

CVD Coated Grade for Steel Turning

Environmentally Friendly Product

MC6100 Series

Series
Addition

Bringing the Ultimate High Speed Cutting Performance

MC6115
MC6125
MC6135

+

FP
MP
LP



CVD Coated Grade for Steel Turning

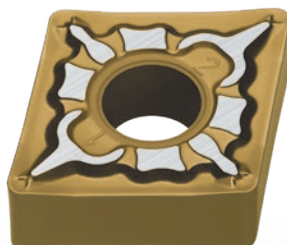
MC6100 Series

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.

MC6100

Conventional A

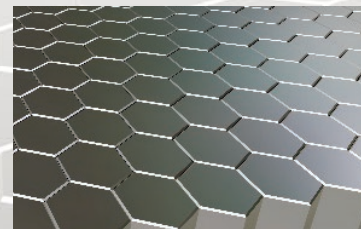


Conventional B



10 times more than conventional inserts

The ratio of Al_2O_3 crystal grains with the same orientation



*By Image



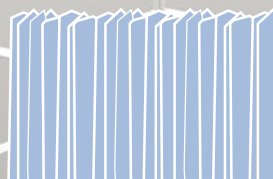
Conventional CVD inserts

Grain size and growth direction are uneven.



Nano Texture

Uniformity of the grain size and growth direction has improved.



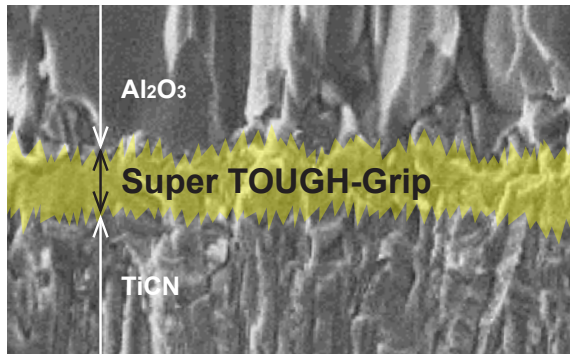
"Super" Nano Texture

Uniformity of the growth direction has drastically improved.

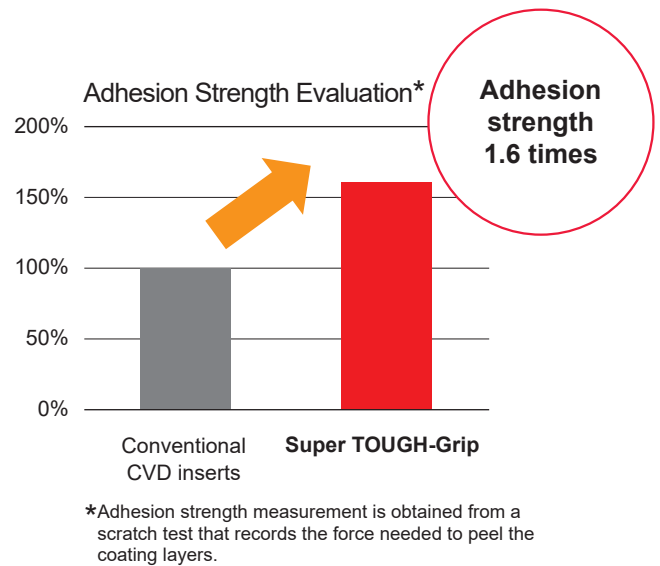
Crystal Orientation

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

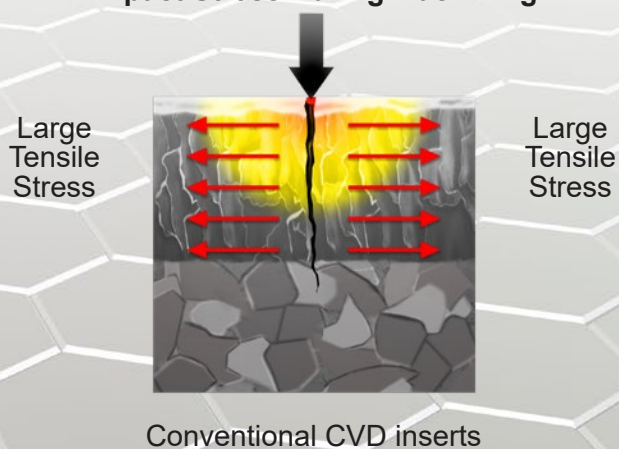


Protection Against Sudden Fracturing

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.

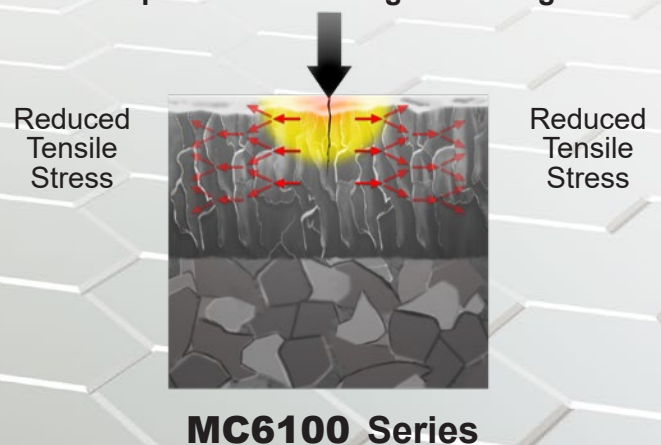
Relaxing of the Tensile Stress

Impact Stress During Machining



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 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.

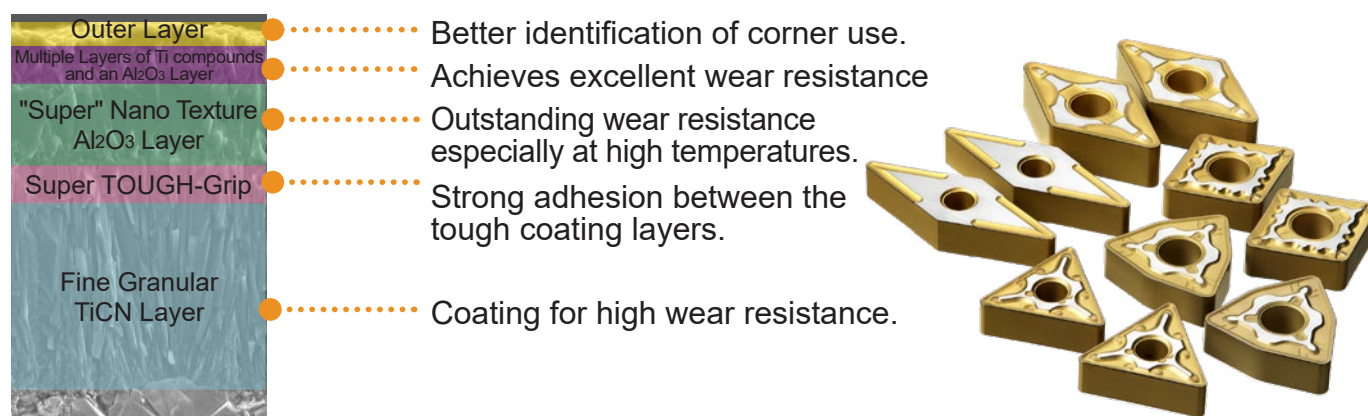
CVD Coated Grade for Steel Turning

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.**

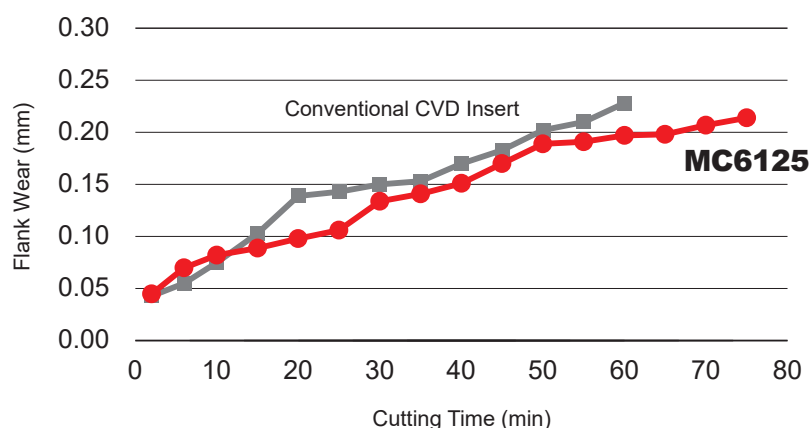


Special Smooth Surface Treatment

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>
Workpiece Material : JIS S45C
Inserts : CNMG120408-MA
Cutting Speed : $v_c = 200$ m/min
Feed per Rev. : $f = 0.3$ mm/rev
Depth of Cut : $a_p = 1.5$ mm
Cutting Mode : Wet Cutting

