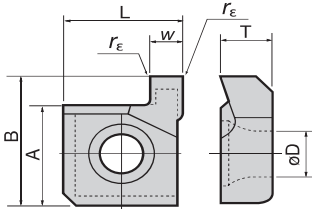


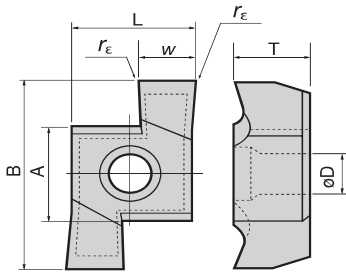
# SNG / CNG

## Inserts (SNG•CNG type)

- One corner type  
6GR/L□□□  
7GR/L□□□



- Two corners type  
8GR/L□□□  
9GR/L□□□  
15GR/L□□□



Right hand (R) shown.

## Inserts for general grooving

Max. groove depth (mm)	Groove width $w \pm 0.025$ (mm)	Insert Cat. No.	Grades						Dimensions (mm)					
			Cermet			Uncoated			A	B	s	øD	L	$r_\epsilon$
			NS9530	TH10	UX30	R	L	R						
1.5	1	6GR/L100	○		○		○	○	4.76	6.44	2.34	2.3	5.56	
	1.5	6GR/L150	○		○	○	○	○						
	2	6GR/L200	○		○	○	○	○						
	1	7GR/L100	○		○		○							
	1.5	7GR/L150	○		○		○							
	2	7GR/L200	○		○		○	○						
2	1	8GR/L100							5.56	10.16	3.87	2.58	6.15	
	1.5	8GR/L150	○		○		○							
	2	8GR/L200	○		○	○	○							
	2.5	8GR/L250	○		○	○	○	○						
	3	8GR/L300	○		○	○	○	○						
3.5	8GR/L350			○		○								
1.5	1	9GR/L100						6.35	12.95	4.66	2.86	7.74	0.2	
2	1.5	9GR/L150	○	○	○		○							○
3	2	9GR/L200	○	○	○	○	○							○
	2.5	9GR/L250	○	○	○		○							○
	3	9GR/L300	○	○	○	○	○							○
	3.5	9GR/L350	○	○	○		○	○						
1.5	1	15GR/L100						9.2	20.8	5.1	4.8	10.8		
2	1.5	15GR/L150												
3	2	15GR/L200	○		○		○							
	2.5	15GR/L250	○		○		○							
	3	15GR/L300	○		○		○							○
	3.5	15GR/L350	○		○		○							
4	4	15GR/L400	○		○		○							
5	4.5	15GR/L450			○	○	○							
5	5	15GR/L500			○		○							

### Standard cutting conditions

Work materials	Cutting speed: (sfm)	Feed: f (in/rev)
Medium carbon steels (1045)	130 ~ 500	.002 ~ .006
Cast irons, Light alloys	200 ~ 650	.002 ~ .006

- Notes:
- Cutting conditions shown left are a guideline only.
  - When grooving close to the minimum bore diameter or with long reach conditions, reduce the conditions shown left by approximately 50 %.
  - To help chip evacuation, use water-soluble cutting fluid. The fluid should be applied sufficiently to the cutting point. When using without cutting fluid, reduce both the cutting speeds and feeds shown on the left by 50 % at least.

○ : Stocked in Japan