

**NEW  
PRODUCT!**

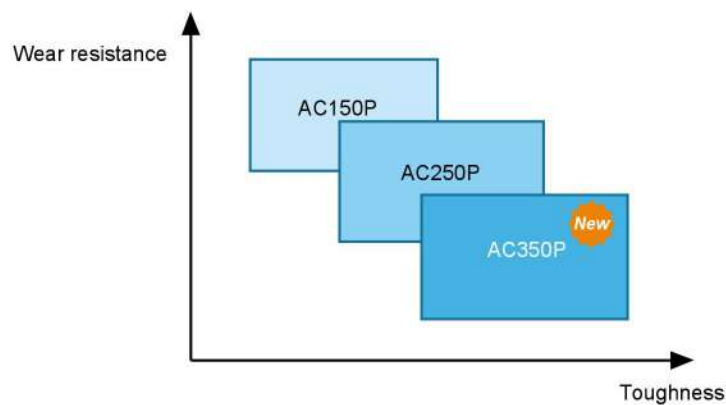
**AC350P**

## **New Turning CVD grade for steels**

For heavy interrupted machining



- **Application range**



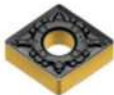
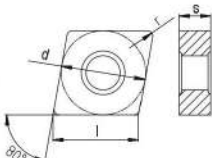
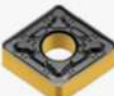
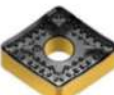
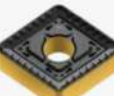
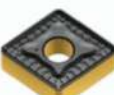
- **Recommended cutting speed by materials**

ISO	Material Classification	Tensile strength (N/mm <sup>2</sup> )	Hardness (HB)	Cutting Speed(m/min)		
				Low feed rate	Medium feed rate	Max feed rate
P (P30-45)	Unalloyed steel	<600	<180	250	182	115
		<950	<280	160	117	75
	Alloy steel	700-950	200-280	148	109	70
		950-1200	280-355	135	100	65
		1200-1400	355-415	93	69	45

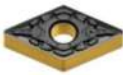
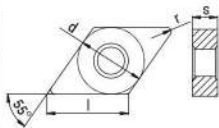
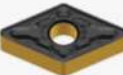
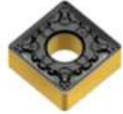
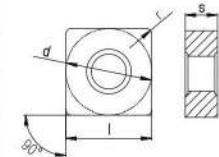
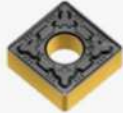
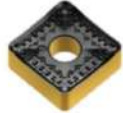
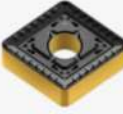
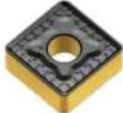
Remark) The recommended cutting speed always refer to general conditons. These cutting speed should be adjusted according to the practical machine rigidity, tools, work piece clamping and coolants.

## ● Stock items


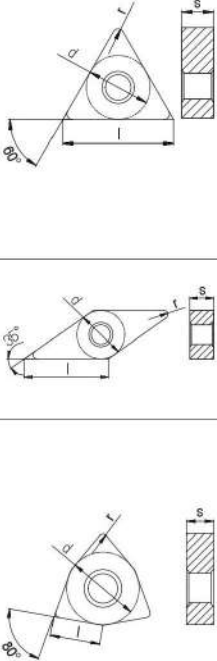

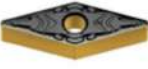
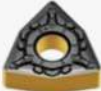
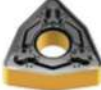
### Negative insert

