



P Steel	H Hardened Steel	M Stainless Steel	S HRSA's	K Cast Iron	N Non-Ferrous
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NC9135

MEDIUM TO LOW SPEED STAINLESS & HRSA TURNING

NC9135 is the first choice for trouble free turning of stainless steel and exotics at medium to low speeds. Excellent tool life in continuous & heavy intermittent cutting.

The CVD coating has exceptional wear resistance under the highest temperature and is ideal for applications with large metal removal.

- Suitable for stainless steel, duplex, 17-4PH & HRSA's.
- Continuous or intermittent cutting.
- Tough substrate prevents the insert chipping in roughing applications.

NC9135 is recommended for **MEDIUM TO LARGE DIAMETER WORKPIECES** (above $\varnothing 50\text{mm}$), especially where machining contact time is longer and heat generation can cause premature wear.

1ST CHOICE FOR MEDIUM TO LOW SPEED TURNING OF STAINLESS & HRSA's

CHIP BREAKER GUIDE

MM

First choice chip breaker for medium and light intermittent turning. Wide chip pockets for stable chip evacuation at high depth of cuts and high feeds.



Depth of cut: 0.5-5.5mm
Feed rate: 0.12-0.45mm/rev

RM

First choice for rough machining of stainless steel and exotics where burrs are an issue. Wide land angle make it ideal for large cuts.



