

STEEL SERIES PERFORMANCE TURNING

NC3215 & NC3225 provide exceptional turning tool life and performance for machining carbon, alloy, pre-hardened and tool steel.

CVD coated grades in combination with steel specific chip breakers give excellent tool life, chip control and performance.

- Grade NC3225 1st choice for medium speed continuous or light intermittent turning, combining excellent toughness and wear resistance.
- Grade NC3215 1st choice for high speed continuous turning where tool life and cycle times are most important.

Chip breakers include LP (medium to finish cuts), MP (medium to roughing) and VR (roughing).

RECOMMENDED CUTTING CONDITIONS

Material Group	Material	Surface Speed (m/min)	
		NC3215	NC3225
Steel	Low Carbon Steel	215-400	190-350
	Alloy Steel	150-300	150-250
	Pre-Hardened Steel	100-200	75-135

P Steel	H Hardened Steel	M Stainless Steel	S HRSA's	K Cast Iron	N Non-Ferrous
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CVD COATED PERFORMANCE TURNING INSERTS FOR STEEL

CHIP BREAKER GUIDE

LP

Medium to finish cutting of steel. Ideal for low power machines where cut depths are less than 2.5mm or for finishing applications with a negative insert.



Depth of cut: 0.5-2.5mm
Feed rate: 0.10-0.40mm/rev

MP (NEGATIVE)

Medium to light roughing of steel with negative geometry inserts. Excellent performance across a wide range of cut depths. Good chip control on long and short chipping steels.



Depth of cut: 0.5-5.5mm
Feed rate: 0.15-0.45mm/rev

MP (POSITIVE)

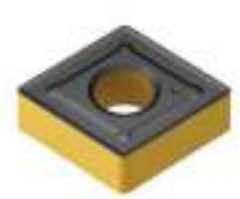
Medium to finishing of steel with positive geometry inserts. Sharp cutting edge and wide chip pocket for low cutting load. Excellent surface finish.



Depth of cut: 0.3-3.0mm
Feed rate: 0.05-0.30mm/rev

VR

Heavy duty cutting, high feed machining or roughing of steel. Shallow chip breaker design prevents chip blocking at high feed. Wide land pockets enables large cut depths.



