3.81
TNMG160412	M	●	●	●	9.525	4.76	1.2	3.81
TNMG160416	M	●	●	●	9.525	4.76	1.6	3.81
TNMG220404	M	●	●	●	12.7	4.76	0.4	5.16
TNMG220408	M	●	●	●	12.7	4.76	0.8	5.16
TNMG220412	M	●	●	●	12.7	4.76	1.2	5.16
TNMG220416	M	●	●	●	12.7	4.76	1.6	5.16
TNMG270608	M	●	●	●	15.875	6.35	0.8	6.35
TNMG270612	M	●	●	●	15.875	6.35	1.2	6.35
TNMG270616	M	●	●	●	15.875	6.35	1.6	6.35
TNMX160408-MW	M	●	●		9.525	4.76	0.8	3.81
TNMX160412-MW	M	●	●		9.525	4.76	1.2	3.81
TNMG160404R-ES	M	●	●		9.525	4.76	0.4	3.81
TNMG160404L-ES	M	●	●		9.525	4.76	0.4	3.81
TNMG160408R-ES	M	●	●		9.525	4.76	0.8	3.81
TNMG160408L-ES	M	●	●		9.525	4.76	0.8	3.81
TNMG220408R-ES	M	●	●		12.7	4.76	0.8	5.16
TNMG220408L-ES	M	●	●		12.7	4.76	0.8	5.16

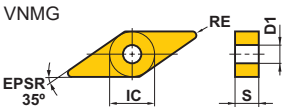
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TNMG160408-RP	R	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-RP	R	●	●	●	9.525	4.76	1.2	3.81
TNMG220408-RP	R	●	●	●	12.7	4.76	0.8	5.16
TNMG220412-RP	R	●	●	●	12.7	4.76	1.2	5.16
TNMG220416-RP	R	●	●	●	12.7	4.76	1.6	5.16
TNMG270612-RP	R	●	●	●	15.875	6.35	1.2	6.35
TNMG270616-RP	R	●	●	●	15.875	6.35	1.6	6.35
TNMG160408-GH	R	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-GH	R	●	●		9.525	4.76	1.2	3.81
TNMG220408-GH	R	●	●	●	12.7	4.76	0.8	5.16
TNMG220412-GH	R	●	●	●	12.7	4.76	1.2	5.16
TNMG220416-GH	R	●	●		12.7	4.76	1.6	5.16
TNMG270612-GH	R	●	●	●	15.875	6.35	1.2	6.35
TNMG270616-GH	R	●	●		15.875	6.35	1.6	6.35
TNMM160408-HL	H		●	●	9.525	4.76	0.8	3.81
TNMM160412-HL	H		●	●	9.525	4.76	1.2	3.81
TNMM220408-HL	H		●	●	12.7	4.76	0.8	5.16
TNMM220412-HL	H		●	●	12.7	4.76	1.2	5.16
TNMM220416-HL	H		●	●	12.7	4.76	1.6	5.16
TNMM160408-HZ	H	●	●	●	9.525	4.76	0.8	3.81
TNMM160412-HZ	H		●	●	9.525	4.76	1.2	3.81
TNMM220408-HZ	H	●	●	●	12.7	4.76	0.8	5.16
TNMM220412-HZ	H	●	●	●	12.7	4.76	1.2	5.16
TNMM220416-HZ	H	●	●	●	12.7	4.76	1.6	5.16

● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class



Finish	Finish	Finish	Finish	Light	Light
FPH	FP	FH	FS	LP	SH
					
Light	**Medium**	**Medium**	**Medium**	**Medium**	**Medium**
SA	MP	MS	MA	MH	Standard
					

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
VNMG160404-FPH	F	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-FPH	F	●	●	●	9.525	4.76	0.8	3.81
VNMG160412-FPH	F	●	●	●	9.525	4.76	1.2	3.81
VNMG160402-FP	F	●	●	●	9.525	4.76	0.2	3.81
VNMG160404-FP	F	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-FP	F	●	●	●	9.525	4.76	0.8	3.81
VNMG160412-FP	F	●	●	●	9.525	4.76	1.2	3.81
VNMG160402-FH	F	●	●	●	9.525	4.76	0.2	3.81
VNMG160404-FH	F	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-FH	F	●	●	●	9.525	4.76	0.8	3.81
VNMG160404-FS	F		●	●	9.525	4.76	0.4	3.81
VNMG160408-FS	F		●	●	9.525	4.76	0.8	3.81
VNMG160404-LP	L	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-LP	L	●	●	●	9.525	4.76	0.8	3.81
VNMG160404-SH	L	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-SH	L	●	●	●	9.525	4.76	0.8	3.81
VNMG160404-SA	L	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-SA	L	●	●	●	9.525	4.76	0.8	3.81

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
VNMG160404-MP	M	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-MP	M	●	●	●	9.525	4.76	0.8	3.81
VNMG160412-MP	M	●	●	●	9.525	4.76	1.2	3.81
VNMG160404-MS	M	●	●		9.525	4.76	0.4	3.81
VNMG160408-MS	M	●	●		9.525	4.76	0.8	3.81
VNMG160404-MA	M	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-MA	M	●	●	●	9.525	4.76	0.8	3.81
VNMG160404-MH	M	●	●	●	9.525	4.76	0.4	3.81
VNMG160408-MH	M	●	●	●	9.525	4.76	0.8	3.81
VNMG160404	M	●	●	●	9.525	4.76	0.4	3.81
VNMG160408	M	●	●	●	9.525	4.76	0.8	3.81
VNMG160412	M	●	●	●	9.525	4.76	1.2	3.81

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

WNMG EPSR 80° RE





Finish	Finish	Finish	Finish	Finish	Light
FPH	FP	FH	FS	FY	LP
					
Light	**Light**	**Light**	**Light**		
SH	SA	SW	SY		
		 (Wiper)			

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
WNMG080404-FPH	F	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-FPH	F	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-FPH	F	●	●	●	12.7	4.76	1.2	5.16
WNMG080402-FP	F	●	●	●	12.7	4.76	0.2	5.16
WNMG080404-FP	F	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-FP	F	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-FP	F	●	●	●	12.7	4.76	1.2	5.16
WNMG080404-FH	F	●	●		12.7	4.76	0.4	5.16
WNMG080408-FH	F	●	●		12.7	4.76	0.8	5.16
WNMG080404-FS	F		●	●	12.7	4.76	0.4	5.16
WNMG080408-FS	F		●	●	12.7	4.76	0.8	5.16
WNMG080408-FY	F	●	●	●	12.7	4.76	0.8	5.16
WNMG06T304-LP	L	●	●	●	9.525	3.97	0.4	3.81
WNMG06T308-LP	L	●	●	●	9.525	3.97	0.8	3.81
WNMG060404-LP	L	●	●	●	9.525	4.76	0.4	3.81
WNMG060408-LP	L	●	●	●	9.525	4.76	0.8	3.81
WNMG080404-LP	L	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-LP	L	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-LP	L	●	●	●	12.7	4.76	1.2	5.16
WNMG06T304-SH	L	●	●		9.525	3.97	0.4	3.81
WNMG06T308-SH	L	●	●		9.525	3.97	0.8	3.81
WNMG060404-SH	L	●	●		9.525	4.76	0.4	3.81
WNMG060408-SH	L	●	●		9.525	4.76	0.8	3.81
WNMG080404-SH	L	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-SH	L	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-SH	L	●	●	●	12.7	4.76	1.2	5.16

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
WNMG080404-SA	L	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-SA	L	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-SA	L	●	●	●	12.7	4.76	1.2	5.16
WNMG060404-SW	L	●	●		9.525	4.76	0.4	3.81
WNMG060408-SW	L	●	●		9.525	4.76	0.8	3.81
WNMG080404-SW	L	●	●		12.7	4.76	0.4	5.16
WNMG080408-SW	L	●	●		12.7	4.76	0.8	5.16
WNMG080412-SW	L	●	●		12.7	4.76	1.2	5.16
WNMG080408-SY	L	●	●	●	12.7	4.76	0.8	5.16

● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class

WNMG EPSR 80° RE





Medium	Medium	Medium	Medium	Medium	Medium
MP	MS	MA	MH	Standard	MW
					 (Wiper)
Rough	Rough				
RP	GH				
					

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
WNMG06T304-MP	M	●	●	●	9.525	3.97	0.4	3.81
WNMG06T308-MP	M	●	●	●	9.525	3.97	0.8	3.81
WNMG06T312-MP	M	●	●	●	9.525	3.97	1.2	3.81
WNMG060404-MP	M	●	●	●	9.525	4.76	0.4	3.81
WNMG060408-MP	M	●	●	●	9.525	4.76	0.8	3.81
WNMG060412-MP	M	●	●	●	9.525	4.76	1.2	3.81
WNMG080404-MP	M	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-MP	M	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-MP	M	●	●	●	12.7	4.76	1.2	5.16
WNMG080416-MP	M	●	●	●	12.7	4.76	1.6	5.16
WNMG06T304-MS	M	●	●		9.525	3.97	0.4	3.81
WNMG06T308-MS	M	●	●		9.525	3.97	0.8	3.81
WNMG060404-MS	M	●	●		9.525	4.76	0.4	3.81
WNMG060408-MS	M	●	●		9.525	4.76	0.8	3.81
WNMG080404-MS	M	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-MS	M	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-MS	M	●	●		12.7	4.76	1.2	5.16
WNMG06T304-MA	M	●	●		9.525	3.97	0.4	3.81
WNMG06T308-MA	M	●	●		9.525	3.97	0.8	3.81
WNMG06T312-MA	M	●	●		9.525	3.97	1.2	3.81
WNMG060404-MA	M	●	●	●	9.525	4.76	0.4	3.81
WNMG060408-MA	M	●	●	●	9.525	4.76	0.8	3.81
WNMG060412-MA	M	●	●	●	9.525	4.76	1.2	3.81
WNMG080404-MA	M	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-MA	M	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-MA	M	●	●	●	12.7	4.76	1.2	5.16
WNMG080416-MA	M	●	●		12.7	4.76	1.6	5.16
WNMG100612-MA	M		●	●	15.875	6.35	1.2	6.35
WNMG080404-MH	M	●	●	●	12.7	4.76	0.4	5.16
WNMG080408-MH	M	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-MH	M	●	●	●	12.7	4.76	1.2	5.16
WNMG080404	M	●	●	●	12.7	4.76	0.4	5.16
WNMG080408	M	●	●	●	12.7	4.76	0.8	5.16
WNMG080412	M	●	●	●	12.7	4.76	1.2	5.16
WNMG060408-MW	M	●	●	●	9.525	4.76	0.8	3.81
WNMG060412-MW	M	●	●	●	9.525	4.76	1.2	3.81
WNMG080408-MW	M	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-MW	M	●	●	●	12.7	4.76	1.2	5.16

