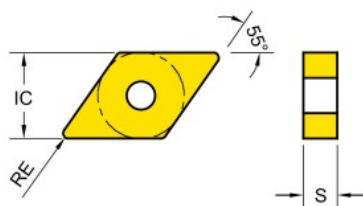


Turning Inserts - Negative DNMG (55° Rhombic)



Series	IC	S
DN** 1104	9.525	4.76
DN** 1504	12.700	4.76
DN** 1506	12.700	6.35

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

DNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..																
					K10	P05	P10	P15	P10	P20	P30	P20	M25	M15	M30	M40	S10	P15 M15 K15	N20	N20	
-UM Medium Machining Unstable condition	DNMG 150404 - UM	0.4	0.15 ~ 0.30	0.5 ~ 3.0	YG1010	YG1001	YG3010	YG3015	YG3115	YG3020	YG3030	YG801	YG2025	YG211	YG213	YG214	YG401	YT100	YG100	YG10	
					1672		1702		2608	1703	1707										
							1106	0688		2360	0689	0701									
							0604	0512		2203	0488	0705									
							1408	1436		2609	1409	1425									
							1128	0240		2201	0241	0242									
-UG Medium Machining at stable condition	DNMG 150404 - UG	0.4	0.20 ~ 0.40	0.5 ~ 3.0																	
					1618		1131		2443	0772	1137										
						1608	0452	0366		2368	0367	0368	0017								
						1514	0703	1107		2442	0487	0704									
						1619		0228		2375	0229	0230									
						1609	0453	0234		2212	0235	0236	0019								
-UC Cast iron and Medium roughing	DNMG 150408 - UC	0.8	0.20 ~ 0.40	1.0 ~ 4.0																	
					1611	0577	0578	1273	2388	1193	0700										
					1512	0579	0580		2373	1168	0702										
					0898	0090	0121	1272	2376	0104	0122										
-UR Roughing	DNMG 150408 - UR	0.8	0.30 ~ 0.50	1.0 ~ 5.0																	
					1621	1095	0585		2446	1096	1097										
					1513	1127	0581		2400	1134	1101										
					1622	0691	0692		2447	0693	0854										
					1510		0371		2416	0372	0373	0020									