ZCC Cutting Tools
Europe GmbH

Main Catalogue

Version 2023

2023

– EN –

Welcome to ZCC Cutting Tools Europe,

and welcome to the latest version of our main catalogue. The entire ZCC Cutting Tools team and I are pleased to present to you our evolving portfolio of products and solutions for optimising the quality and profitability of your production.

In combination with our Product Innovations Catalogues, which are published twice a year, this main catalogue aims at providing you with an optimal overview of our range of services and ZCC-CT's latest innovations.

'Your partner – your value' has been our claim and promise to our customers from the outset, and it's one we will continue to live up to. On this note, our offer goes far beyond the contents of this catalogue. In addition to the development and testing of your customer-specific special solutions in the Test and Demonstration Centre at our European headquarters in Düsseldorf, we also offer comprehensive services such as tool management and tool data provision, tool reconditioning and customer training according to your requirements. Feel free to contact us at any time – we are there for you.

This main catalogue addresses three key application areas. In part A right next, you will find turning tools; part B introduces you to our milling tools; and in part C is all about our drilling tools. ZCC-CT provides a separate catalogue each for tooling systems and boring tools. Please feel free to get in touch with your personal contacts or our internal sales department if you require additional catalogues and supplementary information.

We thank you for your trust and look forward to an excellent partnership.
Your team at ZCC Cutting Tools Europe is always there to support you in a spirit of collaboration.

Quanliang Zhao

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Member of Minmetals Group

Special tools – fine-tuned to your specific application

Special applications call for special solutions optimised to the task. Special tools are able to deliver real benefits from a commercial, technical or process perspective over standard tool solutions in all industry sectors. We work with you to assess the potential in each individual case, taking into account the general conditions available at your company ZCC Cutting Tools Europe's R&D department then develops a custom solution for you at our EU headquarters in Düsseldorf to keep your machining costs as low as possible.

Why opt for special tools from ZCC Cutting Tools?

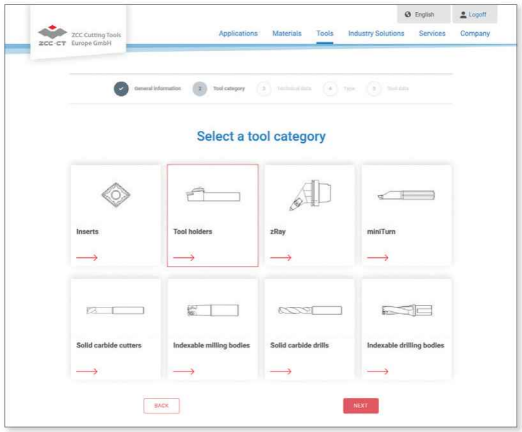
We develop customised tool solutions for you for a wide range of machining operations. We work closely with you from day one to design tools optimised to meet your needs and priorities. From design and production to logistics, we draw on many years of experience to offer a full range of expert services. Take advantage of our expertise to ensure the long-term success of your company.

Example: Special tool holder

Example: Special solid carbide step drill

The easy way to order your custom-made special tool

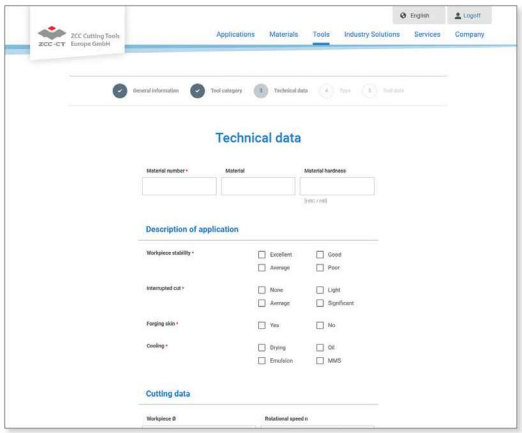
Are there specific applications at your company where having custom tools tailored to your unique needs would deliver real benefits both in terms of logistics and at a technical and commercial level? ZCC Cutting Tools is there to advise and assist you during the planning, development and ordering process. Use our new online tool to request a special tool and get your personal quotation in just a few short steps (www.zccct-europe.com).



'Online tool for special tools' launch page where you can select the tool category

Selecting the tool category

Scan the QR code on this page to go directly to the launch page of our online tool where you can request the special tool you need. You can begin by selecting the tool category you need. It's that easy.



Define the relevant tool parameters

Defining the tool parameters

You are now guided step by step through the process. You can also securely upload your drawings, diagrams and 3D models (where available).

The fast and direct way to order your special tool from ZCC Cutting Tools Europe.

Now go directly to the new **special tool form** on our website and get started.

ZCC Cutting Tools Headquarters, Zhuzhou, China

Production of tool holders

Sintering of inserts

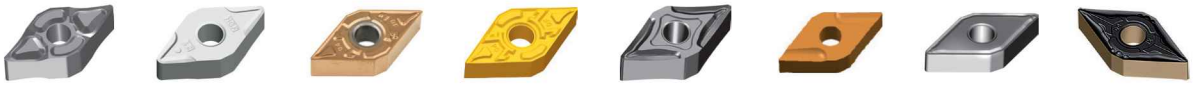
GENERAL TURNING

General turning

Carbide and cermet inserts

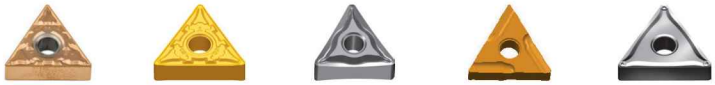
Double sided, negative – Finishing

CNEG-NF	CNMG-ADF	CNMG-DF	CNMG-EF	CNMG-SF	CNMG-XF	
12	12	09 12	09 12	09 12	12	Edge length
A52	A51	A51	A51	A51	A52	Page



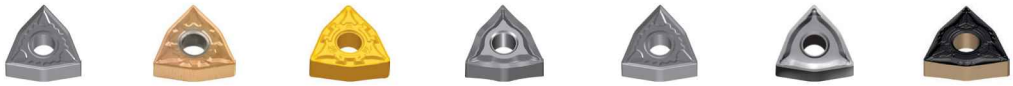
DNEG-NF	DNEG-NGF	DNMG-ADF	DNMG-DF	DNMG-EF	DNMG-FM	DNMG-SF	DNMG-XF	
15	15	15	11 15	11 15	15	11 15	11 15	Edge length
A66	A66	A62	A62	A66	A66	A62	A63	Page

SNMG-ADF	SNMG-DF	SNMG-EF	SNMG-SF	SNMG-XF	
12	12	09 12 15	09 12	12	Edge length
A71	A71	A72	A71	A73	Page



TNMG-ADF	TNMG-DF	TNMG-EF	TNMG-FM	TNMG-SF	
16	16 22	11 16 22	16	16	Edge length
A87	A87	A89	A90	A88	Page

VNEG-NF	VNEG-NGF	VNMG-ADF	VNMG-DF	VNMG-EF	VNMG-SF	VNMG-XF	
16	16	16	16	16	16	16	Edge length
A100	A101	A100	A100	A100	A101	A102	Page



WNEG-NF	WNMG-ADF	WNMG-DF	WNMG-EF	WNMG-NF	WNMG-SF	WNMG-XF	
08	08	06 08	06 08	06	06 08	06 08	Edge length
A106	A105	A105	A106	A106	A105	A107	Page

Double sided, negative, Wiper – Finishing

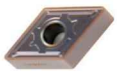
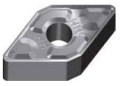
CNMG-WG	DNMX-WG	TNMX-WG	WNMG-WG	
12	11 15	16	08	Edge length
A51	A62	A87	A106	Page

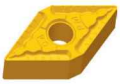
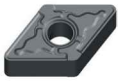
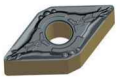
Carbide and cermet inserts

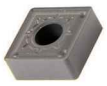
Double sided, negative – Medium machining

					
CNMG	**CNMG-DM**	**CNMG-EG**	**CNMG-EM**	**CNMG-NM**	
12 16 19	09 12 16 19	12	12 16	12	Edge length
A61	A54	A54	A54	A56	Page

					
CNMG-PM	**CNMG-TC**	**CNMG-TK**	**CNMG-XM**	**CNMG-ZM**	
09 12 16 19	12 16	12	12 16 19	12	Edge length
A53	A56	A56	A53	A55	Page