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
WNMG080408-RP	R	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-RP	R	●	●	●	12.7	4.76	1.2	5.16
WNMG080416-RP	R	●	●		12.7	4.76	1.6	5.16
WNMG080408-GH	R	●	●	●	12.7	4.76	0.8	5.16
WNMG080412-GH	R	●	●	●	12.7	4.76	1.2	5.16

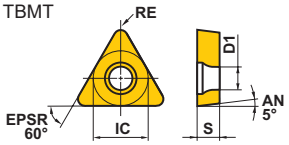
● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

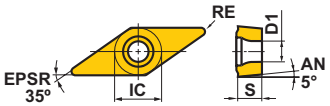
5° Positive Inserts (With Hole)

M Class

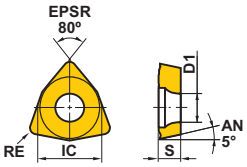
TBMT



VBMT



WBMT



Finish	Finish	Light	Medium	Medium
FP	FV	LP	MP	MV
				
Finish		**Medium**		
FV		MV		
				

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TBMT060102-FV	F	●		●	3.97	1.59	0.2	2.3
TBMT060104-FV	F	●		●	3.97	1.59	0.4	2.3
VBMT110302-FP	F	●	●	●	6.35	3.18	0.2	2.9
VBMT110304-FP	F	●	●	●	6.35	3.18	0.4	2.9
VBMT110308-FP	F	●	●	●	6.35	3.18	0.8	2.9
VBMT160404-FP	F	●	●	●	9.525	4.76	0.4	4.4
VBMT160408-FP	F	●	●	●	9.525	4.76	0.8	4.4
VBMT160412-FP	F	●	●	●	9.525	4.76	1.2	4.4
VBMT110304-FV	F	●	●	●	6.35	3.18	0.4	2.9
VBMT110308-FV	F		●	●	6.35	3.18	0.8	2.9
VBMT160404-FV	F	●	●	●	9.525	4.76	0.4	4.4
VBMT160408-FV	F	●	●	●	9.525	4.76	0.8	4.4
VBMT110304-LP	L	●	●	●	6.35	3.18	0.4	2.9
VBMT110308-LP	L	●	●	●	6.35	3.18	0.8	2.9
VBMT160404-LP	L	●	●	●	9.525	4.76	0.4	4.4
VBMT160408-LP	L	●	●	●	9.525	4.76	0.8	4.4
VBMT160412-LP	L	●	●	●	9.525	4.76	1.2	4.4
VBMT160404-MP	M	●	●	●	9.525	4.76	0.4	4.4
VBMT160408-MP	M	●	●	●	9.525	4.76	0.8	4.4
VBMT110304-MV	M		●	●	6.35	3.18	0.4	2.9
VBMT110308-MV	M		●	●	6.35	3.18	0.8	2.9
VBMT160404-MV	M		●	●	9.525	4.76	0.4	4.4
VBMT160408-MV	M		●	●	9.525	4.76	0.8	4.4

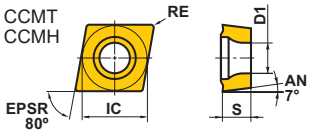
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
WBMTL30202R-MV	M		●	●	4.76	2.38	0.2	2.3
WBMTL30202L-MV	M		●	●	4.76	2.38	0.2	2.3
WBMTL30204R-MV	M		●	●	4.76	2.38	0.4	2.3
WBMTL30204L-MV	M		●	●	4.76	2.38	0.4	2.3

● = NEW

MC6100 Series

7° Positive Inserts (With Hole)

M Class



Finish	Finish	Light	Light
FP	FV	LP	SW
			 (Wiper)
Medium	**Medium**	**Medium**	
MP	MV	MW	
		 (Wiper)	

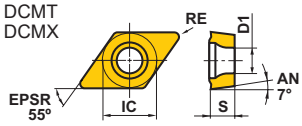
(mm)

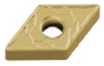
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CCMT060202-FP	F	●	●	●	6.35	2.38	0.2	2.8
CCMT060204-FP	F	●	●	●	6.35	2.38	0.4	2.8
CCMT09T302-FP	F	●	●	●	9.525	3.97	0.2	4.4
CCMT09T304-FP	F	●	●	●	9.525	3.97	0.4	4.4
CCMT09T308-FP	F	●	●	●	9.525	3.97	0.8	4.4
CCMT060202-FV	F		●	●	6.35	2.38	0.2	2.8
CCMT060204-FV	F		●	●	6.35	2.38	0.4	2.8
CCMT09T302-FV	F		●	●	9.525	3.97	0.2	4.4
CCMT09T304-FV	F		●	●	9.525	3.97	0.4	4.4
CCMT09T308-FV	F		●	●	9.525	3.97	0.8	4.4
CCMT060202-LP	L	●	●	●	6.35	2.38	0.2	2.8
CCMT060204-LP	L	●	●	●	6.35	2.38	0.4	2.8
CCMT060208-LP	L	●	●	●	6.35	2.38	0.8	2.8
CCMT09T302-LP	L	●	●	●	9.525	3.97	0.2	4.4
CCMT09T304-LP	L	●	●	●	9.525	3.97	0.4	4.4
CCMT09T308-LP	L	●	●	●	9.525	3.97	0.8	4.4
CCMT060202-SW	L	●	●	●	6.35	2.38	0.2	2.8
CCMT060204-SW	L	●	●	●	6.35	2.38	0.4	2.8
CCMT060208-SW	L	●	●	●	6.35	2.38	0.8	2.8
CCMT09T302-SW	L	●	●	●	9.525	3.97	0.2	4.4
CCMT09T304-SW	L	●	●	●	9.525	3.97	0.4	4.4
CCMT09T308-SW	L	●	●	●	9.525	3.97	0.8	4.4

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CCMT060202-MP	M	●	●	●	6.35	2.38	0.2	2.8
CCMT060204-MP	M	●	●	●	6.35	2.38	0.4	2.8
CCMT060208-MP	M	●	●	●	6.35	2.38	0.8	2.8
CCMT080302-MP	M	●	●		7.94	3.18	0.2	3.4
CCMT080304-MP	M	●	●		7.94	3.18	0.4	3.4
CCMT080308-MP	M	●	●		7.94	3.18	0.8	3.4
CCMT09T302-MP	M	●	●	●	9.525	3.97	0.2	4.4
CCMT09T304-MP	M	●	●	●	9.525	3.97	0.4	4.4
CCMT09T308-MP	M	●	●	●	9.525	3.97	0.8	4.4
CCMT120404-MP	M	●	●	●	12.7	4.76	0.4	5.5
CCMT120408-MP	M	●	●	●	12.7	4.76	0.8	5.5
CCMT120412-MP	M	●	●	●	12.7	4.76	1.2	5.5
CCMH060202-MV	M		●	●	6.35	2.38	0.2	2.8
CCMH060204-MV	M		●	●	6.35	2.38	0.4	2.8
CCMT060204-MW	M	●	●	●	6.35	2.38	0.4	2.8
CCMT060208-MW	M	●	●	●	6.35	2.38	0.8	2.8
CCMT09T304-MW	M	●	●	●	9.525	3.97	0.4	4.4
CCMT09T308-MW	M	●	●	●	9.525	3.97	0.8	4.4
CCMT120404-MW	M	●	●	●	12.7	4.76	0.4	5.5
CCMT120408-MW	M	●	●	●	12.7	4.76	0.8	5.5

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)



Finish	Finish	Light	Light
FP	FV	LP	SW
			 (Wiper)
Medium	**Medium**		
MP	MV		
			

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
DCMT070202-FP	F	●	●	●	6.35	2.38	0.2	2.8
DCMT070204-FP	F	●	●	●	6.35	2.38	0.4	2.8
DCMT11T302-FP	F	●	●	●	9.525	3.97	0.2	4.4
DCMT11T304-FP	F	●	●	●	9.525	3.97	0.4	4.4
DCMT11T308-FP	F	●	●	●	9.525	3.97	0.8	4.4
DCMT070202-FV	F	●	●	●	6.35	2.38	0.2	2.8
DCMT070204-FV	F	●	●	●	6.35	2.38	0.4	2.8
DCMT070208-FV	F		●	●	6.35	2.38	0.8	2.8
DCMT11T302-FV	F		●	●	9.525	3.97	0.2	4.4
DCMT11T304-FV	F	●	●	●	9.525	3.97	0.4	4.4
DCMT11T308-FV	F	●	●	●	9.525	3.97	0.8	4.4
DCMT070202-LP	L	●	●	●	6.35	2.38	0.2	2.8
DCMT070204-LP	L	●	●	●	6.35	2.38	0.4	2.8
DCMT070208-LP	L	●	●	●	6.35	2.38	0.8	2.8
DCMT11T302-LP	L	●	●	●	9.525	3.97	0.2	4.4
DCMT11T304-LP	L	●	●	●	9.525	3.97	0.4	4.4
DCMT11T308-LP	L	●	●	●	9.525	3.97	0.8	4.4
DCMX070202-SW	L	●	●	●	6.35	2.38	0.2	2.8
DCMX070204-SW	L	●	●	●	6.35	2.38	0.4	2.8
DCMX070208-SW	L	●	●	●	6.35	2.38	0.8	2.8
DCMX11T302-SW	L	●	●	●	9.525	3.97	0.2	4.4
DCMX11T304-SW	L	●	●	●	9.525	3.97	0.4	4.4
DCMX11T308-SW	L	●	●	●	9.525	3.97	0.8	4.4