Insert	Item designation	Recommended cutting parameters		Dimension(mm)				Grade (CVD)	Geometry
		Feed (mm/rev)	ap (mm)	d	l	s	r	AC350P	
	CNMG 120404E-PD3	0.08-0.22	0.40-4.30	12.70	12.9	4.76	0.4	○	
	120408E-PD3	0.15-0.44	0.80-4.30	12.70	12.9	4.76	0.8	●	
	120412E-PD3	0.23-0.66	1.20-4.30	12.70	12.9	4.76	1.2	●	
	160608E-PD3	0.15-0.44	0.80-5.30	15.87	16.1	6.35	0.8	○	
	190608E-PD3	0.15-0.44	0.80-6.40	19.05	19.3	6.35	0.8	○	
	CNMG 120408E-PD5	0.20-0.60	1.20-6.40	12.70	12.9	4.76	0.8	●	
	120412E-PD5	0.30-0.90	1.80-6.40	12.70	12.9	4.76	1.2	●	
	160612E-PD5	0.30-0.90	1.80-8.10	15.87	16.1	6.35	1.2	○	
	160616E-PD5	0.40-1.20	2.40-8.10	15.87	16.1	6.35	1.6	●	
	190612E-PD5	0.30-0.90	1.80-9.70	19.05	19.3	6.35	1.2	○	
	190616E-PD5	0.40-1.20	2.40-9.70	19.05	19.3	6.35	1.6	●	
	CNMM 120408E-PD8	0.16-0.32	1.44-5.20	12.70	12.9	4.76	0.8	●	
	120412E-PD8	0.24-0.48	2.16-5.20	12.70	12.9	4.76	1.2	●	
	160612E-PD8	0.24-0.48	2.16-6.40	15.87	16.1	6.35	1.2	○	
	160616E-PD8	0.32-0.64	2.88-6.40	15.87	16.1	6.35	1.6	○	
	160624E-PD8	0.48-0.96	4.32-6.40	15.87	16.1	6.35	2.4	○	
	190612E-PD8	0.24-0.48	2.16-7.70	19.05	19.3	6.35	1.2	○	
	190616E-PD8	0.32-0.64	2.88-7.70	19.05	19.3	6.35	1.6	●	
	190624E-PD8	0.48-0.96	4.32-7.70	19.05	19.3	6.35	2.4	●	
	250724E-PD8	0.48-0.96	4.32-10.3	25.40	25.8	7.94	2.4	○	
	250924E-PD8	0.48-0.96	4.32-10.3	25.40	25.8	9.52	2.4	●	
	CNMM 190612S-PC9	0.26-0.60	2.40-9.70	19.05	19.3	6.35	1.2	○	
	190616S-PC9	0.35-0.80	3.20-9.70	19.05	19.3	6.35	1.6	○	
	190624S-PC9	0.53-1.20	4.80-9.70	19.05	19.3	6.35	2.4	●	
	250724S-PC9	0.53-1.20	4.80-12.9	25.40	25.8	7.94	2.4	●	
	250924S-PC9	0.53-1.20	4.80-12.9	25.40	25.8	9.52	2.4	○	
	CNMM 190612S-PD9	0.30-0.72	2.64-11.6	19.05	19.3	6.35	1.2	○	
	190616S-PD9	0.40-0.96	3.52-11.6	19.05	19.3	6.35	1.6	○	
	190624S-PD9	0.60-1.44	5.28-11.6	19.05	19.3	6.35	2.4	●	
	250724S-PD9	0.60-1.44	5.28-15.5	25.40	25.8	7.94	2.4	○	
	250924S-PD9	0.60-1.44	5.28-15.5	25.40	25.8	9.52	2.4	●	


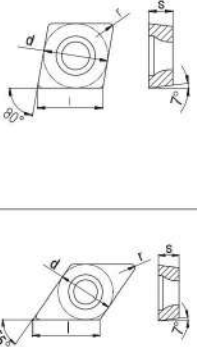
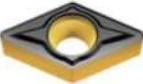
Remark: ● represent for standard stock  
○ represent for Make-To-Order

