

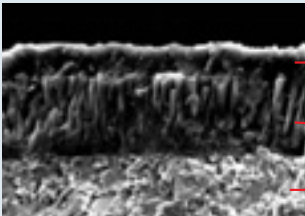


New exclusive grade for high speed turning of cast iron

NC6110

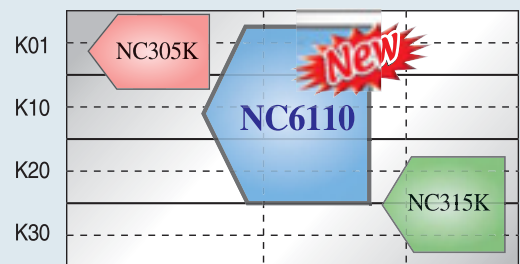
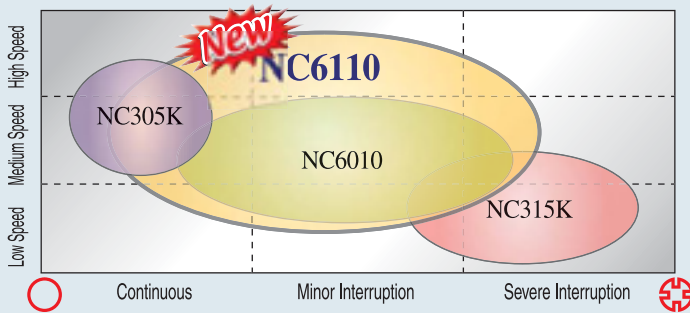


Special Features of NC6110



- The Al₂O₃ film having superior hardness & surface quality
- MT-TiCN film having superior toughness as well as hardness
- Exclusive carbide for K10 coating grade

- Excellent hardness & toughness have been achieved due to the Al₂O₃ 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 (V:m/min, sfm)					Feed (f:mm/rev, ipr)					Depth (d:mm, 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															

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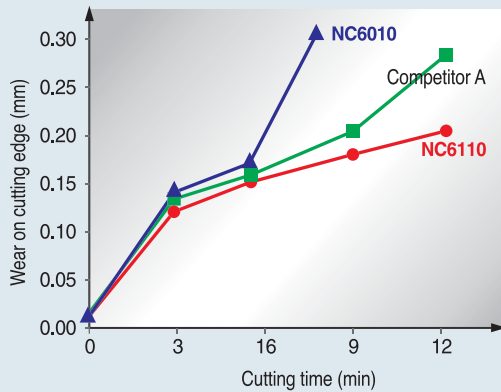
Stock items of NC6110

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	TCMT090204-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	FGD500R-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	MGMN400-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

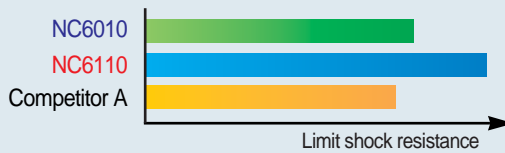
- Work piece : GC25 (Gray Cast Iron)
- Insert : CNMG120408-GR(CNMG432)
- Conditions : V=350m/min (1150sfm),
f=0.3mm/rev (0.012ipr), d=2.0mm (0.08inch), wet



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



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



User Test Examples of NC6110

Insert	CNMG120412-GR CNMG434-GR	<p>Ø476mm</p>						
Work piece	FC25 (Gray Cast Iron)							
V	250~300 m/min (820~1000 sfm)							
f	0.2~0.35 mm/rev (0.008~0.014 ipr)							
D	4.0 mm (0.16 inch)							
Coolant	Wet							
		<table border="0"> <tr> <td>NC6110</td> <td></td> <td>7pcs/edge</td> </tr> <tr> <td>K10 of A maker</td> <td></td> <td>4pcs/edge</td> </tr> </table>	NC6110		7pcs/edge	K10 of A maker		4pcs/edge
NC6110		7pcs/edge						
K10 of A maker		4pcs/edge						

Insert	CNMG120412-GR CNMG434-GR							
Work piece	FCD /Severe Interruption (Ductile Cast Iron)							
V	180 m/min (590 sfm)							
f	0.14~0.20mm/rev (0.006~0.008 ipr)							
D	3.0 mm (0.12 inch)							
Coolant	Wet							
		<table border="0"> <tr> <td>NC6110</td> <td></td> <td>15pcs/edge</td> </tr> <tr> <td>K10 of A maker</td> <td></td> <td>11pcs/edge</td> </tr> </table>	NC6110		15pcs/edge	K10 of A maker		11pcs/edge
NC6110		15pcs/edge						
K10 of A maker		11pcs/edge						



HEAD OFFICE
Hollystar B/D 953-1, Doksarim-Dong, Guro-gu, Seoul, Korea
TEL.: +82 2 522 3181 FAX: +82 2 522 3184, +82 2 3474 4444
WEB: www.korloy.com

CHEONGJU FACTORY
53-16, Sangjeong-Dong, Hungduk-Gu, Cheongju, Chungcheongbuk-Do, Korea
TEL.: +82 43 262 0141 FAX: +82 43 262 0146
E-MAIL: ekpart@korloy.com

JINCHON FACTORY
767-1, Gwanghewon-Ri, Gwanghewon-Myan, Jincheon-Gun, Chungcheongbuk-Do, Korea
TEL.: +82 43 535 0141 FAX: +82 43 535 0144