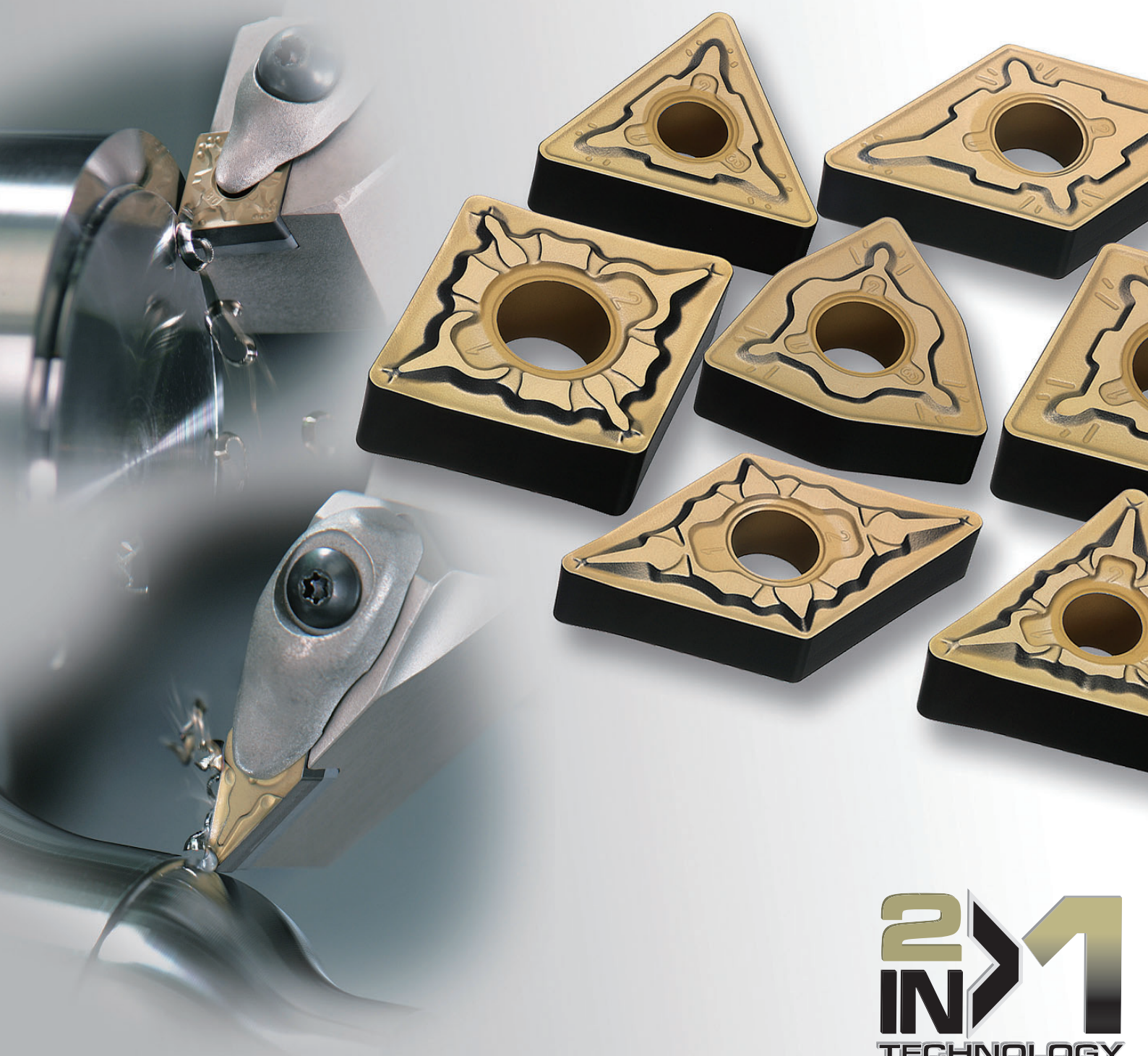


CVD Coated Grade for Steel Turning

# **UE6110**

Series  
Expansion

## **Excellent stability over a wide range of applications!**



# CVD Coated Grade for Steel Turning

# UE6110

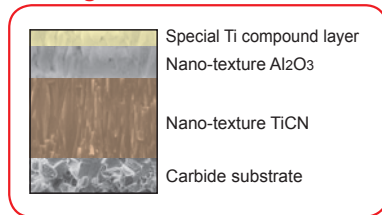
## Features

### Superior machining performance achieved using 2 in 1 technology

#### High Crater Wear Resistance

The gold Ti compound coating on the rake face exhibits exceptionally high crater wear resistance. This outer coating layer further enhances the crater wear resistance of the nano-texture Al<sub>2</sub>O<sub>3</sub>, making it suitable for high-speed, high performance machining.

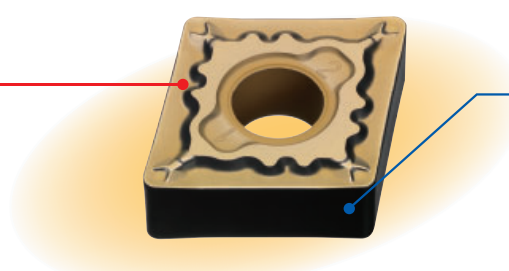
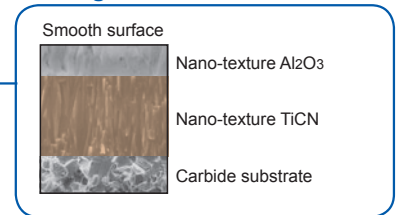
#### Coating structure of the rake face



#### High Flank Wear Resistance

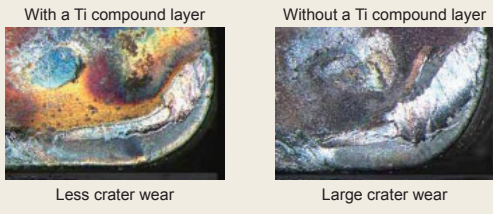
The black coating on the flank face has an extremely smooth surface that prevents abnormal wear and weld chipping. Combined with the nano-texture coating improved surface finishes and stable tool life can be achieved.

#### Coating structure of the flank face



#### Crater Wear Comparison

Insert : CNMG120408-MA  
 Workpiece : JIS SNCM439  
 Cutting Conditions : Cutting speed 250m/min, Feed 0.3mm/rev, Depth of cut 1.5mm, Dry cutting, Cutting time 7min



#### Flank Wear Comparison

Insert : CNMG120408-00  
 Workpiece : JIS SCr420H  
 Cutting Conditions : Cutting speed 200m/min, Feed 0.3mm/rev, Depth of cut 1.5mm, Dry cutting, Cutting time 2min



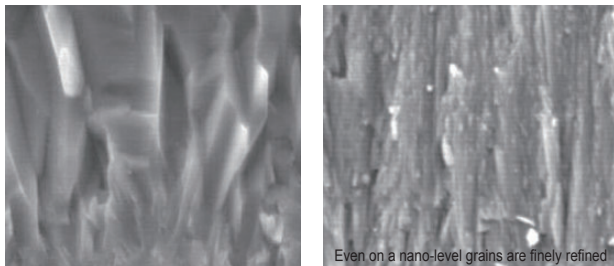
### State-of-the-art coating featuring 2 in 1 technology

#### 1 Newly developed "Nano-texture coating"

Mitsubishi Materials unique, new coating technology consisting of nano-texture TiCN and Al<sub>2</sub>O<sub>3</sub> offers a coating that has both high fracture and wear resistance.

#### Comparison of crystalline microstructure

Conventional coating      Nano-texture coating

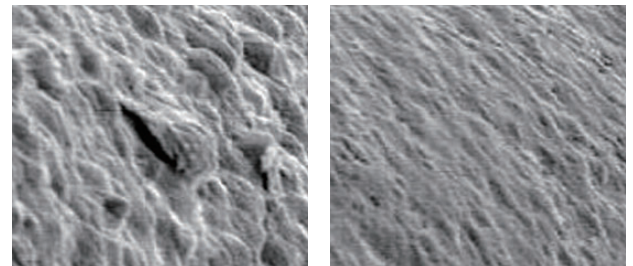


#### 2 Newly developed "Black super-even coating"

An extremely smooth coating surface inhibits wear propagation during machining to achieve high quality surface finishes and prevents welding and chipping.

#### Comparison of coating surface

Conventional coating      Black super-even coating




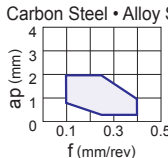

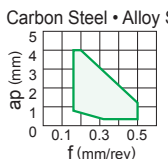

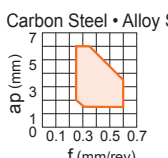
2 in 1 technology for stable cutting with high wear and fracture resistance

# Application Range


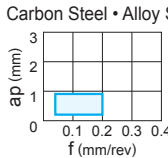

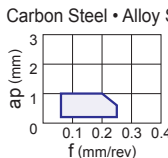

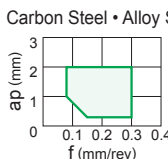
**UE6110** is the first recommendation for steel turning. Suitable for machining mild, carbon, alloy, bearing and lead free steels.