Insert	Item designation	Recommended cutting parameters		Dimension(mm)				Grade (CVD)	Geometry	
		Feed (mm/rev)	ap (mm)	d	l	s	r	AC350P		
	DNMG 150408E-PD3	0.15-0.44	0.8-3.9	12.7	15.5	4.76	0.8	●		
	150412E-PD3	0.23-0.66	1.2-3.9	12.7	15.5	4.76	1.2	●		
	150608E-PD3	0.15-0.44	0.8-3.9	12.7	15.5	6.35	0.8	○		
	150612E-PD3	0.23-0.66	1.2-3.9	12.7	15.5	6.35	1.2	○		
	DNMG 150408E-PD5	0.20-0.60	1.2-5.4	12.7	15.5	4.76	0.8	●		
	150412E-PD5	0.30-0.90	1.8-5.4	12.7	15.5	4.76	1.2	●		
	150416E-PD5	0.40-1.20	2.4-5.4	12.7	15.5	4.76	1.6	●		
	150608E-PD5	0.20-0.60	1.2-5.4	12.7	15.5	6.35	0.8	●		
	150612E-PD5	0.30-0.90	1.8-5.4	12.7	15.5	6.35	1.2	○		
	150616E-PD5	0.40-1.20	2.4-5.4	12.7	15.5	6.35	1.6	○		
	SNMG 120404E-PD3	0.08-0.22	0.4-4.2	12.7	12.7	4.76	0.4	○		
	120408E-PD3	0.15-0.44	0.8-4.2	12.7	12.7	4.76	0.8	●		
	120412E-PD3	0.23-0.66	1.2-4.2	12.7	12.7	4.76	1.2	●		
	190608E-PD3	0.15-0.44	0.8-6.3	19.05	19.05	6.35	0.8	○		
	SNMG 150608E-PD5	0.20-0.60	1.2-7.9	15.87	15.87	6.35	0.8	●		
	150612E-PD5	0.30-0.90	1.8-7.9	15.87	15.87	6.35	1.2	●		
	150616E-PD5	0.40-1.20	2.4-7.9	15.87	15.87	6.35	1.6	○		
	190612E-PD5	0.30-0.90	1.8-9.5	19.05	19.05	6.35	1.2	○		
	190616E-PD5	0.40-1.20	2.4-9.5	19.05	19.05	6.35	1.6	○		
	190624E-PD5	0.40-1.20	2.4-9.5	19.05	19.05	6.35	1.6	○		
	SNMM 120408E-PD8	0.16-0.32	1.44-5.1	12.7	12.7	4.76	0.8	●		
	120412E-PD8	0.24-0.48	2.16-5.1	12.7	12.7	4.76	1.2	○		
	150612E-PD8	0.24-0.48	2.16-6.40	15.87	15.87	6.35	1.2	○		
	190616E-PD8	0.32-0.64	2.88-7.60	19.05	19.05	6.35	1.6	●		
	190624E-PD8	0.48-0.96	4.32-7.60	19.05	19.05	6.35	2.4	●		
	250724E-PD8	0.48-0.96	4.32-10.2	25.4	25.4	7.94	2.4	○		
	250924E-PD8	0.48-0.96	4.32-10.2	25.4	25.4	9.525	2.4	○		
	SNMM 190612S-PC9	0.26-0.60	2.4-9.5	19.05	19.05	6.35	1.2	○		
	190616S-PC9	0.35-0.80	3.20-9.50	19.05	19.05	6.35	1.6	○		
	190624S-PC9	0.53-1.20	4.80-9.50	19.05	19.05	6.35	2.4	●		
	250724S-PC9	0.53-1.20	4.80-12.7	25.4	25.4	7.94	2.4	○		
	250924S-PC9	0.53-1.20	4.80-12.7	25.4	25.4	9.525	2.4	○		
	250924S-PC9	0.53-1.20	4.80-12.7	25.4	25.4	9.525	2.4	○		
	SNMM 190612S-PD9	0.30-0.72	2.64-11.4	19.05	19.05	6.35	1.2	○		
	190616S-PD9	0.40-0.96	3.52-11.4	19.05	19.05	6.35	1.6	○		
	190624S-PD9	0.60-1.44	5.28-11.4	19.05	19.05	6.35	2.4	●		
	250724S-PD9	0.60-1.44	5.28-15.2	25.4	25.4	7.94	2.4	○		
	250924S-PD9	0.60-1.44	5.28-15.2	25.4	25.4	9.525	2.4	●		


