

GROOVING NCG

Inserts .C16

NCG

Circlip grooving

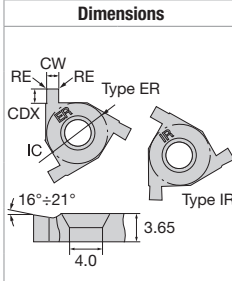
- Triple head top mounted grooving insert
- Available for P/M materials
- According to DIN 471/472
- Can share holders with 16IR/ER threading inserts
- CW Tolerance **0/+0.02**

HF: Micrograin tungstein carbide
PVD: Physical vapor deposition

HF
PVD

JPS130

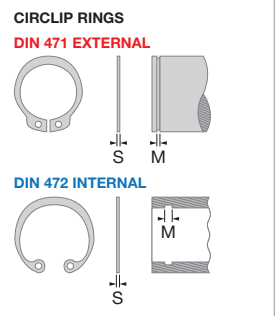
- Stable machining, light cut ● 1st choice ○ suitable
- General machining, medium cut ● 1st choice ○ suitable ●
- Unstable machining, heavy cut ⚠ 1st choice ⚠ suitable ⚠



ISO	Vc(m/min) - suggested cutting speed range (bold: 1 st choice)									
P	60	180								
M	50	110								
K										
N										
S										
H										

EXTERNAL	ER	P M	Designation					Stock
			CW	CDX	RE	IC		
INTERNAL	IR	P M	NCG16ER 110-010	1.1	1.3	0.10	9.525	●
			NCG16ER 130-010	1.3	1.6	0.10	9.525	●
			NCG16ER 160-010	1.6	1.85	0.10	9.525	●
			NCG16ER 185-010	1.85	1.85	0.10	9.525	●
			NCG16ER 215-010	2.15	1.85	0.10	9.525	●
	IR	P M	NCG16IR 110-010	1.1	1.3	0.10	9.525	●
			NCG16IR 130-010	1.3	1.6	0.10	9.525	●
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			NCG16IR 215-010	2.15	1.85	0.10	9.525	●

★ 1st choice, ☆ suitable, ● stock standard, ○ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion



RING (S)	GROOVE (M)	TOLL.	INSERT
1.00	1.10	H13	NCG 16 ^{ER/IR} 110-010
1.20	1.30	H13	NCG 16 ^{ER/IR} 130-010
1.50	1.60	H13	NCG 16 ^{ER/IR} 160-010
1.75	1.85	H13	NCG 16 ^{ER/IR} 185-010
2.00	2.15	H13	NCG 16 ^{ER/IR} 215-010

Code	Material	Speed Range
P1-P2	Low carbon and soft steel	60÷180
P3-P4	Medium and high alloy steel	60÷160
P5-P6	High tensile strength steel	60÷140
P7	Ferritic stainless steel	60÷120
P8	PH stainless steel	40÷70
M1	Austenitic stainless steel	50÷110
M2-M3	Difficult stainless steel	40÷80

	ER	IR
NCG 16 ^{ER/IR} 110-010	0.03÷0.07	0.01÷0.05
NCG 16 ^{ER/IR} 130-010	0.04÷0.08	0.02÷0.06
NCG 16 ^{ER/IR} 160-010	0.04÷0.08	0.02÷0.06
NCG 16 ^{ER/IR} 185-010	0.04÷0.10	0.03÷0.07
NCG 16 ^{ER/IR} 215-010	0.04÷0.10	0.03÷0.07

INDEXABLE

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS