



New exclusive grade for high speed turning of cast iron

# NC6110

**New**

Fono: 055 787169  
www.itachile.com

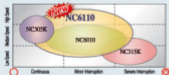


### Special Features of NC6110



- The Al<sub>2</sub>O<sub>3</sub> film having superior hardness & surface quality
- TiN-TiCN film having superior toughness as well as hardness
- Exclusive carbide for K10 coating grade

- ▶ Excellent hardness & toughness have been achieved due to the Al<sub>2</sub>O<sub>3</sub> coating having excellent surface quality as well as hardness.
- ▶ Consistence tool life even under intermittent cutting conditions.



### Recommended cutting conditions of NC6110

Cutting Conditions	Speed (F <sub>z</sub> /min, sfm)					Feed (f <sub>z</sub> /min/rev, ipr)					Depth (d <sub>z</sub> /min, inch)				
	100	200	300	400	500	0.1	0.2	0.3	0.4	0.5	1	2	3	4	5
Work piece	330	660	990	1320	1650	0.004	0.008	0.012	0.16	0.020	0.04	0.08	0.12	0.16	0.20
Gray Cast Iron															
Ductile Cast Iron															



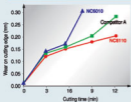
### Stock items of NC6110

CNMA120408	DNMG150608-GR	DNMG150608-B20	CNMG160608-GR	CCMT060204-HMP
CNMG120408-GR	CCMT09T308-HMP	SNMA190616	TNMG160408-GR	TNMG160408-HR
CNMG120412-GR	WNMG080412-GR	TCMT16T308-HMP	TCMT110204-HMP	TCMT060204-HMP
CNMA120412	WNMG080408-HR	DNMG150604-HM	WNMG080408-B25	TNMG160408-HM
CNMG120408-HM	WNMG080408-GR	CNMG120404-B20	DCMT11T308-C25	DCMT11T304-C25
DNMA150608	CNMG120408-B20	DNMG150608-HM	CNMA190612	FGD500F-08
WNMG080408-HM	CCMT120408-HMP	CNMG190608-B20	DNMG150408-HM	TNMA160408EX
CNMG120408-B25	DCMT11T308-HMP	SNMA120412	DNMG110408-HM	SNMG120408-HR
SNMG120408-HM	WNMA080412	SNMG120408-GR	TCMT16T304-HMP	SNMA120408
CNMG120412-B25	CCMT09T304-HMP	CCMT120404-HMP	DNMG150612-B20	MGMF400-M
CNMG120416-GR	CNMG120404-HM	CCMT09T308-C25	DCMT11T304-HMP	CNMG190608-HM
	WNMA080408	TCMT16T308-C25	DNMG150408-GR	

Note) Besides items listed above, order-made item is available. Stock items will be increased gradually.

### Cutting Performance of NC6110

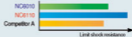
- Work piece: GC25 (Gray Cast Iron)
- Inset: CNMG120408-GR(CNMG432)
- Conditions: V=350m/min (1150sfm), f=0.3mm/rev (0.012ip), d=2.0mm (0.08ind), wet



- Work piece: SCM440 - 4grooves (Alloy steel)
- Inset: CNMG120408-GR(CNMG432)
- Conditions: V=150m/min (500sfm), f=Variable, d=2.0mm (0.08ind), dry



- Work piece: SCM440 - 4grooves (Alloy steel)
- Inset: CNMG120408-GR(CNMG432)
- Conditions: V=200m/min (650sfm), f=Variable, d=2.0mm (0.08ind), dry



### User Test Examples of NC6110

Inset	CNMG120412-GR CNMG434-GR	
Work piece	FC25 (Gray Cast Iron)	
V	250-300m/min (820-1000sfm)	
f	0.2-0.35mm/rev (0.008-0.014ip)	
D	4.0mm (0.16ind)	
Coolant	Wet	

NC6110

K10-d

A rake

7μm/chip
  4μm/chip

Inset	CNMG120412-GR CNMG434-GR	
Work piece	FCI-Sevens Interruption (Ductile Cast Iron)	
V	180m/min (590sfm)	
f	0.14-0.25mm/rev (0.006-0.010ip)	
D	3.0mm (0.12ind)	
Coolant	Wet	

NC6110

K10-d

A rake

11μm/chip
  11μm/chip