

06/2021
NPI

NUK

JC7115



NUK

TURNING

· Universal choice for cast iron machining.
 · From semi-finishing to medium operation.
 · Stable positioning thanks to large contact surfaces that guarantee reliable operation and great vibrations reduction
 · Excellent cutting edge sharpness reduces burr formation
 · Combined with a newly developed CVD coated carbide grade JC7115, especially focused on nodular and vermicular cast iron machining

HC: coated carbide
 CVD: chemical vapour deposition

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)**

RE
RADIUS
D1
HOLE

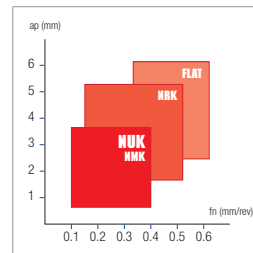
S
THICKNESS
IC
INSCRIBED CIRCLE

ISO P M K N S H
 180 380

Designation		RE	IC	S	D1		Stock													
	CNMG120404-NUK	0.4	12.70	4.76	5.16	●														
	CNMG120408-NUK	0.8	12.70	4.76	5.16	●														
	CNMG120412-NUK	1.2	12.70	4.76	5.16	●														
	DNMG150604-NUK	0.4	12.70	6.35	5.16	●														
	DNMG150608-NUK	0.8	12.70	6.35	5.16	●														
	DNMG150612-NUK	1.2	12.70	6.35	5.16	●														
	TNMG160404-NUK	0.4	9.525	4.76	3.81	●														
	TNMG160408-NUK	0.8	9.525	4.76	3.81	●														
	TNMG160412-NUK	1.2	9.525	4.76	3.81	●														
	WNMG080404-NUK	0.4	12.70	4.76	5.16	●														
	WNMG080408-NUK	0.8	12.70	4.76	5.16	●														
	WNMG080412-NUK	1.2	12.70	4.76	5.16	●														

● stock standard

APPLICATION CHART



NUK

RE 0.4	a_p	0.50	2.00	3.50
	f_n	0.10	0.20	0.30
RE 0.8	a_p	0.50	2.00	3.50
	f_n	0.15	0.25	0.35
RE 1.2	a_p	0.50	2.00	3.50
	f_n	0.20	0.30	0.40

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



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