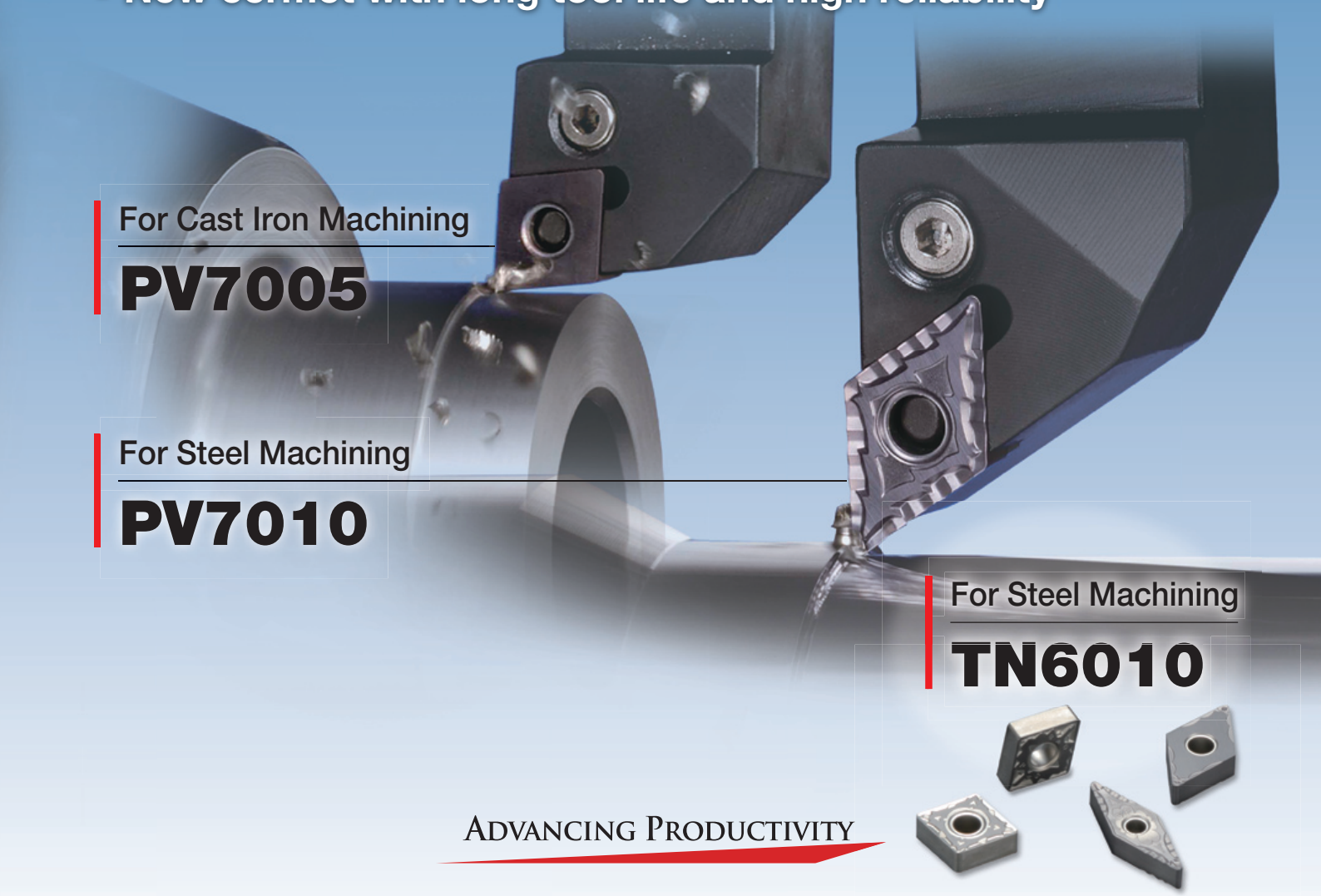
THE NEW VALUE FRONTIER

KYOCERA

MEGACOAT

MEGACOAT Cermet

- Improved version of high performace cermet
- Combination of "New PVD MEGACOAT" and "High Performance Cermet"
- New cermet with long tool life and high reliability