					
DNMG-DM	**DNMG-EG**	**DNMG-EM**	**DNMG-NM**		
11 15	15	11 15	15		Edge length
A64	A67	A67	A67		Page

					
DNMG-PM	**DNMG-TC**	**DNMG-TK**	**DNMG-XM**	**DNMG-ZM**	
11 15	15	15	11 15	15	Edge length
A64	A67	A68	A63	A65	Page

					
SNMG	**SNMG-DM**	**SNMG-EG**	**SNMG-EM**	**SNMG-NM**	
12 25	09 12 15 19	12	12 15	12	Edge length
A83	A75	A75	A76	A77	Page

					
SNMG-PM	**SNMG-TC**	**SNMG-TK**	**SNMG-XM**		
09 12 15 19	12 15	12	12 15 19		Edge length
A74	A76	A76	A73		Page

								
TNMG	**TNMG-DM**	**TNMG-EG**	**TNMG-EM**	**TNMG-PM**	**TNMG-TC**	**TNMG-XM**	**TNMG-ZM**	
16 22 27 33	11 16 22	16	16 22	11 16 22	16 22	16 22	16	Edge length
A98	A91	A93	A93	A91	A93	A90	A92	Page

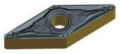
Carbide and cermet inserts

Double sided, negative – Medium machining




VNMG	VNMG-DM	VNMG-EM	VNMG-NM	
16	16	16	16	Edge length
A103	A103	A103	A103	Page




VNMG-PM	VNMG-SNR	VNMG-TC	VNMG-XM	VNMG-ZM	
16	16	16	16	16	Edge length
A104	A104	A104	A102	A104	Page




WNMG-DM	WNMG-EG	WNMG-EM	WNMG-NM	
06 08	08	06 08	08	Edge length
A108	A108	A108	A110	Page





WNMG-PM	WNMG-TC	WNMG-TK	WNMG-XM	WNMG-ZM	
06 08	08	08	06 08	08	Edge length
A109	A110	A110	A107	A109	Page

RNMG	
12	Edge length
A112	Page

Double sided, negative – Medium machining to roughing






CNMA	DNMA	SNMA	SNUN	TNMA	WNMA	
12 16 19	15	12 15 19	12 19	16 22	06 08	Edge length
A61	A69	A84	A86	A99	A111	Page

Double sided, negative – Roughing






CNMG-DR	CNMG-ER	CNMG-SNR	DNMG-DR	DNMG-ER	DNMG-SNR	
12 16 19 25	12 16 19	12 16 19	15	15	15	Edge length
A57	A58	A57	A68	A69	A68	Page

Carbide and cermet inserts

Double sided, negative – Roughing

SNMG-DR	SNMG-ER	SNMG-SNR	TNMG-DR	TNMG-ER	TNMG-SNR	
12 15 19 25	12 15 19	12	16 22 27	16 22	16	Edge length
A77	A78	A78	A94	A95	A92	Page

WNMG-DR	WNMG-SNR					
06 08	08					Edge length
A111	A109					Page

Single sided, negative – Roughing

CNMM	CNMM-DR	CNMM-ER	CNMM-HDR	CNMM-HPR	CNMM-LR	
12 19	12 16 19 25	25	12 16 19 25	19 25	12 16 19 25	Edge length
A60	A58	A58	A60	A60	A59	Page

DNMM-DR	DNMM-ER	DNMM-HDR	DNMM-LR			
15	15	15	15			Edge length
A70	A70	A70	A70			Page

SNMM	SNMM-DR	SNMM-ER	SNMM-HDR	SNMM-HPR	SNMM-LR	
19 25	15 19 25	25	12 15 19 25	19 25	12 15 19 25	Edge length
A85	A79	A79	A81	A82	A80	Page

TNMM	TNMM-DR	TNMM-HDR	TNMM-LR			
16 22 27	16 22 27	22 27	16			Edge length
A99	A95	A97	A95			Page

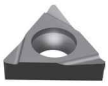
Special form – Finishing

CNMG-RF	CNMM-RF	CNMM-RH	KNUX	LNUX-RF	LNUX-RH	
19	19	19	16	19 30	19 30	Edge length
A114	A114	A114	A113	A115	A115	Page

Carbide and cermet inserts

Positive – Fine-finishing

CCGT-SF	CCGT-USF	CPGT-SF	DCGT-SF	DPGT-SF	
06 09	06 09	06 09	07 11	07 11	Edge length
A116	A116	A124	A125	A131	Page



TBGH	TCGT-SF	TPGH	TPGT-SF	
06	06 09 11	09 11	09 11	Edge length
A139	A140	A146	A147	Page

VBGT-SF	VCGT-SF	
11	11 16	Edge length
A150	A153	Page

Positive – Finishing

CCMT-AHF	CCMT-EF	CCMT-HF	CCMT-XF	CPMT-HF	
06 09 12	06 09 12	06 09 12	06 09	06	Edge length
A117	A118	A117	A118	A124	Page

DCMT-AHF	DCMT-EF	DCMT-HF	DCMT-XF	SCMT-AHF	SCMT-EF	SCMT-HF	SCMT-XF	
07 11	07 11	07 11	07 11	09	09	09	09	Edge length
A125	A126	A126	A126	A134	A134	A135	A134	Page

TCMT-AHF	TCMT-EF	TCMT-HF	TCMT-XF	
11 16	09 11 16	09 11 16	09 11 16	Edge length
A141	A142	A141	A141	Page

VBET-NF	VBET-NGF	VBMT-AHF	VBMT-EF	VBMT-HF	VBMT-XF	
16	16	16	11 16	11	11 16	Edge length
A149	A151	A148	A148	A149	A148	Page

Carbide and cermet inserts

Positive – Finishing

VCGT	VCGT-HF	VCGT-NF	VCMT-EF	VCMT-XF	
13	11	16	16	11 16	Edge length
A153	A153	A153	A156	A156	Page

Positive – Medium machining

CCMT-EM	CCMT-HM	CCMT-XM	CCMW	CPGW	CPMT-HM	
06 09 12	06 09 12	09 12	09 12	06	09	Edge length
A119	A120	A119	A121	A124	A124	Page

DCMT-EM	DCMT-HM	DCMT-XM	DCMW	
07 11	07 11	11	11	Edge length
A127	A128	A127	A129	Page

SCMT-EM	SCMT-HM	SPMW	SCMT-XM	
09 12	09 12	09 12	09 12	Edge length
A134	A135	A138	A135	Page

TCMT	TCMT-EM	TCMT-HM	TCMW	TCMT-XM	
22	09 11 16	09 11 16	16	16	Edge length
A144	A142	A143	A143	A142	Page

VBMT-EM	VBMT-HM	VBMT-XM	VCMT-EM	VCMT-XM	
11 16	16	16	16	16	Edge length
A151	A151	A151	A156	A156	Page

Positive – Roughing

CCMT-HR	CCMT-TC	DCMT-HR	RCMT · RCGT	RCMX	RCMX-PV	SCMT-HR	TCMT-HR	
06 09 12	06 09 12	11	08 10 12 16 20 25	08 10 12 16 20 25 32	32	09 12	09 11 16 22	Edge length
A121	A121	A129	A132	A133	A133	A136	A143	Page

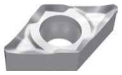
Carbide and cermet inserts

Positive – Roughing


VBMT-HR	VBMT-SNR	
16	16	Edge length
A152	A152	Page

Positive – Aluminium machining




CCGX-LC	CCGX-LH	DCGX-LC	DCGX-LH	RCGX-LH	
06 09 12	06 09 12	07 11	07 11	08 12	Edge length
A122	A122	A129	A130	A132	Page



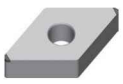



SCGX-LC	SCGX-LH	TCGX-LC	TCGX-LH	VCGX-LC	VCGX-LH	
09 12	09 12	09 11 16	09 11 16	11 16 22	11 16 22	Edge length
A136	A137	A145	A145	A154	A155	Page

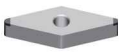
PCBN & PCD

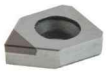
Negative





CNGA-2	CNGA-2W	DNGA-2	SNGA-4	TNGA-3	
12	12	15	12	16	Edge length
A160	A160	A161	A162	A163	Page