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
DCMT070202-MP	M	●	●	●	6.35	2.38	0.2	2.8
DCMT070204-MP	M	●	●	●	6.35	2.38	0.4	2.8
DCMT070208-MP	M	●	●	●	6.35	2.38	0.8	2.8
DCMT11T302-MP	M	●	●	●	9.525	3.97	0.2	4.4
DCMT11T304-MP	M	●	●	●	9.525	3.97	0.4	4.4
DCMT11T308-MP	M	●	●	●	9.525	3.97	0.8	4.4
DCMT11T312-MP	M	●	●		9.525	3.97	1.2	4.4
DCMT150404-MP	M	●	●	●	12.7	4.76	0.4	5.5
DCMT150408-MP	M	●	●	●	12.7	4.76	0.8	5.5
DCMT150412-MP	M	●	●		12.7	4.76	1.2	5.5
DCMT070202-MV	M	●	●	●	6.35	2.38	0.2	2.8
DCMT070204-MV	M	●	●	●	6.35	2.38	0.4	2.8
DCMT070208-MV	M	●	●	●	6.35	2.38	0.8	2.8
DCMT11T302-MV	M	●	●	●	9.525	3.97	0.2	4.4
DCMT11T304-MV	M	●	●	●	9.525	3.97	0.4	4.4
DCMT11T308-MV	M	●	●	●	9.525	3.97	0.8	4.4

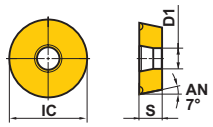
● = NEW

MC6100 Series

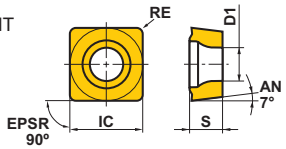
7° Positive Inserts (With Hole)

M Class

RCMT
RCMX



SCMT



Medium	Rough		
Standard	RR		
			
Finish	**Finish**	**Light**	**Medium**
FP	FV	LP	MP
			

(mm)

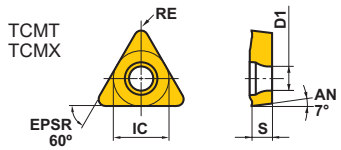
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
RCMT0602M0	M	●	●		6	2.38	-	2.8
RCMT0803M0	M	●	●		8	3.18	-	3.4
RCMX1003M0	M	●	●	●	10	3.18	-	3.6
RCMX1204M0	M	●	●	●	12	4.76	-	4.2
RCMX1606M0	M	●	●	●	16	6.35	-	5.2
RCMX2006M0	M	●	●	●	20	6.35	-	6.5
RCMX2507M0	M	●	●	●	25	7.94	-	7.2
RCMX3209M0	M	●	●	●	32	9.52	-	9.5
RCMX1606M0-RR	R	●	●	●	16	6.35	-	5.2
RCMX2006M0-RR	R	●	●	●	20	6.35	-	6.5
RCMX2507M0-RR	R	●	●	●	25	7.94	-	7.2
RCMX3209M0-RR	R	●	●	●	32	9.52	-	9.5

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
SCMT09T304-FP	F	●	●	●	9.525	3.97	0.4	4.4
SCMT09T308-FP	F	●	●	●	9.525	3.97	0.8	4.4
SCMT09T304-FV	F		●	●	9.525	3.97	0.4	4.4
SCMT09T304-LP	L	●	●	●	9.525	3.97	0.4	4.4
SCMT09T308-LP	L	●	●	●	9.525	3.97	0.8	4.4
SCMT09T304-MP	M	●	●	●	9.525	3.97	0.4	4.4
SCMT09T308-MP	M	●	●	●	9.525	3.97	0.8	4.4
SCMT120404-MP	M	●	●	●	12.7	4.76	0.4	5.5
SCMT120408-MP	M	●	●	●	12.7	4.76	0.8	5.5
SCMT120412-MP	M	●	●		12.7	4.76	1.2	5.5

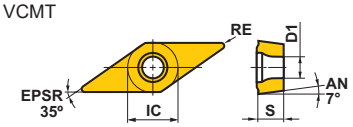
● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

TCMT
TCMX



VCMT



Finish	Finish	Light	Light	Medium
FP	FV	LP	SW	MP
			(Wiper)	
Finish	Finish	Light	Medium	Medium
FP	FV	LP	MP	MV

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TCMT090202-FP	F	●	●	●	5.56	2.38	0.2	2.5
TCMT090204-FP	F	●	●	●	5.56	2.38	0.4	2.5
TCMT110202-FP	F	●	●	●	6.35	2.38	0.2	2.8
TCMT110204-FP	F	●	●	●	6.35	2.38	0.4	2.8
TCMT16T304-FP	F	●	●	●	9.525	3.97	0.4	4.4
TCMT110204-FV	F		●	●	6.35	2.38	0.4	2.8
TCMT16T304-FV	F		●	●	9.525	3.97	0.4	4.4
TCMT090204-LP	L	●	●	●	5.56	2.38	0.4	2.5
TCMT090208-LP	L	●	●	●	5.56	2.38	0.8	2.5
TCMT110202-LP	L	●	●	●	6.35	2.38	0.2	2.8
TCMT110204-LP	L	●	●	●	6.35	2.38	0.4	2.8
TCMT110208-LP	L	●	●	●	6.35	2.38	0.8	2.8
TCMT16T304-LP	L	●	●	●	9.525	3.97	0.4	4.4
TCMT16T308-LP	L	●	●	●	9.525	3.97	0.8	4.4
TCMX090204-SW	L	●	●	●	5.56	2.38	0.4	2.5
TCMX110204-SW	L	●	●	●	6.35	2.38	0.4	2.8
TCMT090204-MP	M	●	●	●	5.56	2.38	0.4	2.5
TCMT090208-MP	M	●	●	●	5.56	2.38	0.8	2.5
TCMT110202-MP	M	●	●	●	6.35	2.38	0.2	2.8
TCMT110204-MP	M	●	●	●	6.35	2.38	0.4	2.8
TCMT110208-MP	M	●	●	●	6.35	2.38	0.8	2.8
TCMT130304-MP	M	●	●	●	7.94	3.18	0.4	3.4
TCMT16T304-MP	M	●	●	●	9.525	3.97	0.4	4.4
TCMT16T308-MP	M	●	●	●	9.525	3.97	0.8	4.4
TCMT16T312-MP	M	●	●	●	9.525	3.97	1.2	4.4

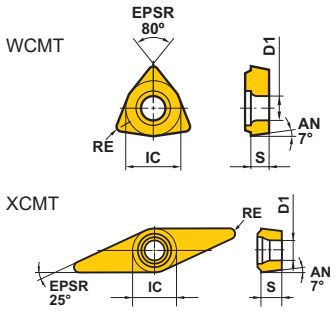
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
VCMT080202-FP	F	●	●	●	4.76	2.38	0.2	2.4
VCMT080204-FP	F	●	●	●	4.76	2.38	0.4	2.4
VCMT110302-FP	F	●	●	●	6.35	3.18	0.2	2.8
VCMT110304-FP	F	●	●	●	6.35	3.18	0.4	2.8
VCMT160404-FP	F	●	●	●	9.525	4.76	0.4	4.4
VCMT160408-FP	F	●	●	●	9.525	4.76	0.8	4.4
VCMT080202-FV	F		●	●	4.76	2.38	0.2	2.4
VCMT080204-FV	F		●	●	4.76	2.38	0.4	2.4
VCMT160404-FV	F	●	●	●	9.525	4.76	0.4	4.4
VCMT160408-FV	F	●	●	●	9.525	4.76	0.8	4.4
VCMT080202-LP	L	●	●	●	4.76	2.38	0.2	2.4
VCMT080204-LP	L	●	●	●	4.76	2.38	0.4	2.4
VCMT110304-LP	L	●	●	●	6.35	3.18	0.4	2.8
VCMT110308-LP	L	●	●	●	6.35	3.18	0.8	2.8
VCMT160404-LP	L	●	●	●	9.525	4.76	0.4	4.4
VCMT160408-LP	L	●	●	●	9.525	4.76	0.8	4.4
VCMT110304-MP	M	●	●	●	6.35	3.18	0.4	2.8
VCMT160404-MP	M	●	●	●	9.525	4.76	0.4	4.4
VCMT160408-MP	M	●	●	●	9.525	4.76	0.8	4.4
VCMT160412-MP	M	●	●	●	9.525	4.76	1.2	4.4
VCMT080202-MV	M		●	●	4.76	2.38	0.2	2.4
VCMT080204-MV	M		●	●	4.76	2.38	0.4	2.4

● = NEW

MC6100 Series

7° Positive Inserts (With Hole)

M Class



Finish	Medium
FV	MP
	

Finish	
SVX	
	

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
WCMT020102-FV	F		●		3.97	1.59	0.2	2.3
WCMT020104-FV	F		●		3.97	1.59	0.4	2.3
WCMTL30202-FV	F		●		4.76	2.38	0.2	2.3
WCMTL30204-FV	F		●		4.76	2.38	0.4	2.3
WCMT040202-FV	F		●		6.35	2.38	0.2	2.8
WCMT040204-FV	F		●		6.35	2.38	0.4	2.8
WCMT06T302-FV	F		●		9.525	3.97	0.2	4.4
WCMT06T304-FV	F		●		9.525	3.97	0.4	4.4
WCMT020102-MP	M	●	●	●	3.97	1.59	0.2	2.3
WCMT020104-MP	M	●	●	●	3.97	1.59	0.4	2.3
WCMTL30202-MP	M	●	●		4.76	2.38	0.2	2.3
WCMTL30204-MP	M	●	●		4.76	2.38	0.4	2.3
WCMT040202-MP	M	●	●	●	6.35	2.38	0.2	2.8
WCMT040204-MP	M	●	●	●	6.35	2.38	0.4	2.8
WCMT040208-MP	M		●	●	6.35	2.38	0.8	2.8
WCMT06T304-MP	M	●	●	●	9.525	3.97	0.4	4.4
WCMT06T308-MP	M	●	●	●	9.525	3.97	0.8	4.4