For Cast Iron Machining

PV7005

For Steel Machining

PV7010

For Steel Machining

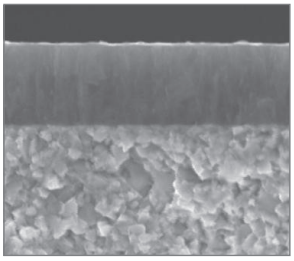
TN6010

ADVANCING PRODUCTIVITY

MEGACOAT Cermet

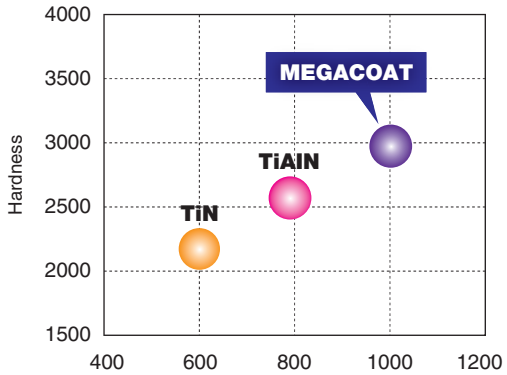
New MEGACOAT PVD technology

- MEGACOAT produces excellent wear resistance and heat resistance
- Achieves beautiful finished surfaces with high temperature stability plus surface smoothness



■ Wear resistant and heat resistant

MEGACOAT
- Nitride solid solution of high melting point metal
- High hardness and oxidation resistant
- Superior surface roughness
- Superior crater wear resistance



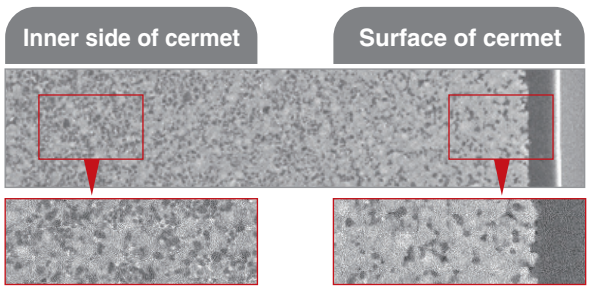
MEGACOAT CERMET for steel machining

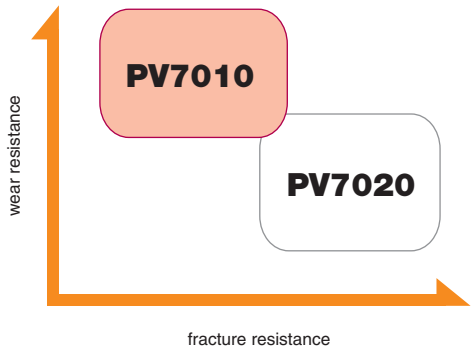
PV7010

Feature
- Achieves long tool life and stable machining with two new technologies, MEGACOAT plus special surface reforming Cermet

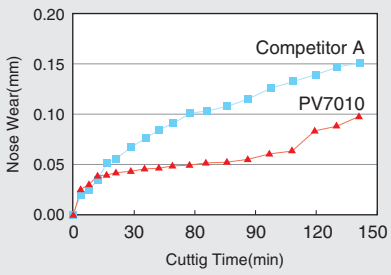
Surface reforming Cermet

- Surface structure has high hardness and high wear resistance and inner structure has high toughness and high fracture resistance.