VNGA-2	WNGA-3	ZNEX	
16	08	04	Edge length
A164	A165	A166	Page







CNGN	CNGN-M	RNGN	SNGN	SNGN-M	WNGN	WNGN-M	
09 12	12	09 12	12	12	08	08	Edge length
A173	A173	A174	A175	A175	A176	A176	Page

PCBN & PCD

Negative

CNGA	DNGA	VNGA	
12	15	16	Edge length
A177	A178	A179	Page

Positive

CCGW-2	DCGW-2	TCGW-3	VBGW-2	VCGW-2	
06 09 12	07 11	11 16	16	11 16	Edge length
A167	A169	A170	A171	A172	Page

CCGT	CCGT-1MED	CCGT-L	CCGW	CCGW-L	
06 09 12	06 09	09 12	06 09 12	06 09 12	Edge length
A180	A180	A181	A182	A183	Page

DCGT	DCGT-1MED	DCGW	
07 11	07 11	07 11	Edge length
A184	A185	A186	Page

TCGT	TCGT-1MED	TCGT-L	TCGW	TCGW-L	
11 16	11 16	11 16	11 16	11 16	Edge length
A187	A187	A188	A189	A190	Page

VBGT	VBGT-1MED	VBGW	VCGT	VCGT-1MED	VCGW	
11 16	16	11 16	11 16	11 16	11 16 22	Edge length
A191	A191	A192	A193	A194	A195	Page

Ceramic inserts

Negative

CNGA	CNGN	CNGX	DNGA	DNGN	DNGX	
12 16	12 16	12	15	15	15	Edge length
A200	A201	A203	A204	A205	A206	Page

Ceramic inserts

Negative

RNGA	RNGN	SNGA	SNGN	SNGX	TNGA	TNGN	
12	06 09 12 15 19 25	12	12 15 19	12	16 22	16 22	Edge length
A207	A208	A210	A211	A213	A214	A215	Page

VNGA	WNGA		
16	08		Edge length
A216	A217		Page

Positive

RCGX	RPGN	RPGX	TPGN	
06 09 12 19	12	09	11 16	Edge length
A218	A219	A220	A221	Page

External tool holders

Holder with double clamping

							
DCLNR/L	**DDJNR/L**	**DSBNR/L**	**DTGNR/L**	**DVJNR/L**	**DVVNN**	**DWLNR/L**	
95°	93°	75°	90°	93°	72.5°	95°	Angle
A230	A231	A232	A233	A235	A234	A236	Page

Holder with knee lever clamping

								
PCBNR/L	**PCLNR/L**	**PDJNR/L**	**PDNNR/L**	**PSBNR/L**	**PSDNN**	**PSKNR/L**	**PSSNR/L**	
75°	95°	93°	63°	75°	45°	75°	45°	Angle
A237	A238	A240	A241	A242	A244	A245	A246	Page

				
PTFNR/L	**PTGNR/L**	**PTTNR/L**	**PWLNR/L**	
91°	90°	60°	95°	Angle
A247	A249	A248	A251	Page

Holder with multi clamping

								
MCBNR/L	**MCLNR/L**	**MDJNR/L**	**MDPNN**	**MRDNN**	**MRGNR/L**	**MSBNR/L**	**MSDNN**	
75°	95°	93°	62.5°	45°	90°	75°	45°	Angle
A252	A253	A254	A255	A267	A268	A256	A259	Page

								
MSKNR/L	**MSRNR/L**	**MTFNR/L**	**MTGNR/L**	**MTJNR/L**	**MTJNR/L-Z**	**MVJNR/L**	**MVVNN**	
75°	75°	90°	90°	93°	93°	93°	72.5°	Angle
A258	A257	A263	A260	A261	A262	A265	A264	Page

								
MWLNR/L								
95°								Angle
A266								Page

External tool holders

Holder with screw clamping

SCACR/L	SCLCR/L	SDACR/L	SDJCR/L	SDNCN	SRDCN	SRGCR/L	SSBCR/L	
90°	95°	90°	93°	63°	45°	90°	75°	Angle
A269	A270	A271	A272	A273	A288	A289	A279	Page

SSDCN	SSKCR/L	SSSCR/L	STACR/L	STFCR/L	STGCR/L	STTCR/L	SVABR/L	
45°	75°	45°	90°	90°	90°	60°	90°	Angle
A280	A281	A282	A283	A284	A285	A286	A275	Page

SVJBR/L	SVJCR/L	SVVBN	SVVCN	SWACR/L				
93°	93°	72.5°	72.5°	90°				Angle
A274	A278	A276	A277	A287				Page

Holder with top clamping

CKJNR/L	CKNNR/L							
93°	63°							Angle
A290	A291							Page

Tool holder for ceramic inserts and solid CBN inserts

CCLNR/L	CDJNR/L	CRDNN	CSDNN	CSKNR/L	CSRNR/L	CTJNR/L	CTUNR/L	
95°	93°	45°	45°	75°	75°	93°	93°	Angle
A292	A294	A298	A299	A296	A297	A293	A295	Page

JCLNR/L	JDJNR/L	JSDNN						
95°	93°	45°						Angle
A300	A301	A302						Page

External tool holders

Swiss turning

SCACR/L-SC	SCLCR/L-SC	SDACR/L-SC	SDHCR/L-SC	SDJCR/L-SC	SDNCN-SC	SVACR/L-SC	SVJCR/L-SC	
90°	95°	90°	107.5°	93°	63°	90°	93°	Angle
A306	A307	A308	A309	A310	A311	A312	A313	Page

Rail applications

RW-PCLNR/L	RW-PLANR/L	RW-PLFNR/L	
90°	90°	90°	Angle
A318	A316	A317	Page

Boring bars

Steel boring bars with knee lever clamping –

A***-PCLNR/L	A***-PDSNR/L	A***-PDUNR/L	A***-PSKNR/L	A***-PTFNR/L	
95°	45°	93°	75°	90°	Angle
A324	A326	A327	A329	A330	Page

S***-PCLNR/L	S***-PDSNR/L	S***-PDUNR/L	S***-PSKNR/L	S***-PTFNR/L	S***-PWLNR/L	
95°	45°	93°	75°	90°	95°	Angle
A324	A326	A327	A329	A330	A332	Page

Steel boring bars with screw clamping –

A***-SCLCR/L	A***-SDQCR/L	A***-SDUCR/L	A***-SDZCR/L	
95°	107.5°	93°	95°	Angle
A334	A336	A337	A338	Page

S***-SCFCR/L	S***-SCLCR/L	S***-SCLPR/L	S***-SDQCR/L	S***-SDQPR/L	S***-SDUCR/L	S***-SDUPR/L	S***-SDZCR/L	
90°	95°	95°	107.5°	107.5°	93°	93°	95°	Angle
A352	A334	A348	A336	A349	A337	A350	A338	Page

Boring bars

Steel boring bars with screw clamping –

A***-SSKCR/L	A***-STFCR/L	A***-SVQBR/L	A***-SVUBR/L	
75°	90°	107.5°	93°	Angle
A339	A341	A345	A346	Page

S***-SSKCR/L	S***-STFCR/L	S***-STUPR/L	S***-SVQBR/L	S***-SVQCR/L	S***-SVUBR/L	S***-SVUCR/L	
75°	90°	93°	107.5°	107.5°	93°	93°	Angle
A339	A341	A351	A345	A343	A346	A344	Page

Solid carbide boring bars with screw clamping –

C***-SCLPR/L	C***-SDQPR/L	C***-SDUPR/L	C***-STUPR/L	C***-SVQCR/L	C***-SVUCR/L	C***-SZLNR/L	
A354	A356	A358	A360	A363	A364	A365	Page

E***-SCLCR/L	E***-SCLPR/L	E***-SDQCR/L	E***-SDUCR/L	E***-STFCR/L	E***-STFPR/L	E***-SVUCR/L	
95°	95°	107.5°	93°	90°	90°	93°	Angle
A355	A354	A357	A359	A361	A362	A364	Page

Notes

Negative inserts

Finishing

XF P

Double-sided chip breaker for finishing operations in the P application field. Superb chip control with low cutting forces.

RF P

Double-sided chip breaker for applications from finishing to medium machining.

SF P M K

Double sided chip breaker in combination with cermet grades. Geometry with high sharpness for improved chip control and great surface quality. Ideal for machining with small cutting depths and feed rates.