Application Range	
ISO	Steel
P01	UE6105
P10	UE6110
P20	ML6025
P30	UE6020
P40	UE6035, UE6400

## Breaker system for steel cutting (Negative inserts)

Application	Tolerance	Breaker Name and Picture	Features	Graph	Cross Section Geometry
Light Cutting	M	<b>NEW</b> LP 	<b>First recommendation for light cutting of carbon steel and alloy steel</b> Stable chip control in the light cutting range. The curved edge allows smooth chip discharge.	Carbon Steel • Alloy Steel 	<b>Nose</b> 0.1 15° <b>Flank</b> 0.2 11°
Medium Cutting	M	<b>NEW</b> MP 	<b>First recommendation for medium cutting of carbon steel and alloy steel</b> Suitable for medium to light cutting. Breaker geometry suitable for copying and back turning. Cutting edge geometry for an optimum balance of sharpness and fracture resistance.	Carbon Steel • Alloy Steel 	<b>Nose</b> 0.15 15° <b>Flank</b> 0.2 11°
Rough Cutting	M	<b>NEW</b> RP 	<b>First recommendation for rough cutting of carbon steel and alloy steel</b> For interrupted cuts and removing scale. Good balance of cutting edge strength and low cutting resistance because of a suitable rake angle.	Carbon Steel • Alloy Steel 	<b>Nose</b> 0.33 3° <b>Flank</b> 0.33

## Breaker system for steel cutting (Positive inserts)

Application	Tolerance	Breaker Name and Picture	Features	Graph	Cross Section Geometry
Finish Cutting	M	<b>NEW</b> FP 	<b>First recommendation for finish cutting of carbon steel and alloy steel</b> The protuberance at the tip of the breaker controls chips even at small depths of cut. Corner strength is maintained to prevent abnormal fracturing. <b>7° Positive Insert</b>	Carbon Steel • Alloy Steel 	<b>Nose</b> 6° <b>Flank</b> 6°
Light Cutting	M	<b>NEW</b> LP 	<b>First recommendation for light cutting of carbon steel and alloy steel</b> Excellent cutting edge sharpness due to the large rake angle. Prevents chip welding of the insert to ensure good surface finishes. Optimised breaker realises a wide range of chip control. <b>7° Positive Insert</b>	Carbon Steel • Alloy Steel 	<b>Nose</b> 18° <b>Flank</b> 8°
Medium Cutting	M	<b>NEW</b> MP 	<b>First recommendation for medium cutting of carbon steel and alloy steel</b> The flat land produces excellent wear resistance and superior fracture resistance. The wide pocket reduces vibration and chip jamming and also prevents increases in cutting resistance even at high depths of cut. <b>7° Positive Insert</b>	Carbon Steel • Alloy Steel 	<b>Nose</b> 0.1 18° <b>Flank</b> 0.1 18°

# Optimum Selection of Insert

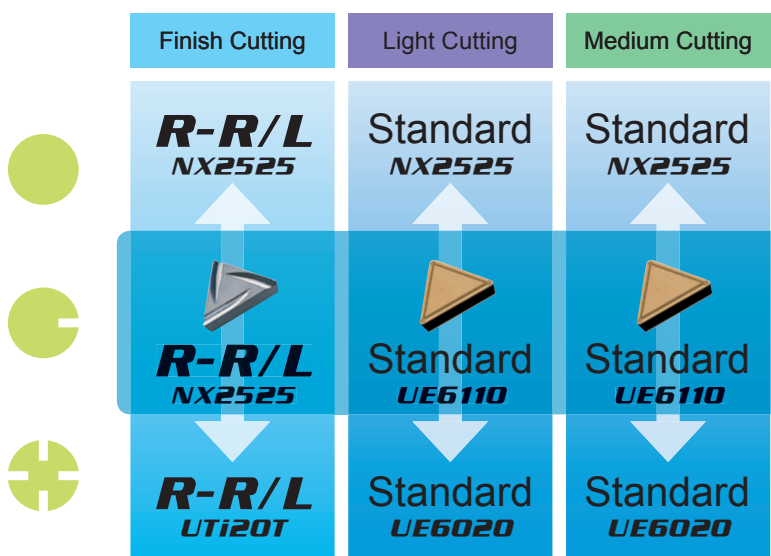
**P** Mild Steel • Carbon Steel • Alloy Steel  
NEGATIVE INSERTS



## 7° POSITIVE INSERTS WITH HOLE



## 11° POSITIVE INSERTS WITH HOLE



### CUTTING CONDITIONS

- Stable Cutting  
Continuous Cutting  
Constant Depth of Cut  
Pre-Machined  
Securely Clamped Component Cutting
- ◐ General Cutting
- ⊕ Unstable Cutting  
Heavy Interrupted Cutting  
Irregular Depth of Cut  
Low Clamping Rigidity Cutting

# Recommended Cutting Conditions

## Negative Inserts (External turning tools)

Work Material	Hardness	Cutting Mode		Breaker	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
Carbon Steel, Alloy Steel (S45C, SCM440 etc.)	180–280HB	General Cutting	Finish Cutting	<b>FH</b>	230–390	0.08–0.20	0.20–1.00
		General Cutting	Light Cutting	<b>LP</b>	210–355	0.10–0.40	0.30–2.00
		General Cutting		<b>SH</b>	210–355	0.10–0.40	0.30–2.00
		General Cutting		<b>SA</b>	210–355	0.10–0.40	0.30–2.00
		General Cutting		<b>SW</b>	210–355	0.10–0.50	0.30–2.50
		General Cutting		Medium Cutting	<b>MP</b>	190–325	0.16–0.50
		General Cutting	<b>MA</b>		190–325	0.20–0.50	0.30–4.00
		General Cutting	<b>MH</b>		190–325	0.20–0.55	1.00–4.00
		General Cutting	<b>Std</b>		190–325	0.25–0.60	1.50–5.00
		General Cutting	<b>MW</b>		190–325	0.20–0.60	0.90–4.00
		General Cutting	Rough Cutting	<b>RP</b>	180–310	0.25–0.60	1.50–6.00
		General Cutting		<b>GH</b>	180–310	0.25–0.60	1.50–6.00
		Stable Cutting	Heavy Cutting	<b>HX</b>	160–275	0.50–1.26	3.00–11.00
		Stable Cutting		<b>HV</b>	135–275	0.70–1.30	4.00–12.00
		General Cutting		<b>HZ</b>	160–275	0.40–1.20	2.00–10.00

## 5°/7° Positive Inserts (HSKT TOOLS, SP Holder)

Work Material	Hardness	Cutting Mode		Breaker	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
Mild Steel (SS400, S10C etc.)	≤180HB	General Cutting	Finish Cutting	<b>FP</b>	250–425	0.04–0.20	0.20–0.90
		General Cutting	Light Cutting	<b>LP</b>	250–425	0.06–0.25	0.20–1.00
		General Cutting	Medium Cutting	<b>MP</b>	205–350	0.08–0.30	0.30–2.00
Carbon Steel, Alloy Steel (S45C, SCM440 etc.)	180–280HB	General Cutting	Finish Cutting	<b>FP</b>	185–310	0.04–0.20	0.20–0.90
		General Cutting	Light Cutting	<b>LP</b>	185–310	0.06–0.25	0.20–1.00
		General Cutting	Medium Cutting	<b>MP</b>	150–260	0.08–0.30	0.30–2.00
Carbon Steel, Alloy Steel (SNM439 etc.)	280–350HB	General Cutting	Medium Cutting	<b>MP</b>	110–185	0.08–0.30	0.30–2.00


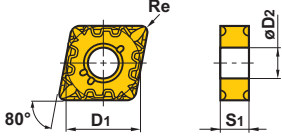

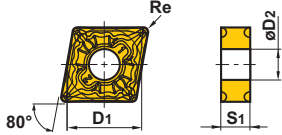

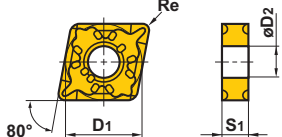

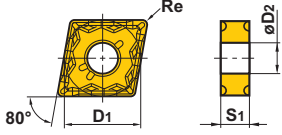

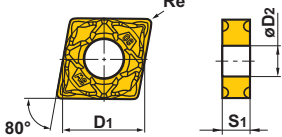

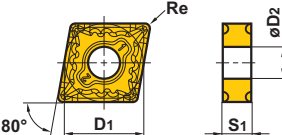

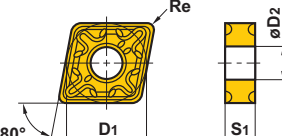
## 11° Positive Inserts (MC Holder)

Work Material	Hardness	Cutting Mode		Breaker	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
Mild Steel (SS400, S10C etc.)	≤180HB	General Cutting	Medium Cutting	<b>Standard</b>	205–350	0.08–0.30	0.30–2.00
Carbon Steel, Alloy Steel (S45C, SCM440 etc.)	180–280HB	General Cutting	Medium Cutting	<b>Standard</b>	150–260	0.08–0.30	0.30–2.00
Gray Cast Iron (FC300 etc.)	≤350MPa	General Cutting	Medium Cutting	—	130–200	0.08–0.30	0.30–2.00
Ductile Cast Iron (FCD450 etc.)	≤450MPa	General Cutting	Medium Cutting	—	120–190	0.08–0.30	0.30–2.00
	≤800MPa	General Cutting	Medium Cutting	—	105–170	0.08–0.30	0.30–2.00


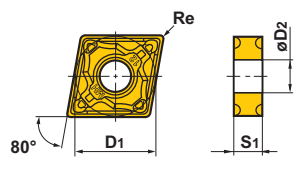

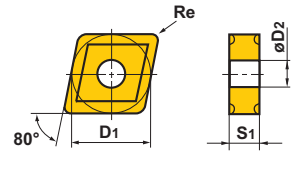

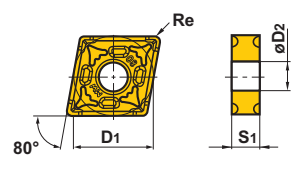

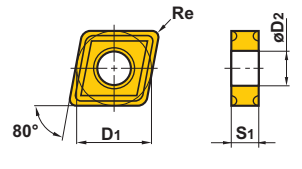

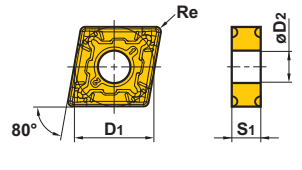

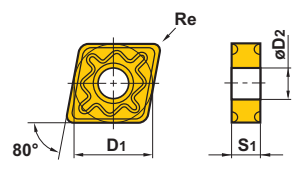
# UE6110

## INSERTS

### ● Negative Inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		UE6110	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
 Finish Cutting	CNMG120402-FH	●	12.7	4.76	0.2	5.16	
	120404-FH	●	12.7	4.76	0.4	5.16	
	120408-FH	●	12.7	4.76	0.8	5.16	
 Light Cutting	CNMG120404-LP	●	12.7	4.76	0.4	5.16	
	120408-LP	●	12.7	4.76	0.8	5.16	
	120412-LP	●	12.7	4.76	1.2	5.16	
 Light Cutting	CNMG09T304-SH	●	9.525	3.97	0.4	3.81	
	09T308-SH	●	9.525	3.97	0.8	3.81	
	120404-SH	●	12.7	4.76	0.4	5.16	
	120408-SH	●	12.7	4.76	0.8	5.16	
	120412-SH	●	12.7	4.76	1.2	5.16	
 Light Cutting	CNMG120404-SA	●	12.7	4.76	0.4	5.16	
	120408-SA	●	12.7	4.76	0.8	5.16	
	120412-SA	●	12.7	4.76	1.2	5.16	
 Light Cutting (Wiper)	CNMG120404-SW	●	12.7	4.76	0.4	5.16	
	120408-SW	●	12.7	4.76	0.8	5.16	
	120412-SW	●	12.7	4.76	1.2	5.16	
 Medium Cutting	CNMG120404-MP	●	12.7	4.76	0.4	5.16	
	120408-MP	●	12.7	4.76	0.8	5.16	
	120412-MP	●	12.7	4.76	1.2	5.16	
	120416-MP	●	12.7	4.76	1.6	5.16	
	160608-MP	●	15.875	6.35	0.8	6.35	
	160612-MP	●	15.875	6.35	1.2	6.35	
	160616-MP	●	15.875	6.35	1.6	6.35	
 Medium Cutting	CNMG120404-MA	●	12.7	4.76	0.4	5.16	
	120408-MA	●	12.7	4.76	0.8	5.16	
	120412-MA	●	12.7	4.76	1.2	5.16	
	120416-MA	●	12.7	4.76	1.6	5.16	
	160608-MA	●	15.875	6.35	0.8	6.35	
	160612-MA	●	15.875	6.35	1.2	6.35	
	160616-MA	●	15.875	6.35	1.6	6.35	
	190612-MA	●	19.05	6.35	1.2	7.93	
	190616-MA	●	19.05	6.35	1.6	7.93	