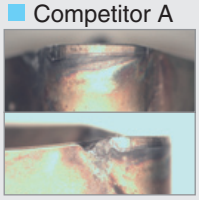


Comparison of wear Resistance



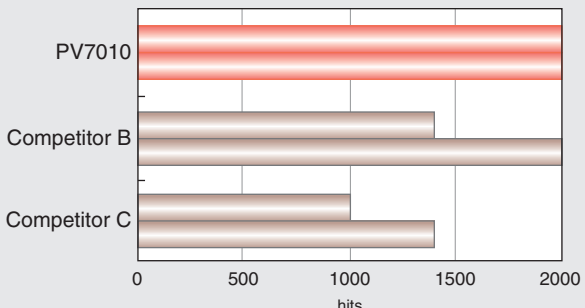
▲ PV7010

■ Competitor A



cutting conditions
SCM435, Vc=250m/min, ap=1.0mm, f=0.20mm/rev, WET, CNMG120408

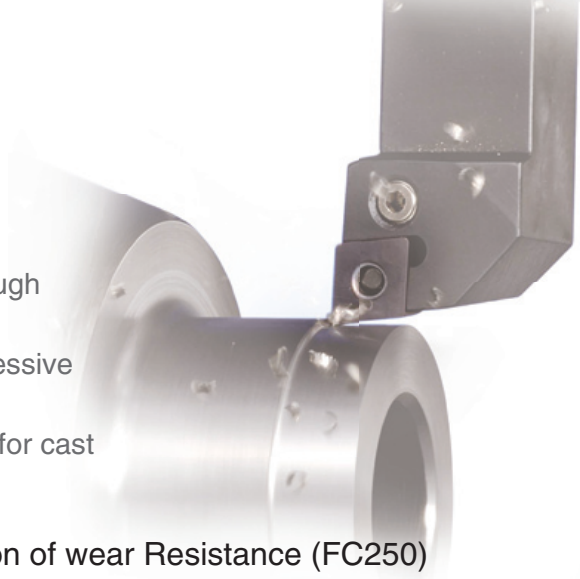
Comparison of fracture resistance



cutting conditions
S45C, Vc=250m/min, ap=1.5mm, f=0.20mm/rev, DRY, CNMG120408

MEGACOAT CERMET for cast iron machining

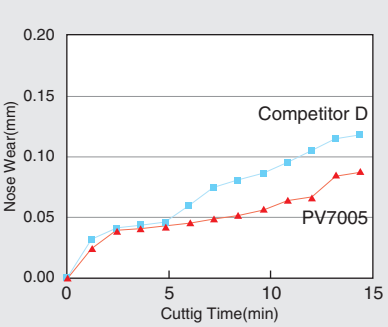
PV7005



Feature

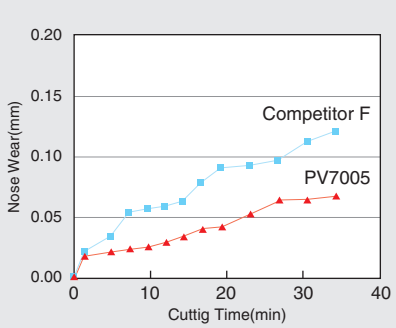
- Improved wear resistance for cast iron machining through the use of MEGACOAT
- Controls deterioration of the cutting edge due to progressive crater wear, enabling stable machining
- The substrate is a special TiC-TiN Cermet exclusively for cast iron machining

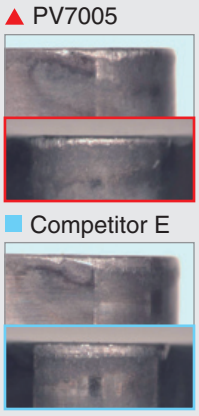
Comparison of wear Resistance (FCD450)



cutting conditions
FCD450, Vc=250m/min, ap=1.0mm,
f=0.20mm/rev, WET, TNGA160408

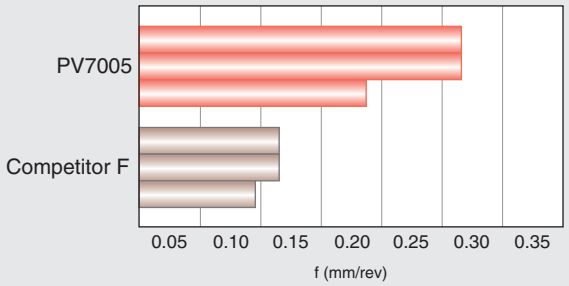
Comparison of wear Resistance (FC250)





cutting conditions
FC250, Vc=350m/min, ap=1.0mm,
f=0.20mm/rev, WET, CNGA120408

Comparison of fracture resistance

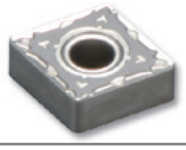


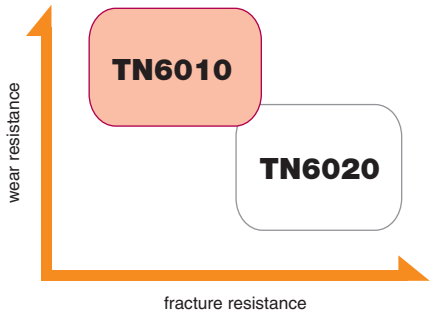
cutting conditions
Vc=100m/min, ap=2.0mm, Dry,
S45C 5mm×4, CNGA120408
* Toughness evaluation performed with S45C

CERMET for steel machining

- Special surface reforming cermet with high wear resistance and anti chipping
- Cost effective performance non coated cermet

TN6010





Recommended Cutting Conditions

Workpiece material	Insert Grade (Vc:m/min)
	PV7010
Carbon Steel	200-250-300
Alloy Steel	150-200-250

