



MEGA TURN HEAVY DUTY TURNING OF LARGE DIAMETER WORKPIECES

Korloy MEGA TURN series inserts are designed for extra large cut depths and high metal removal of steel, stainless steel and exotic extra large diameter shafts, rolls and flanges.

Inserts feature a chip breaker on one side and a flat bottom for highest clamping stability.

- GH chip breaker for large depths of cut.
- VT chip breaker for extra large depths of cut.
- Ultra-tough CVD coated grades.

CVD coated NC3030 (P35) is suitable for heavy continuous or intermittent turning of steel, NC9135 (M35) is suitable for heavy continuous or intermittent turning of Stainless Steel, Titanium and Inconel.

CVD COATED CARBIDE HEAVY TURNING INSERTS

GRADE		ORDER CODE		PRICE	FEED f _n (mm/rev)	DEPTH OF CUT ap (mm)
ISO	RADIUS	NC3030	NC9135			
CNMM120408-GH	0.8	1-02-023525	-		0.30-0.60	2.50-8.00
CNMM120412-GH	1.2	1-02-026592	-		0.30-0.70	2.50-8.00
CNMM160612-GH	1.2	1-02-025187	-		0.30-0.90	2.50-8.00
CNMM160616-GH	1.6	1-02-036495	-		0.30-1.20	2.50-8.00
CNMM160624-GH	2.4	1-02-034206	-		0.30-1.50	2.50-8.00
CNMM190608-GH	0.8	1-02-027432	-		0.30-0.60	2.50-8.00
CNMM190612-GH	1.2	1-02-023143	1-02-073154		0.30-0.70	3.00-8.00
CNMM190616-GH	1.6	1-02-023575	1-02-064094		0.45-0.90	3.00-8.00
CNMM190624-GH	2.4	1-02-030119	1-02-073157		0.55-1.20	4.00-9.00
CNMM250724-GH	2.4	1-02-023001	1-02-073164		0.55-1.20	5.00-12.00
CNMM250924-GH	2.4	1-02-021765	1-02-069543		0.55-1.20	5.00-12.00
CNMM190612-VT	1.2	1-02-031620	1-02-073155		0.60-1.00	6.00-13.00
CNMM190616-VT	1.6	1-02-031621	1-02-073156		0.60-1.10	5.00-10.00
CNMM190624-VT	2.4	1-02-031622	1-02-073158		0.60-1.60	7.00-13.00
CNMM250924-VT	2.4	1-02-031624	1-02-073166		0.75-16.0	7.00-17.00
SNMM120408-GH	0.8	1-02-023788	-		0.30-0.60	2.50-8.00
SNMM120412-GH	1.2	1-02-026409	-		0.30-0.70	2.50-8.00
SNMM150612-GH	1.2	1-02-026616	-		0.30-0.70	2.50-8.00
SNMM190612-GH	1.2	1-02-024361	1-02-073159		0.30-0.70	3.00-8.00
SNMM190616-GH	1.6	1-02-026447	1-02-061098		0.45-1.00	4.00-9.00
SNMM190624-GH	2.4	1-02-026617	-		0.55-1.20	4.00-9.00
SNMM250724-GH	2.4	1-02-022193	1-02-065133		0.55-1.20	5.00-12.00
SNMM250924-GH	2.4	1-02-021764	1-02-073168		0.55-1.20	5.00-12.00
SNMM190612-VT	1.2	1-02-031625	1-02-073160		0.60-1.00	6.00-13.00
SNMM190616-VT	1.6	1-02-031626	1-02-073161		0.60-1.10	6.00-13.00
SNMM190624-VT	2.4	1-02-031627	-		0.60-1.60	7.00-13.00
SNMM250724-VT	2.4	1-02-030299	1-02-073167		0.75-1.60	7.00-15.00
SNMM250924-VT	2.4	1-02-030296	1-02-073169		0.75-1.60	7.00-15.00

RECOMMENDED CUTTING CONDITIONS

Material Group	Material	Surface Speed (m/min)	
		NC3030	NC9135
Steel	Low Carbon Steel	50-150	-
	Alloy Steel	50-150	-
	Pre-Hardened Steel	50-120	-
Stainless Steel	Austenitic Stainless (e.g.316)	-	100-150
	Martensitic Stainless (e.g.404)	-	100-150
	Duplex	-	60-100
	17-4PH	-	60-100
HRSA's	Inconel, Nickel Alloy	-	20-40
	Titanium, Ti-Alloy	-	20-40

1ST CHOICE HEAVY DUTY TURNING OF STEEL, STAINLESS STEEL, TITANIUM & INCONEL WITH EXTRA LARGE CUT DEPTHS

CHIP BREAKER GUIDE

GH

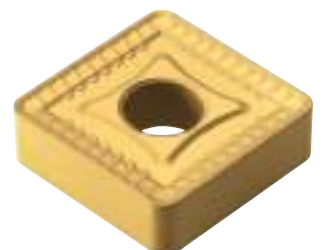
- For long tool life and stable cutting (high feeds, big depth) in heavy machining.
- Wide chip control range with low cutting force.
- The positioning of the chip breaking convex dot deflects the machining heat, optimizes inserts wear & absorb shock.



Depth of cut: 5.0-12.0mm
Feed rate: 0.55-1.20mm/rev

VT

- For long tool life and stable cutting (higher feeds, big depth) in heaviest machining.
- Varied cutting edge land strengthens the cutting edge.
- The positioning of the chip breaking convex dot deflects the machining heat, optimizes inserts wear & absorb shock.



Depth of cut: 7.0-17.0mm
Feed rate: 0.75-1.60mm/rev