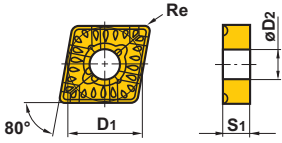

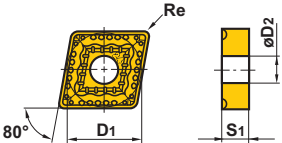

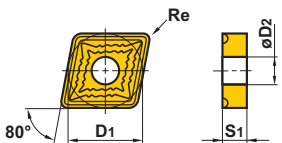

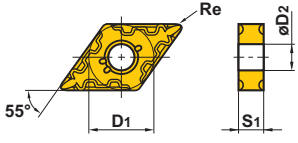

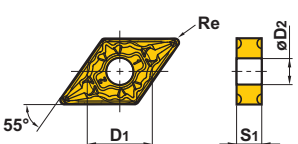

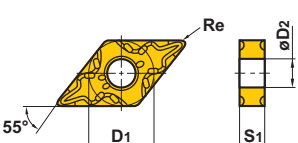

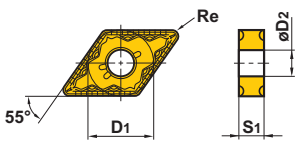
● : Inventory maintained.

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D1	S1	Re	D2	
<b>MH</b> 	<b>CNMG120404-MH</b>	●	12.7	4.76	0.4	5.16	
	120408-MH	●	12.7	4.76	0.8	5.16	
	120412-MH	●	12.7	4.76	1.2	5.16	
	120416-MH	●	12.7	4.76	1.6	5.16	
	160608-MH	●	15.875	6.35	0.8	6.35	
	160612-MH	●	15.875	6.35	1.2	6.35	
	160616-MH	●	15.875	6.35	1.6	6.35	
	190612-MH	●	19.05	6.35	1.2	7.93	
	190616-MH	●	19.05	6.35	1.6	7.93	
Medium Cutting							
<b>Standard</b> 	<b>CNMG090308</b>	●	9.525	3.18	0.8	3.81	
	09T304	●	9.525	3.97	0.4	3.81	
	09T308	●	9.525	3.97	0.8	3.81	
	120404	●	12.7	4.76	0.4	5.16	
	120408	●	12.7	4.76	0.8	5.16	
	120412	●	12.7	4.76	1.2	5.16	
	120416	●	12.7	4.76	1.6	5.16	
	160608	●	15.875	6.35	0.8	6.35	
	160612	●	15.875	6.35	1.2	6.35	
	160616	●	15.875	6.35	1.6	6.35	
	190608	●	19.05	6.35	0.8	7.93	
	190612	●	19.05	6.35	1.2	7.93	
	190616	●	19.05	6.35	1.6	7.93	
Medium Cutting							
<b>MW</b> 	<b>CNMG120408-MW</b>	●	12.7	4.76	0.8	5.16	
	120412-MW	●	12.7	4.76	1.2	5.16	
Medium Cutting (Wiper)							
<b>MS</b> 	<b>CNMG090308-MS</b>	●	9.525	3.18	0.8	3.81	
	09T308-MS	●	9.525	3.97	0.8	3.81	
	120404-MS	●	12.7	4.76	0.4	5.16	
	120408-MS	●	12.7	4.76	0.8	5.16	
	120412-MS	●	12.7	4.76	1.2	5.16	
Medium Cutting							
<b>NEW RP</b> 	<b>CNMG120408-RP</b>	●	12.7	4.76	0.8	5.16	
	120412-RP	●	12.7	4.76	1.2	5.16	
	120416-RP	●	12.7	4.76	1.6	5.16	
	160612-RP	●	15.875	6.35	1.2	6.35	
	160616-RP	●	15.875	6.35	1.6	6.35	
	190612-RP	●	19.05	6.35	1.2	7.93	
	190616-RP	●	19.05	6.35	1.6	7.93	
Rough Cutting							
<b>GH</b> 	<b>CNMG120408-GH</b>	●	12.7	4.76	0.8	5.16	
	120412-GH	●	12.7	4.76	1.2	5.16	
	120416-GH	●	12.7	4.76	1.6	5.16	
	160612-GH	●	15.875	6.35	1.2	6.35	
	160616-GH	●	15.875	6.35	1.6	6.35	
	190612-GH	●	19.05	6.35	1.2	7.93	
	190616-GH	●	19.05	6.35	1.6	7.93	
Rough Cutting							

# UE6110


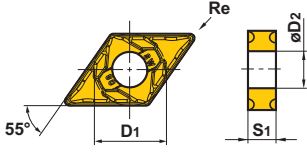

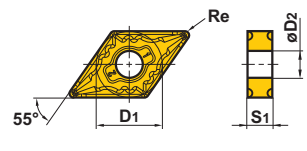

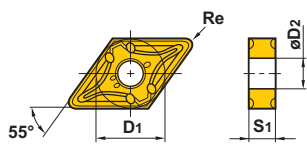

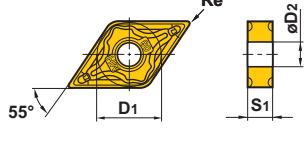

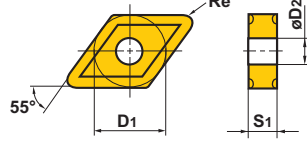

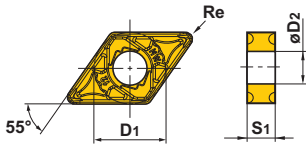
## INSERTS

### ● Negative Inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		UE6110	D1	S1	Re	D2	
 Heavy Cutting	CNMM120408-HZ	●	12.7	4.76	0.8	5.16	
	120412-HZ	●	12.7	4.76	1.2	5.16	
	160612-HZ	●	15.875	6.35	1.2	6.35	
	160616-HZ	●	15.875	6.35	1.6	6.35	
	190612-HZ	●	19.05	6.35	1.2	7.93	
	190616-HZ	●	19.05	6.35	1.6	7.93	
 Heavy Cutting	CNMM190612-HX	●	19.05	6.35	1.2	7.93	
	190616-HX	●	19.05	6.35	1.6	7.93	
	190624-HX	●	19.05	6.35	2.4	7.93	
	250924-HX	●	25.4	9.52	2.4	9.12	
 Heavy Cutting	CNMM190616-HV	●	19.05	6.35	1.6	7.93	
	190624-HV	●	19.05	6.35	2.4	7.93	
	250924-HV	●	25.4	9.52	2.4	9.12	
 Finish Cutting	DNMG150402-FH	●	12.7	4.76	0.2	5.16	
	150404-FH	●	12.7	4.76	0.4	5.16	
	150408-FH	●	12.7	4.76	0.8	5.16	
	150602-FH	●	12.7	6.35	0.2	5.16	
	150604-FH	●	12.7	6.35	0.4	5.16	
	150608-FH	●	12.7	6.35	0.8	5.16	
 Light Cutting	DNMG110404-LP	●	9.525	4.76	0.4	3.81	
	110408-LP	●	9.525	4.76	0.8	3.81	
	150404-LP	●	12.7	4.76	0.4	5.16	
	150408-LP	●	12.7	4.76	0.8	5.16	
	150412-LP	●	12.7	4.76	1.2	5.16	
	150604-LP	●	12.7	6.35	0.4	5.16	
	150608-LP	●	12.7	6.35	0.8	5.16	
	150612-LP	●	12.7	6.35	1.2	5.16	
 Light Cutting	DNMG110404-SH	●	9.525	4.76	0.4	3.81	
	110408-SH	●	9.525	4.76	0.8	3.81	
	150404-SH	●	12.7	4.76	0.4	5.16	
	150408-SH	●	12.7	4.76	0.8	5.16	
	150412-SH	●	12.7	4.76	1.2	5.16	
	150604-SH	●	12.7	6.35	0.4	5.16	
	150608-SH	●	12.7	6.35	0.8	5.16	
	150612-SH	●	12.7	6.35	1.2	5.16	
 Light Cutting	DNMG150404-SA	●	12.7	4.76	0.4	5.16	
	150408-SA	●	12.7	4.76	0.8	5.16	
	150412-SA	●	12.7	4.76	1.2	5.16	
	150604-SA	●	12.7	6.35	0.4	5.16	
	150608-SA	●	12.7	6.35	0.8	5.16	
	150612-SA	●	12.7	6.35	1.2	5.16	

● : Inventory maintained.