Workpiece material	Insert Grade (Vc:m/min)
	TN6010
Carbon Steel	150-200-250
Alloy Steel	100-150-200

Workpiece material	Insert Grade (Vc:m/min)
	PV7005
Gray Cast Iron	300-350-400
Nodular Cast Iron	150-250-300

Stock Items

Insert Handed insert shows Right-Hand	Description	Dimension (mm)					Stock Grades		
							PVD Cermet		Cermet
		I.C.	Thickness	Hole	Corner -R (rε)	Relief Angle	PV7005	PV7010	TN6010
 Finishing With Wiper Edge	CNMG 120404WP	12.70	4.76	5.16	0.4	-		●	
	CNMG 120408WP				0.8			●	
 Finishing-Medium With Wiper Edge	CNMG 120404WQ	12.70	4.76	5.16	0.4	-		●	
	CNMG 120408WQ				0.8			●	
 Finishing	CNMG 120402GP	12.70	4.76	5.16	0.2	-		●	
	CNMG 120404GP				0.4			●	●
	CNMG 120408GP				0.8			●	
 Finishing-Medium	CNMG 120404HQ	12.70	4.76	5.16	0.4	-		●	●
	CNMG 120408HQ				0.8			●	●
 Finishing-Medium / Up facing	CNMG 120404CQ	12.70	4.76	5.16	0.4	-		●	●
	CNMG 120408CQ				0.8			●	●
 Medium-Roughing	CNMG 120404PS	12.70	4.76	5.16	0.4	-		●	●
	CNMG 120408PS				0.8			●	●
 Roughing	CNMG 120404	12.70	4.76	5.16	0.4	-	●		
	CNMG 120408				0.8		●		
	CNMG 120412				1.2		●		
 Low Carbon Steel Finishing	CNMG 120404XP	12.70	4.76	5.16	0.4	-		●	
	CNMG 120408XP				0.8			●	
 Low Carbon Steel Medium Finishing	CNMG 120404XQ	12.70	4.76	5.16	0.4	-		●	
	CNMG 120408XQ				0.8			●	
 Without Chipbreaker	CNGA 120404	12.70	4.76	5.16	0.4	-	●		
	CNGA 120408				0.8		●		
 Finishing	DNMG 150402GP	12.70	4.76	5.16	0.2	-		●	●
	DNMG 150404GP				0.4			●	●
	DNMG 150602GP	12.70	6.35	5.16	0.2	-		●	●
	DNMG 150604GP				0.4			●	●
	DNMG 150608GP				0.8			●	●
 Finishing-Medium	DNMG 150404HQ	12.70	4.76	5.16	0.4	-		●	●
	DNMG 150408HQ				0.8			●	●
	DNMG 150604HQ	12.70	6.35	5.16	0.4	-		●	●
	DNMG 150608HQ				0.8			●	●
	DNMG 150612HQ				1.2			●	●
 Finishing-Medium / Up facing	DNMG 150408CQ	12.70	4.76	5.16	0.8	-		●	●
	DNMG 150604CQ	12.70	6.35	5.16	0.4	-		●	●

