

# NSM

Turning ISO **M** - Finishing





<h1>NSM</h1> <h2>TURNING</h2>	HF: micrograin carbide PVD: physical vapour deposition		HF	HF																
	PVD	PVD																		
<ul style="list-style-type: none"> <li>· Wide application range, from finishing to semi-finishing on ISO M materials</li> <li>· Combined with PVD micrograin carbides</li> <li>· Small slot design in the radius area drastically improves chip control performance</li> <li>· Sharp and curved cutting edge reducing cutting force and burr formation</li> </ul>	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	●	●															
	<b>Dimensions</b>		<b>ISO</b>		<b>Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> choice)</b>															
		P M K N S H	100 80 220 200																	

Designation		RE	IC	S	D1	Stock																
<b>CNMG</b> 	CNMG120404-NSM	0.4	12.70	4.76	5.16	●	●															
	CNMG120408-NSM	0.8	12.70	4.76	5.16	●	●															
<b>DNMG</b> 	DNMG150604-NSM	0.4	12.70	6.35	5.16	●	●															
	DNMG150608-NSM	0.8	12.70	6.35	5.16	●	●															
<b>TNMG</b> 	TNMG160404-NSM	0.4	9.525	4.76	3.81	●	●															
	TNMG160408-NSM	0.8	9.525	4.76	3.81	●	●															
<b>VNMG</b> 	VNMG160404-NSM	0.4	9.525	4.76	3.81	●	●															
	VNMG160408-NSM	0.8	9.525	4.76	3.81	●	●															
<b>WNMG</b> 	WNMG080404-NSM	0.4	12.70	4.76	5.16	●	●															
	WNMG080408-NSM	0.8	12.70	4.76	5.16	●	●															

● stock standard

RE 0.4	$a_p$	0.40	<b>1.20</b>	2.00
	$f_n$	0.08	<b>0.14</b>	0.20
RE 0.8	$a_p$	0.40	<b>1.20</b>	2.00
	$f_n$	0.10	<b>0.18</b>	0.26

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



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