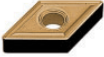
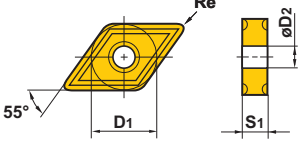

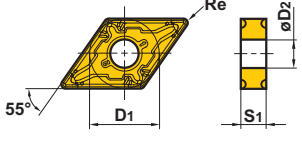
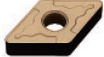
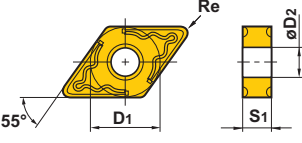

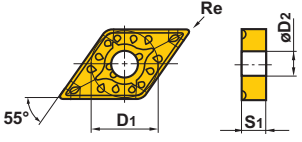

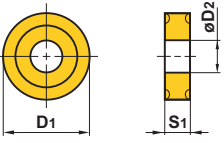

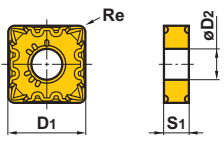

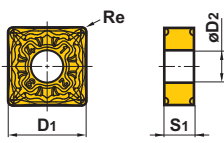

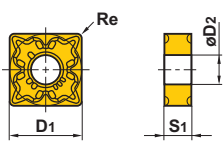


Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
<b>SW</b>  Light Cutting (Wiper)	<b>DNMX150404-SW</b>	●	12.7	4.76	0.4	5.16	
	<b>150408-SW</b>	●	12.7	4.76	0.8	5.16	
	<b>150412-SW</b>	●	12.7	4.76	1.2	5.16	
	<b>150604-SW</b>	●	12.7	6.35	0.4	5.16	
	<b>150608-SW</b>	●	12.7	6.35	0.8	5.16	
	<b>150612-SW</b>	●	12.7	6.35	1.2	5.16	
<b>MP</b>  Medium Cutting	<b>DNMG150404-MP</b>	●	12.7	4.76	0.4	5.16	
	<b>150408-MP</b>	●	12.7	4.76	0.8	5.16	
	<b>150412-MP</b>	●	12.7	4.76	1.2	5.16	
	<b>150416-MP</b>	●	12.7	4.76	1.6	5.16	
	<b>150604-MP</b>	●	12.7	6.35	0.4	5.16	
	<b>150608-MP</b>	●	12.7	6.35	0.8	5.16	
	<b>150612-MP</b>	●	12.7	6.35	1.2	5.16	
	<b>150616-MP</b>	●	12.7	6.35	1.6	5.16	
<b>MA</b>  Medium Cutting	<b>DNMG110404-MA</b>	●	9.525	4.76	0.4	3.81	
	<b>110408-MA</b>	●	9.525	4.76	0.8	3.81	
	<b>110412-MA</b>	●	9.525	4.76	1.2	3.81	
	<b>150404-MA</b>	●	12.7	4.76	0.4	5.16	
	<b>150408-MA</b>	●	12.7	4.76	0.8	5.16	
	<b>150412-MA</b>	●	12.7	4.76	1.2	5.16	
	<b>150604-MA</b>	●	12.7	6.35	0.4	5.16	
	<b>150608-MA</b>	●	12.7	6.35	0.8	5.16	
	<b>150612-MA</b>	●	12.7	6.35	1.2	5.16	
	<b>150616-MA</b>	●	12.7	6.35	1.6	5.16	
<b>MH</b>  Medium Cutting	<b>DNMG150404-MH</b>	●	12.7	4.76	0.4	5.16	
	<b>150408-MH</b>	●	12.7	4.76	0.8	5.16	
	<b>150412-MH</b>	●	12.7	4.76	1.2	5.16	
	<b>150604-MH</b>	●	12.7	6.35	0.4	5.16	
	<b>150608-MH</b>	●	12.7	6.35	0.8	5.16	
	<b>150612-MH</b>	●	12.7	6.35	1.2	5.16	
<b>Standard</b>  Medium Cutting	<b>DNMG110408</b>	●	9.525	4.76	0.8	3.81	
	<b>150404</b>	●	12.7	4.76	0.4	5.16	
	<b>150408</b>	●	12.7	4.76	0.8	5.16	
	<b>150412</b>	●	12.7	4.76	1.2	5.16	
	<b>150416</b>	●	12.7	4.76	1.6	5.16	
	<b>150604</b>	●	12.7	6.35	0.4	5.16	
	<b>150608</b>	●	12.7	6.35	0.8	5.16	
	<b>150612</b>	●	12.7	6.35	1.2	5.16	
	<b>150616</b>	●	12.7	6.35	1.6	5.16	
<b>MW</b>  Medium Cutting (Wiper)	<b>DNMX150408-MW</b>	●	12.7	4.76	0.8	5.16	
	<b>150412-MW</b>	●	12.7	4.76	1.2	5.16	
	<b>150608-MW</b>	●	12.7	6.35	0.8	5.16	
	<b>150612-MW</b>	●	12.7	6.35	1.2	5.16	


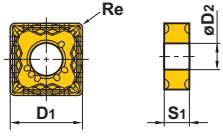

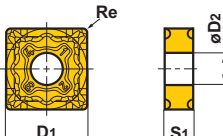

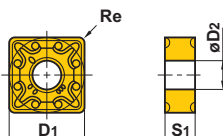

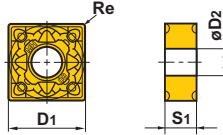

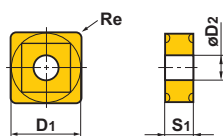

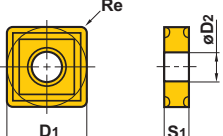

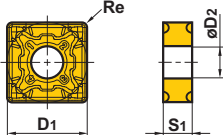
# UE6110

## INSERTS

### ● Negative Inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		UE6110	D1	S1	Re	D2	
 Medium Cutting	DNMG110408-MS	●	9.525	4.76	0.8	3.81	
	150404-MS	●	12.7	4.76	0.4	5.16	
	150408-MS	●	12.7	4.76	0.8	5.16	
	150412-MS	●	12.7	4.76	1.2	5.16	
	150604-MS	●	12.7	6.35	0.4	5.16	
	150608-MS	●	12.7	6.35	0.8	5.16	
	150612-MS	●	12.7	6.35	1.2	5.16	
 Rough Cutting	DNMG150408-RP	●	12.7	4.76	0.8	5.16	
	150412-RP	●	12.7	4.76	1.2	5.16	
	150416-RP	●	12.7	4.76	1.6	5.16	
	150608-RP	●	12.7	6.35	0.8	5.16	
	150612-RP	●	12.7	6.35	1.2	5.16	
	150616-RP	●	12.7	6.35	1.6	5.16	
 Rough Cutting	DNMG150408-GH	●	12.7	4.76	0.8	5.16	
	150412-GH	●	12.7	4.76	1.2	5.16	
	150608-GH	●	12.7	6.35	0.8	5.16	
	150612-GH	●	12.7	6.35	1.2	5.16	
 Heavy Cutting	DNMG150408-HZ	●	12.7	4.76	0.8	5.16	
	150412-HZ	●	12.7	4.76	1.2	5.16	
	150608-HZ	●	12.7	6.35	0.8	5.16	
	150612-HZ	●	12.7	6.35	1.2	5.16	
 Medium Cutting	RNMG120400	●	12.7	4.76	—	5.16	
 Finish Cutting	SNMG120404-FH	●	12.7	4.76	0.4	5.16	
	120408-FH	●	12.7	4.76	0.8	5.16	
 Light Cutting	SNMG120404-LP	●	12.7	4.76	0.4	5.16	
	120408-LP	●	12.7	4.76	0.8	5.16	
	120412-LP	●	12.7	4.76	1.2	5.16	
 Light Cutting	SNMG120404-SH	●	12.7	4.76	0.4	5.16	
	120408-SH	●	12.7	4.76	0.8	5.16	
	120412-SH	●	12.7	4.76	1.2	5.16	


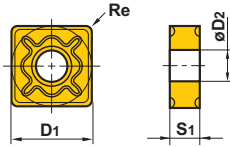

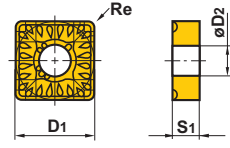

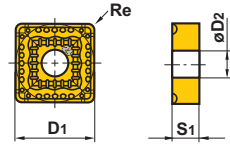

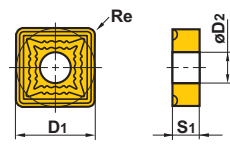

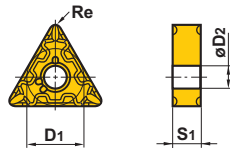

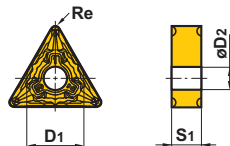

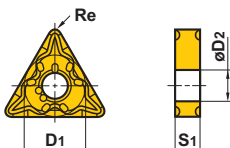

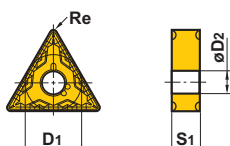
● : Inventory maintained.

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D1	S1	Re	D2	
<b>SA</b>  Light Cutting	<b>SNMG120404-SA</b>	●	12.7	4.76	0.4	5.16	
	<b>120408-SA</b>	●	12.7	4.76	0.8	5.16	
	<b>120412-SA</b>	●	12.7	4.76	1.2	5.16	
<b>MP</b>  Medium Cutting	<b>SNMG120404-MP</b>	●	12.7	4.76	0.4	5.16	
	<b>120408-MP</b>	●	12.7	4.76	0.8	5.16	
	<b>120412-MP</b>	●	12.7	4.76	1.2	5.16	
<b>MA</b>  Medium Cutting	<b>SNMG120404-MA</b>	●	12.7	4.76	0.4	5.16	
	<b>120408-MA</b>	●	12.7	4.76	0.8	5.16	
	<b>120412-MA</b>	●	12.7	4.76	1.2	5.16	
	<b>150608-MA</b>	●	15.875	6.35	0.8	6.35	
	<b>150612-MA</b>	●	15.875	6.35	1.2	6.35	
	<b>150616-MA</b>	●	15.875	6.35	1.6	6.35	
	<b>190612-MA</b>	●	19.05	6.35	1.2	7.93	
	<b>190616-MA</b>	●	19.05	6.35	1.6	7.93	
<b>MH</b>  Medium Cutting	<b>SNMG120408-MH</b>	●	12.7	4.76	0.8	5.16	
	<b>120412-MH</b>	●	12.7	4.76	1.2	5.16	
	<b>190612-MH</b>	●	19.05	6.35	1.2	7.93	
	<b>190616-MH</b>	●	19.05	6.35	1.6	7.93	
<b>Standard</b>  Medium Cutting	<b>SNMG090304</b>	●	9.525	3.18	0.4	3.81	
	<b>090308</b>	●	9.525	3.18	0.8	3.81	
	<b>120404</b>	●	12.7	4.76	0.4	5.16	
	<b>120408</b>	●	12.7	4.76	0.8	5.16	
	<b>120412</b>	●	12.7	4.76	1.2	5.16	
	<b>120416</b>	●	12.7	4.76	1.6	5.16	
	<b>150612</b>	●	15.875	6.35	1.2	6.35	
	<b>190612</b>	●	19.05	6.35	1.2	7.93	
	<b>190616</b>	●	19.05	6.35	1.6	7.93	
<b>MS</b>  Medium Cutting	<b>SNMG120404-MS</b>	●	12.7	4.76	0.4	5.16	
	<b>120408-MS</b>	●	12.7	4.76	0.8	5.16	
	<b>120412-MS</b>	●	12.7	4.76	1.2	5.16	
<b>NEW RP</b>  Rough Cutting	<b>SNMG120408-RP</b>	●	12.7	4.76	0.8	5.16	
	<b>120412-RP</b>	●	12.7	4.76	1.2	5.16	
	<b>120416-RP</b>	●	12.7	4.76	1.6	5.16	
	<b>150612-RP</b>	●	15.875	6.35	1.2	6.35	
	<b>150616-RP</b>	●	15.875	6.35	1.6	6.35	
	<b>190612-RP</b>	●	19.05	6.35	1.2	7.93	
	<b>190616-RP</b>	●	19.05	6.35	1.6	7.93	