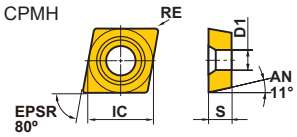
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
XCMT150304-SVX	F		●	●	6.35	3.18	0.4	2.85
XCMT150308-SVX	F		●	●	6.35	3.18	0.8	2.85

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

11° Positive Inserts (With Hole)

M Class



Finish	Finish	Light
FP	FV	LP
		
Medium	**Medium**	**Medium**
MP	MV	Standard
		

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CPMH080202-FP	F		●	●	7.94	2.38	0.2	3.5
CPMH080204-FP	F		●	●	7.94	2.38	0.4	3.5
CPMH090302-FP	F		●	●	9.525	3.18	0.2	4.5
CPMH090304-FP	F		●	●	9.525	3.18	0.4	4.5
CPMH090308-FP	F		●	●	9.525	3.18	0.8	4.5
CPMH080202-FV	F		●	●	7.94	2.38	0.2	3.5
CPMH080204-FV	F		●	●	7.94	2.38	0.4	3.5
CPMH090302-FV	F		●	●	9.525	3.18	0.2	4.5
CPMH090304-FV	F		●	●	9.525	3.18	0.4	4.5
CPMH090308-FV	F		●	●	9.525	3.18	0.8	4.5
CPMH080202-LP	L		●	●	7.94	2.38	0.2	3.5
CPMH080204-LP	L	●	●	●	7.94	2.38	0.4	3.5
CPMH080208-LP	L	●	●	●	7.94	2.38	0.8	3.5
CPMH090302-LP	L		●	●	9.525	3.18	0.2	4.5
CPMH090304-LP	L	●	●	●	9.525	3.18	0.4	4.5
CPMH090308-LP	L	●	●	●	9.525	3.18	0.8	4.5

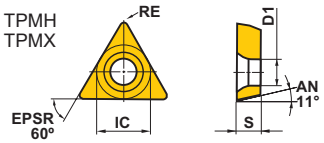
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CPMH080204-MP	M	●	●	●	7.94	2.38	0.4	3.5
CPMH080208-MP	M	●	●	●	7.94	2.38	0.8	3.5
CPMH090304-MP	M	●	●	●	9.525	3.18	0.4	4.5
CPMH090308-MP	M	●	●	●	9.525	3.18	0.8	4.5
CPMH080204-MV	M		●	●	7.94	2.38	0.4	3.5
CPMH080208-MV	M		●	●	7.94	2.38	0.8	3.5
CPMH090304-MV	M		●	●	9.525	3.18	0.4	4.5
CPMH090308-MV	M		●	●	9.525	3.18	0.8	4.5
CPMH080204	M	●	●		7.94	2.38	0.4	3.5
CPMH080208	M	●	●		7.94	2.38	0.8	3.5
CPMH090304	M	●	●		9.525	3.18	0.4	4.5
CPMH090308	M	●	●	●	9.525	3.18	0.8	4.5

● = NEW

MC6100 Series

11° Positive Inserts (With Hole)

M Class



Finish	Finish	Light	Light
FP	FV	LP	SW
			 (Wiper)
Medium			
MV			
			

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TPMH090202-FP	F	●	●	●	5.56	2.38	0.2	2.9
TPMH090204-FP	F	●	●	●	5.56	2.38	0.4	2.9
TPMH110302-FP	F	●	●	●	6.35	3.18	0.2	3.4
TPMH110304-FP	F	●	●	●	6.35	3.18	0.4	3.4
TPMH110308-FP	F	●	●	●	6.35	3.18	0.8	3.4
TPMH080202-FV	F		●	●	4.76	2.38	0.2	2.4
TPMH080204-FV	F		●	●	4.76	2.38	0.4	2.4
TPMH090202-FV	F		●	●	5.56	2.38	0.2	2.9
TPMH090204-FV	F		●	●	5.56	2.38	0.4	2.9
TPMH110302-FV	F		●	●	6.35	3.18	0.2	3.4
TPMH110304-FV	F	●	●	●	6.35	3.18	0.4	3.4
TPMH110308-FV	F	●	●	●	6.35	3.18	0.8	3.4
TPMH160302-FV	F		●	●	9.525	3.18	0.2	4.4
TPMH160304-FV	F	●	●	●	9.525	3.18	0.4	4.4
TPMH160308-FV	F		●	●	9.525	3.18	0.8	4.4
TPMH080202-LP	L		●	●	4.76	2.38	0.2	2.4
TPMH080204-LP	L		●	●	4.76	2.38	0.4	2.4
TPMH090202-LP	L	●	●	●	5.56	2.38	0.2	2.9
TPMH090204-LP	L	●	●	●	5.56	2.38	0.4	2.9
TPMH110302-LP	L	●	●	●	6.35	3.18	0.2	3.4
TPMH110304-LP	L	●	●	●	6.35	3.18	0.4	3.4
TPMH110308-LP	L	●	●	●	6.35	3.18	0.8	3.4
TPMH160302-LP	L	●	●	●	9.525	3.18	0.2	4.4
TPMH160304-LP	L	●	●	●	9.525	3.18	0.4	4.4
TPMH160308-LP	L	●	●	●	9.525	3.18	0.8	4.4
TPMX090202-SW	L	●	●	●	5.56	2.38	0.2	2.9
TPMX090204-SW	L	●	●	●	5.56	2.38	0.4	2.9
TPMX090208-SW	L	●	●	●	5.56	2.38	0.8	2.9
TPMX110302-SW	L	●	●	●	6.35	3.18	0.2	3.4
TPMX110304-SW	L	●	●	●	6.35	3.18	0.4	3.4
TPMX110308-SW	L	●	●	●	6.35	3.18	0.8	3.4

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TPMH080202-MV	M		●	●	4.76	2.38	0.2	2.4
TPMH080204-MV	M		●	●	4.76	2.38	0.4	2.4
TPMH090202-MV	M		●	●	5.56	2.38	0.2	2.9
TPMH090204-MV	M		●	●	5.56	2.38	0.4	2.9
TPMH090208-MV	M		●	●	5.56	2.38	0.8	2.9
TPMH110302-MV	M		●	●	6.35	3.18	0.2	3.4
TPMH110304-MV	M		●	●	6.35	3.18	0.4	3.4
TPMH110308-MV	M		●	●	6.35	3.18	0.8	3.4
TPMH160304-MV	M		●	●	9.525	3.18	0.4	4.4
TPMH160308-MV	M		●	●	9.525	3.18	0.8	4.4

● = NEW

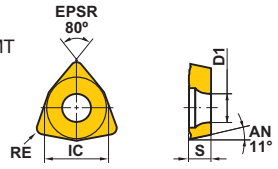
● : Inventory maintained in Japan.
(10 inserts in one case)

Medium

MV



WPMT



(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
WPMT040202-MV	M		●	●	6.35	2.38	0.2	2.8
WPMT040204-MV	M		●	●	6.35	2.38	0.4	2.8
WPMT060304-MV	M		●	●	9.525	3.18	0.4	4.4
WPMT060308-MV	M		●	●	9.525	3.18	0.8	4.4

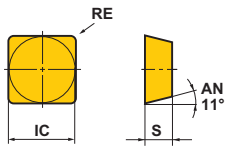
● = NEW

MC6100 Series

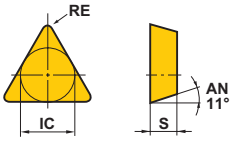
11° Positive Inserts (Without Hole)

M Class

SPMR
SPMN



TPMR
TPMN



Light to Medium	Strong Edge			
Standard	Flat Top			
				
Finish	Light	Light to Medium	Light to Medium	Strong Edge
FV	LP	MP	Standard	Flat Top
				

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
SPMR090304	M	●	●	●	9.525	3.18	0.4	-
SPMR090308	M	●	●	●	9.525	3.18	0.8	-
SPMR120304	M	●	●	●	12.7	3.18	0.4	-
SPMR120308	M	●	●	●	12.7	3.18	0.8	-
SPMN090308	-	●			9.525	3.18	0.8	-
SPMN120304	-	●			12.7	3.18	0.4	-
SPMN120308	-	●			12.7	3.18	0.8	-
SPMN120312	-	●		●	12.7	3.18	1.2	-

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TPMR160304-FV	F		●	●	9.525	3.18	0.4	-
TPMR110304-LP	L		●	●	6.35	3.18	0.4	-
TPMR110308-LP	L		●	●	6.35	3.18	0.8	-
TPMR160304-LP	L	●	●	●	9.525	3.18	0.4	-
TPMR160308-LP	L	●	●	●	9.525	3.18	0.8	-
TPMR110304-MP	M	●	●	●	6.35	3.18	0.4	-
TPMR110308-MP	M	●	●	●	6.35	3.18	0.8	-
TPMR160304-MP	M	●	●	●	9.525	3.18	0.4	-
TPMR160308-MP	M	●	●	●	9.525	3.18	0.8	-
TPMR110304	M	●	●	●	6.35	3.18	0.4	-
TPMR110308	M	●	●	●	6.35	3.18	0.8	-
TPMR160304	M	●	●	●	9.525	3.18	0.4	-
TPMR160308	M	●	●	●	9.525	3.18	0.8	-
TPMR160312	M	●	●		9.525	3.18	1.2	-
TPMN110304	-	●			6.35	3.18	0.4	-
TPMN110308	-	●			6.35	3.18	0.8	-
TPMN160304	-	●			9.525	3.18	0.4	-
TPMN160308	-	●			9.525	3.18	0.8	-
TPMN160312	-	●			9.525	3.18	1.2	-
TPMN220404	-	●			12.7	4.76	0.4	-
TPMN220408	-	●		●	12.7	4.76	0.8	-
TPMN220412	-	●			12.7	4.76	1.2	-

