





MICRONEGA Action

Sharp like a positive, strong like a negative!

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

<h1>MICRONEGA</h1>		HT: cermet HF: micrograin carbide PVD: physical vapour deposition	HT	HF																				
			JU4015	JP5120																				
<h2>TURNING</h2>																								
<ul style="list-style-type: none"> Small negative inserts usable as an alternative to positive inserts for external and internal turning operations. From finishing to medium machining, available both with economical sintered chipbreaker (GM) than precision ground type (SS) for higher accuracy and lower cutting force. Micrograin PVD coated carbide JP5120 can be used as first choice while uncoated cermet JU4015 must be focused on high speed finishing applications. 	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)																					
	S	P	200	60	[Color-coded cutting speed range chart]																			
	THICKNESS	M	380	200																				
		K		60																				
		N		140																				
		S																						
	H																							

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

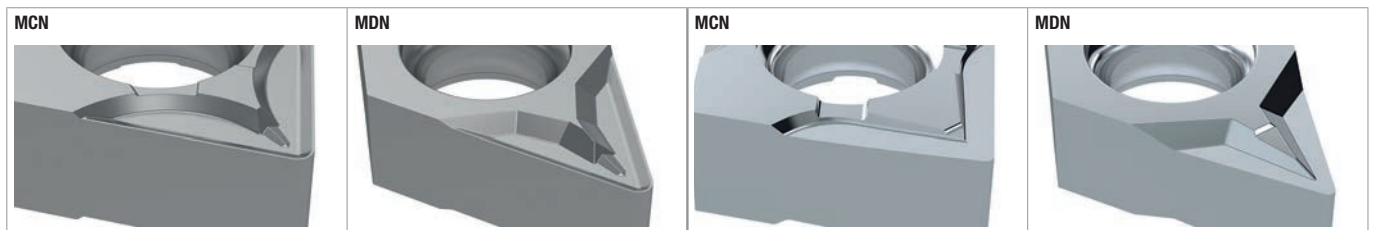
● stock standard

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				SS					
RE 0.4	a_p	0.80	1.50	2.20	RE 0.4	a_p	0.60	1.20	1.80
	f_n	0.08	0.15	0.22		f_n	0.10	0.17	0.24

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

MICRONEGA

P
M
K
N
S
H

- 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 ₀₀₀ -MICRO-CN-1/8 H-00	NT-ST400	NT-FT10
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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										
MCN	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			
MDN	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

NT-EX 000-MICRO000-1/8 H	NT-ST400	NT-FT10
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THE BOX INCLUDES:



VORTEX-MCNR	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	€ 239,00	
VORTEX-MCNR	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	€ 239,00	
VORTEX-MCNL	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	€ 239,00	
VORTEX-MDNL	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	€ 239,00	



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