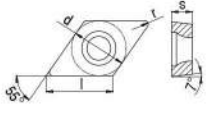

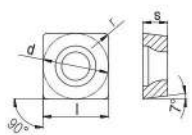

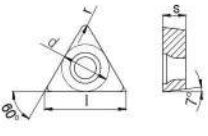

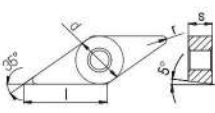

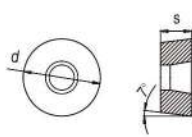
Remark: ● represent for standard stock  
○ represent for Make-To-Order

Insert	Item designation	Recommended cutting parameters		Dimension(mm)				Grade (CVD)	Geometry
		Feed (mm/rev)	ap (mm)	d	l	s	r	AC350P	
	TNMG 160404E-PD3	0.08-0.22	0.4-4.1	9.52	16.5	4.76	0.4	○	
	160408E-PD3	0.15-0.44	0.8-4.1	9.52	16.5	4.76	0.8	●	
	160412E-PD3	0.23-0.66	1.2-4.1	9.52	16.5	4.76	1.2	○	
	TNMG 160408E-PD5	0.20-0.60	1.2-5.8	9.52	16.5	4.76	0.8	●	
	160412E-PD5	0.30-0.90	1.8-5.8	9.52	16.5	4.76	1.2	●	
	220408E-PD5	0.20-0.60	1.2-7.7	12.7	22	4.76	0.8	●	
	220412E-PD5	0.30-0.90	1.8-7.7	12.7	22	4.76	1.2	●	
	220416E-PD5	0.40-1.20	2.4-7.7	12.7	22	4.76	1.6	●	
	VNMG 160404E-PD3	0.08-0.22	0.4-3.3	9.52	16.5	4.76	0.4	○	
	160408E-PD3	0.15-0.44	0.8-3.3	9.52	16.5	4.76	0.8	○	
	160412E-PD3	0.23-0.66	1.2-3.3	9.52	16.5	4.76	1.2	○	
	WNMG 080404E-PD3	0.08-0.22	0.4-2.9	12.7	8.7	4.76	0.4	○	
	080408E-PD3	0.15-0.44	0.8-2.9	12.7	8.7	4.76	0.8	●	
	080412E-PD3	0.23-0.66	1.2-2.9	12.7	8.7	4.76	1.2	●	
	WNMG 080408E-PD5	0.20-0.60	1.2-4.3	12.7	8.7	4.76	0.8	●	
	080412E-PD5	0.30-0.90	1.8-4.3	12.7	8.7	4.76	1.2	●	

### Positive inserts

Insert	Item designation	Recommended cutting parameters		Dimension(mm)				Grade (CVD)	Geometry
		Feed (mm/rev)	ap (mm)	d	l	s	r	AC350P	
	CCMT 060204E-KC2	0.06-0.18	0.4-2.1	6.35	6.45	2.38	0.4	○	
	060208E-KC2	0.12-0.36	0.8-2.1	6.35	6.45	2.38	0.8	●	
	09T304E-KC2	0.06-0.18	0.4-3.2	9.52	9.67	3.97	0.4	○	
	09T308E-KC2	0.12-0.36	0.8-3.2	9.52	9.67	3.97	0.8	●	
	120404E-KC2	0.06-0.18	0.4-4.3	12.7	12.9	4.76	0.4	○	
	120408E-KC2	0.12-0.36	0.8-4.3	12.7	12.9	4.76	0.8	●	
	120412E-KC2	0.18-0.54	1.2-4.3	12.7	12.9	4.76	1.2	○	
	DCMT 070204E-KC2	0.06-0.18	0.4-2.3	6.35	7.75	2.38	0.4	○	
	070208E-KC2	0.12-0.36	0.8-2.3	6.35	7.75	2.38	0.8	●	
	11T304E-KC2	0.06-0.18	0.4-3.5	9.52	11.63	3.97	0.4	○	
	11T308E-KC2	0.12-0.36	0.8-3.5	9.52	11.63	3.97	0.8	●	
	11T312E-KC2	0.18-0.54	1.2-3.5	9.52	11.63	3.97	1.2	○	

