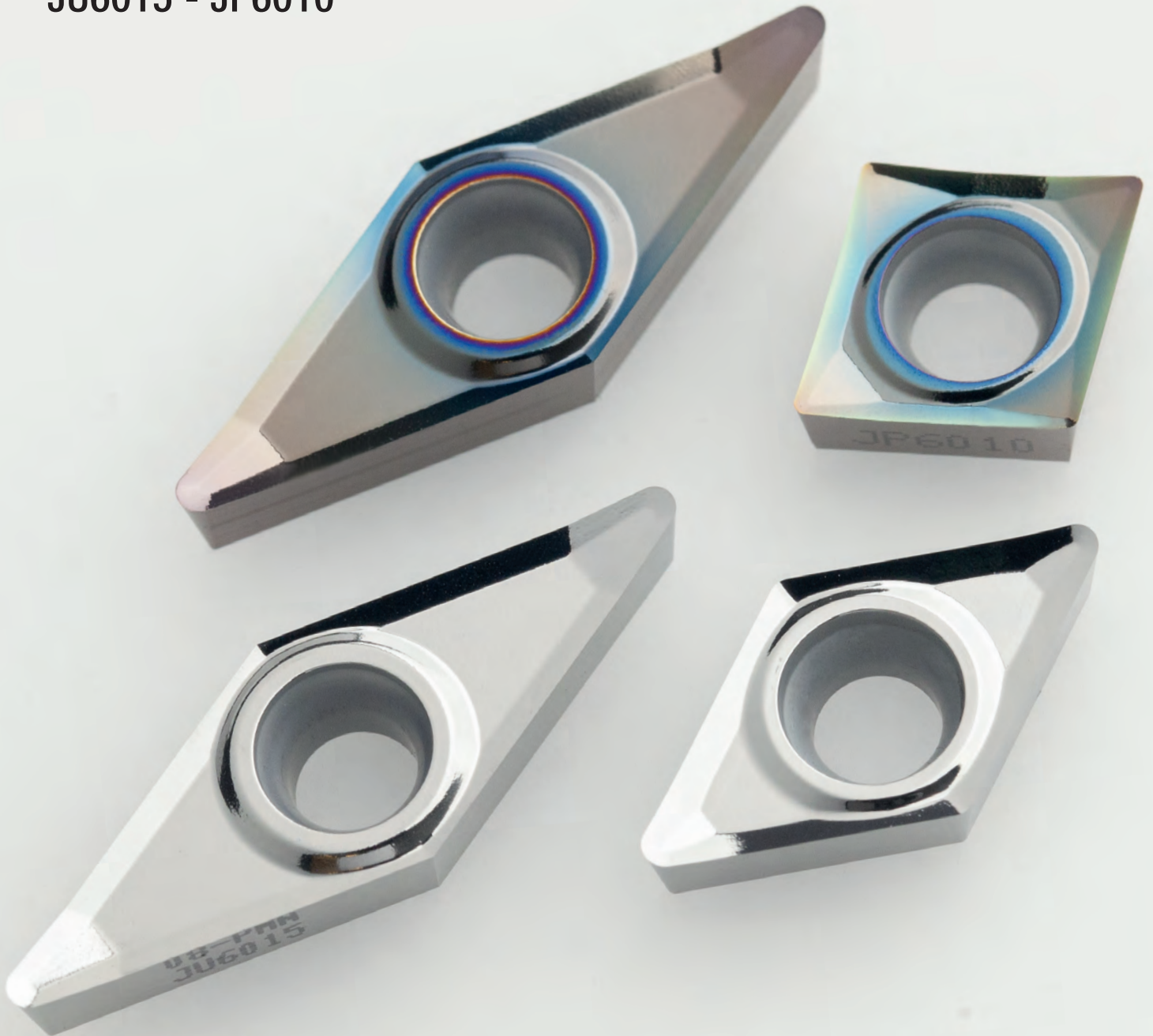


06/2021
NPI

6000 SERIES

JU6015 - JP6010



6000 series

TURNING

- Broad range of geometries and radii for non ferrous materials machining
- High precision ground and polished insert
- Large rake angle for low cutting force
- Curved cutting edge for better chip flow from finishing to medium cutting
- Uncoated micrograin carbide JU6015 for general machining and special coated JP6010 for extended tool life