DF P K

Double sided chip breaker with good chip control. Suitable for finishing and medium machining of steel and cast iron.

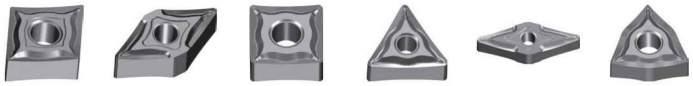
ADF P M

Ground, double sided chip breaker with good chip control. Wide range of application due to excellent balance of sharpness and cutting edge stability.

Negative inserts

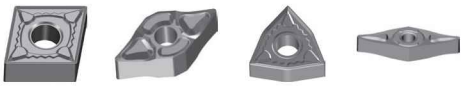
Finishing

EF M S



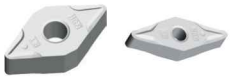
Double sided chip breaker with sharp cutting edge and large rake angle for finishing of stainless steel.

NF S M



Double sided chip breaker with ground cutting edge and large rake angle for finishing. E-tolerance for high repeatability.

NGF S M



Double sided chip breaker with ground cutting edge and large rake angle for finishing. E-tolerance for high repeatability.

Wiper

WG P M K

Double sided chip breaker with wiper geometry. Allows to double the feed rate and improves the surface quality.

Medium machining

XM P

Double-sided chip breaker for medium machining operations in the P application field. Superb chip control at high and low feed rates.

Negative inserts

Medium machining

DM P K

Double sided chip breaker for medium machining. Wide range of application due to excellent balance of sharpness and cutting edge stability.

ZM P

Double sided chip breaker for medium machining. Wide range of application due to stable cutting edge and large rake angle. Very suitable for machining of steel.

PM P K

Double sided chip breaker for medium machining. Wide range of application in steel and cast iron.

TC K P

Double sided chip breaker with surrounding cutting edge. Process reliable machining due to highest cutting edge stability.

TK K

Double-sided chip breaker for medium machining operations in the K application field. Optimum combination of impact resistance and cutting edge sharpness.

Negative inserts

Medium machining

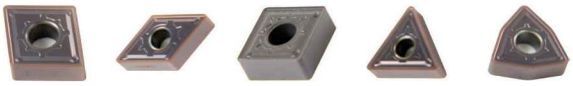
NM S M

Double sided chip breaker with ground cutting edge and large rake angle for medium machining of heat-resistant materials.

EM M S

Double sided chip breaker with sharp cutting edge and large rake angle. Process reliable medium machining of stainless steel.

EG M S



Double sided chip breaker with grinded cutting edge and large rake angle. Wide range of application for medium machining of stainless steel.

Basic P K

Double sided chip breaker with surrounding cutting edge for universal machining of steel and cast iron.

Roughing

DR double sided P K

Double sided chip breaker with positive rake angle and stable cutting edge for light to medium roughing of steel and cast iron.

Negative inserts

Roughing

DR single sided P K

Single sided chipbreaker with positive rake angle and stable cutting edge for light to medium roughing of steel and cast iron.

RH P

Double-sided chip breaker for applications from medium machining to roughing.

LR P M

Single sided chip breaker with curved cutting edge and unique bumpy geometry. Low cutting pressure for process reliable machining. Light roughing of steel and stainless steel.

ER double sided M S

Double sided chip breaker with large rake angle for low cutting forces. Suitable for roughing of stainless steel.

ER single sided M S

Single sided chip breaker with large rake angle for low cutting forces. Suitable for roughing of stainless steel.

Negative inserts

Roughing

HDR P K

Single sided chip breaker with high cutting edge stability and deformation resistance. Excellent for roughing with high cutting depths in steel and stainless steel.

HPR P K

Single sided chip breaker with high cutting edge stability and large chip space. Excellent for heavy roughing in steel and cast iron.

Flat K

Double sided insert without chip breaker. Stable cutting edge design, due to missing microgeometry. Excellent for roughing in cast iron.

SNR M S N

Double sided chip breaker for roughing. Wide range of application due to excellent balance of sharpness and cutting edge stability.

PCBN & PCD inserts

Flat N H

With brazed CBN or PCD cutting edge. For machining of hardened steel (CBN) or non-ferrous metals (PCD).

Negative inserts

PCBN & PCD inserts

Flat H K

Solid CBN insert for machining od steel and cast iron.

Ceramic inserts

Flat K H

Ceramic inserts for machining of low hardened steel and cast iron.

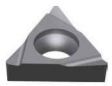
Positive inserts

Fine-finishing

USF P M

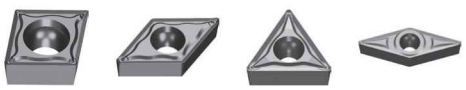
Single sided chip breaker for fine finishing. Sharp cutting edge with large hollow flute, excellently suitable for machining small work pieces. G-tolerance for high repeatability.

R/L P M



Single sided chip breaker for fine finishing. Excellent for high surface quality. G-tolerance for high repeatability.

SF P M



Single sided chip breaker in combination with cermet grades. Geometry with high sharpness for improved chip control and great surface quality. Ideal for machining with small cutting depths and feed rates.

Positive inserts

Finishing

XF P

Single-sided chip breaker for finishing operations in the P application field. Superb chip control with low cutting forces.

HF P K

Single sided chip breaker with good chip control. Suitable for finishing to medium machining of steel and cast iron.

AHF M S P

Ground, single sided chip breaker with good chip control. Wide range of application due to excellent balance of sharpness and cutting edge stability.

EF M S

Single sided chip breaker with sharp cutting edge and large rake angle for finishing of stainless steel.

NF M S

Single sided chip breaker with ground cutting edge and large rake angle for finishing. E-tolerance for high repeatability.

Positive inserts

Finishing

NGF M S


Single sided chip breaker with ground cutting edge and large rake angle for finishing. E-tolerance for high repeatability.

Medium machining

XM P


Single-sided chip breaker for medium machining operations in the P application field. Superb chip control at high and low feed rates.

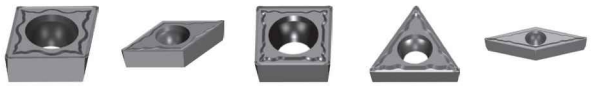
TC K P


Single sided chip breaker with encircling cutting edge. Process reliable machining due to highest cutting edge stability.

HM P K


Single sided chip breaker for medium machining. Wide range of application due to excellent balance of sharpness and cutting edge stability.

EM M S

Single sided chip breaker with sharp cutting edge and large rake angle. Process reliable medium machining of stainless steel.

Positive inserts

Medium machining

Basic P K

Single sided chip breaker with encircling cutting edge for universal machining of steel and cast iron.

Roughing

Flat K

Single sided insert without chip breaker. Stable cutting edge design due to missing microgeometry. Excellent for roughing in cast iron.

HR P K

Single sided chip breaker with positive rake angle and stable cutting edge for light to medium roughing of steel and cast iron.

SNR S M

Single sided chip breaker for roughing. Wide range of application due to excellent balance of sharpness and cutting edge stability.

Basic P K

Single sided chip breaker with encircling cutting edge for universal machining of steel and cast iron.

Positive inserts

Aluminium machining

LC N

Single sided chip breaker with excellent cutting edge design. Sharp cutting edge with positive rake angle. G-tolerance for high repeatability.

LH N

Single sided chipbreaker for machining of cast aluminium alloys. Sharp cutting edge with positive rake angle. G-tolerance for high repeatability.

PCBN & PCD inserts

Flat N H

With brazed CBN or PCD cutting edge. For machining of hardened steel (CBN) or non-ferrous metals (PCD).