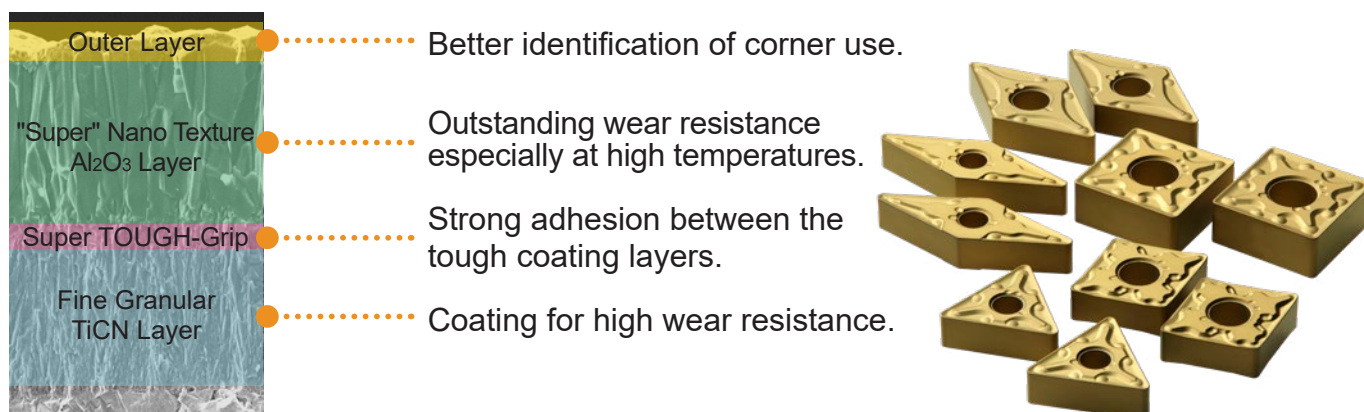
CVD Coated Grade for Steel Turning

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.



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.

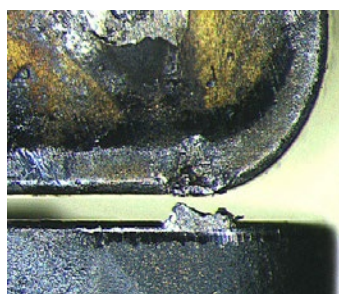
Example when machining Scr420H

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

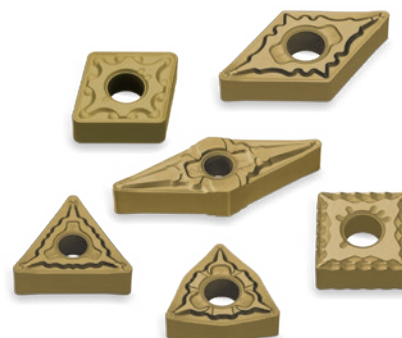
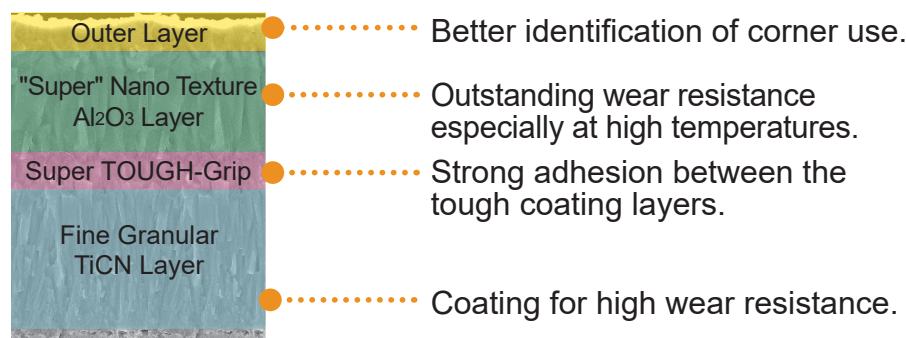
<Cutting Conditions>

Workpiece Material	: JIS SCr420H 170HB
Inserts	: CNMG120408-MH
Cutting Speed	: $v_c = 200$ m/min
Feed per Rev.	: $f = 0.3$ mm/rev
Depth of Cut	: $a_p = 1.5$ mm
Cutting Mode	: Dry Cutting

CVD Coated Grade for Steel Turning

MC6135 NEW

Optimal versatility for machining continuous through to intermittent applications.

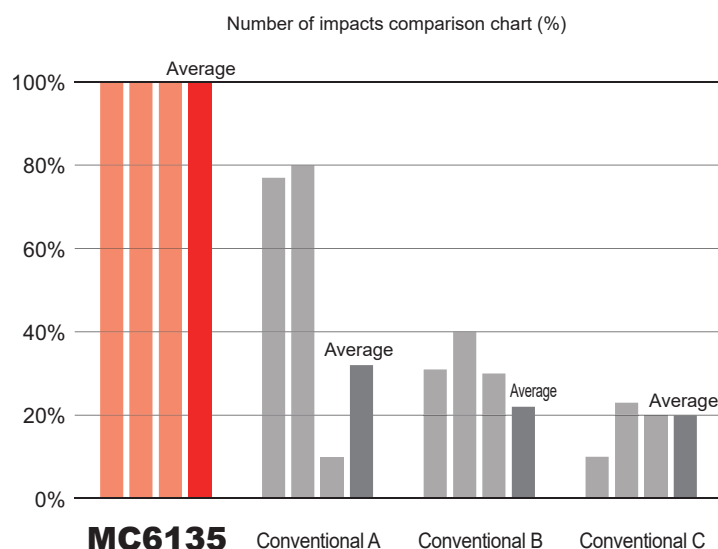


Thinner Coatings Optimised for General Purpose Machining

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>

Workpiece Material	: JIS SCM440
Inserts	: CNMG120408-
Cutting Speed	: $v_c=200$ m/min
Feed per Rev.	: $f=0.35$ mm/rev
Depth of Cut	: 2.5 mm
Cutting Mode	: Wet Cutting

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

Application Range

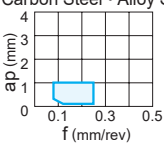
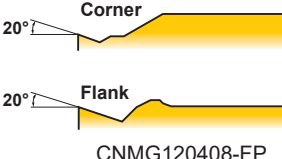
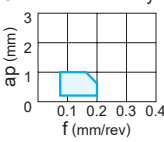
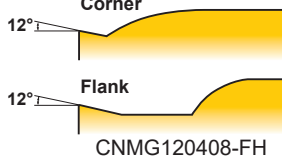
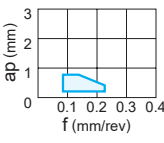
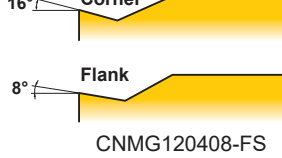
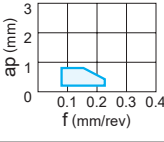
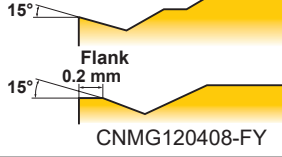
ISO		CVD	
Steel	10	MC6115	MC6015
	20	UE6110	MC6125
	30	MC6025	MC6135
	40		

Selection Criteria

Work Material		Cutting Mode	Grade
P	Steel	Continuous Cutting	MC6115
		Low	MC6125
		Medium	MC6135
		High	
		Interrupted Cutting	