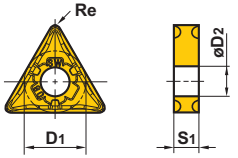

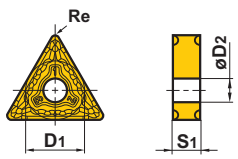

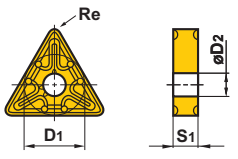

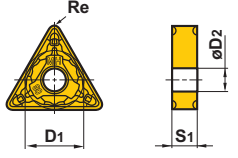

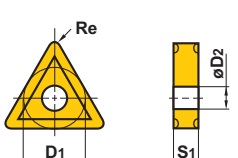

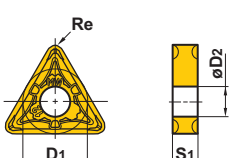
# UE6110

## INSERTS

### ● Negative Inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		UE6110	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
 Rough Cutting	SNMG120408-GH	●	12.7	4.76	0.8	5.16	
	120412-GH	●	12.7	4.76	1.2	5.16	
	120416-GH	●	12.7	4.76	1.6	5.16	
	150612-GH	●	15.875	6.35	1.2	6.35	
	150616-GH	●	15.875	6.35	1.6	6.35	
	190612-GH	●	19.05	6.35	1.2	7.93	
	190616-GH	●	19.05	6.35	1.6	7.93	
 Heavy Cutting	SNMM120408-HZ	●	12.7	4.76	0.8	5.16	
	120412-HZ	●	12.7	4.76	1.2	5.16	
	150612-HZ	●	15.875	6.35	1.2	6.35	
	190612-HZ	●	19.05	6.35	1.2	7.93	
	190616-HZ	●	19.05	6.35	1.6	7.93	
 Heavy Cutting	SNMM190612-HX	●	19.05	6.35	1.2	7.93	
	190616-HX	●	19.05	6.35	1.6	7.93	
	190624-HX	●	19.05	6.35	2.4	7.93	
	250724-HX	●	25.4	7.94	2.4	9.12	
	250924-HX	●	25.4	9.52	2.4	9.12	
 Heavy Cutting	SNMM190616-HV	●	19.05	6.35	1.6	7.93	
	190624-HV	●	19.05	6.35	2.4	7.93	
	250724-HV	●	25.4	7.94	2.4	9.12	
	250924-HV	●	25.4	9.53	2.4	9.12	
 Finish Cutting	TNMG160402-FH	●	9.525	4.76	0.2	3.81	
	160404-FH	●	9.525	4.76	0.4	3.81	
	160408-FH	●	9.525	4.76	0.8	3.81	
 Light Cutting	TNMG160404-LP	●	9.525	4.76	0.4	3.81	
	160408-LP	●	9.525	4.76	0.8	3.81	
	160412-LP	●	9.525	4.76	1.2	3.81	
	220408-LP	●	12.7	4.76	0.8	5.16	
	220412-LP	●	12.7	4.76	1.2	5.16	
 Light Cutting	TNMG160404-SH	●	9.525	4.76	0.4	3.81	
	160408-SH	●	9.525	4.76	0.8	3.81	
	220408-SH	●	12.7	4.76	0.8	5.16	
 Light Cutting	TNMG160404-SA	●	9.525	4.76	0.4	3.81	
	160408-SA	●	9.525	4.76	0.8	3.81	
	160412-SA	●	9.525	4.76	1.2	3.81	
	220408-SA	●	12.7	4.76	0.8	5.16	
	220412-SA	●	12.7	4.76	1.2	5.16	


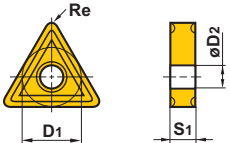

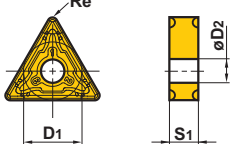

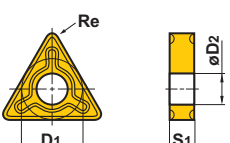

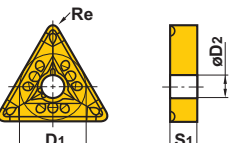

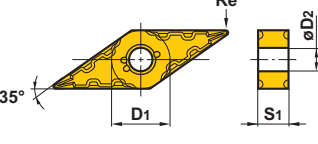

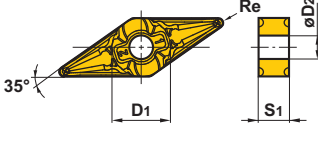

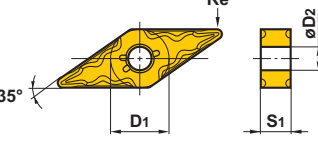

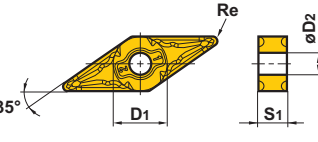
● : Inventory maintained.

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
<b>SW</b>  Light Cutting (Wiper)	<b>TNMX160404-SW</b>	●	9.525	4.76	0.4	3.81	
	<b>160408-SW</b>	●	9.525	4.76	0.8	3.81	
<b>MP</b>  Medium Cutting	<b>TNMG160404-MP</b>	●	9.525	4.76	0.4	3.81	
	<b>160408-MP</b>	●	9.525	4.76	0.8	3.81	
	<b>160412-MP</b>	●	9.525	4.76	1.2	3.81	
	<b>220408-MP</b>	●	12.7	4.76	0.8	5.16	
	<b>220412-MP</b>	●	12.7	4.76	1.2	5.16	
<b>MA</b>  Medium Cutting	<b>TNMG160404-MA</b>	●	9.525	4.76	0.4	3.81	
	<b>160408-MA</b>	●	9.525	4.76	0.8	3.81	
	<b>160412-MA</b>	●	9.525	4.76	1.2	3.81	
	<b>220408-MA</b>	●	12.7	4.76	0.8	5.16	
	<b>220412-MA</b>	●	12.7	4.76	1.2	5.16	
	<b>270608-MA</b>	●	15.875	6.35	0.8	6.35	
<b>MH</b>  Medium Cutting	<b>TNMG160404-MH</b>	●	9.525	4.76	0.4	3.81	
	<b>160408-MH</b>	●	9.525	4.76	0.8	3.81	
	<b>160412-MH</b>	●	9.525	4.76	1.2	3.81	
	<b>220408-MH</b>	●	12.7	4.76	0.8	5.16	
	<b>220412-MH</b>	●	12.7	4.76	1.2	5.16	
<b>Standard</b>  Medium Cutting	<b>TNMG110304</b>	●	6.35	3.18	0.4	2.26	
	<b>110308</b>	●	6.35	3.18	0.8	2.26	
	<b>160304</b>	●	9.525	3.18	0.4	3.81	
	<b>160308</b>	●	9.525	3.18	0.8	3.81	
	<b>160404</b>	●	9.525	4.76	0.4	3.81	
	<b>160408</b>	●	9.525	4.76	0.8	3.81	
	<b>160412</b>	●	9.525	4.76	1.2	3.81	
	<b>160416</b>	●	9.525	4.76	1.6	3.81	
	<b>220404</b>	●	12.7	4.76	0.4	5.16	
	<b>220408</b>	●	12.7	4.76	0.8	5.16	
	<b>220412</b>	●	12.7	4.76	1.2	5.16	
	<b>220416</b>	●	12.7	4.76	1.6	5.16	
	<b>270608</b>	●	15.875	6.35	0.8	6.35	
	<b>270612</b>	●	15.875	6.35	1.2	6.35	
	<b>270616</b>	●	15.875	6.35	1.6	6.35	
<b>MW</b>  Light Cutting (Wiper)	<b>TNMX160408-MW</b>	●	9.525	4.76	0.8	3.81	
	<b>160412-MW</b>	●	9.525	4.76	1.2	3.81	