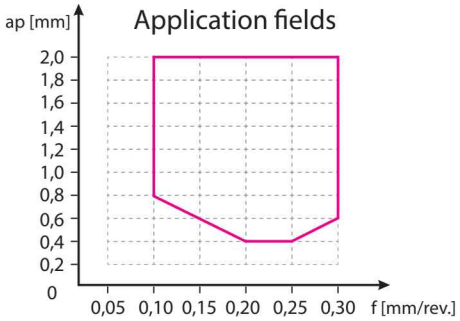
MED N

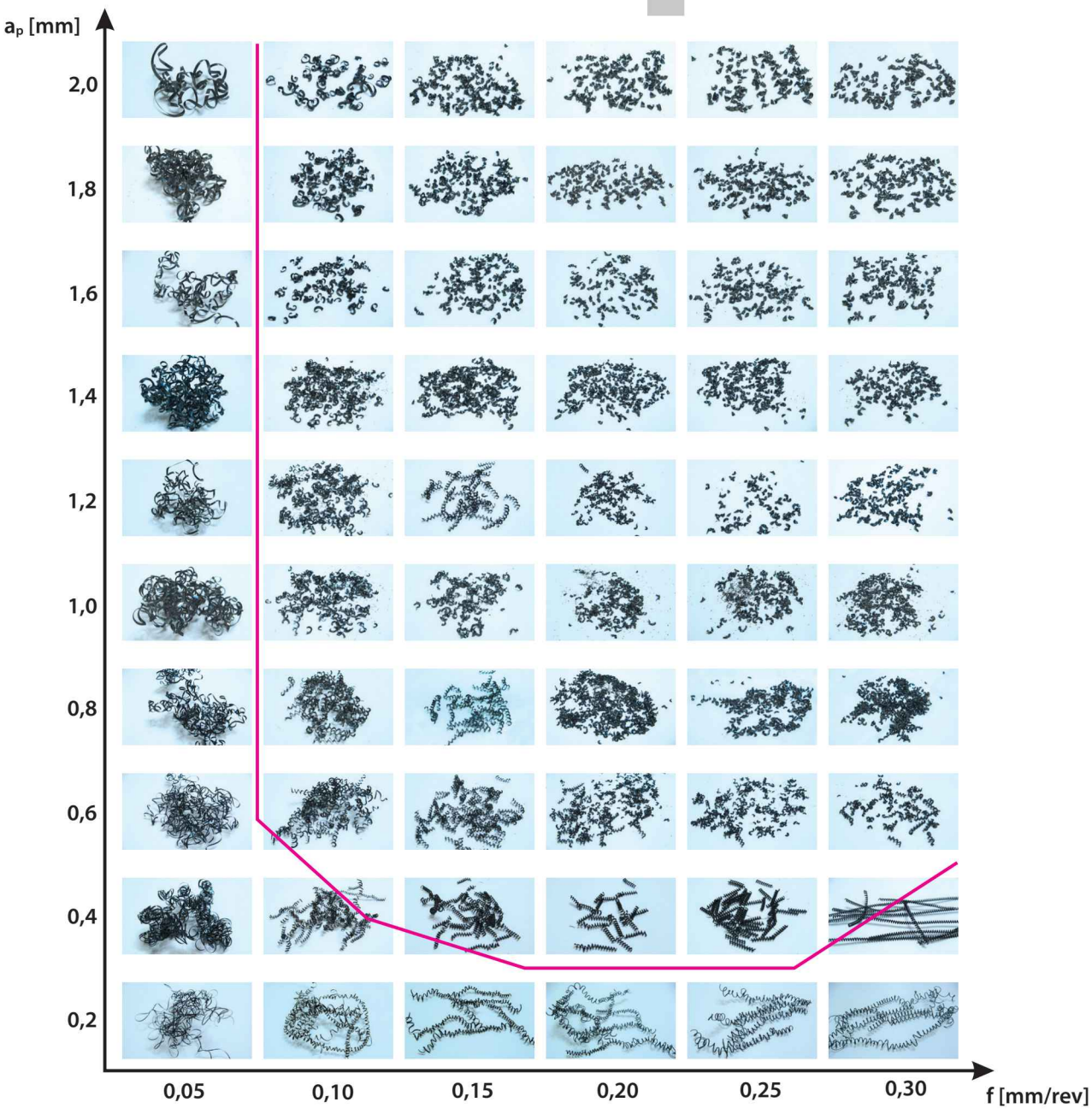
Laser-cut chip breaker for finishing and medium machining operations.

General turning

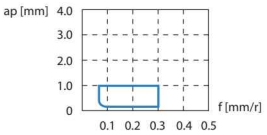
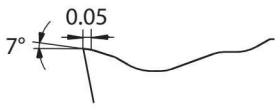
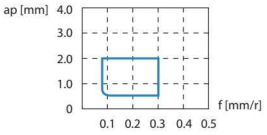
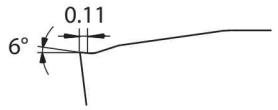
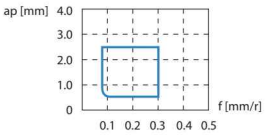
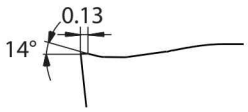
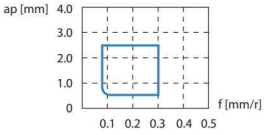
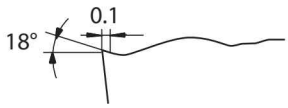
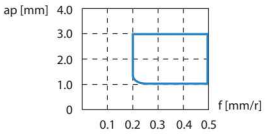
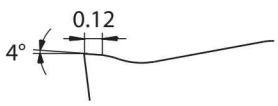
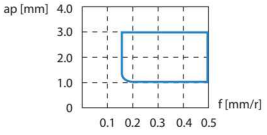
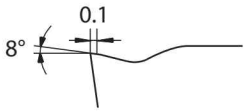
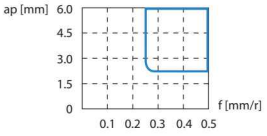
Application fields of chip breakers

Example
Insert: CNMG120408-DF
Holder: PCLNL2525M12
Material: C45 steel
V_C : 200 m/min

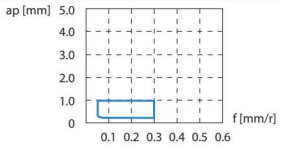
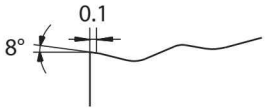
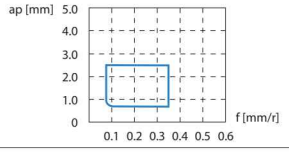
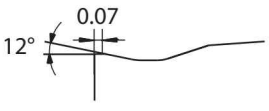
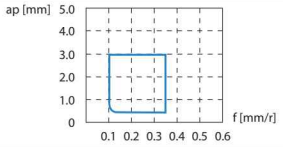
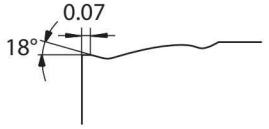
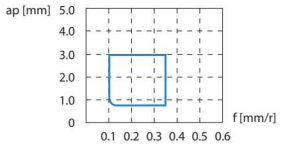
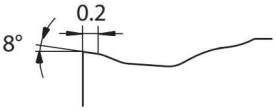
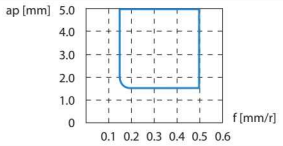
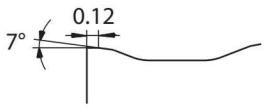
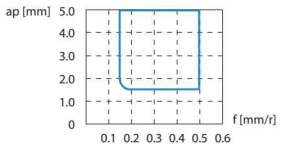
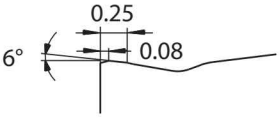
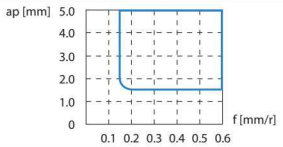
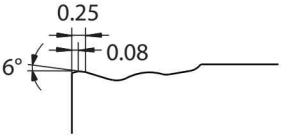
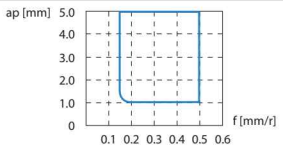
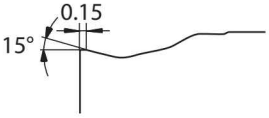
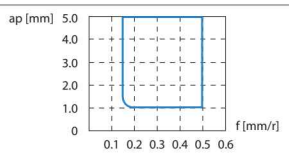
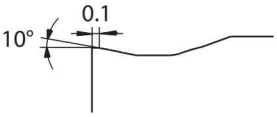
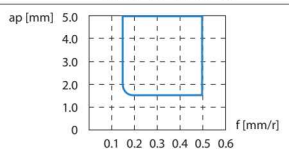
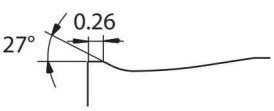
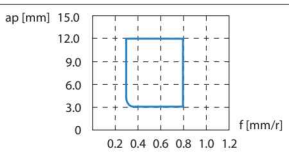
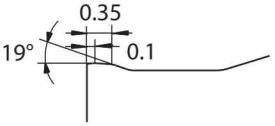




