



K SERIES

HIGH PERFORMANCE TURNING OF CAST IRON

Korloy K series CVD coated inserts are designed for turning grey cast iron and ductile cast iron, providing stable tool life in various kinds of machining such as high feed, heavy interrupted or continuous cutting.

Inserts are available with a flat top for heavy machining or with a chip breaker for lower powered lathes.

- NC6315 CVD coated grade is suitable for medium to high speed continuous or interrupted cutting with high heat resistance and excellent wear qualities.
- MK chip breaker for medium machining with low cutting load.
- RK chip breaker for large cut depths and heavy intermittent cutting.

1ST CHOICE FOR PERFORMANCE TURNING OF CAST IRON

CHIP BREAKER GUIDE

MK

First choice medium cutting and continuous turning of cast iron. Angled land provides excellent surface finish and low cutting resistance.



Depth of cut: 1.0-5.0mm
Feed rate: 0.10-0.50mm/rev

RK

First choice high speed, roughing, high feed and interrupted turning of cast iron. Flat land provides excellent toughness and chipping resistance.



Depth of cut: 1.5-6.0mm
Feed rate: 0.20-0.60mm/rev

GRADE		ORDER CODE NC6315	PRICE	FEED f _n (mm/rev)	DEPTH OF CUT a _p (mm)
ISO	RADIUS				
CCMT060204-C25	0.4	1-02-064213		0.05-0.15	0.60-2.30
CCMT060208-C25	0.8	1-02-064695		0.07-0.20	0.80-2.30
CCMT09T304-C25	0.4	1-02-064214		0.08-0.25	0.80-3.00
CCMT09T308-C25	0.8	1-02-062511		0.10-0.30	1.00-3.00
CCMT120404-C25	0.4	1-02-064215		0.10-0.32	0.80-3.00
CCMT120408-C25	0.8	1-02-062510		0.12-0.36	1.20-3.50
CNMA120408	0.8	1-02-061297		0.15-0.60	1.00-6.00
CNMA120412	1.2	1-02-060507		0.15-0.70	1.50-6.00
CNMA160612	1.2	1-02-062521		0.15-0.70	2.00-6.00
CNMA160616	1.6	1-02-063064		0.15-0.70	2.00-6.00
CNMA190612	1.2	1-02-061948		0.15-0.70	2.00-10.00
CNMA190616	1.6	1-02-061949		0.20-1.00	3.00-10.00
CNMG120404-MK	0.4	1-02-064191		0.05-0.30	0.90-4.00
CNMG120408-MK	0.8	1-02-061690		0.10-0.50	1.00-5.00
CNMG120412-MK	1.2	1-02-062210		0.13-0.60	1.30-5.00
CNMG120408-RK	0.8	1-02-061692		0.20-0.50	1.50-6.00
CNMG120412-RK	1.2	1-02-062488		0.28-0.53	1.80-6.00
CNMG120416-RK	1.6	1-02-064199		0.28-0.63	2.00-6.00
CNMG160612-RK	1.2	1-02-066682		0.28-0.72	2.00-8.00
CNMG160616-RK	1.6	1-02-066637		0.28-0.74	2.00-8.00
CNMG190612-RK	1.2	1-02-066916		0.35-0.78	2.60-9.50
CNMG190616-RK	1.6	1-02-066917		0.35-0.80	2.60-10.00
DCMT070204-C25	0.4	1-02-064703		0.05-0.20	0.50-2.50
DCMT070208-C25	0.8	1-02-064704		0.06-0.25	0.80-2.50
DCMT11T304-C25	0.4	1-02-061447		0.08-0.30	0.80-3.00