Depth of cut: 1.2-7.0mm
Feed rate: 0.25-0.55mm/rev

NC3215/NC3225 CVD COATED TURNING INSERTS FOR STEEL



GRADE		ORDER CODE		PRICE	FEED f _n (mm/rev)	DEPTH OF CUT a _p (mm)
ISO	RADIUS	NC3215	NC3225			
CCMT060202-MP	0.2	1-02-057543	1-02-057563		0.04-0.12	0.20-1.50
CCMT060204-MP	0.5	1-02-057544	1-02-057564		0.05-0.15	0.30-1.50
CCMT060208-MP	0.8	-	1-02-069207		0.07-0.15	0.50-2.00
CCMT09T302-MP	0.2	1-02-057545	1-02-056344		0.07-0.15	0.30-2.00
CCMT09T304-MP	0.4	1-02-056032	1-02-055979		0.08-0.25	0.50-2.50
CCMT09T308-MP	0.8	1-02-056033	1-02-055980		0.10-0.30	0.50-2.50
CCMT120404-MP	0.4	-	1-02-068812		0.10-0.30	0.50-3.50
CCMT120408-MP	0.8	-	1-02-055981		0.15-0.35	0.80-3.50
CNMG090308-LP	0.8	1-02-070409	1-02-062802		0.10-0.30	0.30-1.50
CNMG120404-LP	0.4	1-02-056911	1-02-057565		0.10-0.35	0.30-2.00
CNMG120408-LP	0.8	1-02-055610	1-02-056872		0.10-0.40	0.50-2.50
CNMG120412-LP	1.2	1-02-056478	1-02-056873		0.13-0.45	0.80-3.00
CNMG090304-MP	0.4	1-02-063623	1-02-063638		0.10-0.40	0.40-3.80
CNMG090308-MP	0.8	1-02-063624	1-02-063639		0.15-0.40	0.50-4.00
CNMG120404-MP	0.4	1-02-057143	1-02-057182		0.10-0.40	0.40-4.00
CNMG120408-MP	0.8	1-02-056507	1-02-056846		0.15-0.45	0.50-4.50
CNMG120412-MP	1.2	1-02-056238	1-02-056880		0.15-0.50	0.80-5.00
CNMG120416-MP	1.6	1-02-060877	1-02-063640		0.28-0.55	1.00-5.00
CNMG160608-MP	0.8	1-02-058362	1-02-058363		0.15-0.50	0.50-7.00
CNMG160612-MP	1.2	1-02-058367	1-02-058368		0.18-0.60	0.80-7.00
CNMG160616-MP	1.6	1-02-061408	1-02-059617		0.15-0.60	1.00-7.00
CNMG190612-VR	1.2	1-02-057694	1-02-057692		0.35-0.70	2.00-10.00
CNMG190616-VR	1.6	1-02-058804	1-02-058805		0.35-0.75	2.20-10.00
DCMT070202-MP	0.2	1-02-057546	1-02-057566		0.04-0.12	0.12-1.80
DCMT070204-MP	0.4	1-02-057547	1-02-057567		0.05-0.15	0.30-1.80
DCMT070208-MP	0.8	1-02-057548	1-02-057568		0.08-0.22	0.30-1.80
DCMT11T302-MP	0.2	1-02-057549	1-02-056366		0.04-0.15	0.30-2.00
DCMT11T304-MP	0.4	1-02-056035	1-02-055982		0.08-0.20	0.50-2.30
DCMT11T308-MP	0.8	1-02-056036	1-02-055983		0.10-0.30	0.50-2.30
DNMG110404-LP	0.4	1-02-062889	1-02-060847		0.07-0.30	0.30-1.50
DNMG150404-LP	0.4	1-02-057550	1-02-057569		0.10-0.35	0.30-2.00
DNMG150408-LP	0.8	1-02-056479	1-02-056874		0.10-0.40	0.50-2.50
DNMG150412-LP	1.2	1-02-056480	1-02-056875		0.13-0.45	0.80-3.00
DNMG150604-LP	0.4	1-02-057043	1-02-057570		0.10-0.35	0.30-2.00
DNMG150608-LP	0.8	1-02-056979	1-02-056876		0.10-0.40	0.50-2.50
DNMG150612-LP	1.2	1-02-056980	1-02-056877		0.13-0.45	0.80-3.00
DNMG110404-MP	0.4	1-02-063630	1-02-063642		0.10-0.40	0.40-3.80
DNMG110408-MP	0.8	1-02-062888	1-02-060848		0.15-0.40	0.50-4.00
DNMG150404-MP	0.4	1-02-057144	1-02-057183		0.10-0.40	0.40-4.00
DNMG150408-MP	0.8	1-02-056239	1-02-056881		0.15-0.45	0.50-4.50
DNMG150412-MP	1.2	1-02-056240	1-02-056882		0.15-0.50	0.80-5.00
DNMG150604-MP	0.4	1-02-057145	1-02-057184		0.10-0.40	0.40-4.00
DNMG150608-MP	0.8	1-02-056537	1-02-056883		0.15-0.45	0.50-4.50
DNMG150612-MP	1.2	1-02-056538	1-02-056884		0.15-0.50	0.80-5.00
KNUX160405R-11	0.5	-	1-02-055969		0.20-0.35	1.00-6.00
KNUX160405L-11	0.5	-	1-02-058248		0.20-0.35	1.00-6.00