● = NEW

● : Inventory maintained in Japan.
(10 inserts in one case)

Memo

Recommended Cutting Conditions

Negative Inserts (For External Turning)

(mm)

Material	Properties	Cutting Range		Priority	Grade	Chipbreaker	Cutting Speed **vc** (m/min)	Feed **f** (mm/rev)	Depth of Cut **ap**
P									
Mild Steel	Hardness ≤180HB	✠	F	1	**MC6125**	**FY**	385–605	0.09–0.23	0.20–0.80
		✠	F	2	**MC6135**	**FY**	315–480	0.09–0.23	0.20–0.80
		✠	L	1	**MC6125**	**SY**	350–550	0.16–0.33	0.50–1.20
		✠	L	2	**MC6135**	**SY**	290–435	0.16–0.33	0.50–1.20
Carbon Steel Alloy Steel	Hardness 180–280HB	●	F	1	**MC6115**	**FPH**	275–525	0.20–0.50	0.10–1.00
		●	F	1	**MC6115**	**FP**	250–480	0.08–0.25	0.10–1.00
		●	F	2	**MC6125**	**FP**	275–425	0.08–0.25	0.10–1.00
		●	L	1	**MC6115**	**LP**	250–480	0.10–0.40	0.30–2.00
		●	L	2	**MC6125**	**LP**	275–425	0.10–0.40	0.30–2.00
		●	L	3	**MC6115**	**SH**	250–480	0.10–0.40	0.30–2.00
		●	L	4	**MC6125**	**SH**	275–425	0.10–0.40	0.30–2.00
		●	L	5	**MC6115**	**SA**	250–480	0.10–0.40	0.30–2.00
		●	L	6	**MC6125**	**SA**	275–425	0.10–0.40	0.30–2.00
		●	L	7	**MC6115**	**SW**	250–480	0.10–0.50	0.30–2.50
		●	L	8	**MC6125**	**SW**	275–425	0.10–0.50	0.30–2.50
		●	M	1	**MC6115**	**MP**	230–440	0.16–0.50	0.30–4.00
		●	M	2	**MC6125**	**MP**	250–390	0.16–0.50	0.30–4.00
		●	M	3	**MC6115**	**MA**	230–440	0.20–0.50	0.30–4.00
		●	M	4	**MC6125**	**MA**	250–390	0.20–0.50	0.30–4.00
		●	M	5	**MC6115**	**Std**	230–440	0.25–0.60	1.50–5.00
		●	M	6	**MC6125**	**Std**	250–390	0.25–0.60	1.50–5.00
		●	M	7	**MC6115**	**MW**	230–440	0.20–0.60	0.90–4.00
		●	M	8	**MC6125**	**MW**	250–390	0.20–0.60	0.90–4.00
		●	R	1	**MC6115**	**RP**	215–415	0.25–0.60	1.50–6.00
		●	R	2	**MC6125**	**RP**	235–370	0.25–0.60	1.50–6.00
		●	R	3	**MC6115**	**GH**	215–415	0.25–0.60	1.50–6.00
		●	R	4	**MC6125**	**GH**	235–370	0.25–0.60	1.50–6.00
		●	H	1	**MC6125**	**HX**	210–330	0.50–1.26	3.00–11.00
		●	H	2	**MC6135**	**HX**	170–260	0.50–1.26	3.00–11.00
		●	H	3	**MC6125**	**HV**	175–270	0.58–1.26	4.00–12.00
		●	H	4	**MC6135**	**HV**	140–215	0.58–1.26	4.00–12.00
		◐	F	1	**MC6125**	**FPH**	300–465	0.20–0.50	0.10–1.00
		◐	F	1	**MC6115**	**FP**	250–480	0.08–0.25	0.10–1.00
		◐	F	2	**MC6125**	**FP**	275–425	0.08–0.25	0.10–1.00
		◐	L	1	**MC6115**	**LP**	250–480	0.10–0.40	0.30–2.00
		◐	L	2	**MC6125**	**LP**	275–425	0.10–0.40	0.30–2.00
		◐	L	3	**MC6115**	**SH**	250–480	0.10–0.40	0.30–2.00
		◐	L	4	**MC6125**	**SH**	275–425	0.10–0.40	0.30–2.00
		◐	L	5	**MC6115**	**SA**	250–480	0.10–0.40	0.30–2.00
		◐	L	6	**MC6125**	**SA**	275–425	0.10–0.40	0.30–2.00
		◐	L	7	**MC6115**	**SW**	250–480	0.10–0.50	0.30–2.50
		◐	L	8	**MC6125**	**SW**	275–425	0.10–0.50	0.30–2.50
		◐	M	1	**MC6125**	**MP**	250–390	0.16–0.50	0.30–4.00
		◐	M	2	**MC6135**	**MP**	205–310	0.16–0.50	0.30–4.00
		◐	M	3	**MC6125**	**MA**	250–390	0.20–0.50	0.30–4.00
		◐	M	4	**MC6135**	**MA**	205–310	0.20–0.50	0.30–4.00
		◐	M	5	**MC6125**	**MH**	250–390	0.20–0.55	1.00–4.00
		◐	M	6	**MC6135**	**MH**	205–310	0.20–0.55	1.00–4.00
		◐	M	7	**MC6125**	**Std**	250–390	0.25–0.60	1.50–5.00
		◐	M	8	**MC6135**	**Std**	205–310	0.25–0.60	1.50–5.00
		◐	M	9	**MC6125**	**MW**	250–390	0.20–0.60	0.90–4.00
		◐	M	10	**MC6135**	**MW**	205–310	0.20–0.60	0.90–4.00

Note 1) Recommended cutting conditions for 5º/7º/11º positive inserts are provided as a guideline only.
Verify the recommended conditions for each boring bar as cutting conditions for internal machining will vary depending on the length of overhang.

Cutting Conditions : ● : Stable Cutting ◐ : General Cutting ✠ : Unstable Cutting
Cutting Area : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting **R** : Rough Cutting **H** : Heavy Cutting

(mm)

Material	Properties	Cutting Range		Priority	Grade	Chipbreaker	Cutting Speed **vc** (m/min)	Feed **f** (mm/rev)	Depth of Cut **ap**
Carbon Steel Alloy Steel	Hardness 180–280HB		R	1	**MC6135**	**RP**	190–290	0.25–0.60	1.50–6.00
			R	2	**MC6125**	**RP**	235–370	0.25–0.60	1.50–6.00
			R	3	**MC6135**	**GH**	190–290	0.25–0.60	1.50–6.00
			R	4	**MC6125**	**GH**	235–370	0.25–0.60	1.50–6.00
			H	1	**MC6135**	**HX**	170–260	0.50–1.26	3.00–11.00
			H	2	**MC6125**	**HX**	210–330	0.50–1.26	3.00–11.00
			H	3	**MC6135**	**HV**	140–215	0.58–1.26	4.00–12.00
			H	4	**MC6125**	**HV**	175–270	0.58–1.26	4.00–12.00
			F	1	**MC6135**	**FP**	245–370	0.08–0.25	0.10–1.00
			F	2	**MC6125**	**FP**	300–465	0.08–0.25	0.10–1.00
			F	3	**MC6135**	**FPH**	245–370	0.20–0.50	0.10–1.00
			L	1	**MC6135**	**LP**	225–340	0.10–0.40	0.30–2.00
			L	2	**MC6125**	**LP**	275–425	0.10–0.40	0.30–2.00
			L	3	**MC6135**	**SH**	225–340	0.10–0.40	0.30–2.00
			L	4	**MC6125**	**SH**	275–425	0.10–0.40	0.30–2.00
			L	5	**MC6135**	**SA**	225–340	0.10–0.40	0.30–2.00
			L	6	**MC6125**	**SA**	275–425	0.10–0.40	0.30–2.00
			M	1	**MC6135**	**MP**	205–310	0.16–0.50	0.30–4.00
			M	2	**MC6125**	**MP**	250–390	0.16–0.50	0.30–4.00
			M	3	**MC6135**	**MA**	205–310	0.20–0.50	0.30–4.00
			M	4	**MC6125**	**MA**	250–390	0.20–0.50	0.30–4.00
			M	5	**MC6135**	**MH**	205–310	0.20–0.55	1.00–4.00
			M	6	**MC6125**	**MH**	250–390	0.20–0.55	1.00–4.00
			M	7	**MC6135**	**Std**	205–310	0.25–0.60	1.50–5.00
			M	8	**MC6125**	**Std**	250–390	0.25–0.60	1.50–5.00
			M	9	**MC6135**	**MW**	205–310	0.20–0.60	0.90–4.00
			M	10	**MC6125**	**MW**	250–390	0.20–0.60	0.90–4.00
			R	1	**MC6135**	**RP**	190–290	0.25–0.60	1.50–6.00
			R	2	**MC6125**	**RP**	235–370	0.25–0.60	1.50–6.00
			R	3	**MC6135**	**GH**	190–290	0.25–0.60	1.50–6.00
			R	4	**MC6125**	**GH**	235–370	0.25–0.60	1.50–6.00
			H	1	**MC6135**	**HX**	170–260	0.50–1.26	3.00–11.00
			H	2	**MC6125**	**HX**	210–330	0.50–1.26	3.00–11.00

Note 1) Recommended cutting conditions for 5º/7º/11º positive inserts are provided as a guideline only.
Verify the recommended conditions for each boring bar as cutting conditions for internal machining will vary depending on the length of overhang.