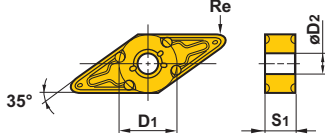

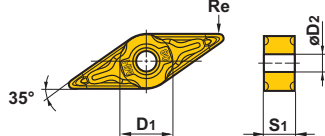

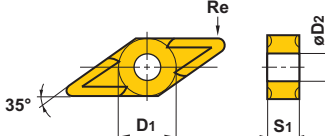

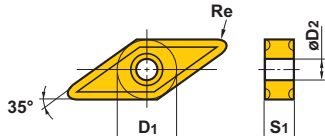

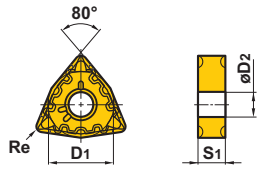

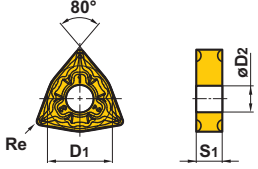

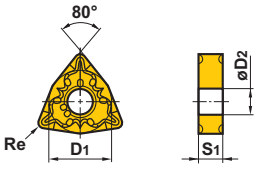

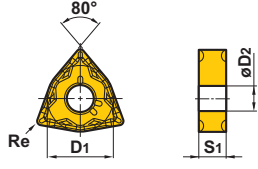
# UE6110

## INSERTS

### ● Negative Inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		UE6110	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
	TNMG160404-MS	●	9.525	4.76	0.4	3.81	
	160408-MS	●	9.525	4.76	0.8	3.81	
	160412-MS	●	9.525	4.76	1.2	3.81	
	220408-MS	●	12.7	4.76	0.8	5.16	
Medium Cutting							
	TNMG160408-RP	●	9.525	4.76	0.8	3.81	
	160412-RP	●	9.525	4.76	1.2	3.81	
	220408-RP	●	12.7	4.76	0.8	5.16	
	220412-RP	●	12.7	4.76	1.2	5.16	
	220416-RP	●	12.7	4.76	1.6	5.16	
	270612-RP	●	15.875	6.35	1.2	6.35	
	270616-RP	●	15.875	6.35	1.6	6.35	
Rough Cutting							
	TNMG160408-GH	●	9.525	4.76	0.8	3.81	
	160412-GH	●	9.525	4.76	1.2	3.81	
	220408-GH	●	12.7	4.76	0.8	5.16	
	220412-GH	●	12.7	4.76	1.2	5.16	
	220416-GH	●	12.7	4.76	1.6	5.16	
	270612-GH	●	15.875	6.35	1.2	6.35	
270616-GH	●	15.875	6.35	1.6	6.35		
Rough Cutting							
	TNMM160408-HZ	●	9.525	4.76	0.8	3.81	
	220408-HZ	●	12.7	4.76	0.8	5.16	
	220412-HZ	●	12.7	4.76	1.2	5.16	
	220416-HZ	●	12.7	4.76	1.6	5.16	
Heavy Cutting							
	VNMG160402-FH	●	9.525	4.76	0.2	3.81	
	160404-FH	●	9.525	4.76	0.4	3.81	
	160408-FH	●	9.525	4.76	0.8	3.81	
Finish Cutting							
	VNMG160404-LP	●	9.525	4.76	0.4	3.81	
	160408-LP	●	9.525	4.76	0.8	3.81	
Light Cutting							
	VNMG160404-SH	●	9.525	4.76	0.4	3.81	
	160408-SH	●	9.525	4.76	0.8	3.81	
Light Cutting							
	VNMG160404-MP	●	9.525	4.76	0.4	3.81	
	160408-MP	●	9.525	4.76	0.8	3.81	
	160412-MP	●	9.525	4.76	1.2	3.81	
Medium Cutting							


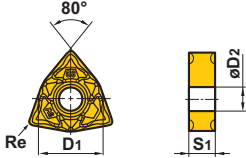

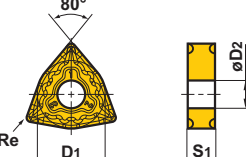

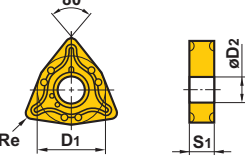

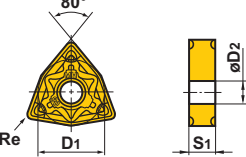

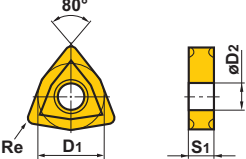

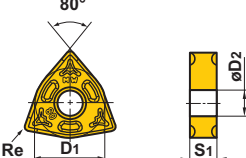
● : Inventory maintained.

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
<b>MA</b>  Medium Cutting	VNMG160404-MA	●	9.525	4.76	0.4	3.81	
	160408-MA	●	9.525	4.76	0.8	3.81	
<b>MH</b>  Medium Cutting	VNMG160404-MH	●	9.525	4.76	0.4	3.81	
	160408-MH	●	9.525	4.76	0.8	3.81	
<b>Standard</b>  Medium Cutting	VNMG160404	●	9.525	4.76	0.4	3.81	
	160408	●	9.525	4.76	0.8	3.81	
	160412	●	9.525	4.76	1.2	3.81	
<b>MS</b>  Medium Cutting	VNMG160404-MS	●	9.525	4.76	0.4	3.81	
	160408-MS	●	9.525	4.76	0.8	3.81	
<b>FH</b>  Finish Cutting	WNMG080404-FH	●	12.7	4.76	0.4	5.16	
	080408-FH	●	12.7	4.76	0.8	5.16	
<b>NEW LP</b>  Light Cutting	WNMG06T304-LP	●	9.525	3.97	0.4	3.81	
	06T308-LP	●	9.525	3.97	0.8	3.81	
	060404-LP	●	9.525	4.76	0.4	3.81	
	060408-LP	●	9.525	4.76	0.8	3.81	
	080404-LP	●	12.7	4.76	0.4	5.16	
	080408-LP	●	12.7	4.76	0.8	5.16	
	080412-LP	●	12.7	4.76	1.2	5.16	
<b>SH</b>  Light Cutting	WNMG06T304-SH	●	9.525	3.97	0.4	3.81	
	06T308-SH	●	9.525	3.97	0.8	3.81	
	060404-SH	●	9.525	4.76	0.4	3.81	
	060408-SH	●	9.525	4.76	0.8	3.81	
	080404-SH	●	12.7	4.76	0.4	5.16	
	080408-SH	●	12.7	4.76	0.8	5.16	
	080412-SH	●	12.7	4.76	1.2	5.16	
<b>SA</b>  Light Cutting	WNMG080404-SA	●	12.7	4.76	0.4	5.16	
	080408-SA	●	12.7	4.76	0.8	5.16	
	080412-SA	●	12.7	4.76	1.2	5.16	

# UE6110


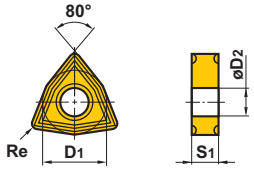

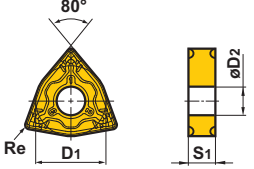

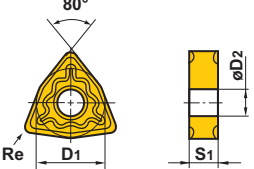
## INSERTS

### ● Negative Inserts (With hole)


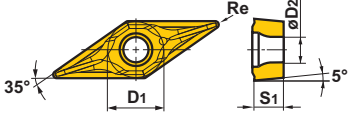

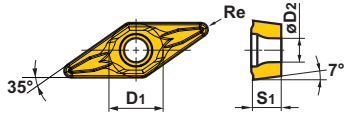

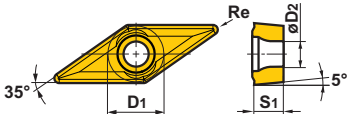

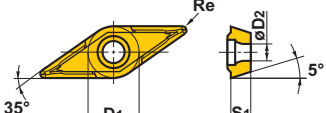
Shape	Order Number	Stock	Dimensions (mm)				Geometry
		UE6110	D1	S1	Re	D2	
 Light Cutting (Wiper)	WNMG060404-SW	●	9.525	4.76	0.4	3.81	
	060408-SW	●	9.525	4.76	0.8	3.81	
	080404-SW	●	12.7	4.76	0.4	5.16	
	080408-SW	●	12.7	4.76	0.8	5.16	
	080412-SW	●	12.7	4.76	1.2	5.16	
 Medium Cutting	WNMG06T304-MP	●	9.525	3.97	0.4	3.81	
	06T308-MP	●	9.525	3.97	0.8	3.81	
	06T312-MP	●	9.525	3.97	1.2	3.81	
	060404-MP	●	9.525	4.76	0.4	3.81	
	060408-MP	●	9.525	4.76	0.8	3.81	
	060412-MP	●	9.525	4.76	1.2	3.81	
	080404-MP	●	12.7	4.76	0.4	5.16	
	080408-MP	●	12.7	4.76	0.8	5.16	
	080412-MP	●	12.7	4.76	1.2	5.16	
080416-MP	●	12.7	4.76	1.6	5.16		
 Medium Cutting	WNMG06T304-MA	●	9.525	3.97	0.4	3.81	
	06T308-MA	●	9.525	3.97	0.8	3.81	
	06T312-MA	●	9.525	3.97	1.2	3.81	
	060404-MA	●	9.525	4.76	0.4	3.81	
	060408-MA	●	9.525	4.76	0.8	3.81	
	060412-MA	●	9.525	4.76	1.2	3.81	
	080404-MA	●	12.7	4.76	0.4	5.16	
	080408-MA	●	12.7	4.76	0.8	5.16	
	080412-MA	●	12.7	4.76	1.2	5.16	
080416-MA	●	12.7	4.76	1.6	5.16		
 Medium Cutting	WNMG080404-MH	●	12.7	4.76	0.4	5.16	
	080408-MH	●	12.7	4.76	0.8	5.16	
	080412-MH	●	12.7	4.76	1.2	5.16	
 Medium Cutting	WNMG080404	●	12.7	4.76	0.4	5.16	
	080408	●	12.7	4.76	0.8	5.16	
	080412	●	12.7	4.76	1.2	5.16	
 Medium Cutting (Wiper)	WNMG060408-MW	●	9.525	4.76	0.8	3.81	
	060412-MW	●	9.525	4.76	1.2	3.81	
	080408-MW	●	12.7	4.76	0.8	5.16	
	080412-MW	●	12.7	4.76	1.2	5.16	

● : Inventory maintained.



Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
<b>MS</b>  Medium Cutting	<b>WNMG06T304-MS</b>	●	9.525	3.97	0.4	3.81	
	<b>06T308-MS</b>	●	9.525	3.97	0.8	3.81	
	<b>060404-MS</b>	●	9.525	4.76	0.4	3.81	
	<b>060408-MS</b>	●	9.525	4.76	0.8	3.81	
	<b>080404-MS</b>	●	12.7	4.76	0.4	5.16	
	<b>080408-MS</b>	●	12.7	4.76	0.8	5.16	
	<b>080412-MS</b>	●	12.7	4.76	1.2	5.16	
<b>NEW RP</b>  Rough Cutting	<b>WNMG080408-RP</b>	●	12.7	4.76	0.8	5.16	
	<b>080412-RP</b>	●	12.7	4.76	1.2	5.16	
<b>GH</b>  Rough Cutting	<b>WNMG080408-GH</b>	●	12.7	4.76	0.8	5.16	
	<b>080412-GH</b>	●	12.7	4.76	1.2	5.16	