GRADE		ORDER CODE		PRICE	FEED f _n (mm/rev)	DEPTH OF CUT a _p (mm)
ISO	RADIUS	NC3215	NC3225			
SCMT09T308-MP	0.8	1-02-056037	1-02-055984		0.10-0.30	0.50-2.80
SCMT120404-MP	0.4	1-02-069365	1-02-068815		0.10-0.30	0.50-2.80
SCMT120408-MP	0.8	1-02-062353	1-02-058259		0.15-0.35	0.80-3.50
SNMG120404-MP	0.4	1-02-057552	1-02-057330		0.10-0.40	0.40-4.00
SNMG120408-MP	0.8	1-02-056241	1-02-056885		0.15-0.45	0.50-4.50
SNMG120412-MP	1.2	1-02-058411	1-02-058251		0.15-0.50	0.80-5.00
SNMG120416-MP	1.6	1-02-062750	1-02-062751		0.18-0.60	0.80-7.00
SNMG190612-VR	1.2	1-02-058818	1-02-058819		0.35-0.70	2.00-10.00
SNMG190616-VR	1.6	1-02-058821	1-02-058822		0.35-0.75	2.20-10.00
TCMT110202-MP	0.2	1-02-057917	1-02-057935		0.03-0.12	0.20-1.50
TCMT110204-MP	0.4	1-02-057919	1-02-057937		0.05-0.15	0.20-15.0
TCMT110208-MP	0.8	1-02-057921	1-02-057938		0.10-0.28	0.25-2.00
TCMT16T304-MP	0.4	1-02-056038	1-02-055985		0.08-0.20	0.30-2.50
TCMT16T308-MP	0.8	1-02-056039	1-02-055986		0.10-0.30	0.50-2.50
TCMT16T312-MP	1.2	1-02-057553	1-02-056399		0.20-0.40	0.50-2.50
TNMG160404-MP	0.4	1-02-057146	1-02-057185		0.10-0.40	0.40-3.50
TNMG160408-MP	0.8	1-02-056242	1-02-056886		0.15-0.45	0.50-4.00
TNMG160412-MP	1.2	1-02-057555	1-02-057186		0.15-0.50	0.80-4.50
TNMG220404-MP	0.4	1-02-058428	1-02-058429		0.10-0.35	0.40-5.00
TNMG220408-MP	0.8	1-02-058433	1-02-058254		0.15-0.45	0.50-5.50
TNMG220412-MP	1.2	1-02-058439	1-02-058255		0.15-0.50	0.80-6.00
TNMG220416-MP	1.6	1-02-063633	1-02-063645		0.20-0.55	1.00-6.00
VBMT110304-MP	0.4	1-02-064307	1-02-064310		0.05-0.15	0.20-1.50
VBMT110308-MP	0.8	1-02-064756	1-02-070540		0.10-0.28	0.30-2.00
VBMT160404-MP	0.4	1-02-057556	1-02-056414		0.08-0.20	0.30-2.00
VBMT160408-MP	0.8	1-02-057068	1-02-056416		0.10-0.25	0.50-2.30
VBMT160412-MP	1.2	1-02-057557	1-02-056417		0.10-0.35	0.50-2.30
VCMT160404-MP	0.4	1-02-057926	1-02-057941		0.08-0.20	0.30-2.00
VCMT160408-MP	0.8	1-02-054812	1-02-057573		0.10-0.25	0.50-2.30
VCMT160412-MP	1.2	-	1-02-062363		0.10-0.35	0.50-2.30
VNMG160404-LP	0.4	1-02-068803	1-02-066287		0.10-0.35	0.30-1.50
VNMG160408-LP	0.8	1-02-062177	1-02-062178		0.10-0.40	0.50-2.00
VNMG160404-MP	0.4	1-02-057558	1-02-057331		0.10-0.40	0.40-3.50
VNMG160408-MP	0.8	1-02-057559	1-02-057332		0.15-0.45	0.50-4.00
VNMG160412-MP	1.2	1-02-062748	1-02-062749		0.15-0.50	0.80-4.50
WNMG060408-LP	0.8	1-02-059668	1-02-061644		0.10-0.30	0.30-1.50
WNMG080404-LP	0.4	1-02-057560	1-02-057574		0.10-0.35	0.30-2.00
WNMG080408-LP	0.8	1-02-057561	1-02-057575		0.10-0.40	0.50-2.50
WNMG080412-LP	1.2	1-02-057562	1-02-057576		0.13-0.45	0.80-3.00
WNMG060404-MP	0.4	1-02-063636	1-02-063649		0.10-0.40	0.40-2.80
WNMG060408-MP	0.8	1-02-057685	1-02-057686		0.15-0.45	0.50-3.00
WNMG060412-MP	1.2	-	1-02-058778		0.15-0.50	0.80-3.20
WNMG080404-MP	0.4	1-02-057147	1-02-057187		0.10-0.40	0.40-4.00
WNMG080408-MP	0.8	1-02-056888	1-02-056958		0.15-0.45	0.50-4.50
WNMG080412-MP	1.2	1-02-056889	1-02-056960		0.15-0.50	0.80-5.00

POSITIVE TURNING INSERTS



NEGATIVE TURNING INSERTS

