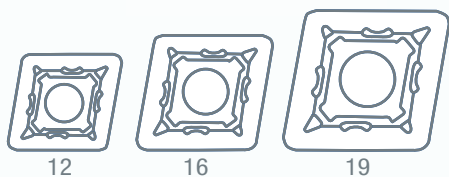


# NRM

Turning ISO **M** - Roughing



LARGE INSERTS AVAILABLE



# NRM

## TURNING

- Reliable operation on ISO M roughing
- Wide groove design to support big cutting depth
- Cutting edge with a perfect balancing between sharpness and strength
- Available in combination with high wear resistance CVD coated grade and with tough micrograin carbide with PVD coating
- Large size inserts available

HC: coated carbide  
 HF: micrograin carbide  
 CVD: chemical vapour deposition  
 PVD: physical vapour deposition

HC CVD: **JC9025**  
 HF PVD: **JP9030**

Stable machining, light cut: ● 1<sup>st</sup> choice ○ suitable  
 General machining, medium cut: ● 1<sup>st</sup> choice ○ suitable  
 Unstable machining, heavy cut: ● 1<sup>st</sup> choice ○ suitable

**Dimensions** ISO **Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> choice)**

ISO	Vc(m/min) range
P	80 - 200
M	120 - 240
K	120 - 240
N	120 - 240
S	120 - 240
H	120 - 240

Designation		RE	IC	S	D1			Stock													
<b>CNMG</b> 	CNMG120408-NRM	0.8	12.70	4.76	5.16	●	●														
	CNMG120412-NRM	1.2	12.70	4.76	5.16	●	●														
	CNMG160612-NRM	1.2	15.87	6.35	6.35	●	●														
	CNMG190612-NRM	1.2	19.05	6.35	7.94		●														
	CNMG190616-NRM	1.6	19.05	6.35	7.94		●														
<b>DNMG</b> 	DNMG150608-NRM	0.8	12.70	6.35	5.16		●														
	DNMG150612-NRM	1.2	12.70	6.35	5.16		●														
<b>SNMG</b> 	SNMG120408-NRM	0.8	12.70	4.76	5.16		●														
	SNMG120412-NRM	1.2	12.70	4.76	5.16		●														
	SNMG190612-NRM	1.2	19.05	6.35	7.94		●														
	SNMG190616-NRM	1.6	19.05	6.35	7.94		●														
<b>TNMG</b> 	TNMG160408-NRM	0.8	9.525	4.76	3.81		●														
	TNMG160412-NRM	1.2	9.525	4.76	3.81		●														
<b>WNMG</b> 	WNMG080408-NRM	0.8	12.70	4.76	5.16	●	●														
	WNMG080412-NRM	1.2	12.70	4.76	5.16	●	●														

● stock standard



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**NRM** (CNMG12, DNMG15, SNMG12, WNMG08)

RE 0.8	$a_p$	2.00 <b>3.50</b> 5.00
	$f_n$	0.20 <b>0.35</b> 0.50
RE 1.2	$a_p$	2.00 <b>3.50</b> 5.00
	$f_n$	0.25 <b>0.40</b> 0.55

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

**NRM** (CNMG16)

RE 1.2	$a_p$	3.00 <b>5.50</b> 8.00
	$f_n$	0.30 <b>0.45</b> 0.60

**NRM** (CNMG19, SNMG19)

RE 1.2	$a_p$	5.00 <b>7.50</b> 10.00
	$f_n$	0.40 <b>0.55</b> 0.70
RE 1.6	$a_p$	5.00 <b>7.50</b> 10.00
	$f_n$	0.45 <b>0.60</b> 0.75