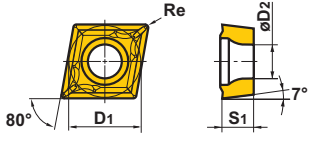

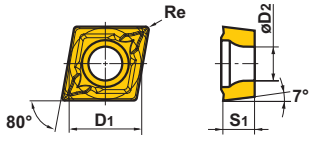

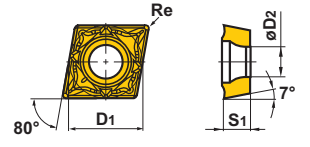

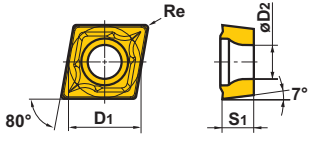

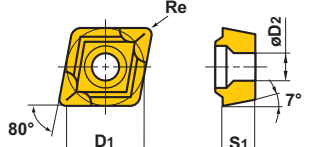

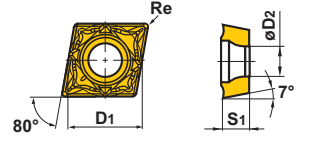

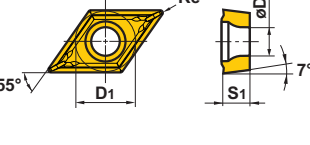
### ● 5° Positive inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
<b>FH</b>  Finish Cutting	<b>VBMT110302-FP</b>	●	6.35	3.18	0.2	2.9	
	<b>110304-FP</b>	●	6.35	3.18	0.4	2.9	
	<b>110308-FP</b>	●	6.35	3.18	0.8	2.9	
	<b>160404-FP</b>	●	9.525	4.76	0.4	4.4	
	<b>160408-FP</b>	●	9.525	4.76	0.8	4.4	
<b>LP</b>  Light Cutting	<b>VBMT110304-LP</b>	●	6.35	3.18	0.4	2.9	
	<b>110308-LP</b>	●	6.35	3.18	0.8	2.9	
	<b>160404-LP</b>	●	9.525	4.76	0.4	4.4	
	<b>160408-LP</b>	●	9.525	4.76	0.8	4.4	
<b>MP</b>  Medium Cutting	<b>VBMT160404-MP</b>	●	9.525	4.76	0.4	4.4	
	<b>160408-MP</b>	●	9.525	4.76	0.8	4.4	
<b>Standard</b>  Medium Cutting	<b>VBMT160404</b>	●	9.525	4.76	0.4	4.43	
	<b>160408</b>	●	9.525	4.76	0.8	4.43	


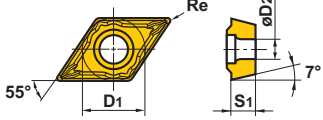

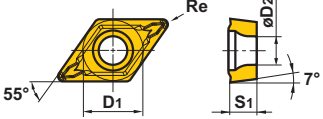

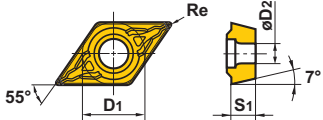

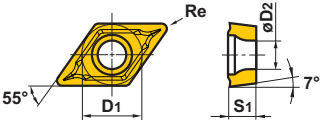
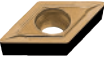
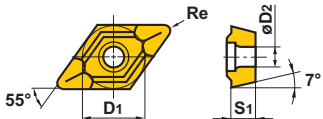

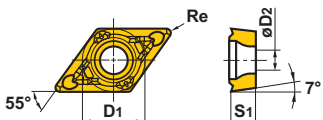


# UE6110

## INSERTS

### ● 7° Positive inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		UE6110	D1	S1	Re	D2	
	<b>NEW</b> CCMT060202-FP	●	6.35	2.38	0.2	2.8	
	060204-FP	●	6.35	2.38	0.4	2.8	
	09T302-FP	●	9.525	3.97	0.2	4.4	
	09T304-FP	●	9.525	3.97	0.4	4.4	
	09T308-FP	●	9.525	3.97	0.8	4.4	
Finish Cutting							
	<b>NEW</b> CCMT060204-LP	●	6.35	2.38	0.4	2.8	
	060208-LP	●	6.35	2.38	0.8	2.8	
	09T304-LP	●	9.525	3.97	0.4	4.4	
	09T308-LP	●	9.525	3.97	0.8	4.4	
Light Cutting							
	CCMT060202-SW	●	6.35	2.38	0.2	2.8	
	060204-SW	●	6.35	2.38	0.4	2.8	
	09T302-SW	●	9.525	3.97	0.2	4.4	
	09T304-SW	●	9.525	3.97	0.4	4.4	
Light Cutting (Wiper)							
	<b>NEW</b> CCMT060204-MP	●	6.35	2.38	0.4	2.8	
	060208-MP	●	6.35	2.38	0.8	2.8	
	09T304-MP	●	9.525	3.97	0.4	4.4	
	09T308-MP	●	9.525	3.97	0.8	4.4	
	120404-MP	●	12.7	4.76	0.4	5.5	
	120408-MP	●	12.7	4.76	0.8	5.5	
	120412-MP	●	12.7	4.76	1.2	5.5	
Medium Cutting							
	<b>Standard</b> CCMT060202	●	6.35	2.38	0.2	2.8	
	060204	●	6.35	2.38	0.4	2.8	
	060208	●	6.35	2.38	0.8	2.8	
	080302	●	7.94	3.18	0.2	3.4	
	080304	●	7.94	3.18	0.4	3.4	
	080308	●	7.94	3.18	0.8	3.4	
	09T302	●	9.525	3.97	0.2	4.4	
	09T304	●	9.525	3.97	0.4	4.4	
	09T308	●	9.525	3.97	0.8	4.4	
	120404	●	12.7	4.76	0.4	5.5	
	120408	●	12.7	4.76	0.8	5.5	
	120412	●	12.7	4.76	1.2	5.5	
	Medium Cutting						
	CCMT060208-MW	●	6.35	2.38	0.8	2.8	
	09T304-MW	●	9.525	3.97	0.4	4.4	
	09T308-MW	●	9.525	3.97	0.8	4.4	
	120404-MW	●	12.7	4.76	0.4	5.5	
	120408-MW	●	12.7	4.76	0.8	5.5	
Medium Cutting (Wiper)							
	<b>NEW</b> DCMT070202-FP	●	6.35	2.38	0.2	2.8	
	070204-FP	●	6.35	2.38	0.4	2.8	
	11T302-FP	●	9.525	3.97	0.2	4.4	
	11T304-FP	●	9.525	3.97	0.4	4.4	
	11T308-FP	●	9.525	3.97	0.8	4.4	
Finish Cutting							


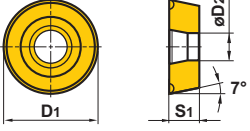

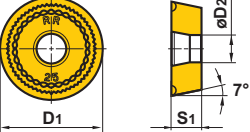

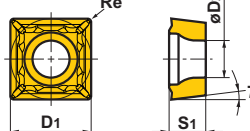

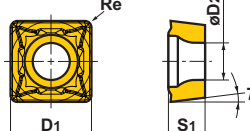

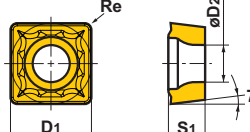

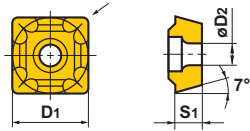

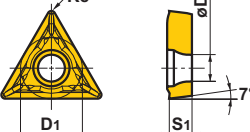

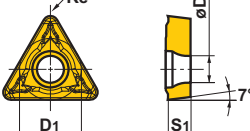
● : Inventory maintained.

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
	DCMT070202-FV	●	6.35	2.38	0.2	2.8	
	070204-FV	●	6.35	2.38	0.4	2.8	
	11T304-FV	●	9.525	3.97	0.4	4.4	
	11T308-FV	●	9.525	3.97	0.8	4.4	
Finish Cutting							
	DCMT070204-LP	●	6.35	2.38	0.4	2.8	
	070208-LP	●	6.35	2.38	0.8	2.8	
	11T304-LP	●	9.525	3.97	0.4	4.4	
	11T308-LP	●	9.525	3.97	0.8	4.4	
Light Cutting							
	DCMT070204-SV	●	6.35	2.38	0.4	2.8	
	070208-SV	●	6.35	2.38	0.8	2.8	
	11T302-SV	●	9.525	3.97	0.2	4.4	
	11T304-SV	●	9.525	3.97	0.4	4.4	
11T308-SV	●	9.525	3.97	0.8	4.4		
Light Cutting							
	DCMT070204-MP	●	6.35	2.38	0.4	2.8	
	070208-MP	●	6.35	2.38	0.8	2.8	
	11T304-MP	●	9.525	3.97	0.4	4.4	
	11T308-MP	●	9.525	3.97	0.8	4.4	
	150404-MP	●	12.7	4.76	0.4	5.5	
	150408-MP	●	12.7	4.76	0.8	5.5	
Medium Cutting							
	DCMT070202	●	6.35	2.38	0.2	2.8	
	070204	●	6.35	2.38	0.4	2.8	
	070208	●	6.35	2.38	0.8	2.8	
	11T302	●	9.525	3.97	0.2	4.4	
	11T304	●	9.525	3.97	0.4	4.4	
	11T308	●	9.525	3.97	0.8	4.4	
	11T312	●	9.525	3.97	1.2	4.4	
	150404	●	12.7	4.76	0.4	5.5	
	150408	●	12.7	4.76	0.8	5.5	
	150412	●	12.7	4.76	1.2	5.5	
Medium Cutting							
	DCMT070202-MV	●	6.35	2.38	0.2	2.8	
	070204-MV	●	6.35	2.38	0.4	2.8	
	070208-MV	●	6.35	2.38	0.8	2.8	
	11T302-MV	●	9.525	3.97	0.2	4.4	
	11T304-MV	●	9.525	3.97	0.4	4.4	
11T308-MV	●	9.525	3.97	0.8	4.4		
Medium Cutting							
	RCMT0602M0	●	6	2.38	—	2.8	
	0803M0	●	8	3.18	—	3.4	
Medium Cutting							