DCMT11T308-C25	0.8	1-02-061524		0.10-0.30	1.00-3.00
DNMA150608	0.8	1-02-064207		0.25-0.55	0.80-4.00
DNMA150612	1.2	1-02-064208		0.25-0.65	1.20-4.00
DNMG150404-MK	0.4	1-02-064302		0.05-0.30	0.90-5.00
DNMG150408-MK	0.8	1-02-064300		0.10-0.50	1.00-5.00
DNMG150604-MK	0.4	1-02-063942		0.05-0.30	0.90-5.00
DNMG150608-MK	0.8	1-02-064038		0.10-0.50	1.00-5.00
DNMG150612-MK	1.2	1-02-064039		0.13-0.60	1.30-5.00
DNMG150608-RK	0.8	1-02-064042		0.15-0.50	1.50-5.00
DNMG150612-RK	1.2	1-02-064043		0.20-0.60	1.80-5.00
SNMA120408	0.8	1-02-063393		0.15-0.70	1.00-6.00
SNMA120412	1.2	1-02-064209		0.20-0.80	1.50-6.00
SNMA120416	1.6	1-02-064210		0.30-1.00	2.00-6.00
SNMA190616	1.6	1-02-064713		0.25-0.85	2.50-10.00
SNMG120408-MK	0.8	1-02-064040		0.10-0.50	1.00-5.00
SNMG120412-MK	1.2	1-02-064041		0.13-0.60	1.30-5.00
SNMG120408-RK	0.8	1-02-064044		0.23-0.53	1.50-6.00
SNMG120412-RK	1.2	1-02-064045		0.28-0.53	1.80-6.00
TCMT16T304-C25	0.4	1-02-064219		0.08-0.28	0.80-3.00
TCMT16T308-C25	0.8	1-02-062512		0.10-0.30	1.00-3.00
TNMA160408	0.8	1-02-060508		0.10-0.40	1.00-4.00
TNMA160412	1.2	1-02-060509		0.10-0.50	1.50-4.50
TNMA220408	0.8	1-02-064211		0.15-0.40	1.50-5.00
TNMA220412	1.2	1-02-064212		0.20-0.50	1.50-5.00
TNMG160404-MK	0.4	1-02-064192		0.05-0.30	0.90-3.50
TNMG160408-MK	0.8	1-02-064193		0.10-0.50	1.00-4.00
TNMG160412-MK	1.2	1-02-064194		0.12-0.60	1.20-4.50
TNMG220408-RK	0.8	1-02-064202		0.17-0.45	1.50-5.00
TNMG220412-RK	1.2	1-02-064203		0.21-0.50	1.30-5.50
TNMG220416-RK	1.6	1-02-064204		0.23-0.52	1.40-5.50
VBMT160408-MP	0.8	1-02-064305		0.10-0.25	0.50-2.30
VCMT160404-MP	0.4	1-02-064231		0.10-0.23	0.30-2.00
VCMT160408-MP	0.8	1-02-064232		0.10-0.33	0.50-2.30
VNMG160404-MK	0.4	1-02-064196		0.08-0.45	0.50-3.00
VNMG160408-MK	0.8	1-02-064197		0.10-0.50	1.00-3.50
VNMG160412-MK	1.2	1-02-064198		0.20-0.50	1.50-4.00
WNMA060408	0.8	1-02-064782		0.10-0.30	0.50-3.00
WNMA080408	0.8	1-02-060512		0.15-0.60	1.00-6.00
WNMA080412	1.2	1-02-062051		0.15-0.70	1.50-6.00
WNMG060408-MK	0.8	1-02-066758		0.08-0.30	0.80-2.50
WNMG080404-MK	0.4	1-02-064195		0.10-0.45	1.00-3.00
WNMG080408-MK	0.8	1-02-061951		0.10-0.50	1.00-3.50
WNMG080412-MK	1.2	1-02-063938		0.10-0.50	1.00-4.00

RECOMMENDED CUTTING CONDITIONS

Material Group	Material	Surface Speed (m/min)
Ductile Cast Iron	Ductile cast iron (<400N/mm ²)	160-390
	Ductile cast iron (400-600N/mm ²)	150-350
	Ductile cast iron (600-800N/mm ²)	150-350
Grey Cast Iron	Grey cast iron (<100N/mm ²)	180-450
	Grey cast iron (100-300N/mm ²)	160-400
	Grey cast iron (>300N/mm ²)	155-350