Insert Handed insert shows Right-Hand	Description	Dimension (mm)					Stock Grades		
							PVD Cermet		Cermet
		I.C.	Thickness	Hole	Corner -R (rε)	Relief Angle	PV7005	PV7010	TN6010
 Medium-Roughing	DNMG 150404PS	12.70	4.76	5.16	0.4	-		●	●
	150408PS				0.8			●	●
	DNMG 150604PS	12.70	6.35	5.16	0.4	-		●	●
	150608PS				0.8			●	●
	150612PS				1.2			●	●
 Roughing	DNMG 150408	12.70	4.76	5.16	0.8	-	●		
	DNMG 150608	12.70	6.35	5.16	0.8	-	●		
 Low Carbon Steel Finishing	DNMG 150404XP	12.70	4.76	5.16	0.4	-		●	
	150408XP				0.8			●	
	DNMG 150604XP	12.70	6.35	5.16	0.4	-		●	
	150608XP				0.8			●	
 Low Carbon Steel Medium Finishing	DNMG 150404XQ	12.70	4.76	5.16	0.4	-		●	
	150408XQ				0.8			●	
	DNMG 150604XQ	12.70	6.35	5.16	0.4	-		●	
	150608XQ				0.8			●	
 Medium cutting	DNGG 150404R/L	12.70	4.76	5.16	0.4	-	●		
	150408R/L				0.8		●		
 Medium-Roughing	RNMG 090300	9.525	3.18	3.81	-	-	●		
	RNMG 120400	12.70	4.76	5.16	-	-	●		
 Finishing-Medium	SNMG 120404HQ	12.70	4.76	5.16	0.4	-		●	●
	120408HQ				0.8			●	●
 Medium-Roughing	SNMG 120408PS	12.70	4.76	5.16	0.8	-		●	●
 Roughing	SNMG 120404	12.70	4.76	5.16	0.4	-	●		
	120408				0.8		●		
 Low Carbon Steel Finishing	SNMG 120408XP	12.70	4.76	5.16	0.8	-		●	
 Low Carbon Steel Medium Finishing	SNMG 120408XQ	12.70	4.76	5.16	0.8	-		●	
 Without Chipbreaker	SNGA 120408	12.70	4.76	5.16	0.8	-	●		
 '-B:Finishing-Medium '-C:Medium-Roughing	SNGG 090304R/L-B	9.525	3.18	3.81	0.4	-	●		
	SNGG 120404R/L-C	12.70	4.76	5.16	0.4	-	●		
	120408R/L-C				0.8		●		

Insert Handed insert shows Right-Hand	Description	Dimension (mm)					Stock Grades	
							PVD Cermet	Cermet
		I.C.	Thickness	Hole	Corner -R (rε)	Relief Angle	PV7005	PV7010	TN6010
 Finishing	TNMG 160402GP 160404GP 160408GP	9.525	4.76	3.81	0.2 0.4 0.8	-		● ● ●	● ● ●
 Finishing-Medium	TNMG 160404HQ 160408HQ	9.525	4.76	3.81	0.4 0.8	-		● ●	● ●
 Finishing-Medium	TNMG 160404CQ 160408CQ	9.525	4.76	3.81	0.4 0.8	-		● ●	● ●
 Medium-Roughing	TNMG 160404PS 160408PS	9.525	4.76	3.81	0.4 0.8	-		● ●	● ●
 Roughing	TNMG 160404 160408	9.525	4.76	3.81	0.4 0.8	-	● ●	●	
 Low Carbon Steel Finishing	TNMG 160404XP 160408XP	9.525	4.76	3.81	0.4 0.8	-		● ●	
 Low Carbon Steel Medium Finishing	TNMG 160404XQ 160408XQ	9.525	4.76	3.81	0.4 0.8	-		● ●	
 Without Chipbreaker	TNGA 160404 160408	9.525	4.76	3.81	0.4 0.8	-	● ●		
 Finishing / Surface Roughness Oriented	TNGG 160402R/L-S 160404R/L-S 160408R/L-S	9.525	4.76	3.81	0.2 0.4 0.8	-			● ● ●
 '-B:Finishing-Medium '-C:Medium-Roughing	TNGG 160402R/L-B 160404R/L-B	9.525	4.76	3.81	0.2 0.4	-	●	R ●	● ●
	TNGG 160404R/L-C 160408R/L-C 160412R/L-C 160416R/L-C	9.525	4.76	3.81	0.4 0.8 1.2 1.6	-	● ● ● R	● ●	● ●
	TNGG 220404R/L-C 220408R/L-C	12.70	4.76	5.16	0.4 0.8	-	● ●		
 Finishing	VNMG 160402GP 160404GP 160408GP	9.525	4.76	3.81	0.2 0.4 0.8	-		● ● ●	● ● ●
 Finishing-Medium	VNMG 160404VF	9.525	4.76	3.81	0.4	-		●	●