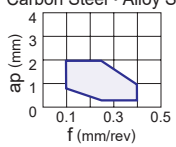
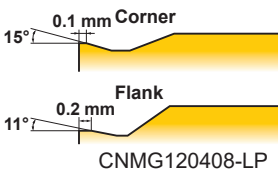
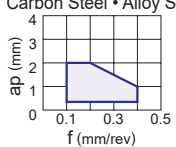
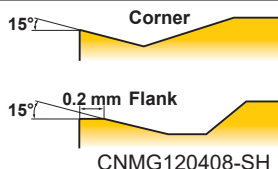
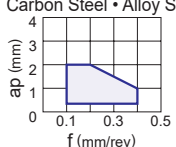
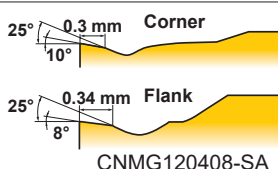
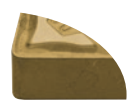
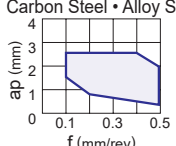
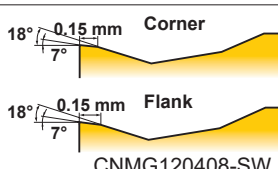
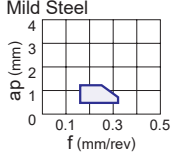
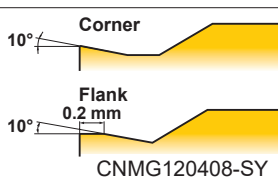
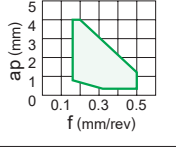
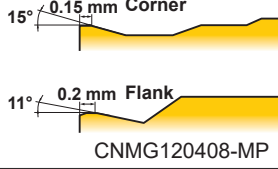
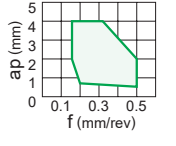
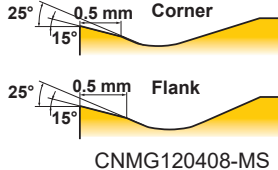
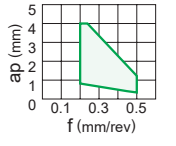
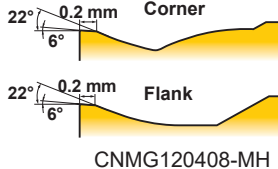
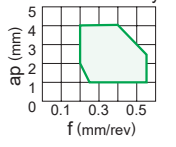
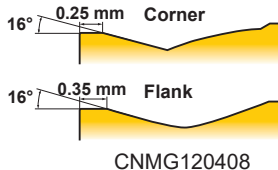
Chip Breaker System for Steel Turning

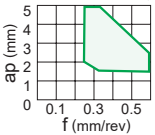
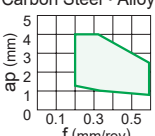
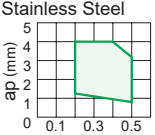
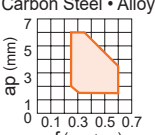
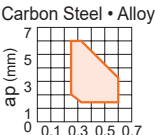
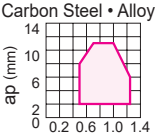
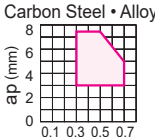
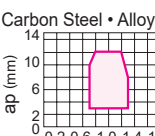
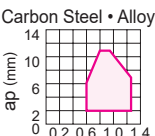
Negative Inserts

Application	Tolerance	Chip Breaker 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 in machining of low rigidity workpiece material.	Carbon Steel • Alloy Steel   CNMG120408-FP
		FH 	First recommendation 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

Chip Breaker System for Steel Turning

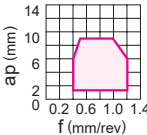
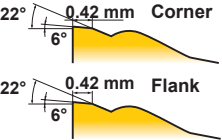
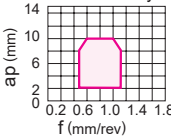
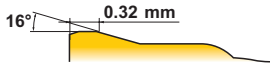
Negative Inserts

Application	Tolerance	Chip Breaker Name and Picture	Features	Cross Section Geometry
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 chipbreaker, 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 mild steel light cutting.	Mild Steel   CNMG120408-SY
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 	First recommendation 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-MH
		MH 	Alternative chipbreaker for medium cutting of carbon steel and alloy steel Flat land offers high edge strength. Good chip control with suitable chip pocket.	Carbon Steel • Alloy Steel   CNMG120408

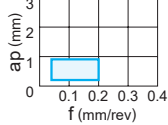
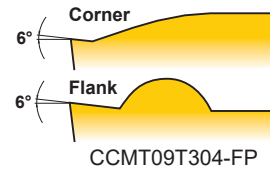
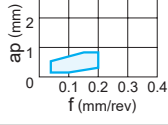
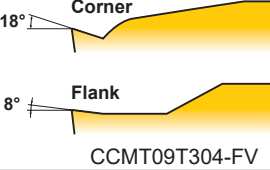
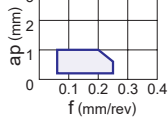
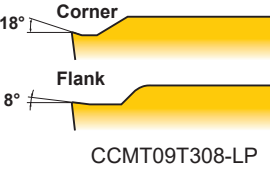
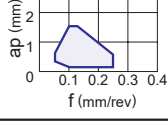
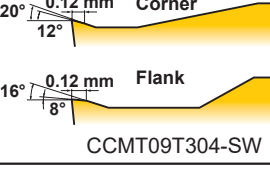
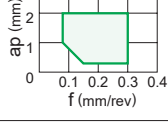
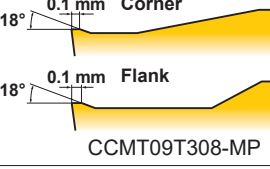
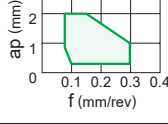
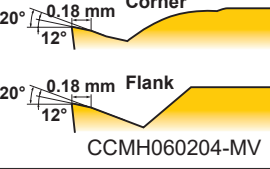
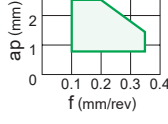
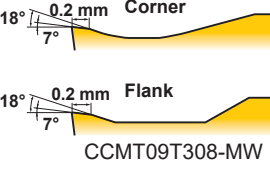
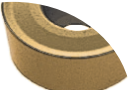
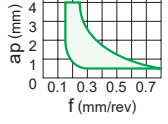
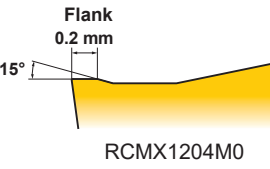
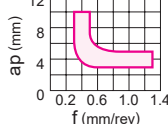
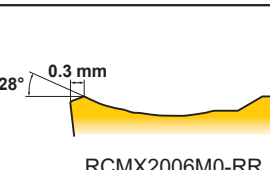
Application	Tolerance	Chip Breaker Name and Picture	Features	Cross Section Geometry
Medium Cutting	M	Standard 	Alternative chipbreaker for medium cutting of carbon steel and alloy steel Flat land offers high edge strength. Flat top chipbreaker shape offers high edge strength.	Carbon Steel • Alloy Steel  15° 0.25 mm Corner 15° 0.25 mm Flank CNMG120408
		MW 	Wiper insert for medium cutting 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  19° 0.25 mm Corner 19° 0.3 mm Flank 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  15° 0.16 mm Flank 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  3° 0.33 mm Corner 0.33 mm Flank 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  18° 0.32 mm Corner 18° 0.32 mm Flank CNMG120408-GH
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.	Carbon Steel • Alloy Steel  23° 0.43 mm Corner 21° 0.52 mm Flank 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.	Carbon Steel • Alloy Steel  15° 0.34 mm 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.	Carbon Steel • Alloy Steel  20° 0.58 mm CNMM250924-HR
		HV 	Alternative chipbreaker for heavy cutting of carbon steel and alloy steel Covers the upper end of the heavy cutting region. Wide land and large chamfer offer high edge strength. A wide chipbreaker prevents chip jamming.	Carbon Steel • Alloy Steel  20° 0.68 mm Corner 20° 0.68 mm Flank SNMM190616-HV