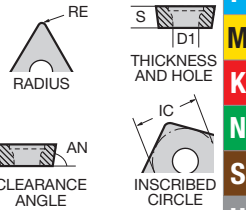
HF: micrograin carbide
PVD: physical vapour deposition

HF PVD

JP6010 JU6015

- Stable machining, light cut ● 1st choice ○ suitable
- General machining, medium cut ● 1st choice ○ suitable
- Unstable machining, heavy cut ● 1st choice ○ suitable

Dimensions



ISO Vc(m/min) - suggested cutting speed range (bold: 1st choice)

ISO	P	M	K	N	S	H
	600	500	2000	1500		

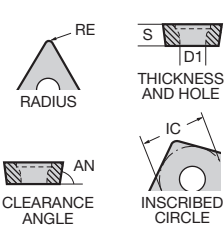
Designation		RE	IC	S	D1	AN	Stock	
	CCGX060202-PMN	0.2	6.35	2.38	2.80	7°	○ ●	
	CCGX060204-PMN	0.4	6.35	2.38	2.80	7°	● ●	
	CCGX060208-PMN	0.8	6.35	2.38	2.80	7°	○ ●	
	CCGX09T302-PMN	0.2	9.525	3.97	4.40	7°	○ ●	
	CCGX09T304-PMN	0.4	9.525	3.97	4.40	7°	● ●	
	CCGX09T308-PMN	0.8	9.525	3.97	4.40	7°	● ●	
	CCGX120402-PMN	0.2	12.70	4.76	5.50	7°	○ ○	
	CCGX120404-PMN	0.4	12.70	4.76	5.50	7°	● ●	
	CCGX120408-PMN	0.8	12.70	4.76	5.50	7°	● ●	
	DCGX070202-PMN	0.2	6.35	2.38	2.80	7°	○ ●	
	DCGX070204-PMN	0.4	6.35	2.38	2.80	7°	● ●	
	DCGX070208-PMN	0.8	6.35	2.38	2.80	7°	○ ●	
	DCGX11T302-PMN	0.2	9.525	3.97	4.40	7°	● ●	
	DCGX11T304-PMN	0.4	9.525	3.97	4.40	7°	● ●	
	DCGX11T308-PMN	0.8	9.525	3.97	4.40	7°	● ●	
	SCGX09T304-PMN	0.4	9.525	3.97	4.40	7°	○ ●	
	SCGX09T308-PMN	0.8	9.525	3.97	4.40	7°	○ ●	
	SCGX120404-PMN	0.4	12.70	4.76	5.50	7°	○ ●	
	SCGX120408-PMN	0.8	12.70	4.76	5.50	7°	○ ●	
	TCGX090204-PMN	0.4	5.56	2.38	2.50	7°	● ●	
	TCGX110202-PMN	0.2	6.35	2.38	2.80	7°	○ ○	
	TCGX110204-PMN	0.4	6.35	2.38	2.80	7°	● ●	
	TCGX110208-PMN	0.8	6.35	2.38	2.80	7°	○ ○	
	TCGX16T302-PMN	0.2	9.525	3.97	4.40	7°	○ ○	
	TCGX16T304-PMN	0.4	9.525	3.97	4.40	7°	● ●	
	TCGX16T308-PMN	0.8	9.525	3.97	4.40	7°	● ●	


