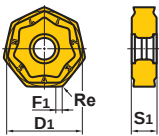
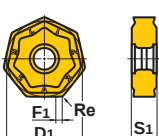
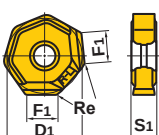


INSERTS

Shape	Order Number	Class	Honing	Coated	Dimensions (mm)				Geometry
					D1	S1	F1	Re	
MK Breaker 	NNMU200608ZEN-MK	M	E	●	20	6.55	1.0	0.8	
General									
HK Breaker 	NNMU200608ZEN-HK	M	E	●	20	6.55	1.0	0.8	
Strong Cutting Edge Type									
Wiper 	WNEU2006ZEN7C-WK	E	E	●	20	6.55	7.4	0.8	

★ The inserts can be used with both right and left hand cutters.

INSERT APPLICATIONS



RECOMMENDED CUTTING CONDITIONS

General Machining

Work Material	Tensile Strength	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)	
K	Cast Iron	MC5020	300 (250—350)	0.3 (0.2—0.4)	
			220 (150—300)	0.3 (0.2—0.4)	
	Ductile Cast Iron		200 (150—250)	0.2 (0.1—0.3)	
			500—800 MPa	170 (150—200)	0.2 (0.1—0.3)

Finishing (When using wiper insert)

Work Material	Axial Depth of Cut (mm)	Cutting Speed (m/min)	Feed per Revolution (mm/rev.)
K	Cast Iron	320 (250—400)	0.2 (0.1—0.3)
		270 (200—350)	
	Ductile Cast Iron	270 (200—350)	
		220 (200—250)	