



# MICRONEGA Action

Sharp like a positive, strong like a negative!

**MicroNega technology - Special kit:  
4 holders & 10 inserts for 239 €**

MICRONEGA TURNING	HT: cermet HF: micrograin carbide PVD: physical vapour deposition		HT	HF													
			JU4015	JP5120													
<ul style="list-style-type: none"> <li>Small negative inserts usable as an alternative to positive inserts for external and internal turning operations.</li> <li>From finishing to medium machining, available both with economical sintered chipbreaker (GM) than precision ground type (SS) for higher accuracy and lower cutting force.</li> <li>Micrograin PVD coated carbide JP5120 can be used as first choice while uncoated cermet JU4015 must be focused on high speed finishing applications.</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	○															
Dimensions		ISO	Vc(m/min) - suggested cutting speed range (bold: 1 <sup>st</sup> choice)														
		P	200	60													
		M	380	200													
		K	60														
		N	140														
		S															
		H															

Designation		RE	IC	S	D1			Stock																		
GM 	MCN.R04M-GM	0.4	7.50	3.18	3.60	●	●																			
MCN	general purpose																									
SS 	MCN.R04G-SS	0.4	7.50	3.18	3.60	●	●																			
MCN	low cutting force																									
GM 	MDN.R04M-GM	0.4	7.00	3.18	3.60	●	●																			
MDN	general purpose																									
SS 	MDN.R04G-SS	0.4	7.00	3.18	3.60	●	●																			
MDN	low cutting force																									

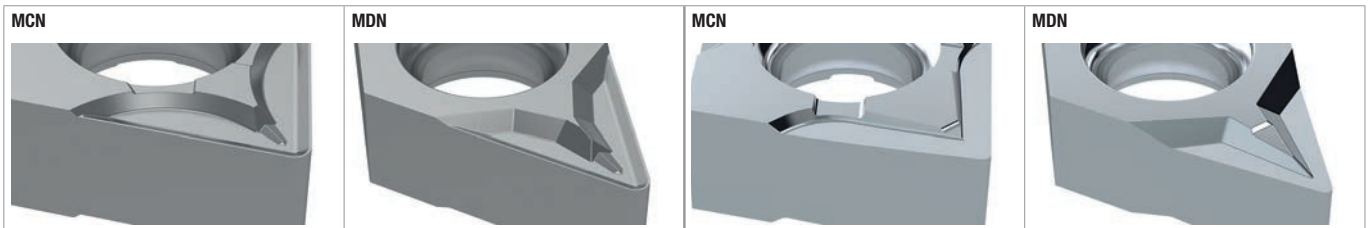
● stock standard

### GM CHIPBREAKER

General machining chipbreaker, suitable from light to medium cutting with perfect chip control. Very competitive cost per edge!

### SS CHIPBREAKER

Ground chipbreaker with slant cutting edge, for precision machining and very low cutting force. Best choice for stainless steel and free cutting steel.



### GM

RE 0.4	a <sub>p</sub>	0.80	<b>1.50</b>	2.20
	f <sub>n</sub>	0.08	<b>0.15</b>	0.22

### SS

RE 0.4	a <sub>p</sub>	0.60	<b>1.20</b>	1.80
	f <sub>n</sub>	0.10	<b>0.17</b>	0.24

a<sub>p</sub>: depth of cut (mm)

f<sub>n</sub>: feed rate (mm/rev)

## MICRONEGA

PMKNSH

- Boring bar with VORTEX technology that improves chip ejection thanks to innovative head design.
- Made with a special alloyed steel that improves stiffness and reduces vibrations allowing overhang up to 5 times the diameter.
- Super positive positioning dramatically reduces cutting forces.
- Coolant hole.

