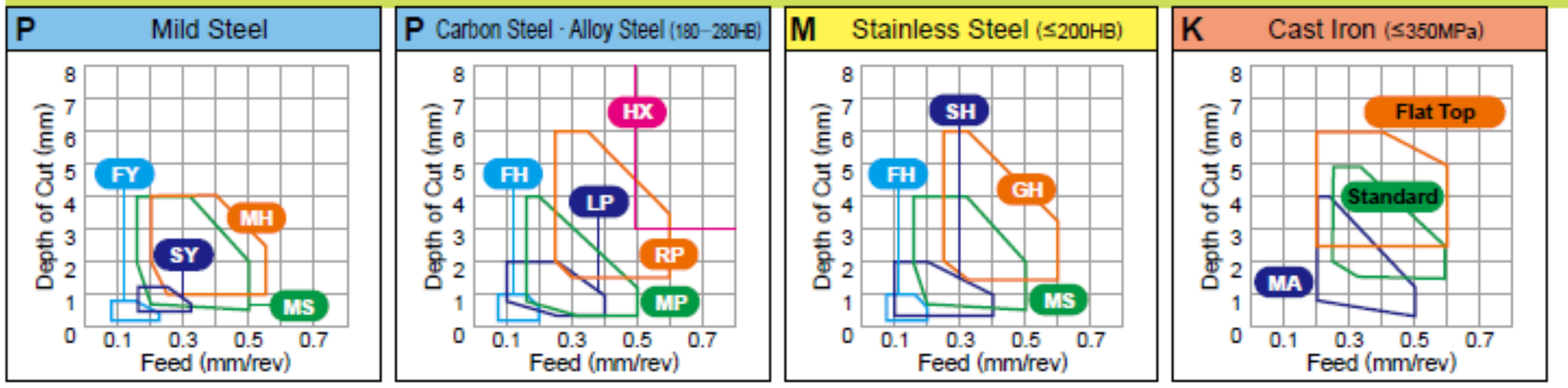
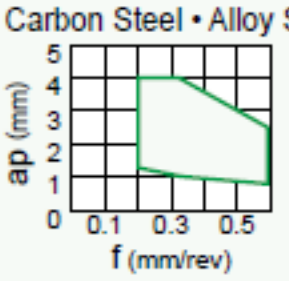
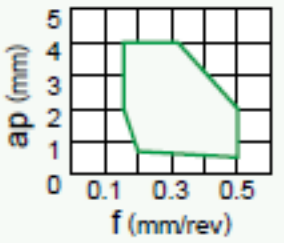
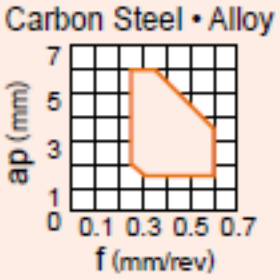
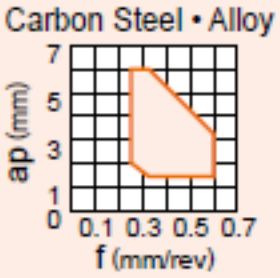
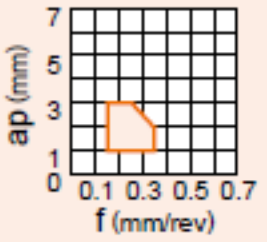
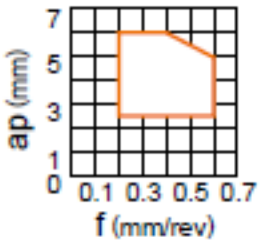
CHIP CONTROL RANGE FOR WORK MATERIALS

Finish Cutting ····· Light Cutting ····· Medium Cutting ····· Rough Cutting ····· Heavy Cutting ·····



Cutting Conditions (Guide) : ● : Stable Cutting ◐ : General Cutting ✱ : Unstable Cutting

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	

Shape	Chip Control Range ap : Depth of Cut f : Feed	Order Number	Corner R Re (mm)	Coated UE6105	UE6110	UE6020	MC6025 (NEW)	UE6035	UH6400	US7020	US735	US905	UC5105	UC5115	VP05RT	VP10RT	VP15TF	UP20M	Cermet NX2525	NX3035	Coated Cermet MP3025 (NEW)	AP25N	VP25N	Carbide UTi20T	HTi05T	HTi10	RT9010	Applicable Holder Page
* MW Medium Cutting (Wiper)	Carbon Steel • Alloy Steel 	WNMG060408-MW	0.8	●	●	●	●						●	●														C022 C023 E016 E040
		060412-MW	1.2	●	●								●	●														
		080408-MW	0.8	●	●	●	●			●			●	●														
		080412-MW	1.2	●	●					●			●	●														
MS Medium Cutting	Stainless Steel 	WNMG06T304-MS	0.4		●					★	●																	C022 C023 E016 E038 E040
		06T308-MS	0.8		●					★	●																	
		060404-MS	0.4		★					●	●																	
		060408-MS	0.8		★					●	●																	
		080404-MS	0.4		●	★				●	●																	
		080408-MS	0.8		●	★				●	●	●			●	●	●										●	
		080412-MS	1.2		★						●	●			●	●								●				
RP (NEW) Rough Cutting	Carbon Steel • Alloy Steel 	WNMG080408-RP	0.8	●	●		●																					C022 C023 E016
		080412-RP	1.2	●	●		●																					
GH Rough Cutting	Carbon Steel • Alloy Steel 	WNMG080408-GH	0.8	●	●	●		●		●	●		●	●														C022 C023 E016 E040
		080412-GH	1.2	●	●	●					●		●	●														
GJ Rough Cutting	Difficult-to-Cut Materials 	WNMG080408-GJ	0.8								●				●												●	C022 C023 E016 E040
		080412-GJ	1.2								●				●												●	
		080416-GJ	1.6								★				●												●	
		100612-GJ	1.2												●												●	
Flat Top	Cast Iron 	WNMA080404	0.4										●	●												●		C022 C023 E016 E040
		080408	0.8										●	●												●		
		080412	1.2										●	●												●		
		080416	1.6											●														