Insert Handed insert shows Right-Hand	Description	Dimension (mm)					Stock Grades	
							PVD Cermet	Cermet
		I.C.	Thickness	Hole	Corner -R (rε)	Relief Angle	PV7005	PV7010	TN6010
 Finishing-Medium	VNMG 160404HQ 160408HQ	9.525	4.76	3.81	0.4 0.8	-		● ●	● ●
 Roughing	VNMG 160408	9.525	4.76	3.81	0.8	-	●		
 Medium cutting	VNGG 160402R/L 160404R/L 160408R/L	9.525	4.76	3.81	0.2 0.4 0.8	-			R R R
 Without Chipbreaker	VNGA 160404 160408	9.525	4.76	3.81	0.4 0.8	-	● ●		
 Finishing With Wiper Edge	WNMG 080404WP 080408WP	12.70	4.76	3.81	0.4 0.8	-		● ●	●
 Finishing-Medium With Wiper Edge	WNMG 080404WQ 080408WQ	12.70	4.76	3.81	0.4 0.8	-		● ●	●
 Finishing	WNMG 080404GP 080408GP	12.70	4.76	3.81	0.4 0.8	-		● ●	● ●
 Finishing-Medium	WNMG 080404HQ 080408HQ	12.70	4.76	3.81	0.4 0.8	-		● ●	● ●
 Finishing-Medium / Up facing	WNMG 080404CQ 080408CQ	12.70	4.76	3.81	0.4 0.8	-		● ●	● ●
 Medium-Roughing	WNMG 080404PS 080408PS	12.70	4.76	3.81	0.4 0.8	-		● ●	● ●
 Roughing	WNMG 080408	12.70	4.76	3.81	0.8	-	●		
 Low Carbon Steel Finishing	WNMG 080404XP 080408XP	12.70	4.76	3.81	0.4 0.8	-		● ●	
 Low Carbon Steel Medium Finishing	WNMG 080404XQ 080408XQ	12.70	4.76	3.81	0.4 0.8	-		● ●	

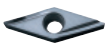
●:Standard Stock R:R-hand Only

Stock Items

Insert Handed insert shows Left-Hand	Description	Dimension (mm)					Stock Grades		
							PVD Cermet		Cermet
		I.C.	Thickness	Hole	Corner -R (rε)	Relief Angle	PV7005	PV7010	TN6010
 Finishing-Medium	CCMT 060202GK	6.35	2.38	2.8	0.2	7°		●	●
	CCMT 060204GK				0.4			●	●
	CCMT 09T302GK	9.525	3.97	4.4	0.2	7°		●	●
	CCMT 09T304GK				0.4			●	●
	CCMT 120404GK	12.70	4.76	5.5	0.4	7°		●	●
	CCMT 120408GK				0.8			●	●
 Finishing-Medium	CCMT 060202HQ	6.35	2.38	2.8	0.2	7°		●	●
	CCMT 060204HQ				0.4			●	●
	CCMT 09T302HQ	9.525	3.97	4.4	0.2	7°		●	●
	CCMT 09T304HQ				0.4			●	●
	CCMT 09T308HQ				0.8			●	●
 Finishing	CCGT 030102^{R}/$_{L}$-F	3.5	1.4	1.9	0.2	7°			L
	CCGT 030104^{R}/$_{L}$-F				0.4				L
	CCGT 040102^{R}/$_{L}$-F	4.3	1.8	2.3	0.2	7°			L
	CCGT 040104^{R}/$_{L}$-F				0.4				L
 Finishing	CPMT 080204GP	7.94	2.38	3.3	0.4	11°		●	●
	CPMT 090304GP	9.525	2.38	4.5	0.4	11°		●	●
	CPMT 090308GP				0.8			●	●
 Finishing-Medium	CPMH 080204HQ	7.94	2.38	3.5	0.4	11°		●	●
	CPMH 080208HQ				0.8			●	●
	CPMH 090304HQ	9.525	3.18	4.5	0.4	11°		●	●
	CPMH 090308HQ				0.8			●	●
 Medium cutting	CPMH 080204	7.94	2.38	3.5	0.4	11°	●	●	●
	CPMH 080208				0.8		●	●	●
	CPMH 090304	9.525	3.18	4.5	0.4	11°	●	●	●
	CPMH 090308				0.8		●	●	●
 Low Carbon Steel Finishing	CPMT 080204XP	7.94	2.38	3.3	0.4	11°		●	
	CPMT 090304XP	9.525	3.18	4.5	0.4	11°		●	
	CPMT 090308XP				0.8			●	
 Low Carbon Steel Finishing-Medium	CPMT 090304XQ	9.525	3.18	4.5	0.4	11°		●	
	090308XQ				0.8			●	
 Finishing	DCMT 070202GP	6.35	2.38	2.8	0.2	7°		●	●
	DCMT 070204GP				0.4			●	●
	DCMT 11T304GP	9.525	3.97	4.4	0.4	7°		●	●
	11T308GP				0.8			●	●
 Finishing-Medium	DCMT 070202GK	6.35	2.38	2.8	0.2	7°		●	●
	DCMT 070204GK				0.4			●	●
	DCMT 070208GK				0.8			●	●
	DCMT 11T302GK	9.525	3.97	4.4	0.2	7°		●	●
	DCMT 11T304GK				0.4			●	●
	DCMT 11T308GK				0.8			●	●