Chip Breaker System for Steel Turning

Negative Inserts

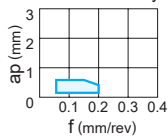
Application	Tolerance	Chip Breaker Name and Picture	Features	Cross Section Geometry
Heavy Cutting	M	HZ 	Alternative chipbreaker for heavy cutting of carbon steel and alloy steel Covers the lower end of the heavy cutting region. Low cutting resistance due to positive land and curved edge. Teardrop dots improve chip control without increasing cutting resistance.	Carbon Steel • Alloy Steel   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.	Carbon Steel • Alloy Steel   CNMM190616-HM

5°, 7° Positive Inserts

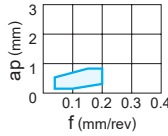
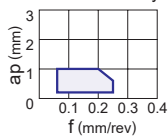
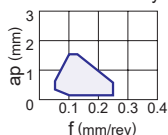
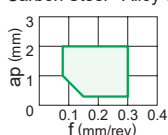
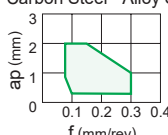
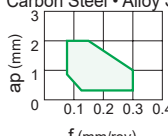
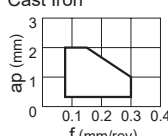
Application	Tolerance	Chip Breaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	M	FP 	First recommendation for finishing carbon steel, alloy steel and mild steel Chipbreaker protrusion at the corner tip controls chips even at small depth of cut. Maintains the edge strength at the corner 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 chip breakers, 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 increasing of the 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 achieve a wide range of 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, 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
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

Chip Breaker System for Steel Turning

7° Positive Inserts

Application	Tolerance	Chip Breaker Name and Picture	Features	Cross Section Geometry
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  18° Corner 8° Flank XCMT150304-SVX

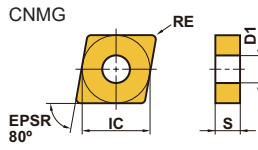
11° Positive Inserts

Application	Tolerance	Chip Breaker Name and Picture	Features	Cross Section Geometry
Finish Cutting	M	FV 	First recommendation 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  18° Corner 8° Flank CPMH090304-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  18° Corner 8° Flank CPMH09T304-LP
		SW 	Wiper insert for light cutting of carbon steel, alloy steel, mild steel and stainless steel In comparison to conventional chip breakers, the surface finish is maintained even if the feed per revolution is doubled. Positive land improves sharpness.	Carbon Steel • Alloy Steel  20° 0.12 mm Corner 16° 0.12 mm Flank 8° TPMV09T308-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 increasing of the cutting resistance and reduces vibration and chip jamming even at large depths of cut.	Carbon Steel • Alloy Steel  18° 0.1 mm Corner 18° 0.1 mm Flank CPMH090308-MP
		MV 	First recommendation for medium cutting of carbon steel, alloy steel, mild steel, stainless steel and cast iron A positive insert and large rake angle achieves sharp cutting edge performance. Double chipbreaker in the rake face achieve a wide range of chip discharge.	Carbon Steel • Alloy Steel  20° 0.2 mm Corner 20° 0.2 mm Flank 8° CPMH090304-MV
		Standard 	Alternative chipbreaker for medium cutting of carbon steel, alloy steel and stainless steel Standard, general purpose chipbreaker.	Carbon Steel • Alloy Steel  10° Corner 10° Flank CPMX090304
Strong Cutting Edge	M	Flat Top 	Chipbreaker for Heavy cutting Flat top. Most effective for unstable machining due to its high edge strength.	Cast Iron  0° SPMW120308

MC6100 Series

Negative Inserts (With Hole)

M Class



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

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
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
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

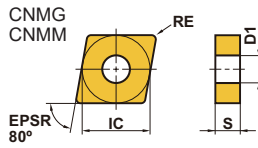
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CNMG120404-MA	M	●	●	●	12.7	4.76	0.4	5.16
CNMG120408-MA	M	●	●	●	12.7	4.76	0.8	5.16
CNMG120412-MA	M	●	●	●	12.7	4.76	1.2	5.16
CNMG120416-MA	M	●	●	○	12.7	4.76	1.6	5.16
CNMG160608-MA	M	●	●	●	15.875	6.35	0.8	6.35
CNMG160612-MA	M	●	●	●	15.875	6.35	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

● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class



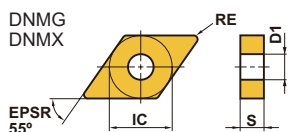
Medium	Medium	Medium	Rough	Rough	
MH	Standard	MW (Wiper)	RP	GH	
					
Heavy	Heavy	Heavy	Heavy	Heavy	Heavy
HX	HL	HR	HV	HZ	HM
					

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
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
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

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



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

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
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	6.35	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
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

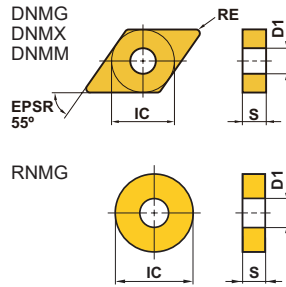
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
DNMX110404-SW	L	●	○	○	9.525	4.76	0.4	3.81
DNMX110408-SW	L	●	○	○	9.525	4.76	0.8	3.81
DNMX150404-SW	L	●	○	○	12.7	4.76	0.4	5.16
DNMX150408-SW	L	●	○	○	12.7	4.76	0.8	5.16
DNMX150412-SW	L	●	○	○	12.7	4.76	1.2	5.16
DNMX150604-SW	L	●	○	○	12.7	6.35	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
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	M	●	○	○	12.7	6.35	1.6	5.16

● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class



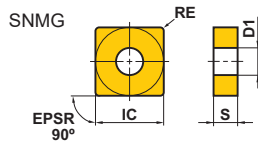
Medium	Medium	Medium	Rough	Rough
MH	Standard	MW (Wiper)	RP	GH
Heavy	Heavy		Medium	
HL	HZ		Standard	

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
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
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

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

● = NEW



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

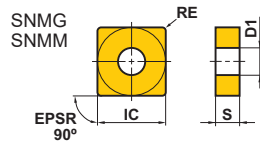
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
SNMG090304	M	●	○	○	9.525	3.18	0.4	3.81
SNMG090308	M	●	○	○	9.525	3.18	0.8	3.81
SNMG120404	M	●	●	●	12.7	4.76	0.4	5.16
SNMG120408	M	●	●	●	12.7	4.76	0.8	5.16
SNMG120412	M	●	●	●	12.7	4.76	1.2	5.16
SNMG120416	M	●	○	●	12.7	4.76	1.6	5.16
SNMG120420	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

MC6100 Series

Negative Inserts (With Hole)

M Class



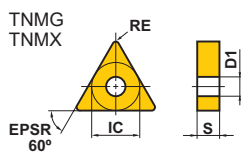
Rough	Rough				
RP	GH				
Heavy	Heavy	Heavy	Heavy	Heavy	Heavy
HX	HL	HR	HV	HZ	HM

(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



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

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
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

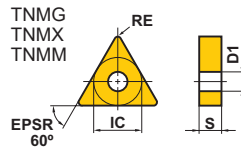
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TNMG160404-MP	M	●	●	●	9.525	4.76	0.4	3.81
TNMG160408-MP	M	●	●	●	9.525	4.76	0.8	3.81
TNMG160412-MP	M	●	●	●	9.525	4.76	1.2	3.81
TNMG220408-MP	M	●	●	●	12.7	4.76	0.8	5.16
TNMG220412-MP	M	●	●	●	12.7	4.76	1.2	5.16
TNMG160404-MS	M	●	○	○	9.525	4.76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

● = NEW

MC6100 Series

Negative Inserts (With Hole)

M Class



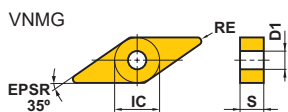
Medium	Medium	Medium	Medium
MH	Standard	MW (Wiper)	ES
			
Rough	Rough	Heavy	Heavy
RP	GH	HL	HZ
			

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
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	4.76	0.4	2.26
TNMG110308	M	●	○	○	6.35	4.76	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



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

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
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