Remark: ● represent for standard stock  
○ represent for Make-To-Order

Insert	Item designation	Recommended cutting parameters		Dimension(mm)				Grade (CVD)	Geometry
		Feed (mm/rev)	ap (mm)	d	l	s	r	AC350P	
	DCMT 070204E-KC2	0.06-0.18	0.4-2.3	6.35	7.75	2.38	0.4	○	
	070208E-KC2	0.12-0.36	0.8-2.3	6.35	7.75	2.38	0.8	○	
	11T304E-KC2	0.06-0.18	0.4-3.5	9.52	11.63	3.97	0.4	○	
	11T308E-KC2	0.12-0.36	0.8-3.5	9.52	11.63	3.97	0.8	●	
	11T312E-KC2	0.18-0.54	1.2-3.5	9.52	11.63	3.97	1.2	○	
	SCMT 09T304E-KC2	0.06-0.18	0.4-3.1	9.52	9.52	3.97	0.4	●	
	09T308E-KC2	0.12-0.36	0.8-3.1	9.52	9.52	3.97	0.8	●	
	120404E-KC2	0.06-0.18	0.4-4.2	12.7	12.7	4.76	0.4	○	
	120408E-KC2	0.12-0.36	0.8-4.2	12.7	12.7	4.76	0.8	●	
	120412E-KC2	0.18-0.54	1.2-4.2	12.7	12.7	4.76	1.2	○	
	TCMT 090204E-KC2	0.06-0.18	0.4-2.9	5.56	9	2.38	0.4	○	
	090208E-KC2	0.12-0.36	0.8-2.9	5.56	9	2.38	0.8	○	
	110204E-KC2	0.06-0.18	0.4-3.3	6.35	11	2.38	0.4	○	
	110208E-KC2	0.12-0.36	0.8-3.3	6.35	11	2.38	0.8	○	
	16T304E-KC2	0.06-0.18	0.4-4.9	9.52	16.5	3.97	0.4	○	
	16T308E-KC2	0.12-0.36	0.8-4.9	9.52	16.5	3.97	0.8	●	
	16T312E-KC2	0.18-0.54	1.2-4.9	9.52	16.5	3.97	1.2	○	
	VBMT 160404E-KC2	0.06-0.18	0.4-3.3	9.52	16.61	4.76	0.4	○	
	160408E-KC2	0.12-0.36	0.8-3.3	9.52	16.61	4.76	0.8	●	
	160412E-KC2	0.18-0.54	1.2-3.3	9.52	16.61	4.76	1.2	○	
	RCMX 100300S	0.25-0.50	1.5-4.0	10	-	3.18	5	○	
	120400S	0.30-0.60	2.5-5.0	12	-	4.76	6	●	
	160600S	0.40-0.75	3.0-7.0	16	-	6.35	8	○	
	200600S	0.48-0.90	3.5-9.0	20	-	6.35	10	○	
	250700S	0.55-1.20	4.0-12.0	25	-	7.94	12.5	●	
	320900S	0.65-1.50	5.0-15.0	32	-	9.52	16	○	

Remark: ● represent for standard stock  
○ represent for Make-To-Order