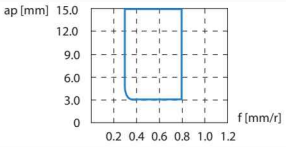
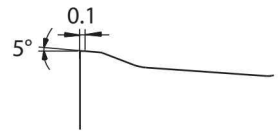
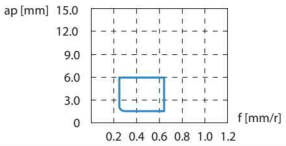
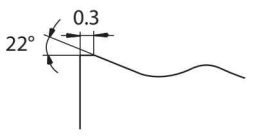
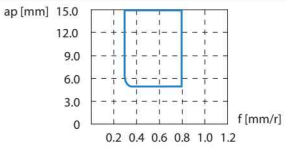
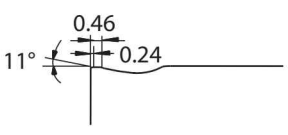
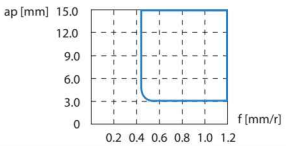
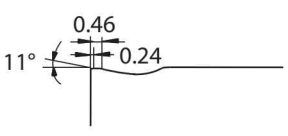
P Positive inserts

Chip breaker	Application		Application fields	Cutting edge design
SF	Fine-finishing	●		
HF	Finishing	● ✻		
AHF	Finishing	● ✻		
XF	Finishing	● ✻		
HM	Medium machining	● ✻		
XM	Medium machining	● ✻		
HR	Roughing	● ✻ ✻		

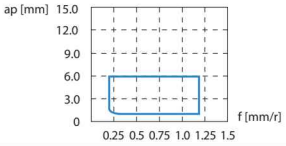
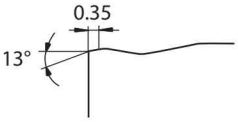
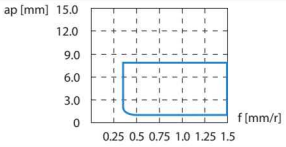
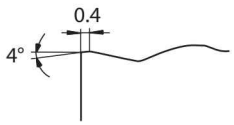
P Negative inserts

Chip breaker	Application		Application fields	Cutting edge design
SF	Fine-finishing			
DF	Finishing			
XF	Finishing			
ADF	Finishing			
DM	Medium machining			
PM	Medium machining			
ZM	Medium machining			
XM	Medium machining			
WG	Medium machining			
Basic	Medium machining			
DR	Roughing			

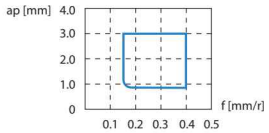
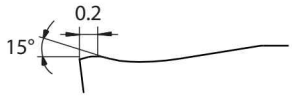
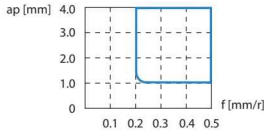
P Negative inserts

Chip breaker	Application		Application fields	Cutting edge design
DR (single sided)	Roughing			
LR (single sided)	Roughing			
HDR (single sided)	Roughing			
HPR (single sided)	Roughing			

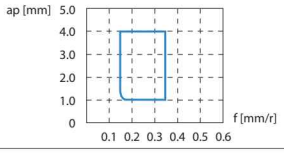
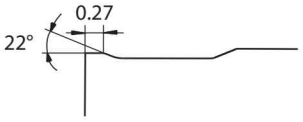
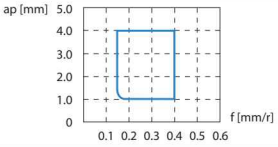
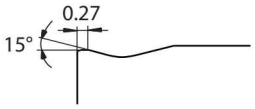
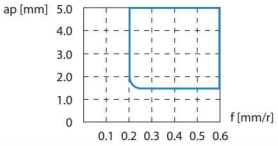
P Negative inserts (rail technology)

Chip breaker	Application		Application fields	Cutting edge design
RF	Finishing			
RH	Roughing			

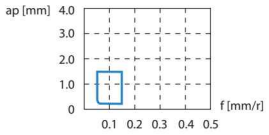
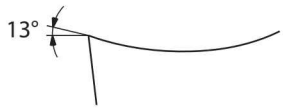
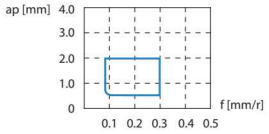
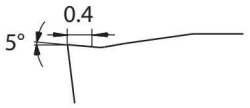
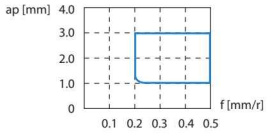
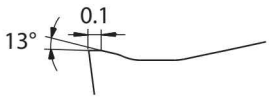
K Positive inserts

Chip breaker	Application		Application fields	Cutting edge design
TC	Medium machining			
Flat	Roughing			

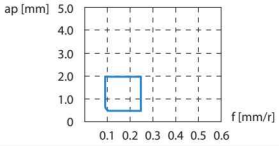
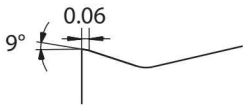
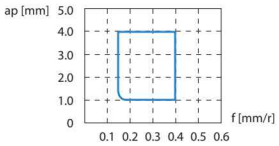
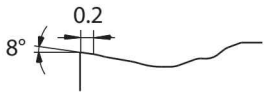
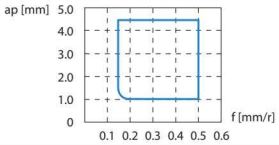
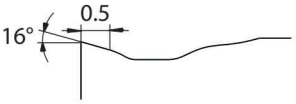
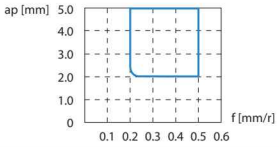
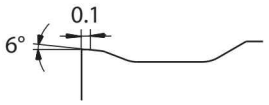
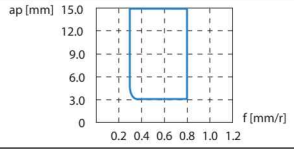
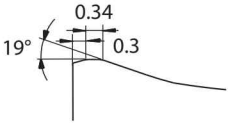
K Negative inserts

Chip breaker	Application		Application fields	Cutting edge design
TK	Medium machining			
TC	Medium machining			
Flat	Roughing			

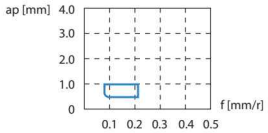
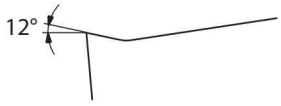
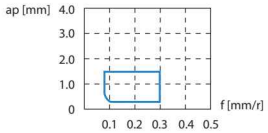
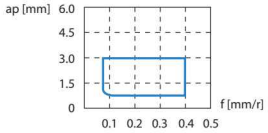
M Positive inserts

Chip breaker	Application		Application fields	Cutting edge design
USF	Fine-finishing	●		
EF	Finishing	● ✱		
EM	Medium machining	● ✱ ✱		

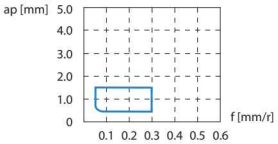
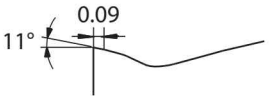
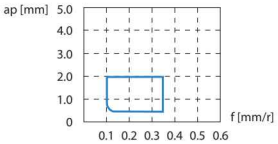
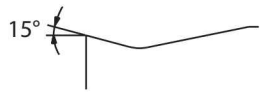
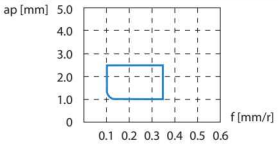
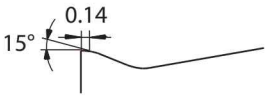
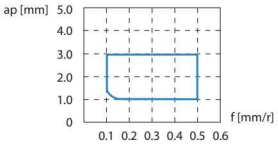
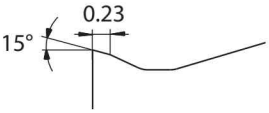
M Negative inserts