Recommended Cutting Conditions

5° 7° Positive Inserts (For External Turning)

(mm)

Material	Properties	Cutting Range		Priority	Grade	Chipbreaker	Cutting Speed **vc** (m/min)	Feed **f** (mm/rev)	Depth of Cut **ap**
P									
Mild Steel	Hardness ≤180HB	◐	F	1	**MC6115**	**FP**	295—570	0.04—0.20	0.20—0.90
		◐	F	2	**MC6115**	**FV**	295—570	0.04—0.20	0.20—0.90
		◐	L	1	**MC6115**	**LP**	295—570	0.06—0.25	0.20—1.00
		◐	L	2	**MC6115**	**SW**	295—570	0.06—0.24	0.20—1.50
		◐	M	1	**MC6115**	**MP**	245—475	0.08—0.30	0.30—2.00
		◐	M	2	**MC6115**	**MV**	245—475	0.08—0.30	0.30—2.00
		◐	M	3	**MC6115**	**MW**	245—475	0.10—0.35	0.80—2.50
		✣	F	1	**MC6125**	**FP**	320—505	0.04—0.20	0.20—0.90
		✣	F	2	**MC6135**	**FP**	265—400	0.04—0.20	0.20—0.90
		✣	L	1	**MC6125**	**LP**	320—505	0.06—0.25	0.20—1.00
		✣	L	2	**MC6135**	**LP**	265—400	0.06—0.25	0.20—1.00
		✣	L	3	**MC6125**	**SW**	320—505	0.06—0.24	0.20—1.50
		✣	M	1	**MC6125**	**MP**	270—420	0.08—0.30	0.30—2.00
		✣	M	2	**MC6135**	**MP**	220—330	0.08—0.30	0.30—2.00
		✣	M	3	**MC6125**	**MV**	270—420	0.08—0.30	0.30—2.00
		✣	M	4	**MC6125**	**MW**	270—420	0.10—0.35	0.80—2.50
Carbon Steel Alloy Steel	Hardness 180—280HB	◐	F	1	**MC6115**	**FP**	220—420	0.04—0.20	0.20—0.90
		◐	F	2	**MC6125**	**FP**	240—370	0.04—0.20	0.20—0.90
		◐	F	3	**MC6115**	**FV**	220—420	0.04—0.20	0.20—0.90
		◐	L	1	**MC6115**	**LP**	220—420	0.06—0.25	0.20—1.00
		◐	L	2	**MC6125**	**LP**	240—370	0.06—0.25	0.20—1.00
		◐	M	1	**MC6125**	**MP**	200—310	0.08—0.30	0.30—2.00
		◐	M	2	**MC6115**	**MP**	180—350	0.08—0.30	0.30—2.00
		◐	M	3	**MC6125**	**MV**	200—310	0.08—0.30	0.30—2.00
		◐	M	4	**MC6115**	**MV**	180—350	0.08—0.30	0.30—2.00
		◐	M	5	**MC6115**	**MW**	180—350	0.10—0.35	0.80—2.50
		✣	F	1	**MC6125**	**FP**	240—370	0.04—0.20	0.20—0.90
		✣	F	2	**MC6135**	**FP**	195—295	0.04—0.20	0.20—0.90
		✣	F	3	**MC6125**	**FV**	240—370	0.04—0.20	0.20—0.90
		✣	L	1	**MC6125**	**LP**	240—370	0.06—0.25	0.20—1.00
		✣	L	2	**MC6135**	**LP**	195—295	0.06—0.25	0.20—1.00
		✣	L	3	**MC6125**	**SW**	240—370	0.06—0.24	0.20—1.50
		✣	M	1	**MC6125**	**MP**	200—310	0.08—0.30	0.30—2.00
		✣	M	2	**MC6135**	**MP**	160—245	0.08—0.30	0.30—2.00
		✣	M	3	**MC6125**	**MV**	200—310	0.08—0.30	0.30—2.00
Carbon Steel Alloy Steel	Hardness 280—350HB	◐	F	1	**MC6115**	**FP**	155—295	0.04—0.20	0.20—0.90
		◐	F	2	**MC6115**	**FV**	155—295	0.04—0.20	0.20—0.90
		◐	L	1	**MC6115**	**LP**	155—295	0.06—0.25	0.20—1.00
		◐	M	1	**MC6115**	**MP**	130—245	0.08—0.30	0.30—2.00
		◐	M	2	**MC6115**	**MV**	130—245	0.08—0.30	0.30—2.00
		✣	F	1	**MC6125**	**FP**	170—265	0.04—0.20	0.20—0.90
		✣	F	2	**MC6135**	**FP**	135—210	0.04—0.20	0.20—0.90
		✣	L	1	**MC6125**	**LP**	170—265	0.06—0.25	0.20—1.00
		✣	L	2	**MC6135**	**LP**	135—210	0.06—0.25	0.20—1.00
		✣	M	1	**MC6125**	**MP**	140—220	0.08—0.30	0.30—2.00
		✣	M	2	**MC6135**	**MP**	115—175	0.08—0.30	0.30—2.00
		✣	M	3	**MC6125**	**MV**	140—220	0.08—0.30	0.30—2.00

Note 1) Recommended cutting conditions for 5º/7º/11º positive inserts are provided as a guideline only.
Verify the recommended conditions for each boring bar as cutting conditions for internal machining will vary depending on the length of overhang.

Note 2) Please scan the QR code for a leaflet of the recommended conditions for the XCMT profile holder insert.

Cutting Conditions : ● : Stable Cutting ◐ : General Cutting ✣ : Unstable Cutting
Cutting Area : **F** : Finish Cutting **L** : Light Cutting **M** : Medium Cutting

11° Positive Inserts (For External Turning)

(mm)

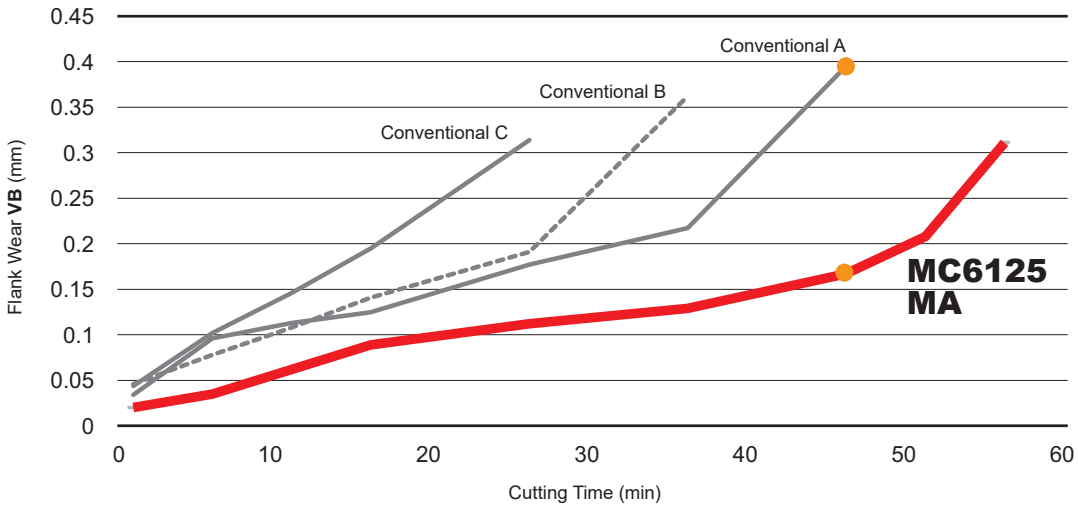
Material	Properties	Cutting Range		Priority	Grade	Chipbreaker	Cutting Speed **vc** (m/min)	Feed **f** (mm/rev)	Depth of Cut **ap**
P									
Mild Steel	Hardness ≤180HB		F	1	**MC6125**	**FP**	320–505	0.04–0.20	0.20–0.90
			F	2	**MC6125**	**FV**	320–505	0.04–0.20	0.20–0.90
			L	1	**MC6125**	**LP**	320–505	0.06–0.25	0.20–1.00
			L	2	**MC6115**	**R-Std**	245–475	0.08–0.30	0.30–2.00
			M	1	**MC6125**	**MP**	270–420	0.08–0.30	0.30–2.00
			M	2	**MC6115**	**MP**	245–475	0.08–0.30	0.30–2.00
			M	3	**MC6125**	**MV**	270–420	0.08–0.30	0.30–2.00
			M	4	**MC6115**	**MV**	245–475	0.08–0.30	0.30–2.00
			L	1	**MC6125**	**LP**	320–505	0.06–0.25	0.20–1.00
			L	2	**MC6135**	**LP**	265–400	0.06–0.25	0.20–1.00
			M	1	**MC6125**	**MP**	270–420	0.08–0.30	0.30–2.00
			M	2	**MC6135**	**MP**	220–330	0.08–0.30	0.30–2.00
			M	3	**MC6125**	**MV**	270–420	0.08–0.30	0.30–2.00
			M	4	**MC6135**	**MV**	220–330	0.08–0.30	0.30–2.00
Carbon Steel Alloy Steel	Hardness 180–280HB		F	1	**MC6125**	**FP**	240–370	0.04–0.20	0.20–0.90
			F	2	**MC6125**	**FV**	240–370	0.04–0.20	0.20–0.90
			L	1	**MC6125**	**LP**	240–370	0.06–0.25	0.20–1.00
			L	2	**MC6115**	**LP**	220–420	0.06–0.25	0.20–1.00
			M	1	**MC6125**	**MP**	200–310	0.08–0.30	0.30–2.00
			M	2	**MC6125**	**MV**	200–310	0.08–0.30	0.30–2.00
			M	3	**MC6115**	**R-Std**	180–350	0.08–0.30	0.30–2.00
			M	4	**MC6125**	**R-Std**	200–310	0.08–0.30	0.30–2.00
			L	1	**MC6125**	**LP**	240–370	0.06–0.25	0.20–1.00
			L	2	**MC6135**	**LP**	195–295	0.06–0.25	0.20–1.00
			M	1	**MC6125**	**MP**	200–310	0.08–0.30	0.30–2.00
			M	2	**MC6135**	**MP**	160–245	0.08–0.30	0.30–2.00
			M	3	**MC6125**	**MV**	200–310	0.08–0.30	0.30–2.00
			M	4	**MC6135**	**MV**	160–245	0.08–0.30	0.30–2.00

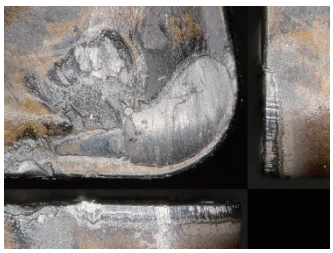
Note 1) Recommended cutting conditions for 5º/7º/11º positive inserts are provided as a guideline only.
Verify the recommended conditions for each boring bar as cutting conditions for internal machining will vary depending on the length of overhang.