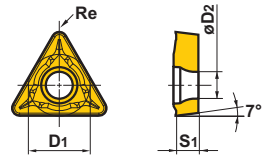

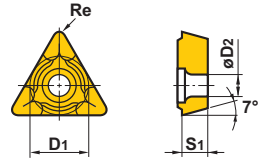

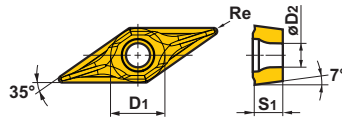

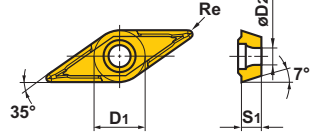

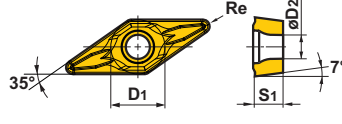

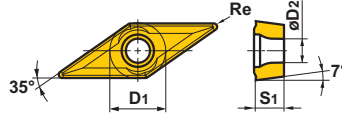

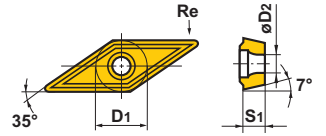
# UE6110

## INSERTS

### ● 7° Positive inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		UE6110	D1	S1	Re	D2	
 Medium Cutting	RCMX1003M0	●	10	3.18	—	3.6	
	1204M0	●	12	4.76	—	4.2	
	1606M0	●	16	6.35	—	5.2	
	2006M0	●	20	6.35	—	6.5	
	2507M0	●	25	7.94	—	7.2	
	3209M0	●	32	9.52	—	9.5	
 Medium Cutting	RCMX1606M0-RR	●	16	6.35	—	5.2	
	2006M0-RR	●	20	6.35	—	6.5	
	2507M0-RR	●	25	7.94	—	7.2	
	3209M0-RR	●	32	9.52	—	9.5	
 Finish Cutting	SCMT09T304-FP	●	9.525	3.97	0.4	4.4	
	09T308-FP	●	9.525	3.97	0.8	4.4	
 Light Cutting	SCMT09T304-LP	●	9.525	3.97	0.4	4.4	
	09T308-LP	●	9.525	3.97	0.8	4.4	
 Medium Cutting	SCMT09T304-MP	●	9.525	3.97	0.4	4.4	
	09T308-MP	●	9.525	3.97	0.8	4.4	
	120404-MP	●	12.7	4.76	0.4	5.5	
	120408-MP	●	12.7	4.76	0.8	5.5	
 Medium Cutting	SCMT09T304	●	9.525	3.97	0.4	4.4	
	09T308	●	9.525	3.97	0.8	4.4	
	120404	●	12.7	4.76	0.4	5.5	
	120408	●	12.7	4.76	0.8	5.5	
	120412	●	12.7	4.76	1.2	5.5	
 Finish Cutting	TCMT090202-FP	●	5.56	2.38	0.2	2.5	
	090204-FP	●	5.56	2.38	0.4	2.5	
	110202-FP	●	6.35	2.38	0.2	2.8	
	110204-FP	●	6.35	2.38	0.4	2.8	
	16T304-FP	●	9.525	3.97	0.4	4.4	
 Light Cutting	TCMT090204-LP	●	5.56	2.38	0.4	2.5	
	090208-LP	●	5.56	2.38	0.8	2.5	
	110204-LP	●	6.35	2.38	0.4	2.8	
	110208-LP	●	6.35	2.38	0.8	2.8	
	16T304-LP	●	9.525	3.97	0.4	4.4	
	16T308-LP	●	9.525	3.97	0.8	4.4	


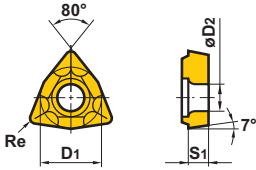
● : Inventory maintained.

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<i>UE6110</i>	D <sub>1</sub>	S <sub>1</sub>	Re	D <sub>2</sub>	
 Medium Cutting	<b>NEW</b> MP	●	5.56	2.38	0.4	2.5	
	TCMT090204-MP	●	5.56	2.38	0.8	2.5	
	090208-MP	●	6.35	2.38	0.4	2.8	
	110204-MP	●	6.35	2.38	0.8	2.8	
	130304-MP	●	7.94	3.18	0.4	3.4	
	16T304-MP	●	9.525	3.97	0.4	4.4	
	16T308-MP	●	9.525	3.97	0.8	4.4	
	16T312-MP	●	9.525	3.97	1.2	4.4	
 Medium Cutting	Standard	●	5.56	2.38	0.4	2.5	
	TCMT090204	●	6.35	2.38	0.2	2.8	
	110202	●	6.35	2.38	0.4	2.8	
	110204	●	6.35	2.38	0.8	2.8	
	130304	●	7.94	3.18	0.4	3.4	
	16T304	●	9.525	3.97	0.4	4.4	
	16T308	●	9.525	3.97	0.8	4.4	
	16T312	●	9.525	3.97	1.2	4.4	
 Finish Cutting	<b>NEW</b> FP	●	6.35	3.18	0.2	2.8	
	VCMT110302-FP	●	6.35	3.18	0.4	2.8	
	110304-FP	●	9.525	4.76	0.4	4.4	
	160404-FP	●	9.525	4.76	0.8	4.4	
 Finish Cutting	FV	●	9.525	4.76	0.4	4.4	
	VCMT160404-FV	●	9.525	4.76	0.8	4.4	
 Light Cutting	<b>NEW</b> LP	●	6.35	3.18	0.4	2.8	
	VCMT110304-LP	●	6.35	3.18	0.8	2.8	
	110308-LP	●	9.525	4.76	0.4	4.4	
	160404-LP	●	9.525	4.76	0.8	4.4	
 Medium Cutting	<b>NEW</b> MP	●	9.525	4.76	0.4	4.4	
	VCMT160404-MP	●	9.525	4.76	0.8	4.4	
	160408-MP	●	9.525	4.76	1.2	4.4	
 Medium Cutting	Standard	●	6.35	3.18	0.4	2.8	
	VCMT110304	●	9.525	4.76	0.4	4.4	
	160404	●	9.525	4.76	0.8	4.4	
	160408	●	9.525	4.76	1.2	4.4	


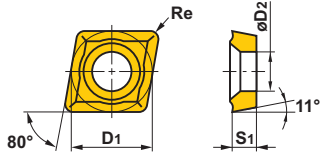
# UE6110

## INSERTS


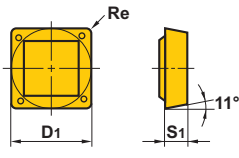

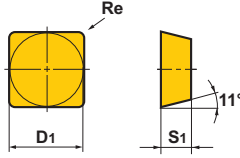
### ● 7° Positive inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<b>UE6110</b>	D1	S1	Re	D2	
 Medium Cutting	<b>WCMT020102</b>	●	3.97	1.59	0.2	2.3	
	<b>020104</b>	●	3.97	1.59	0.4	2.3	
	<b>L30202</b>	●	4.76	2.38	0.2	2.3	
	<b>L30204</b>	●	4.76	2.38	0.4	2.3	
	<b>040202</b>	●	6.35	2.38	0.2	2.8	
	<b>040204</b>	●	6.35	2.38	0.4	2.8	
	<b>06T304</b>	●	9.525	3.97	0.4	4.4	
	<b>06T308</b>	●	9.525	3.97	0.8	4.4	


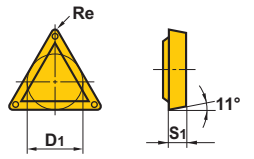

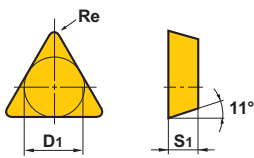
### ● 11° Positive inserts (With hole)

Shape	Order Number	Stock	Dimensions (mm)				Geometry
		<b>UE6110</b>	D1	S1	Re	D2	
 Medium Cutting	<b>CPMX080204</b>	●	7.94	2.38	0.4	3.5	
	<b>080208</b>	●	7.94	2.38	0.8	3.5	
	<b>090304</b>	●	9.525	3.18	0.4	4.6	
	<b>090308</b>	●	9.525	3.18	0.8	4.6	

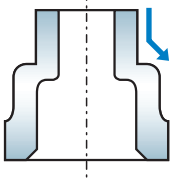
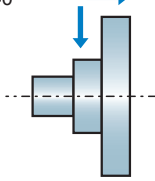
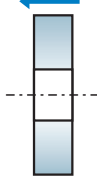
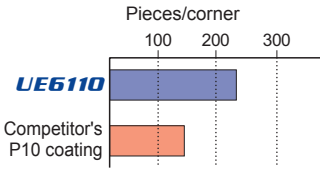
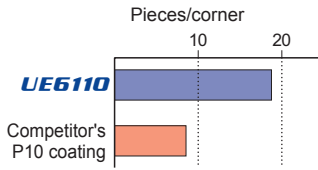

### ● 11° Positive inserts (Without hole)

Shape	Order Number	Stock	Dimensions (mm)			Geometry
		<b>UE6110</b>	D1	S1	Re	
 Light to Medium Cutting	<b>SPMR090304</b>	●	9.525	3.18	0.4	
	<b>090308</b>	●	9.525	3.18	0.8	
	<b>120304</b>	●	12.7	3.18	0.4	
	<b>120308</b>	●	12.7	3.18	0.8	
 Flat Top	<b>SPMN090308</b>	●	9.525	3.18	0.8	
	<b>120304</b>	●	12.7	3.18	0.4	
	<b>120308</b>	●	12.7	3.18	0.8	
	<b>120312</b>	●	12.7	3.18	1.2	

● : Inventory maintained.

Shape	Order Number	Stock	Dimensions (mm)			Geometry
		<b>UE6110</b>	D <sub>1</sub>	S <sub>1</sub>	Re	
<b>Standard</b>  Light to Medium Cutting	<b>TPMR110304</b>	●	6.35	3.18	0.4	
	<b>110308</b>	●	6.35	3.18	0.8	
	<b>160304</b>	●	9.525	3.18	0.4	
	<b>160308</b>	●	9.525	3.18	0.8	
	<b>160312</b>	●	9.525	3.18	1.2	
<b>Flat Top</b> 	<b>TPMN110304</b>	●	6.35	3.18	0.4	
	<b>110308</b>	●	6.35	3.18	0.8	
	<b>160304</b>	●	9.525	3.18	0.4	
	<b>160308</b>	●	9.525	3.18	0.8	
	<b>160312</b>	●	9.525	3.18	1.2	
	<b>220404</b>	●	12.7	4.76	0.4	
	<b>220408</b>	●	12.7	4.76	0.8	
<b>220412</b>	●	12.7	4.76	1.2		

## APPLICATION EXAMPLES

Insert	CNMG120416-MA	WNMG080412-MW	TNMG160408-RP	
Workpiece	JIS SUJ2 	JIS SCM440 	JIS SCM420H 	
Cutting Conditions	Cutting Speed (m/min)	240	210	250
	Feed (mm/min)	0.3 – 0.4	0.3	0.25
	Depth of Cut (mm)	3.0 – 4.0	3.0	2.0
Coolant	Wet cutting	Wet cutting	Wet cutting	
Results	<p>Pieces/corner</p>  <p>UE6110 achieved 1.5 times longer tool life without any abnormal wear due to its excellent wear resistance compared to a competitor's product.</p>	<p>Pieces/corner</p>  <p>UE6110 achieved more than double tool life.</p>	<p><b>UE6110</b>      conventional</p>  <p>UE6110 prevented crater wear because of its excellent wear resistance compared to a competitor's product.</p>	

### For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or driver. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

## MITSUBISHI MATERIALS CORPORATION

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(Tools specifications subject to change without notice.)