MC6100 Series

Negative Inserts (With Hole)

M Class

WNMG



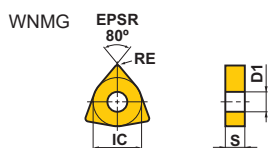
Finish	Finish	Finish	Finish	Light	Light
FP	FH	FS	FY	LP	SH
Light	Light	Light			
SA	SW	SY			
	 (Wiper)				

(mm)

Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
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



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

(mm)

Order Number	Cutting Area	MC6115	MC6125	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

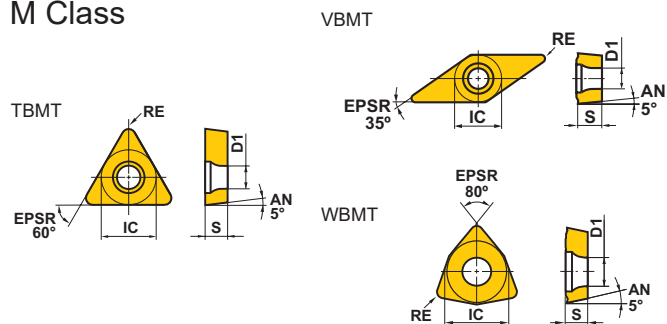
● = NEW

Order Number	Cutting Area	MC6115	MC6125	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

MC6100 Series

5° Positive Inserts (With Hole)

M Class



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

(mm)

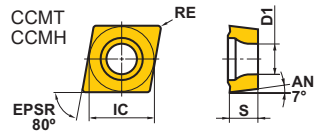
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
TBMT060102-FV	F	●		○	3.97	1.59	0.2	2.3
TBMT060104-FV	F	●		○	3.97	1.59	0.4	2.3
VBMT110302-FP	F	●	●	○	6.35	3.18	0.2	2.9
VBMT110304-FP	F	●	●	○	6.35	3.18	0.4	2.9
VBMT110308-FP	F	●	●	○	6.35	3.18	0.8	2.9
VBMT160404-FP	F	●	●	○	9.525	4.76	0.4	4.4
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

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

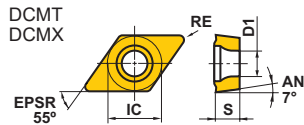
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
CCMT060202-MP	M	●	●	○	6.35	2.38	0.2	2.8
CCMT060204-MP	M	●	●	○	6.35	2.38	0.4	2.8
CCMT060208-MP	M	●	●	○	6.35	2.38	0.8	2.8
CCMT080302-MP	M	●	●		7.94	3.18	0.2	3.4
CCMT080304-MP	M	●	●		7.94	3.18	0.4	3.4
CCMT080308-MP	M	●	●		7.94	3.18	0.8	3.4
CCMT09T302-MP	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

MC6100 Series

7° Positive Inserts (With Hole)

M Class



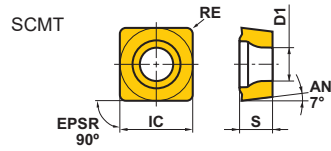
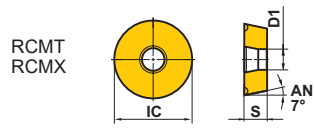
Finish	Finish	Light	Light
FP	FV	LP	SW
			
			(Wiper)
Medium	Medium		
MP	MV		
			

(mm)

Order Number	Cutting Area	MC6115	MC6125	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	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



Medium	Rough	
Standard	RR	
		
Finish	Finish	Medium
FP	FV	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

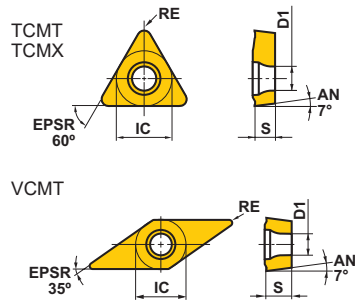
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
SCMT09T304-FP	F	●	●	○	9.525	3.97	0.4	4.4
SCMT09T308-FP	F	●	●	○	9.525	3.97	0.8	4.4
SCMT09T304-FV	F		●	○	9.525	3.97	0.4	4.4
SCMT09T304-LP	L	●	●	○	9.525	3.97	0.4	4.4
SCMT09T308-LP	L	●	●	○	9.525	3.97	0.8	4.4
SCMT09T304-MP	M	●	●	○	9.525	3.97	0.4	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

MC6100 Series

7° Positive Inserts (With Hole)

M Class



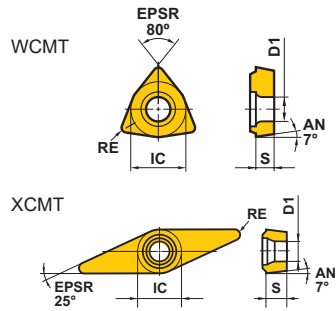
Finish	Light	Light	Light	Medium
FP	FV	LP	SW (Wiper)	MP
Finish	Finish	Light	Medium	Medium
FP	FV	LP	MP	MV

(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



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

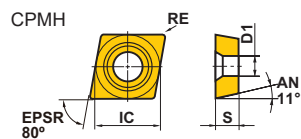
Order Number	Cutting Area	MC6115	MC6125	NEW MC6135	IC	S	RE	D1
XCMT150304-SVX	F		●	○	6.35	3.18	0.4	2.85
XCMT150308-SVX	F		●	○	6.35	3.18	0.8	2.85

● = NEW

MC6100 Series

11° Positive Inserts (With Hole)

M Class



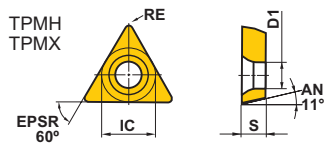
Finish	Finish	Light
FP	FV	LP
		
Medium	Medium	Medium
MP	MV	Standard
		

(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



Finish	Finish	Light	Light
FP	FV	LP	SW
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

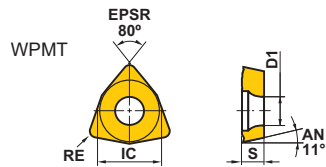
MC6100 Series

11° Positive Inserts (With Hole)

M Class

Medium

MV



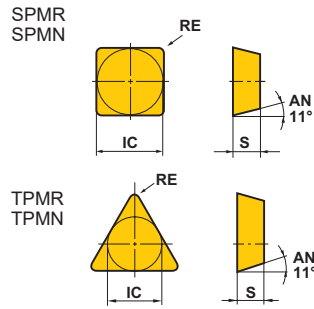
(mm)

Order Number	Cutting Area	MC6100 Series			IC	S	RE	D1
		MC6115	MC6125	MC6135 NEW				
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**

11° Positive Inserts (Without Hole)

M Class



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

Recommended Cutting Conditions

Negative Inserts (For External Turning)

(mm)

Workpiece Material	Properties	Cutting Range	Priority	Grade	Chip Breaker	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
		✱	F	2	MC6135	FY	315–480	0.09–0.23
		✱	L	1	MC6125	SY	350–550	0.16–0.33
		✱	L	2	MC6135	SY	290–435	0.16–0.33
Carbon Steel Alloy Steel	Hardness 180–280HB	●	F	1	MC6115	FP	250–480	0.08–0.25
		●	F	2	MC6125	FP	275–425	0.08–0.25
		●	L	1	MC6115	LP	250–480	0.10–0.40
		●	L	2	MC6125	LP	275–425	0.10–0.40
		●	L	3	MC6115	SH	250–480	0.10–0.40
		●	L	4	MC6125	SH	275–425	0.10–0.40
		●	L	5	MC6115	SA	250–480	0.10–0.40
		●	L	6	MC6125	SA	275–425	0.10–0.40
		●	L	7	MC6115	SW	250–480	0.10–0.50
		●	L	8	MC6125	SW	275–425	0.10–0.50
		●	M	1	MC6115	MP	230–440	0.16–0.50
		●	M	2	MC6125	MP	250–390	0.16–0.50
		●	M	3	MC6115	MA	230–440	0.20–0.50
		●	M	4	MC6125	MA	250–390	0.20–0.50
		●	M	5	MC6115	Std	230–440	0.25–0.60
		●	M	6	MC6125	Std	250–390	0.25–0.60
		●	M	7	MC6115	MW	230–440	0.20–0.60
		●	M	8	MC6125	MW	250–390	0.20–0.60
		●	R	1	MC6115	RP	215–415	0.25–0.60
		●	R	2	MC6125	RP	235–370	0.25–0.60
		●	R	3	MC6115	GH	215–415	0.25–0.60
		●	R	4	MC6125	GH	235–370	0.25–0.60
		●	H	1	MC6125	HX	210–330	0.50–1.26
		●	H	2	MC6135	HX	170–260	0.50–1.26
		●	H	3	MC6125	HV	175–270	0.58–1.26
		●	H	4	MC6135	HV	140–215	0.58–1.26
		●	F	1	MC6115	FP	250–480	0.08–0.25
		●	F	2	MC6125	FP	275–425	0.08–0.25
		●	L	1	MC6115	LP	250–480	0.10–0.40
		●	L	2	MC6125	LP	275–425	0.10–0.40
		●	L	3	MC6115	SH	250–480	0.10–0.40
		●	L	4	MC6125	SH	275–425	0.10–0.40
		●	L	5	MC6115	SA	250–480	0.10–0.40
		●	L	6	MC6125	SA	275–425	0.10–0.40
		●	L	7	MC6115	SW	250–480	0.10–0.50
		●	L	8	MC6125	SW	275–425	0.10–0.50
		●	M	1	MC6125	MP	250–390	0.16–0.50
		●	M	2	MC6135	MP	205–310	0.16–0.50
		●	M	3	MC6125	MA	250–390	0.20–0.50
		●	M	4	MC6135	MA	205–310	0.20–0.50
		●	M	5	MC6125	MH	250–390	0.20–0.55
		●	M	6	MC6135	MH	205–310	0.20–0.55
		●	M	7	MC6125	Std	250–390	0.25–0.60
		●	M	8	MC6135	Std	205–310	0.25–0.60
		●	M	9	MC6125	MW	250–390	0.20–0.60
		●	M	10	MC6135	MW	205–310	0.20–0.60

Note 1) Recommended cutting conditions for 5°/7°/11° 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 : L : Light Cutting M : Medium Cutting R : Rough Cutting

(mm)									
Workpiece Material	Properties	Cutting Range		Priority	Grade	Chip Breaker	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
			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 5°/7°/11° 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)

Workpiece Material	Properties	Cutting Range	Priority	Grade	Chip Breaker	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
		●	F	2	MC6115	FV	295–570	0.04–0.20
		●	L	1	MC6115	LP	295–570	0.06–0.25
		●	L	2	MC6115	SW	295–570	0.06–0.24
		●	M	1	MC6115	MP	245–475	0.08–0.30
		●	M	2	MC6115	MV	245–475	0.08–0.30
		●	M	3	MC6115	MW	245–475	0.10–0.35
		✱	F	1	MC6125	FP	320–505	0.04–0.20
		✱	F	2	MC6135	FP	265–400	0.04–0.20
		✱	L	1	MC6125	LP	320–505	0.06–0.25
		✱	L	2	MC6135	LP	265–400	0.06–0.25
		✱	L	3	MC6125	SW	320–505	0.06–0.24
		✱	M	1	MC6125	MP	270–420	0.08–0.30
		✱	M	2	MC6135	MP	220–330	0.08–0.30
		✱	M	3	MC6125	MV	270–420	0.08–0.30
		✱	M	4	MC6125	MW	270–420	0.10–0.35
Carbon Steel Alloy Steel	Hardness 180–280HB	●	F	1	MC6115	FP	220–420	0.04–0.20
		●	F	2	MC6125	FP	240–370	0.04–0.20
		●	F	3	MC6115	FV	220–420	0.04–0.20
		●	L	1	MC6115	LP	220–420	0.06–0.25
		●	L	2	MC6125	LP	240–370	0.06–0.25
		●	M	1	MC6125	MP	200–310	0.08–0.30
		●	M	2	MC6115	MP	180–350	0.08–0.30
		●	M	3	MC6125	MV	200–310	0.08–0.30
		●	M	4	MC6115	MV	180–350	0.08–0.30
		●	M	5	MC6115	MW	180–350	0.10–0.35
		✱	F	1	MC6125	FP	240–370	0.04–0.20
		✱	F	2	MC6135	FP	195–295	0.04–0.20
		✱	F	3	MC6125	FV	240–370	0.04–0.20
		✱	L	1	MC6125	LP	240–370	0.06–0.25
		✱	L	2	MC6135	LP	195–295	0.06–0.25
		✱	L	3	MC6125	SW	240–370	0.06–0.24
		✱	M	1	MC6125	MP	200–310	0.08–0.30
		✱	M	2	MC6135	MP	160–245	0.08–0.30
		✱	M	3	MC6125	MV	200–310	0.08–0.30
Carbon Steel Alloy Steel	Hardness 280–350HB	●	F	1	MC6115	FP	155–295	0.04–0.20
		●	F	2	MC6115	FV	155–295	0.04–0.20
		●	L	1	MC6115	LP	155–295	0.06–0.25
		●	M	1	MC6115	MP	130–245	0.08–0.30
		●	M	2	MC6115	MV	130–245	0.08–0.30
		✱	F	1	MC6125	FP	170–265	0.04–0.20
		✱	F	2	MC6135	FP	135–210	0.04–0.20
		✱	L	1	MC6125	LP	170–265	0.06–0.25
		✱	L	2	MC6135	LP	135–210	0.06–0.25
		✱	M	1	MC6125	MP	140–220	0.08–0.30
		✱	M	2	MC6135	MP	115–175	0.08–0.30
		✱	M	3	MC6125	MV	140–220	0.08–0.30

Note 1) Recommended cutting conditions for 5°/7°/11° 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 pamphlet of the recommended conditions for the XCMT profile holder insert.



Cutting Conditions : ● : Stable Cutting ● : General Cutting ✱ : Unstable Cutting
Cutting Area : L : Light Cutting M : Medium Cutting R : Rough Cutting

11° Positive Inserts (For External Turning)

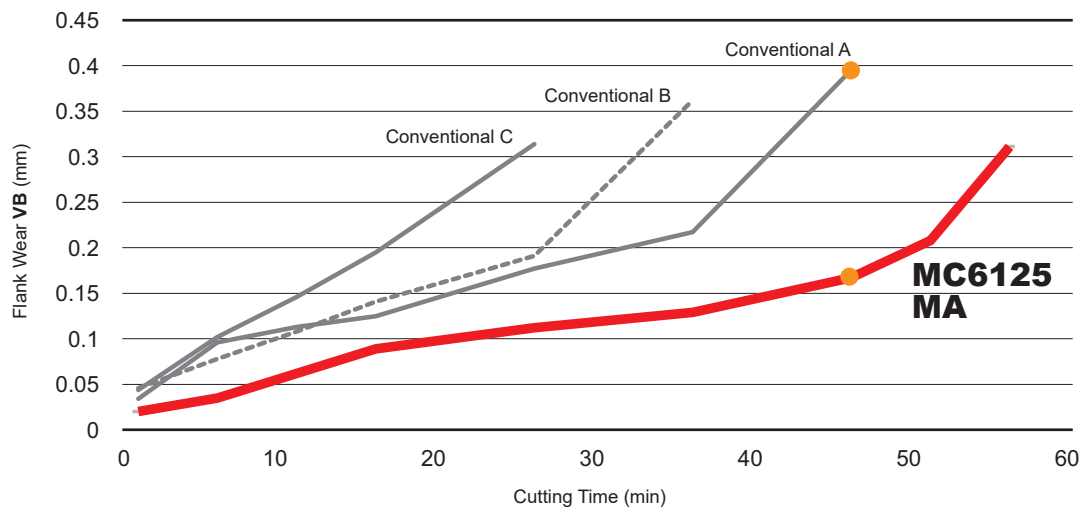
(mm)

Workpiece Material	Properties	Cutting Range		Priority	Grade	Chip Breaker	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

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.