Chip breaker	Application		Application fields	Cutting edge design
EF	Finishing	●		
EM	Medium machining	● ✱		
EG	Medium machining	● ✱		
ER	Roughing	● ✱ ✱		
ER (single sided)	Roughing	● ✱ ✱		

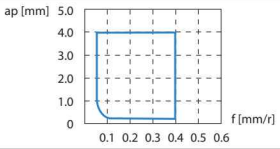
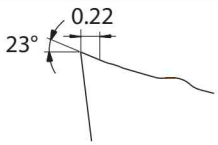
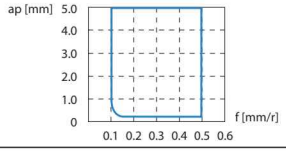
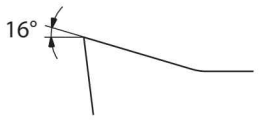
S Positive inserts

Chip breaker	Application		Application fields	Cutting edge design
NF	Finishing			
NGF	Finishing			
SNR	Roughing			

S Negative inserts

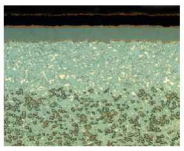
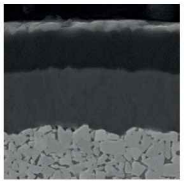
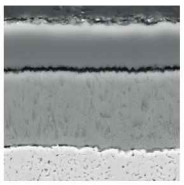
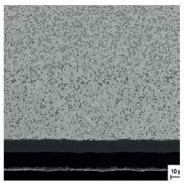
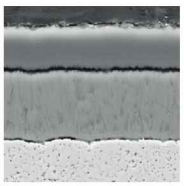
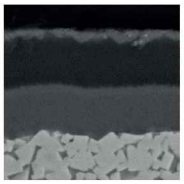
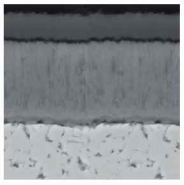
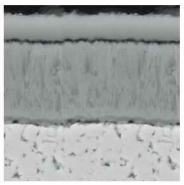
Chip breaker	Application		Application fields	Cutting edge design
NF	Finishing			
NGF	Medium machining			
NM	Medium machining			
SNR	Roughing			

N Positive inserts

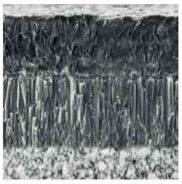
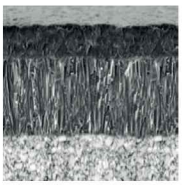
Chip breaker	Application		Application fields	Cutting edge design
LC	Finishing	●		
LH	Finishing	●		

Notes

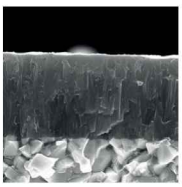
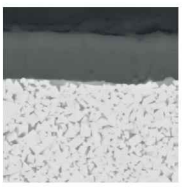
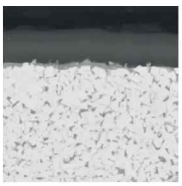
Coated cemented carbide CVD

Grade	ISO	Micro structure	Grade description
YBC103	P05 – P15		P10 grade with excellent wear resistance at higher cutting speeds. Latest sinter processes and CVD coating technologies enable a wide range of applications in the P material range.
YB6315	P05 – P20		CVD coated P10–P20 carbide grade for finishing to medium operation of steel, casting steel and high chrome material. Outstanding performance under high cutting speed and temperature with excellent wear resistance.
YBC152	P10 – P20		CVD coated P10–P20 carbide grade for finishing to medium operation of steel and casting steel. Outstanding performance under higher cutting speed and temperature with excellent wear resistance.
YBC203	P15 – P25		P20 grade with exceptional wear resistance and toughness for reliable machining operations. Ultra-modern sintering technique and CVD coating technologies allow for a wide range of applications in the P material range.
YBC252	P20 - P35		CVD coated P20–P35 carbide grade for medium operation to roughing of steel and casting steel. Optimal performance of wear resistance and toughness for a wide application field.
YBC352	P20 - P40		CVD coated P20–P40 carbide grade for roughing operation of steel and casting steel. Optimal performance of wear resistance and toughness for a wide application field.
YBM153	M10 - M25		CVD coated M10–M25 carbide grade for finishing to medium application in stainless steel. High wear resistance and capability against plastic deformation at higher cutting speed.
YBM253	M15 - M35		CVD coated M15–M35 carbide grade for medium to roughing operation in stainless steel with wide application field. High wear resistance and capability against plasctic deformation at higher cutting speed.

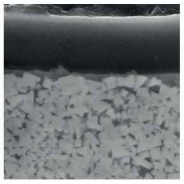
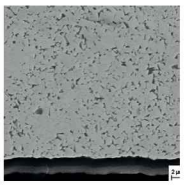
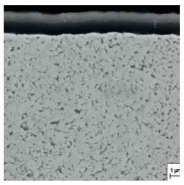
Coated cemented carbide CVD

Grade	ISO	Micro structure	Grade description
YBD102	K05 - K20		CVD coated K05–K20 carbide substrate. Optimized for medium operation of cast iron, special nodular cast iron and hard steel at high cutting speed.
YB7315	K10 - K25		CVD coated K10–K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Improved wear resistance and toughness at high cutting speed.
YBD152	K10 - K25		CVD coated K10–K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Good wear resistance and toughness at higher cutting speed.
YBD152C	K10 - K25		Thick Al2O3 CVD coated K05–K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Higher wear resistance and toughness at higher cutting speed in combination with TC chip breaker.

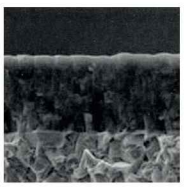
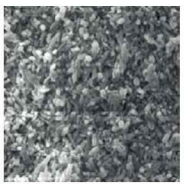
Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
YBG101	N05 - N20		PVD coated N05–N20 carbide substrate for finishing to semi-finishing in aluminium materials. Coating only on the top face, in combination with the aluminium chip breakers, prevents built-up edges and gives a smooth cut.
YBG102	S05 - S15		PVD coated S05–S15 carbide substrate for finishing to medium application of super alloy material, stainless steel and aluminum. Good wear resistance in a wide application field.
YBG105	S05 - S20		PVD multilayer coated S05–S20 carbide substrate for finishing to medium application of super alloy material but also stainless steel. Good wear resistance and thermal stability in a wide application field.

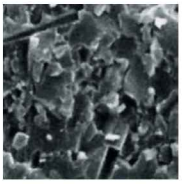
Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
YBG205	P10 - P30 M20 - M40 S15-S25		PVD multilayer coated P10–P30/M20–M40/S15–S25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (milling). Excellent wear resistance and thermal stability in a wide range of applications.
YB9320	P10 - P30 M10 - M25		PVD multilayer coated P10–P30/M10–M25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (grooving/milling). Optimised coating stability for higher wear resistance and thermal stability in a wide range of applications.
YPD201	S20 – S30		Carbide grade for semi-roughing to chip breaking of high-strength and high-alloy materials. High-performance grade with high wear resistance. Balanced hardness and internal stress ratio provide a wide range of applications.
YBS103	S10 – S20		Turning grade for processing nickel-base materials. A special carbide substrate and the latest PVD coating technology enable a very good wear behaviour and high thermal stability.

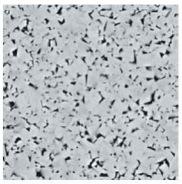
Ceramic

Grade	ISO	Micro structure	Grade description
CA1000	K10 - K25 H10 - H25		Uncoated H10–H25/K10–K25 mixed ceramic grade for finishing to medium operation in hardened steel and nodular cast iron. Good wear resistance and toughness.
CM1000	K10 - K25 H10 - H25		Coated H1–H25/K10–K25 mixed ceramic grade for finishing to medium operations in hardened steel, tool steel, HSS material and nodular cast iron. Good wear resistance and toughness.
CN1000	K05 - K15		Uncoated K05-K15 Si3N4 ceramic grade for finishing to medium operation in grey cast iron. Good wear resistance and thermal stability.

Ceramic

Grade	ISO	Micro structure	Grade description
CS1000	S05 – S20		Uncoated SiAlON ceramic grade for medium machining to roughing of nickel- and cobalt-based alloys at medium to low cutting speeds.
CW1400	S10 – S20 H10-H20		Uncoated whisker ceramic grade for medium and low speed cutting in HSS steel, high chrome steel and cobalt-base alloy also with interrupted cut. Good wear resistance, notch wear resistance and thermal stability.
CW1800	S10 – S25		Uncoated whisker ceramic grade for finishing to rough operations in Ni-base alloy material like Inconel, Nimonic or Hastelloy. Good wear resistance, notch wear resistance and thermal stability.