Cutting Performance

Machining SCr420H : Comparison of Wear Resistance During Continuous Wet Cutting

The thick coating exclusively for MC6125 effectively suppresses early wear.





MC6125 MA 46 min.

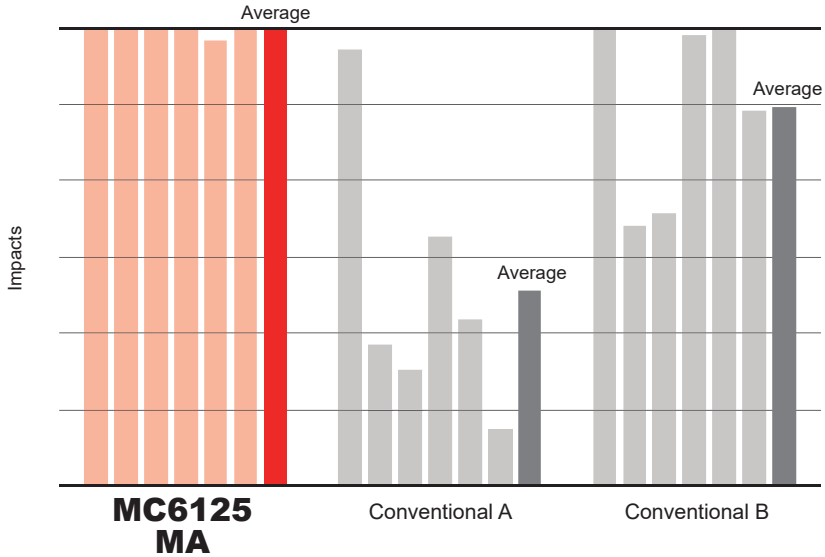


Conventional A 46 min.

<Cutting Conditions>
Material : JIS SCr420H
Inserts : CNMG120408-○○
Cutting Speed : vc=300m/min
Feed per Rev. : f=0.3mm/rev
Depth of Cut : ap=1.5mm
Cutting Mode : Wet Cutting

Comparison of Toughness During Interrupted Cutting

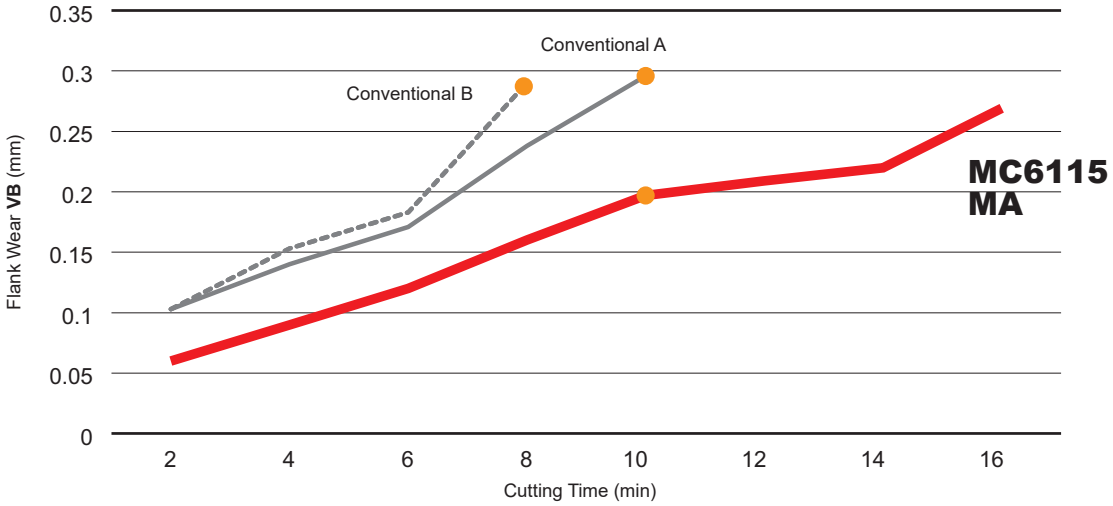
Provides stable cutting under severe cutting conditions that are likely to cause sudden fracturing.

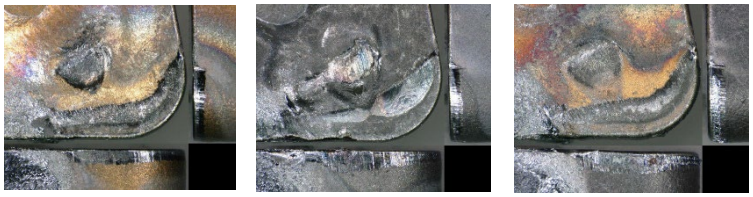


<Cutting Conditions>
Material : JIS SCM440
Inserts : CNMG120408-○○
Cutting Speed : vc=200m/min
Feed per Rev. : f=0.25mm/rev
Depth of Cut : ap=1.5mm
Cutting Mode : Wet Cutting

Machining S45C : Comparison of Wear Resistance During Continuous Dry Cutting

The "Super" Nano Texture Technology increases tool life even when dry cutting by suppressing crater wear.



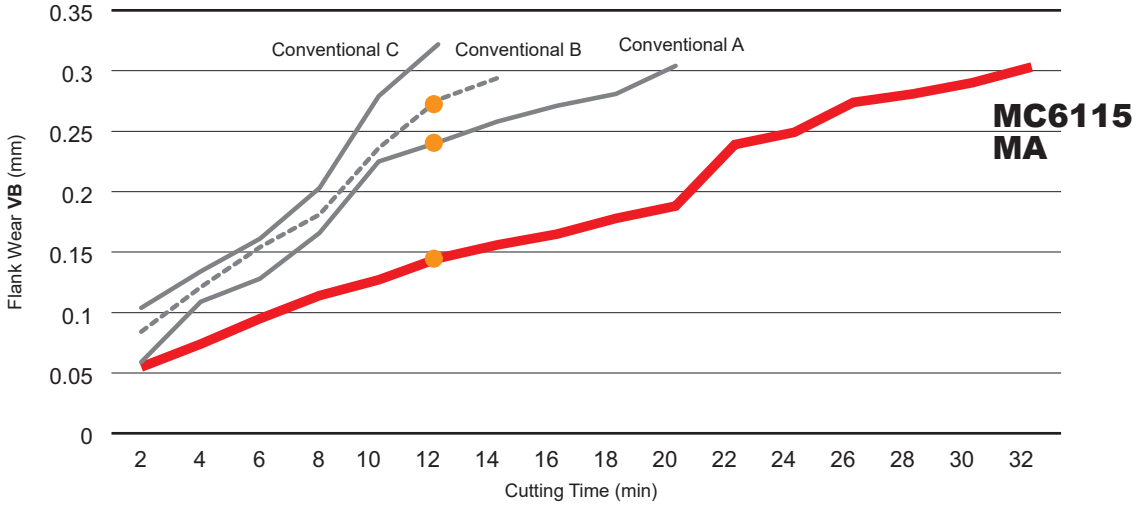


MC6115 10 min. Conventional A 10 min. Conventional B 8 min.

<Cutting Conditions>
Material : JIS S45C
Inserts : CNMG120408-○○
Cutting Speed : vc=300m/min
Feed per Rev. : f=0.3mm/rev
Depth of Cut : ap=1.5mm
Cutting Mode : Dry Cutting

Machining SUJ2 : Comparison of Wear Resistance During Continuous Wet Cutting

The thick coating provides high flank wear resistance.





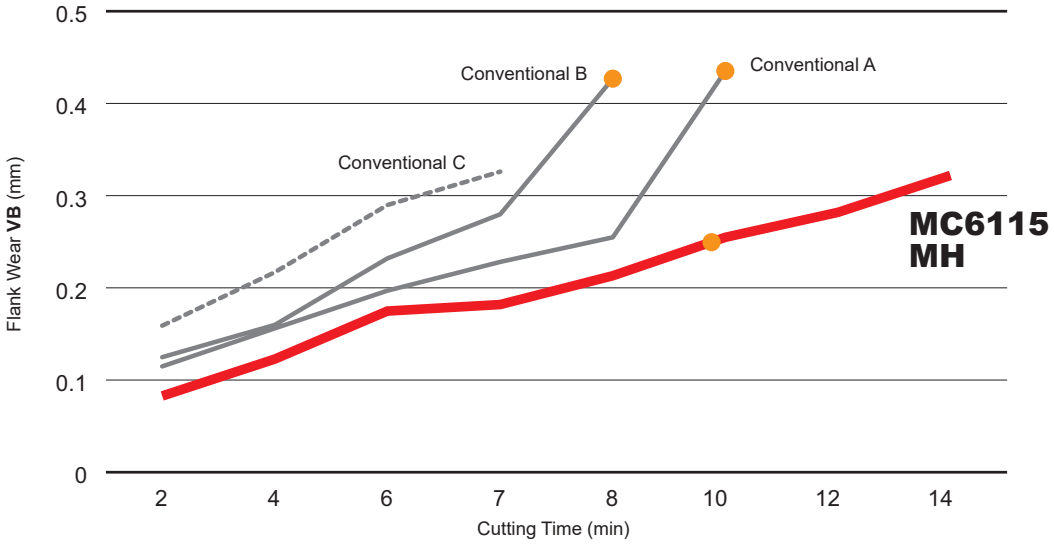
MC6115 12 min. Conventional A 12 min. Conventional B 12 min.