Depth of cut: 2.0-6.0mm
Feed rate: 0.15-0.55mm/rev

NC9135 - CVD COATED TURNING INSERTS

GRADE		ORDER CODE NC9135	PRICE	FEED f _n (mm/rev)	DEPTH OF CUT ap (mm)
ISO	RADIUS				
CCMT060202-MP	0.2	1-02-061700		0.04-0.12	0.20-1.50
CCMT060204-MP	0.4	1-02-061703		0.05-0.15	0.30-1.50
CCMT09T302-MP	0.2	1-02-061709		0.07-0.15	0.30-2.00
CCMT09T304-MP	0.4	1-02-061712		0.07-0.15	0.50-2.00
CCMT09T308-MP	0.8	1-02-061718		0.08-0.25	0.50-2.50
CCMT120404-MP	0.4	1-02-0665377		0.10-0.30	0.80-3.50
CCMT120408-MP	0.8	1-02-0665378		0.15-0.35	1.00-3.50
CNMG120404-MM	0.4	1-02-063690		0.10-0.40	0.50-5.50
CNMG120408-MM	0.8	1-02-059541		0.12-0.45	0.50-5.50
CNMG120412-MM	1.2	1-02-060712		0.15-0.60	0.50-5.50
CNMG160608-MM	0.8	1-02-063693		0.12-0.45	0.50-7.00
CNMG160612-MM	1.2	1-02-063367		0.15-0.60	0.50-7.00
CNMG160616-MM	1.6	1-02-062505		0.18-0.65	0.50-7.00
CNMG190608-MM	0.8	1-02-063695		0.12-0.45	0.50-8.50
CNMG190612-MM	1.2	1-02-063697		0.15-0.60	0.50-8.50
CNMG190616-MM	1.6	1-02-063699		0.18-0.65	0.50-8.50
CNMG160616-RM	1.6	1-02-062507		0.25-0.70	2.00-8.00
CNMG190612-RM	1.2	1-02-063698		0.20-0.60	2.00-10.00
CNMG190616-RM	1.6	1-02-063700		0.25-0.70	2.00-10.00
DCMT070202-MP	0.2	1-02-061744		0.04-0.12	0.12-1.80
DCMT070204-MP	0.4	1-02-061747		0.06-0.17	0.20-2.30
DCMT11T302-MP	0.2	1-02-061756		0.04-0.15	0.30-2.00
DCMT11T304-MP	0.4	1-02-061760		0.08-0.23	0.30-3.00
DCMT11T308-MP	0.8	1-02-061766		0.10-0.30	0.50-3.00
DNMG110404-MP	0.4	1-02-070452		0.08-0.35	0.50-5.00
DNMG110408-MP	0.8	1-02-070454		0.10-0.40	0.50-5.00
DNMG150404-MM	0.4	1-02-063701		0.10-0.40	0.50-6.40
DNMG150408-MM	0.8	1-02-060715		0.12-0.45	0.50-6.40
DNMG150412-MM	1.2	1-02-060718		0.15-0.60	0.50-6.40
DNMG150604-MM	0.4	1-02-063703		0.10-0.40	0.50-6.40
DNMG150608-MM	0.8	1-02-060721		0.12-0.45	0.50-6.40
DNMG150612-MM	1.2	1-02-060724		0.15-0.60	0.50-6.40
DNMG150608-RM	0.8	1-02-060819		0.15-0.55	2.00-6.00
DNMG150612-RM	1.2	1-02-060822		0.20-0.60	2.00-6.00
SCMT09T304-MP	0.4	1-02-061789		0.05-0.25	0.30-2.80
SCMT09T308-MP	0.8	1-02-061795		0.10-0.30	0.50-2.80
SCMT120404-MP	0.4	1-02-070494		0.10-0.30	0.50-2.80
SCMT120408-MP	0.8	1-02-061801		0.15-0.35	0.80-3.50
SNMG120404-MM	0.4	1-02-060727		0.10-0.40	0.50-6.40
SNMG120408-MM	0.8	1-02-060730		0.12-0.45	0.50-6.40
SNMG120412-MM	1.2	1-02-063705		0.15-0.60	0.50-6.40
SNMG150612-MM	1.2	1-02-063373		0.15-0.60	0.50-8.00
SNMG150616-MM	1.6	1-02-070500		0.18-0.65	0.50-8.00
SNMG190608-MM	0.8	1-02-063707		0.12-0.45	0.50-9.50
SNMG190612-MM	1.2	1-02-063709		0.15-0.60	0.50-9.50
SNMG190616-MM	1.6	1-02-069096		0.18-0.65	0.50-9.50
SNMG190608-RM	0.8	1-02-063708		0.20-0.60	2.00-10.00
SNMG190612-RM	1.2	1-02-063112		0.20-0.60	2.00-10.00
TCMT110204-MP	0.4	1-02-061822		0.06-0.19	0.20-2.50
TCMT16T304-MP	0.4	1-02-061828		0.08-0.23	0.30-3.00
TCMT16T308-MP	0.8	1-02-061834		0.10-0.30	0.50-3.00
TNMG160404-MM	0.4	1-02-060733		0.10-0.40	0.50-4.80
TNMG160408-MM	0.8	1-02-060736		0.12-0.45	0.50-4.80
TNMG160412-MM	1.2	1-02-070229		0.15-0.50	0.80-4.50
TNMG220408-MM	0.8	1-02-063710		0.12-0.45	0.50-6.50
TNMG220412-MM	1.2	1-02-063711		0.15-0.60	0.50-6.50
TNMG220408-RM	0.8	1-02-063712		0.10-0.50	2.00-7.50
TNMG220412-RM	1.2	1-02-063715		0.15-0.55	2.00-7.50
VBMT110304-MP	0.4	1-02-070539		0.05-0.15	0.20-1.50
VBMT160404-MP	0.4	1-02-061864		0.08-0.20	0.30-2.00
VBMT160408-MP	0.8	1-02-061870		0.10-0.25	0.50-2.30
VBMT160412-MP	1.2	1-02-061876		0.10-0.35	0.50-2.30
VCMT160404-MP	0.4	1-02-061882		0.08-0.20	0.30-2.00
VCMT160408-MP	0.8	1-02-061888		0.10-0.25	0.50-2.30
VCMT160412-MP	1.2	1-02-061894		0.10-0.35	0.50-2.30
VNMG160404-MM	0.4	1-02-063713		0.10-0.40	0.50-4.80
VNMG160408-MM	0.8	1-02-063714		0.12-0.45	0.50-4.80
WNMG060408-MM	0.8	1-02-070587		0.08-0.35	0.50-4.00
WNMG060412-MM	1.2	1-02-070591		0.10-0.40	0.50-4.00
WNMG080404-MM	0.4	1-02-063716		0.10-0.40	0.50-4.00
WNMG080408-MM	0.8	1-02-060739		0.12-0.45	0.50-4.00
WNMG080412-MM	1.2	1-02-060742		0.15-0.60	0.50-4.00

RECOMMENDED CUTTING CONDITIONS

Material Group	Material	Surface Speed (m/min)
Stainless Steel	Austenitic Stainless (e.g.316)	100-150
	Martensitic Stainless (e.g.404)	100-150
	Duplex 17-4PH	50-80 30-80
HRSA's	Inconel, Nickel Alloy	20-40
	Titanium, Ti-Alloy	20-40