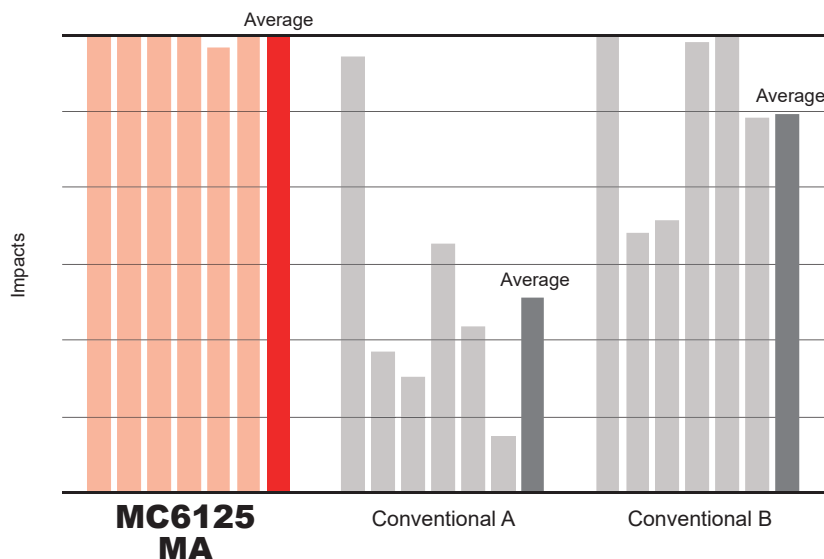


Conventional A 46 min.

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

Comparison of Toughness During Interrupted Cutting

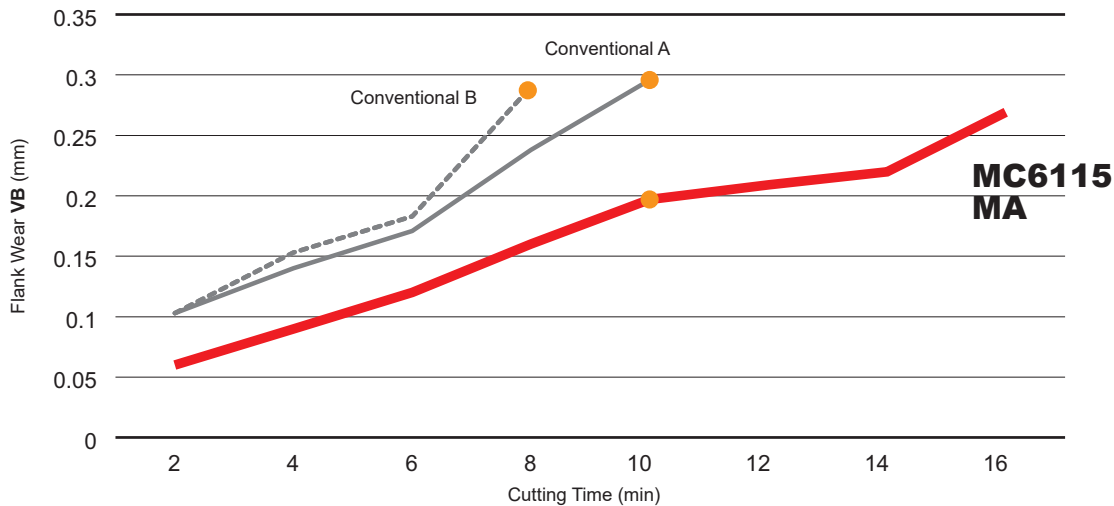
Provides stable cutting under severe cutting conditions that are likely to cause sudden fracturing.



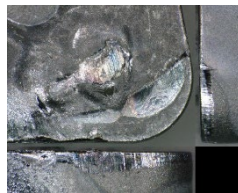
<Cutting Conditions>
 Work Material : JIS SCM440
 Inserts : CNMG120408-
 Cutting Speed : $v_c = 200$ m/min
 Feed per Rev. : $f = 0.25$ mm/rev
 Depth of Cut : $a_p = 1.5$ mm
 Cutting Mode : Wet Cutting

Machining S45C : Comparison of Wear Resistance During Continuous Dry Cutting

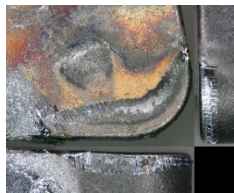
The "Super" Nano Texture Technology increases tool life even when dry cutting by suppressing crater wear.



MC6115 10 min.



Conventional A 10 min.

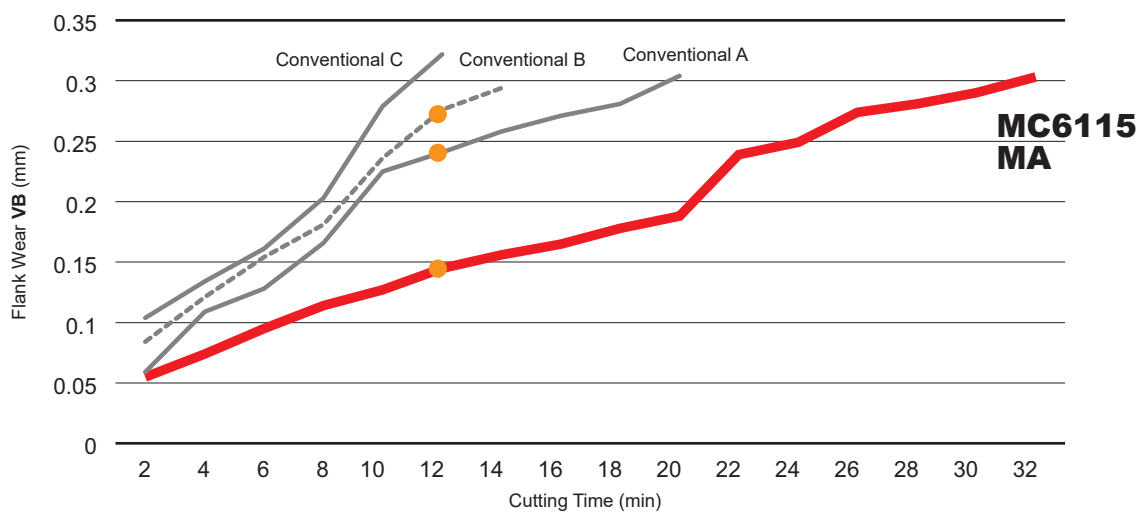


Conventional B 8 min.

<Cutting Conditions>
 Work Material : JIS S45C
 Inserts : CNMG120408-
 Cutting Speed : $v_c=300$ m/min
 Feed per Rev. : $f=0.3$ mm/rev
 Depth of Cut : $a_p=1.5$ mm
 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.



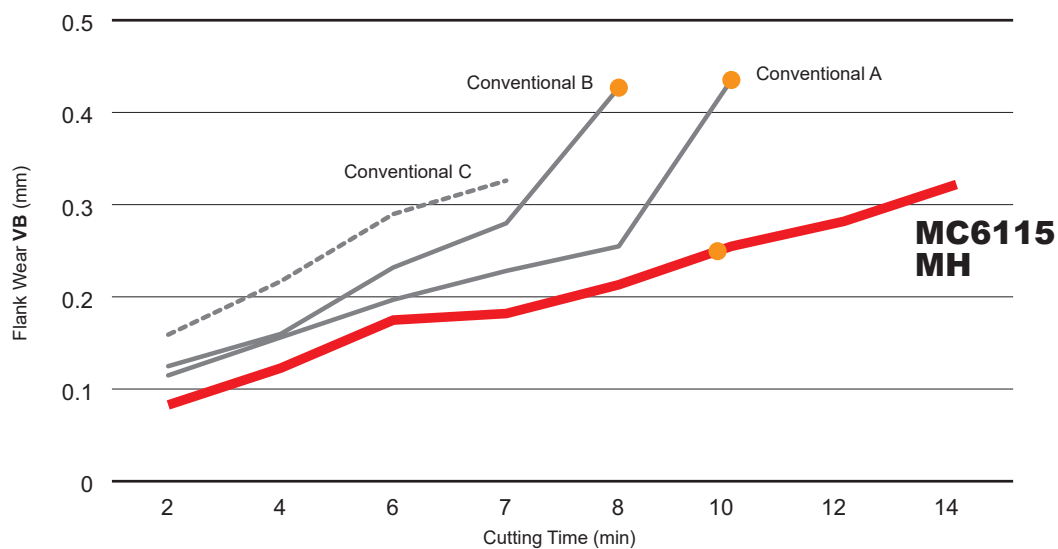
Conventional B 12 min.