**MCN** right-hand shown

**MDN** right-hand shown

Designation		Stock		DMIN	DCON	WF	LF	LH	GAMO	WT	MIID		
		L	R										
MCN	NT-V08H-MICRO-CN-1/8 H-10	●	●	10	8	5.5	100	20	24°	0.10	MCN		
	NT-V10K-MICRO-CN-1/8 H-12	●	●	12	10	6.0	125	21	21°	0.10	MCN		
	NT-V12M-MICRO-CN-1/8 H-14	●	●	14	12	7.0	150	25	20°	0.20	MCN		
	NT-V16Q-MICRO-CN-1/8 H-18	●	●	18	16	9.0	180	31	17°	0.30	MCN		
	NT-V20R-MICRO-CN-1/8 H-22	●	●	22	20	11.0	200	37	17°	0.50	MCN		
MDN	NT-V10K-MICRO-DN-1/8 H-15	●	●	15	10	9.8	125	19	19°	0.10	MDN		
	NT-V12M-MICRO-DN-1/8 H-16	●	●	16	12	9.0	150	22	17°	0.20	MDN		
	NT-V16Q-MICRO-DN-1/8 H-20	●	●	20	16	11.0	180	22	15°	0.30	MDN		
	NT-V20R-MICRO-DN-1/8 H-25	●	●	25	20	13.0	200	23	13°	0.50	MDN		

Spare Parts

**INSERT SCREW**

**INSERT WRENCH**

NT-V<sub>000</sub>-MICRO-CN-1/8 H-<sub>00</sub>

NT-ST400

NT-FT10

**CONTACT SURFACE**

The chipbreaker design has been studied to leave wide supporting surfaces and a stable coupling with the tool holder (red highlighted areas).



**GAP WITH HOLDER**

The gap between the tool holder seat and the cutting edge is absolutely normal. The contact points are designed to be in the internal part, around the insert hole.



### MICRONEGA

PMKNSH

- External tool holders for small parts machining.
- Small dimensions, thanks to head design without offset
- Super positive positioning dramatically reduces cutting forces

**MCN** right-hand shown

**MDN** right-hand shown

Designation		Stock		H	B	WF	LF	LH	WT	MIID			
		L	R										
<b>MCN</b>	NT-EX10H-MICRO-CN-1/8 H	●	●	10	10	10	100	15	0.10	MCN			
	NT-EX12H-MICRO-CN-1/8 H	●	●	12	12	12	100	15	0.20	MCN			
	NT-EX16K-MICRO-CN-1/8 H	●	●	16	16	16	120	15	0.30	MCN			
<b>MDN</b>	NT-EX10H-MICRO-DN-1/8 H	●	●	10	10	10	100	15	0.10	MDN			
	NT-EX12H-MICRO-DN-1/8 H	●	●	12	12	12	100	15	0.20	MDN			
	NT-EX16K-MICRO-DN-1/8 H	●	●	16	16	16	120	15	0.30	MDN			

Spare Parts

**INSERT SCREW**

**INSERT WRENCH**

<b>NT-EX000-MICRO000-1/8 H</b>	NT-ST400	NT-FT10
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THE BOX INCLUDES:



<b>VORTEX-MCNR</b>	1x NT-V10K-MICRO-CN-RH-12 1x NT-V12M-MICRO-CN-RH-14 1x NT-V16Q-MICRO-CN-RH-18 1x NT-V20R-MICRO-CN-RH-22 5x MCN.R04M-GM JP5120 5x MCN.R04G-SS JP5120	<b>€ 239,00</b>
<b>VORTEX-MCNR</b>	1x NT-V10K-MICRO-DN-RH-15 1x NT-V12M-MICRO-DN-RH-16 1x NT-V16Q-MICRO-DN-RH-20 1x NT-V20R-MICRO-DN-RH-25 5x MDN.R04M-GM JP5120 5x MDN.R04G-SS JP5120	<b>€ 239,00</b>
<b>VORTEX-MCNL</b>	1x NT-V10K-MICRO-CN-LH-12 1x NT-V12M-MICRO-CN-LH-14 1x NT-V16Q-MICRO-CN-LH-18 1x NT-V20R-MICRO-CN-LH-22 5x MCN.R04M-GM JP5120 5x MCN.R04G-SS JP5120	<b>€ 239,00</b>
<b>VORTEX-MDNL</b>	1x NT-V10K-MICRO-DN-LH-15 1x NT-V12M-MICRO-DN-LH-16 1x NT-V16Q-MICRO-DN-LH-20 1x NT-V20R-MICRO-DN-LH-25 5x MDN.R04M-GM JP5120 5x MDN.R04G-SS JP5120	<b>€ 239,00</b>



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