MC6115

SELECTION CRITERIA AND APPLICATION RANGE

	Material	Cutting mode		Grade
P	Carbon and alloy steels	Continuous cutting	*Low*	MC6115
			Medium	MC6025
		Interrupted cutting	*High*	MC6035

P	CVD
P10	MC6115, MC6015, UE6110
P20	MC6115, MC6015, UE6110
P30	MC6115, MC6015, UE6110, MC6025
P40	MC6025, MC6035
P50	MC6035

RECOMMENDED CUTTING CONDITIONS

NEGATIVE INSERTS (FOR EXTERNAL TURNING)

Cutting conditions: ●: Stable cutting ◐: General cutting ✥: Unstable cutting

	Material	Properties	Conditions	L M R	Grade		Vc	f	ap
P	Carbon and alloy steels	180–280HB	●	L	MC6115	LP	250–480	0.10–0.40	0.30–2.00
			●	L	MC6115	SH	250–480	0.10–0.40	0.30–2.00
			●	L	MC6115	SA	250–480	0.10–0.40	0.30–2.00
			●	L	MC6115	SW	250–480	0.10–0.50	0.30–2.50
			●	M	MC6115	MP	230–440	0.16–0.50	0.30–4.00
			●	M	MC6115	MA	230–440	0.20–0.50	0.30–4.00
			●	M	MC6115	Std	230–440	0.25–0.60	1.50–5.00
			●	M	MC6115	MW	230–440	0.20–0.60	0.90–4.00
			●	R	MC6115	RP	215–415	0.25–0.60	1.50–6.00
			●	R	MC6115	GH	215–415	0.25–0.60	1.50–6.00
			◐	L	MC6115	LP	250–480	0.10–0.40	0.30–2.00
			◐	L	MC6115	SH	250–480	0.10–0.40	0.30–2.00
			◐	L	MC6115	SA	250–480	0.10–0.40	0.30–2.00
			◐	L	MC6115	SW	250–480	0.10–0.50	0.30–2.50
			◐	M	MC6115	MP	230–440	0.16–0.50	0.30–4.00
			◐	M	MC6115	MA	230–440	0.20–0.50	0.30–4.00
			◐	M	MC6115	MH	230–440	0.20–0.55	1.00–4.00
			◐	M	MC6115	Std	230–440	0.25–0.60	1.50–5.00
			◐	M	MC6115	MW	230–440	0.20–0.60	0.90–4.00
			◐	R	MC6115	RP	215–415	0.25–0.60	1.50–6.00
			◐	R	MC6115	GH	215–415	0.25–0.60	1.50–6.00

1. Verify the recommended conditions for each boring bar as cutting conditions for internal machining will vary depending on the length of overhang.