<Cutting Conditions>
 Work Material : JIS SUJ2
 Inserts : CNMG120408-
 Cutting Speed : $v_c=300$ m/min
 Feed per Rev. : $f=0.3$ mm/rev
 Depth of Cut : $a_p=1.5$ mm
 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.

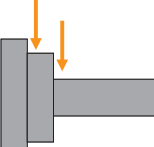
Conventional B 8 min.

<Cutting Conditions>
 Work Material : JIS SCM440
 Inserts : CNMG120408-
 Cutting Speed: $v_c = 350 \text{ m/min}$
 Feed per Rev. : $f = 0.3 \text{ mm/rev}$
 Depth of Cut : $a_p = 1.5 \text{ mm}$
 Cutting Mode : Wet Cutting

Examples of Usage

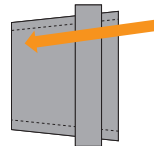
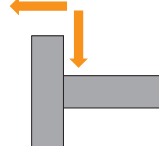
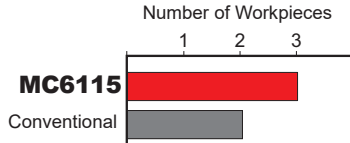
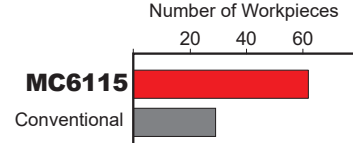
Insert		CNMG120408-MA	WNMG080408-MP
Workpiece Material	JIS S45C		Carbon Steel
			
Component		Hex Bar Parts	Automotive Parts
Application		Interrupted Finish Turning	External Turning and Facing
Cutting Conditions	Cutting Speed v_c (m/min)	150	80
	Feed per Rev. f (mm/rev)	0.2	0.1-0.5
	Depth of Cut a_p (mm)	2.0, 1.6	0.5
Cutting Mode		Wet Cutting	Wet Cutting
Results	Number of Workpieces 500 1000 MC6125  Conventional  Conventional products fractured after chipping but MC6125 formed good chip shapes and achieved a longer tool life.		Number of Workpieces 500 1000 1500 2000 2500 MC6125  Conventional  MC6125 achieved more than 1.3 times longer tool life due to its high wear resistance.

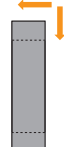
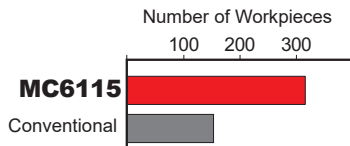
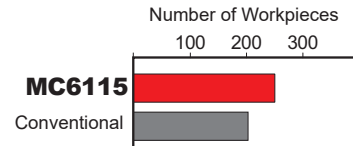
Insert		DNMG150412-SH	CNMG120408-MH
Workpiece Material	JIS S53C		General Structural Steel
			
Component		—	Hun Parts
Application		Interrupted Finish Turning	Face Turning
Cutting Conditions	Cutting Speed v_c (m/min)	200	200→240
	Feed per Rev. f (mm/rev)	0.3	0.25
	Depth of Cut a_p (mm)	1.2	2.0
Cutting Mode		Wet Cutting	Wet Cutting
Results	Number of Workpieces 50 100 150 MC6125  Conventional  MC6125 provided a stable cutting action and achieved 1.5 times more tool life than conventional products.		Number of Workpieces 50 100 150 200 MC6125  Conventional  MC6125 improved efficiency and tool life by increasing the cutting speed.

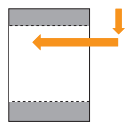
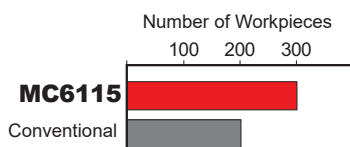
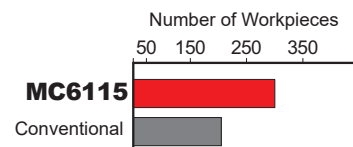
Insert		CNMG120412-RP
Workpiece Material	JIS SCM435	
		
Component		Flange Parts
Application		External Turning and Facing
Cutting Conditions	Cutting Speed v_c (m/min)	200
	Feed per Rev. f (mm/rev)	0.25
	Depth of Cut a_p (mm)	1.5
Cutting Mode		Wet Cutting
Results	Number of Workpieces 50 100 MC6125  Conventional  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.

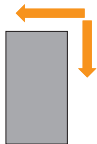
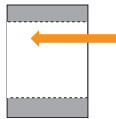
Examples of Usage

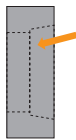
Insert		CNMG120408-MA	WNMG080408-MA	
Workpiece Material			JIS SCM440	
			JIS SCr440	
Component			Heavy Machinery Parts	Automotive Parts
Application			Internal Turning	External Face Turning
Cutting Conditions	Cutting Speed v_c (m/min)	150	290	
	Feed per Rev. f (mm/rev)	0.3	0.25	
	Depth of Cut a_p (mm)	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 Material	JIS SUJ2		
Component		Bearing Parts	Machine Parts
Application		External Face Turning	Face Turning
Cutting Conditions	Cutting Speed v_c (m/min)	198-278	235
	Feed per Rev. f (mm/rev)	0.21-0.3	0.35
	Depth of Cut a_p (mm)	1.0	1.0
	Cutting Mode	Wet Cutting	Wet Cutting
Results	Number of Workpieces		
		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 Material		JIS SCr440 	JIS S50C 
Component		Hub	Joint Parts
Application		External Turning and Facing	Internal Turning and Facing
Cutting Conditions	Cutting Speed v_c (m/min)	300	215
	Feed per Rev. f (mm/rev)	0.25-0.35	0.25-0.27
	Depth of Cut a_p (mm)	1-2.5	3.15
Cutting Mode		Wet Cutting	Wet Cutting
Results		Number of Workpieces 100 200 300 MC6115  Conventional Superior wear resistance compared to conventional products meant tool life was extended.	Number of Workpieces 50 150 250 350 MC6115  Conventional 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 Material	Bearing Steel		JIS SCr440
			
Component		Bearing Parts	Shaft Parts
Application		External Turning and Facing	Internal Turning
Cutting Conditions	Cutting Speed v_c (m/min)	260	280
	Feed per Rev. f (mm/rev)	0.3-0.35	0.29
	Depth of Cut a_p (mm)	0.5	2.5
Cutting Mode		Wet Cutting	Wet Cutting
Results	Number of Workpieces 50 100 150 200 250 MC6115  Conventional  Extreme resistance to chipping achieved 150% tool life and enabled easy identification of wear.		Number of Workpieces 50 150 250 350 MC6115  Conventional  Number of components machined increased by 50% due to improved wear resistance.

Insert		WNNMG080408-MP
Workpiece Material	Heated Tool Steel	
		
Component		Die Casting Parts
Application		Internal Turning
Cutting Conditions	Cutting Speed v_c (m/min)	160
	Feed per Rev. f (mm/rev)	0.25
	Depth of Cut a_p (mm)	2.0
Cutting Mode		Wet Cutting
Results	Number of Workpieces 1 2 3 4 MC6115  Conventional  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.

This brochure is published by

MITSUBISHI MATERIALS CORPORATION

MITSUBISHI MATERIALS CORPORATION

Overseas Sales Dept, Asian Region

Marunouchi Nijubashi Building 22F, 3-2-3, Marunouchi, Chiyoda-ku, Tokyo 100-8117, Japan

Overseas Sales Dept, European & American Region

Marunouchi Nijubashi Building 22F, 3-2-3, Marunouchi, Chiyoda-ku, Tokyo 100-8117, Japan

<http://www.mmc-carbide.com/>

(Tools specifications subject to change without notice.)

EXP-20-E006
2024.4.E