● stock standard, ○ non-standard stock

6000 series

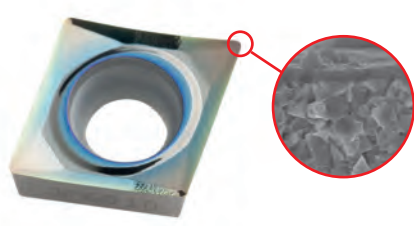
TURNING

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HF: micrograin carbide PVD: physical vapour deposition		HF	HF																				
		JP6010	JU6015																				
Stable machining, light cut	● 1 st choice ○ suitable	●	●																				
General machining, medium cut	● 1 st choice ○ suitable	○	●																				
Unstable machining, heavy cut	⚙️ 1 st choice ⚙️ suitable	⚙️																					
Dimensions		ISO			Vc(m/min) - suggested cutting speed range (bold: 1 st choice)																		
	ISO	P																					
		M																					
		K																					
		N	600	500																			
		S	2000	1500																			
H																							

Designation		RE	IC	S	D1	AN	Stock																				
MEDIUM		VCGX110302-PMN	0.2	6.35	3.18	2.80	7°	○	●																		
		VCGX110304-PMN	0.4	6.35	3.18	2.80	7°	●	●																		
		VCGX110308-PMN	0.8	6.35	3.18	2.80	7°	○	○																		
		VCGX160402-PMN	0.2	9.525	4.76	4.40	7°	○	●																		
		VCGX160404-PMN	0.4	9.525	4.76	4.40	7°	●	●																		
		VCGX160408-PMN	0.8	9.525	4.76	4.40	7°	●	●																		
		VCGX160412-PMN	1.2	9.525	4.76	4.40	7°	○	○																		
		VCGX220512-PMN	1.2	12.70	5.56	5.50	7°	○	○																		
		VCGX220516-PMN	1.6	12.70	5.56	5.50	7°	○	○																		
		VCGX220530-PMN	3.0	12.70	5.56	5.50	7°	●	●																		

● stock standard, ○ non-standard stock

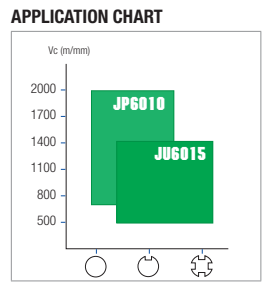


NEW COATED GRADE JP6010

Extremely hard thin film for a tool life improvement higher than 50%

The special ceramic coating reduces chemical adhesion between chips and cutting edge.

Very low friction coefficient for a smooth cutting action and low heat generation.



CC06, DC07, TC11, VC11

RE 0.2	a _p	0.30	1.50	2.70
	f _n	0.05	0.10	0.15
RE 0.4	a _p	0.30	1.50	2.70
	f _n	0.06	0.13	0.20
RE 0.8	a _p	0.30	1.50	2.70
	f _n	0.08	0.16	0.24

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

CC09, DC11, SC09, TC16, VC16

RE 0.2	a _p	0.50	2.00	3.50
	f _n	0.06	0.11	0.16
RE 0.4	a _p	0.50	2.00	3.50
	f _n	0.08	0.16	0.24
RE 0.8	a _p	0.50	2.00	3.50
	f _n	0.10	0.20	0.30
RE 1.2	a _p	0.50	2.00	3.50
	f _n	0.12	0.24	0.36

CC12, SC12, VC22

RE 0.2	a _p	0.50	3.00	5.50
	f _n	0.08	0.14	0.20
RE 0.4	a _p	0.50	3.00	5.50
	f _n	0.10	0.20	0.30
RE 0.8	a _p	0.50	3.00	5.50
	f _n	0.15	0.25	0.35
RE 1.2	a _p	0.50	3.00	5.50
	f _n	0.16	0.28	0.40
RE 1.6	a _p	0.50	3.00	5.50
	f _n	0.16	0.31	0.46
RE 3.0	a _p	0.50	3.00	5.50
	f _n	0.20	0.40	0.60



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