<Cutting Conditions>
Material : JIS SUJ2
Inserts : CNMG120408-○○
Cutting Speed : vc=300m/min
Feed per Rev. : f=0.3mm/rev
Depth of Cut : ap=1.5mm
Cutting Mode : Wet Cutting

Cutting Performance

Machining SCM440 : Comparison of Wear Resistance During Continuous Wet Cutting

MC6115 with high edge strength chipbreaker can also enable excellent wear resistance during high speed turning.





MC6115 10 min.



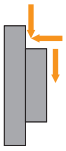
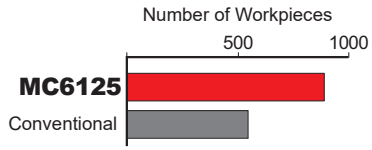
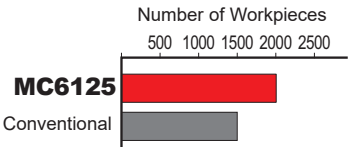
Conventional A 10 min.

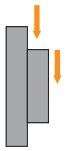
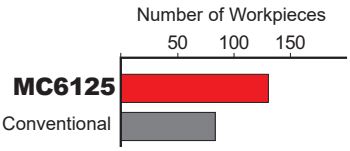
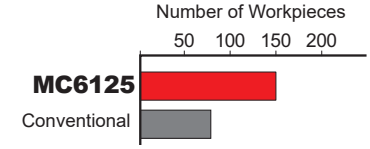


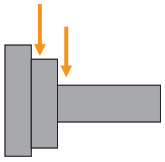
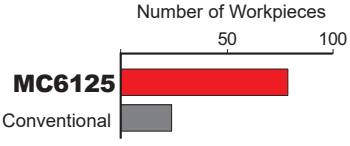
Conventional B 8 min.

<Cutting Conditions>
Material : JIS SCM440
Inserts : CNMG120408-◯◯
Cutting Speed : vc=350m/min
Feed per Rev. : f=0.3mm/rev
Depth of Cut : ap=1.5mm
Cutting Mode : Wet Cutting

Examples of Usage

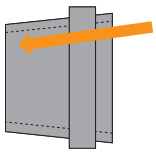
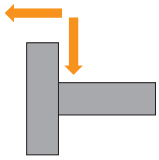
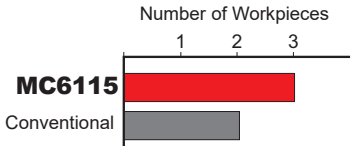
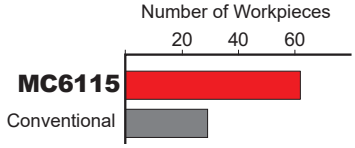
Insert		CNMG120408-MA	WNMG080408-MP
Workpiece		JIS S45C 	Carbon Steel 
Component		Hex Bar Parts	Automotive Parts
Application		Interrupted Finish Turning	External Turning and Facing
Cutting Conditions	Cutting Speed vc (m/min)	150	80
	Feed per Rev. f (mm/rev)	0.2	0.1-0.5
	Depth of Cut ap (mm)	2.0, 1.6	0.5
Cutting Mode		Wet Cutting	Wet Cutting
Results		 Conventional products fractured after chipping but MC6125 formed good chip shapes and achieved a longer tool life.	 MC6125 achieved more than 1.3 times longer tool life due to its high wear resistance.

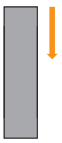
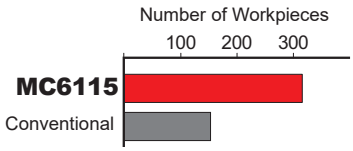
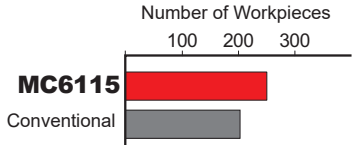
Insert		DNMG150412-SH	CNMG120408-MH
Workpiece		JIS S53C 	General Structural Steel 
Component		–	Hun Parts
Application		Interrupted Finish Turning	Face Turning
Cutting Conditions	Cutting Speed vc (m/min)	200	200→240
	Feed per Rev. f (mm/rev)	0.3	0.25
	Depth of Cut ap (mm)	1.2	2.0
Cutting Mode		Wet Cutting	Wet Cutting
Results		 MC6125 provided a stable cutting action and achieved 1.5 times more tool life than conventional products.	 MC6125 improved efficiency and tool life by increasing the cutting speed.

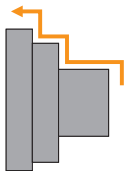
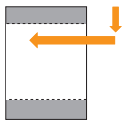
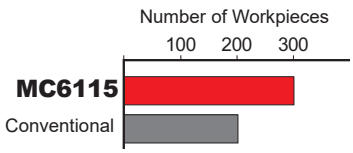
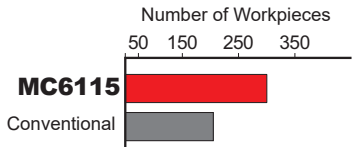
Insert		CNMG120412-RP
Workpiece		JIS SCM435 
Component		Flange Parts
Application		External Turning and Facing
Cutting Conditions	Cutting Speed vc (m/min)	200
	Feed per Rev. f (mm/rev)	0.25
	Depth of Cut ap (mm)	1.5
Cutting Mode		Wet Cutting
Results		 Conventional products machined an inconsistent number of components. MC6125 was more consistent and improved tool life.

The application examples are from customers workpieces and can therefore differ from the recommended cutting conditions.

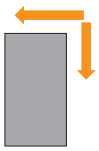
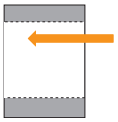
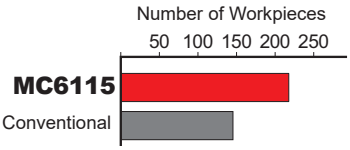
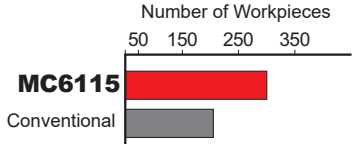
Examples of Usage

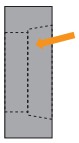
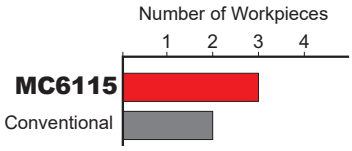
Insert		CNMG120408-MA	WNMG080408-MA
Workpiece		JIS SCM440 	JIS SCr440 
Component		Heavy Machinery Parts	Automotive Parts
Application		Internal Turning	External Face Turning
Cutting Conditions	Cutting Speed vc (m/min)	150	290
	Feed per Rev. f (mm/rev)	0.3	0.25
	Depth of Cut ap (mm)	1.5	1.0
Cutting Mode		Wet Cutting	Wet Cutting
Results		 Tool life increased x 1.5 on a large workpiece (inner diameter 430 mm)	 The excellent wear resistance of MC6115 helped achieve double tool life.

Insert		WNMG080408-MA	WNMG080412-MP
Workpiece		JIS SUJ2 	JIS SCr420H 
Component		Bearing Parts	Machine Parts
Application		External Face Turning	Face Turning
Cutting Conditions	Cutting Speed vc (m/min)	198-278	235
	Feed per Rev. f (mm/rev)	0.21-0.3	0.35
	Depth of Cut ap (mm)	1.0	1.0
Cutting Mode		Wet Cutting	Wet Cutting
Results		 The excellent wear resistance of MC6115 helped achieve double tool life.	 MC6115 achieved longer tool life compared to a conventional product.

Insert		WNMG080408-MP	WNMG080416-MA
Workpiece		JIS SCr440 	JIS S50C 
Component		Hub	Joint Parts
Application		External Turning and Facing	Internal Turning and Facing
Cutting Conditions	Cutting Speed vc (m/min)	300	215
	Feed per Rev. f (mm/rev)	0.25-0.35	0.25-0.27
	Depth of Cut ap (mm)	1-2.5	3.15
Cutting Mode		Wet Cutting	Wet Cutting
Results		 Superior wear resistance compared to conventional products meant tool life was extended.	 Excellent wear resistance during rough machining of forged product applications helped achieve 150% tool life.

The application examples are from customers workpieces and can therefore differ from the recommended cutting conditions.

Insert		DNMG150612-SA	CNMG120408-MP
Workpiece		Bearing Steel 	JIS SCr440 
Component		Bearing Parts	Shaft Parts
Application		External Turning and Facing	Internal Turning
Cutting Conditions	Cutting Speed vc (m/min)	260	280
	Feed per Rev. f (mm/rev)	0.3-0.35	0.29
	Depth of Cut ap (mm)	0.5	2.5
Cutting Mode		Wet Cutting	Wet Cutting
Results		 Extreme resistance to chipping achieved 150% tool life and enabled easy identification of wear.	 Number of components machined increased by 50% due to improved wear resistance.

Insert		WNMG080408-MP
Workpiece		Heated Tool Steel 
Component		Die Casting Parts
Application		Internal Turning
Cutting Conditions	Cutting Speed vc (m/min)	160
	Feed per Rev. f (mm/rev)	0.25
	Depth of Cut ap (mm)	2.0
Cutting Mode		Wet Cutting
Results		 MC6115 gave 1.5 x longer tool life even when machining heat treated materials.

The application examples are from customers workpieces and can therefore differ from the recommended cutting conditions.



CVD Coated Grade for Steel Turning

MC6100 Series

Environmentally Friendly Product

This product has been certified as an environmentally friendly product in the machine tool industry by the Japan Cutting & Wear-resistant Tool Association. This is a product unique to the industry, in harmony with the environment, and with the aim of fulfilling the social responsibilities of the machine tool industry.

The Japan Cutting & Wear-resistant Tool Association evaluates the product's environmental impact during the manufacturing and usage stages and issues a certification according to the evaluation score.



For People, Society and the Earth

More information about MITSUBISHI MATERIALS' efforts to address social and environmental issues can be found in the website below or by scanning the QR code.

https://mmc.disclosure.site/en/



For Your Safety
●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or driver. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds, etc.

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(Tool specifications are subject to change without notice.)

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