

New combination of excellent cermet & exclusive chip breaker

**New**

# CN2000

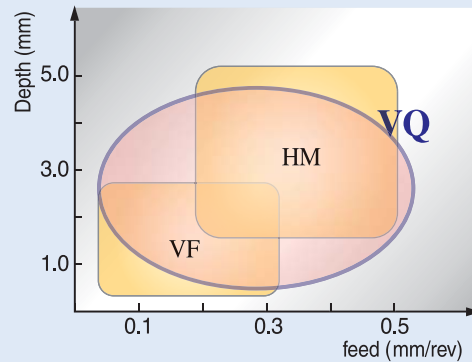
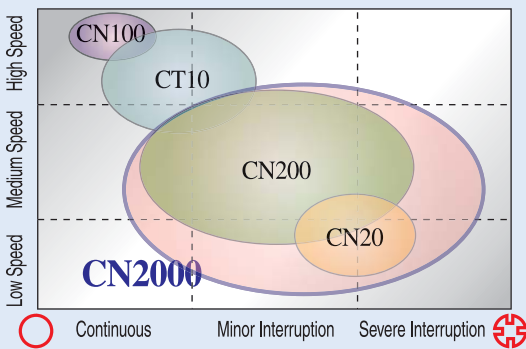


### Special Features of CN2000

- Prolonged tool life due to enhanced cratering resistance !!
- Chipping & fracture of cutting edge have been reduced due to "The Functionally Graded Zone" at the surface area of insert !!
- Consistence quality acquired through stablized manufacturing process !!

### New exclusive chip breaker for Cermet grade, VQ

- Tough cutting edge for Medium-Finishing has taken.
- Finishing chip breaker has taken for better chip control, especially for low depth of cut condition.
- Wavy cutting edge has taken to reduce cutting load.
- Contact area of insert with holder has been en-larged, especially at the corner radius area to get stable cutting.



### Recommended cutting conditions of CN2000

Cutting Conditions	Speed (V:m/min, sfm)					Feed (f:mm/rev, ipr)					Depth (d:mm, inch )				
	50	150	250	400	500	0.2	0.4	0.6	0.8	1.0	1	2	3	4	5
Work piece	160	500	820	1320	1650	0.008	0.016	0.024	0.032	0.040	0.04	0.08	0.12	0.16	0.20
Steel															

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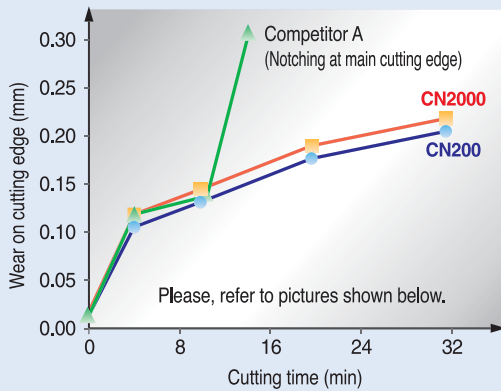
## Stock items of CN2000

OD turning			ID turning		
CNMG120404-VQ	VNMG160404-VQ	TNMG160404-VQ	CCMT060204-C25	DCMT11T304-HMP	CCMT060202-C25
CNMG120408-VQ	VNMG160408-VQ	TNMG160408-VQ	CCMT060204-HMP	SCMT09T304-C25	CCMT09T308-C25
DNMG150404-VQ	TNMX160402R	WNMG080404-VQ	CCMT09T304-C25	TCMT110204-C25	DCMT11T302-C25
DNMG150408-VQ	TNMX160404R	WNMG080408-VQ	CCMT09T304-HMP	TCMT110204-HMP	DCMT11T308-C25
DNMG150604-VQ	SNMG120404-VQ		CCMT09T308-HMP	TCMT110208-C25	SCMT09T308-C25
DNMG150608-VQ	SNMG120408-VQ		DCMT070204-C25	TCMT16T304-C25	VBMT160404-X29
			DCMT11T304-C25	VBMT160404	

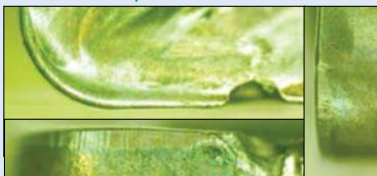
Note) Besides items listed above, order-made item is available. Stock items will be increased gradually.

## Cutting Performance of CN2000

- Work piece : S45C (Medium carbon steel)
- Insert : CNMG120408-VQ (CNMG432)
- V=200m/min (660sfm), f=0.3mm/rev (0.012ipr), d=1.5mm (0.06inch), dry



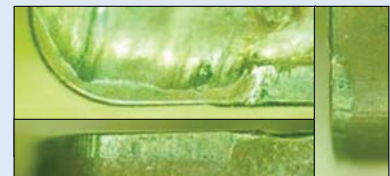
Competitor A



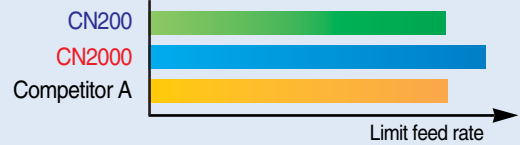
CN2000



CN200



- Work piece : S45C - 4grooves
- Insert : CNMG120408-VQ (CNMG432)
- V=100m/min (330sfm), f=Variable, d=1.5mm (0.06inch), dry



- Work piece : S45C - 4grooves
- Insert : CNMG120408-VQ (CNMG432)
- V=200m/min (660sfm), f=Variable, d=1.5mm (0.06inch), dry



### ➤ CN2000

- CN2000 can last longer than CN200 due to the improved cratering resistance with similar level of wear resistance on main cutting edge.
- CN2000 can provide excellent cutting performance especially at the severe interrupted condition due to the reinforced cutting edge strength with improved notching resistance.

## User Test Examples of CN2000

Insert	CNMG120408-VQ CNMG432-VQ	
Work piece	S10C (low carbon steel)	
V	180 ~ 200 m/min (590~660 sfm)	
f	0.23 mm/rev (0.010 ipr)	
D	0.5 mm (0.02 inch)	
Coolant	Wet	
	CN2000 140pcs/edge P20 of A maker 100pcs/edge	

Insert	CNMG120408-VQ CNMG432-VQ	
Work piece	S55C - 4grooves (high carbon steel)	
V	200 m/min (660 sfm)	
f	0.15 mm/rev (0.006 ipr)	
D	1.5 mm (0.06 inch)	
Coolant	Wet	
	CN2000 146pcs/edge P20 of A maker 70pcs/edge	



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