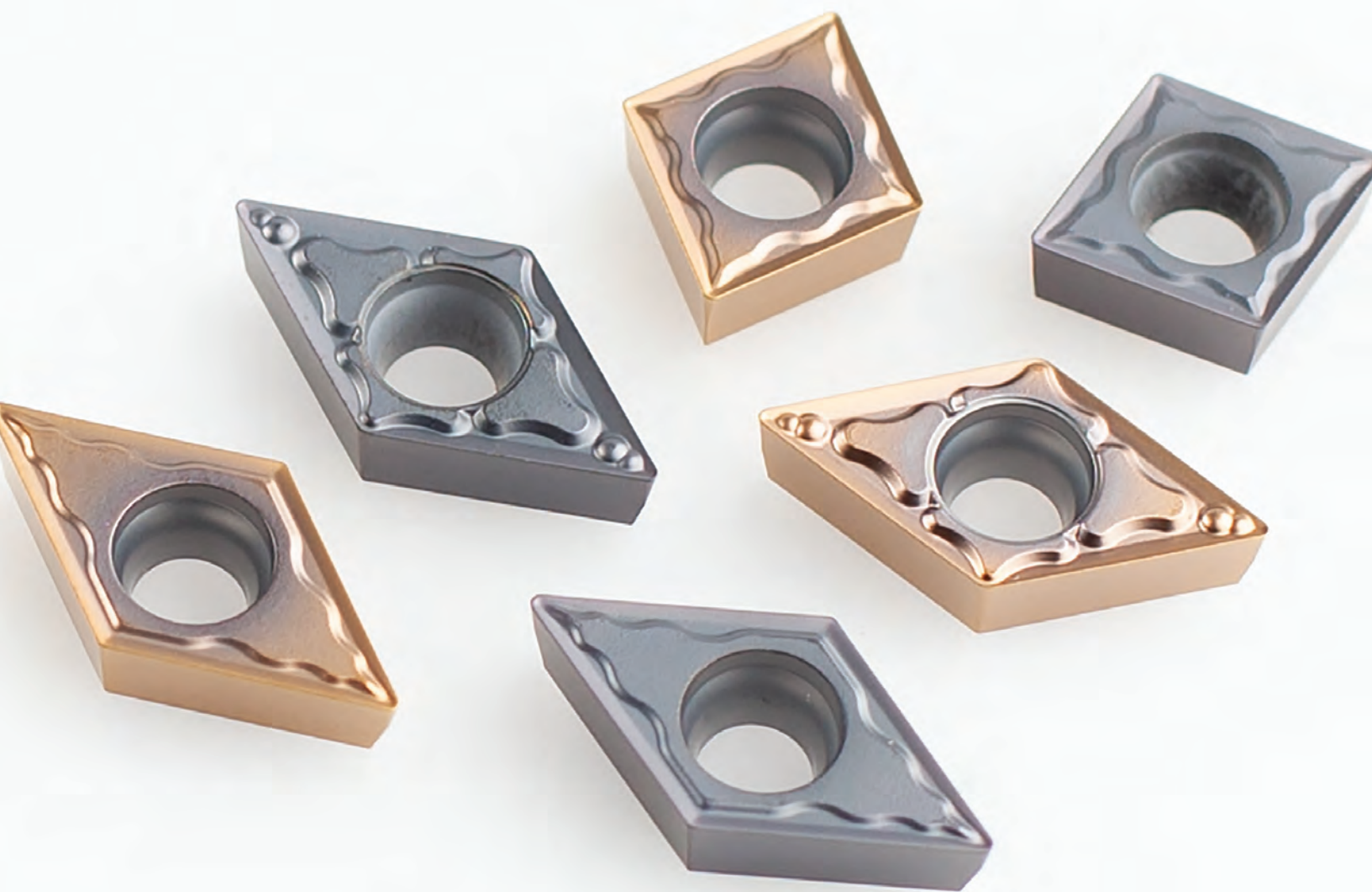


New Product Information

01/2021
NPI

JPS1 SERIES

Turning PVD micrograin carbide



nikkoTOOLS

JP51

TURNING

HF: micrograin carbide
PVD: physical vapour deposition

	HF PVD																																																																																																																																																																				
	JP5120	JP5125																																																																																																																																																																			
<ul style="list-style-type: none"> Wide application range, from finishing to medium machining and from low to medium-high cutting speed High Cobalt micrograin substrate with very high toughness PVD coatings with nano multilayer technology guarantee perfect adesion and higher tool life Special surface treatment reduce built-up edge phenomena on sticky materials 	<ul style="list-style-type: none"> Stable machining, light cut <input checked="" type="radio"/> 1st choice <input type="radio"/> suitable General machining, medium cut <input checked="" type="radio"/> 1st choice <input type="radio"/> suitable Unstable machining, heavy cut <input checked="" type="radio"/> 1st choice <input type="radio"/> suitable 	<ul style="list-style-type: none"> <input checked="" type="radio"/> <input type="radio"/> <input checked="" type="radio"/> <input type="radio"/> <input checked="" type="radio"/> <input type="radio"/> 																																																																																																																																																																			
	<p>Dimensions ISO Vc(m/min) - suggested cutting speed range (bold: 1st choice)</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td rowspan="2" style="text-align: center;"> <p>RADIUS THICKNESS AND HOLE</p> </td> <td style="text-align: center;">P</td> <td>60</td> <td>60</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="text-align: center;">M</td> <td>200</td> <td>180</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td rowspan="2" style="text-align: center;"> <p>CLEARANCE ANGLE INSCRIBED CIRCLE</p> </td> <td style="text-align: center;">K</td> <td>60</td> <td>60</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="text-align: center;">N</td> <td>140</td> <td>120</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td style="text-align: center;">S</td> <td>80</td> <td>80</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td style="text-align: center;">H</td> <td>170</td> <td>150</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>30</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>60</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>		<p>RADIUS THICKNESS AND HOLE</p>	P	60	60																	M	200	180																		<p>CLEARANCE ANGLE INSCRIBED CIRCLE</p>	K	60	60																	N	140	120																			S	80	80																			H	170	150																									30																					60												
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Designation		RE	IC	S	D1	AN	Stock																	
FINISHING	 VBMT-PFU	VBMT110304-PFU	0.4	6.35	3.18	2.80	5°	<input checked="" type="radio"/>																
		VBMT160404-PFU	0.4	9.525	4.76	4.40	5°	<input checked="" type="radio"/>																
		VBMT160408-PFU	0.8	9.525	4.76	4.40	5°	<input checked="" type="radio"/>																
MEDIUM	 VBMT-PMU	VBMT160404-PMU	0.4	9.525	4.76	4.40	5°	<input checked="" type="radio"/>	<input checked="" type="radio"/>															
		VBMT160408-PMU	0.8	9.525	4.76	4.40	5°	<input checked="" type="radio"/>	<input checked="" type="radio"/>															
MEDIUM	 VCMT-PMU	VCMT160404-PMU	0.4	9.525	4.76	4.40	7°	<input checked="" type="radio"/>																
		VCMT160408-PMU	0.8	9.525	4.76	4.40	7°	<input checked="" type="radio"/>																

● stock standard, ● semi-standard, ○ non-standard stock

PFU (CCMT06, DCMT07, TCMT11, VBMT11)

RE 0.2	a_p	0.20	0.80	1.40
	f_n	0.04	0.08	0.12
RE 0.4	a_p	0.20	0.80	1.40
	f_n	0.05	0.11	0.17

PFU (CCMT09, DCMT11, TCMT16, VBMT16, VCMT16)

RE 0.2	a_p	0.30	1.00	1.70
	f_n	0.05	0.10	0.15
RE 0.4	a_p	0.30	1.00	1.70
	f_n	0.06	0.14	0.22
RE 0.8	a_p	0.30	1.00	1.70
	f_n	0.08	0.16	0.24

PMU (CCMT06, DCMT07, TCMT11, VBMT11)

RE 0.4	a_p	0.50	1.50	2.50
	f_n	0.06	0.13	0.20
RE 0.8	a_p	0.50	1.50	2.50
	f_n	0.08	0.16	0.24

PMU (CCMT09, DCMT11, TCMT16, VBMT16, VCMT16)

RE 0.4	a_p	0.60	1.80	3.00
	f_n	0.07	0.16	0.25
RE 0.8	a_p	0.60	1.80	3.00
	f_n	0.08	0.19	0.30
RE 1.2	a_p	0.60	1.80	3.00
	f_n	0.10	0.22	0.34

a_p : depth of cut (mm)
 f_n : feed rate (mm/rev)



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