Insert Handed insert shows Left-Hand	Description	Dimension (mm)					Stock Grades		
							PVD Cermet		Cermet
		I.C.	Thickness	Hole	Corner -R (rε)	Relief Angle	PV7005	PV7010	TN6010
 Finishing-Medium	DCMT 070202HQ	6.35	2.38	2.8	0.2	7°		●	●
	DCMT 070204HQ				0.4			●	●
	DCMT 070208HQ				0.8			●	●
	DCMT 11T302HQ	9.525	3.97	4.4	0.2	7°		●	●
	DCMT 11T304HQ				0.4			●	●
	DCMT 11T308HQ				0.8			●	●
 Low Carbon Steel Finishing	DCMT 070204XP	6.35	2.38	2.8	0.4	7°		●	
	DCMT 11T302XP	9.525	3.97	4.4	0.2	7°		●	
	DCMT 11T304XP				0.4			●	
	DCMT 11T308XP				0.8			●	
 Low Carbon Steel Finishing-Medium	DCMT 11T304XQ	9.525	3.97	4.4	0.4	7°		●	
	DCMT 11T308XQ				0.8			●	
 Finishing-Medium	SCMT 09T304HQ	9.525	3.97	4.4	0.4	7°		●	●
	SCMT 09T308HQ				0.8			●	●
 Finishing	SPGR 090304^{R}/$_{L}$	9.525	3.18	4.5	0.4	11°	●		
	SPGR 120308^{R}/$_{L}$	12.7	3.18	5.5	0.8	11°	●		
 Without Chipbreaker	SPGN 090304	9.525	3.18	-	0.4	11°	●		
	090308				0.8		●		
	SPGN 120304	12.7	3.18	-	0.4	11°	●		
	120308				0.8		●		
 Finishing-Medium	TCMT 090202HQ	5.56	2.38	2.5	0.2	7°		●	●
	TCMT 090204HQ				0.4			●	●
	TCMT 110202HQ	6.35	2.38	2.8	0.2	7°		●	●
	TCMT 110204HQ				0.4			●	●
	TCMT 110208HQ				0.8			●	●
 Finishing	TPMT 090202GP	5.56	2.38	2.8	0.2	11°		●	●
	TPMT 090204GP				0.4			●	●
	TPMT 110304GP	6.35	3.18	3.3	0.4	11°		●	●
	TPMT 110308GP				0.8			●	●
	TPMT 160304GP	9.525	3.18	4.4	0.4	11°		●	●
 Finishing-Medium	TPMT 090202HQ	5.56	2.38	2.8	0.2	11°		●	●
	TPMT 090204HQ				0.4			●	●
	TPMT 110302HQ	6.35	3.18	3.3	0.2	11°		●	●
	TPMT 110304HQ				0.4			●	●
	TPMT 110308HQ				0.8			●	●
	TPMT 160304HQ	9.525	3.18	4.4	0.4	11°		●	●
	TPMT 160308HQ				0.8			●	●
 Low Carbon Steel Finishing	TPMT 090204XP	5.56	2.38	2.8	0.4	11°		●	
	TPMT 110304XP	6.35	3.18	3.3	0.4	11°		●	
	TPMT 110308XP				0.8			●	●
	TPMT 160304XP	9.525	3.18	4.4	0.4	11°		●	
	TPMT 160308XP				0.8			●	

Insert Handed insert shows Left-Hand	Description	Dimension (mm)					Stock Grades		
							PVD Cermet		Cermet
		I.C.	Thickness	Hole	Corner -R (rε)	Relief Angle	PV7005	PV7010	TN6010
 Low Carbon Steel Finishing-Medium	TPMT 110304XQ 110308XQ	6.35	3.18	3.3	0.4 0.8	11°		● ●	●
	TPMT 160304XQ 160308XQ	9.525	3.18	4.4	0.4 0.8	11°		● ●	
 Finishing	TPGH 080202R/L 080204R/L	4.76	2.38	2.3	0.2 0.4	11°	● ●		L L
	TPGH 090202R/L 090204R/L	5.56	2.38	3.0	0.2 0.4	11°	● ●		L L
	TPGH 110202R/L 110204R/L	6.35	2.38	3.5	0.2 0.4	11°	●		L L
	TPGH 110302R/L 110304R/L 110308R/L	6.35	3.18	3.3	0.2 0.4 0.8	11°	● ●		L L L
	TPGH 160302R/L 160304R/L 160308R/L	9.525	3.18	4.5	0.2 0.4 0.8	11°	● ●		L L
 Medium cutting	TPGH 110302R/L-H 110304R/L-H 110308R/L-H	6.35	3.18	3.3	0.2 0.4 0.8	11°			L L L
	TPGH 160304R/L-H	9.525	3.18	4.5	0.4	11°			L
 Without Chipbreaker	TPGB 090204	5.56	2.38	3.0	0.4	11°	●		
	TPGB 110304 110308	6.35	3.18	3.3	0.4 0.8	11°	● ●		
	TPGB 160304	9.525	3.18	4.5	0.4	11°	●		
 Finishing-Medium	TPMR 160304HQ 160308HQ	9.525	3.18	4.5	0.4 0.8	11°		● ●	● ●
 Medium cutting	TPMR 160304 160308	9.525	3.18	4.5	0.4 0.8	11°	● ●	●	●
 'L-A:Finishing 'L-B:Finishing-Medium 'L-C:Medium cutting	TPGR 110302R/L-A 110304R/L-A	6.35	3.18	-	0.2 0.4	11°	L L		
	TPGR 160302R/L-B 160304R/L-B 160308R/L-B	9.525	3.18	-	0.2 0.4 0.8	11°	L L L	L L	L L
	TPGR 160304R/L-C	9.525	3.18	-	0.4	11°		L	L
 Without Chipbreaker	TPGN 110304 110308	6.35	3.18	-	0.4 0.8	11°	● ●		
	TPGN 160304 160308	9.525	3.18	-	0.4 0.8	11°	● ●		

Insert Handed insert shows Left-Hand	Description	Dimension (mm)					Stock Grades		
							PVD Cermet		Cermet
		I.C.	Thickness	Hole	Corner -R (rε)	Relief Angle	PV7005	PV7010	TN6010
 Finishing	VBMT 110304GP	6.35	3.18	2.8	0.4	5°		●	●
	VBMT 160404GP 160408GP	9.525	4.76	4.4	0.4 0.8	5°		● ●	● ●
 Finishing	VBMT 110302VF 110304VF 110308VF	6.35	3.18	2.8	0.2 0.4 0.8	5°		● ● ●	● ● ●
	VBMT 160402VF 160404VF 160408VF 160412VF	9.525	4.76	4.4	0.2 0.4 0.8 1.2	5°		● ● ● ●	● ● ● ●
 Finishing-Medium	VBMT 110304HQ 110308HQ	6.35	3.18	2.8	0.4 0.8	5°		● ●	● ●
	VBMT 160404HQ 160408HQ 160412HQ	9.525	4.76	4.4	0.4 0.8 1.2	5°		● ● ●	● ● ●
 Finishing	VBGT 110302R/L-F	6.35	3.18	2.8	0.2	5°			●
 Finishing-Medium	VBGT 110302R/L-Y 110304R/L-Y	6.35	3.18	2.8	0.2 0.4	5°			● ●
	VBGT 160402R/L-Y 160404R/L-Y	9.525	4.76	4.4	0.2 0.4	5°			● ●
 Finishing	VCMT 080202VF 080204VF	4.76	2.38	2.3	0.2 0.4	7°		● ●	● ●
 Finishing-Medium	VCMT 080202HQ VCMT 080204HQ	4.76	2.38	2.3	0.2 0.4	7°		● ●	● ●
 Finishing	WBMT060102R/L-DP 060104R/L-DP	3.97	1.59	2.3	0.2 0.4	5°		L L	L L
	WBMT080202R/L-DP 080204R/L-DP	4.76	2.38	2.3	0.2 0.4	5°		L L	L L
 Finishing	WBGT060102R/L-F 060104R/L-F	3.97	1.59	2.3	0.2 0.4	5°			L L
	WBGT080202R/L-F 080204R/L-F	4.76	2.38	2.3	0.2 0.4	5°			L L
 Finishing-Medium	WPMT110204HQ	6.35	2.38	2.8	0.4	11°		●	●
	WPMT160304HQ 160308HQ	9.525	3.18	4.4	0.4 0.8	11°		● ●	● ●

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