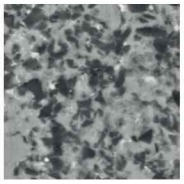
Uncoated cemented carbide

Grade	ISO	Micro structure	Grade description
YD101	N05 - N20 K05 - K20		Uncoated N05–N20/K05–K20 carbide substrate for fine to medium application in aluminum and other material.
YD201	N10 - N30 K10 - K30		Uncoated N10–N30/K10–K30 carbide substrate for medium application in aluminum and other material.

CBN

Grade	ISO	Micro structure	Grade description
YCB112	S10 – S20		Uncoated, brazed S10–S20 CBN grade for fine finishing operations on hardened steel and super alloys. Excellent wear resistance and thermal stability.

CBN

Grade	ISO	Micro structure	Grade description
YCB113	H01 - H10		Uncoated, brazed H01–H10 CBN grade for fine finishing operation in hardened steel with continuous cut. High wear resistance and productivity at higher cutting speed.
YCB121	H10 - H25		Uncoated, brazed H10–H25 CBN grade for fine to medium application in hardened steel from continuous to light interrupted cut. Good wear resistance and toughness for universal use.
YCB131	H20 - H35		Uncoated, brazed H20–H35 CBN grade for fine to medium application in hardened steel with interrupted cut. Good wear resistance and optimized toughness for safe process.
YCB113C	H01 - H10		Coated, brazed H01–H10 CBN grade for fine finishing operations on hardened steel with a continuous cut. High wear resistance and productivity at higher cutting speeds
YCB121C	H10 - H25		Coated, brazed H10–H25 CBN grade for fine to medium machining operations on hardened steel with a continuous to partially interrupted cut. Good wear resistance and toughness for universal application.
YCB131C	H20 - H25		Coated, brazed H20–H35 CBN grade for fine to medium machining operations on hardened steel with an interrupted cut. Good wear resistance and optimum toughness for reliable operations.
YCB215	K10 - K20		Uncoated, brazed K10 –K20 CBN grade for fine to medium machining operations on cast iron. Excellent wear resistance and thermal conductivity.
YZB630	H20 - H30		Uncoated H20–H30 solid CBN grade for medium machining operations on hardened steel with a slight to medium interrupted cut. Excellent combination of wear resistance and thermal stability.

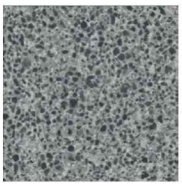
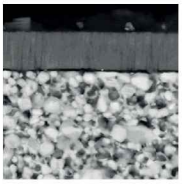
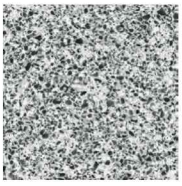
CBN

Grade	ISO	Micro structure	Grade description
YZB630C	H20 - H30		Coated H20–H30 solid CBN grade for medium machining operations on hardened steel with a slight to medium interrupted cut. Excellent combination of wear resistance and thermal stability.
YZB223	K10 - K25		Uncoated H10–H25/K10–K25 mixed ceramic grade for finishing to medium operation in hardened steel and nodular cast iron. Good wear resistance and toughness.

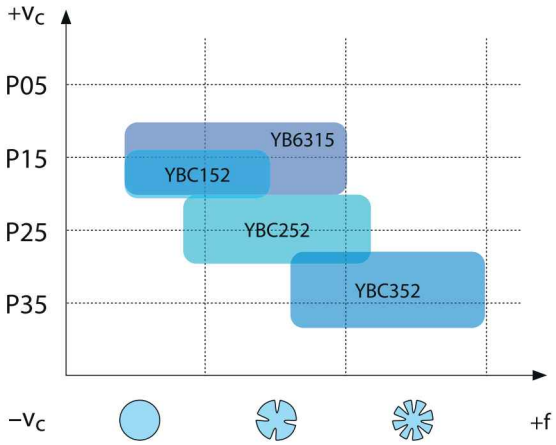
PCD

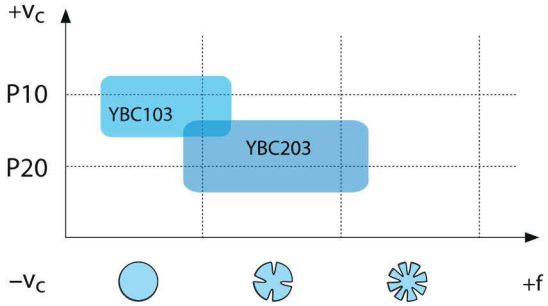
Grade	ISO	Micro structure	Grade description
YCD421	N01 - N10		Uncoated, brazed N01–N10 PCD grade for fine finishing operation of aluminum alloys less than 12 % Si, composites, copper/magnesium and other alloys. Medium grain size grade with good wear resistance for a wide application field.

Cermet

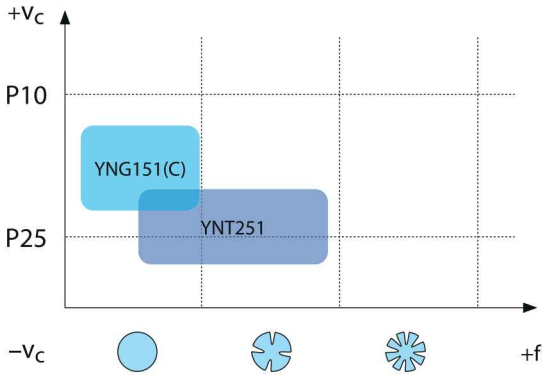
Grade	ISO	Micro structure	Grade description
YNG151	P05 – P15		Uncoated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good resistance against plastic deformation for good surface finishing.
YNG151C	P05 – P15		PVD coated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good wear resistance and capability against plastic deformation for good surface roughness.
YNT251	P10 - P25		Uncoated P10–P25 cermet grade for fine finishing to medium operation of steel and stainless steel. Good wear resistance and toughness. Suitable also in light interrupted cut.

CVD coated carbide grades for steel

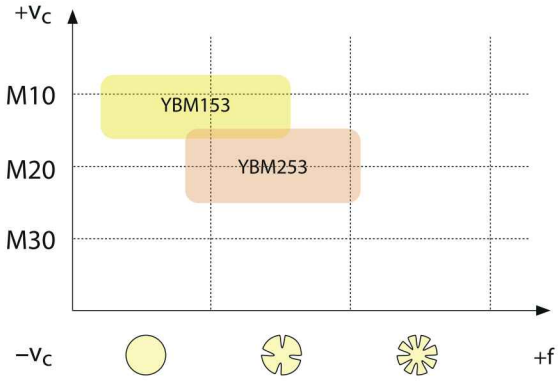




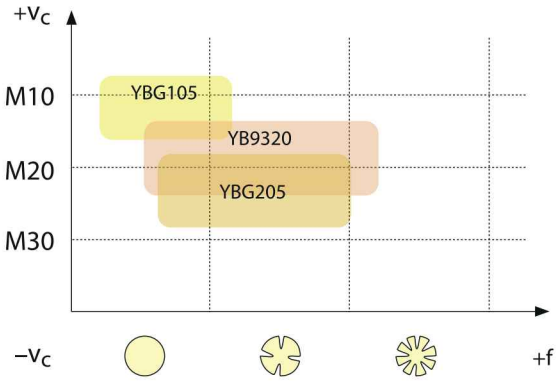
Cermet grades for steel



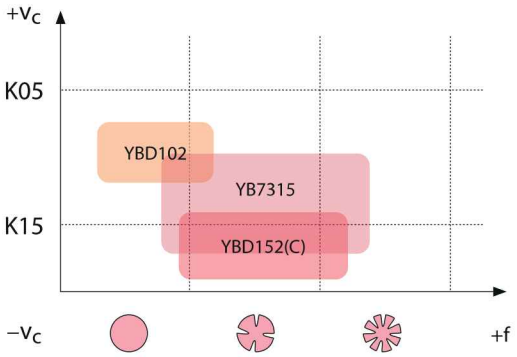
CVD coated carbide grades for stainless steel



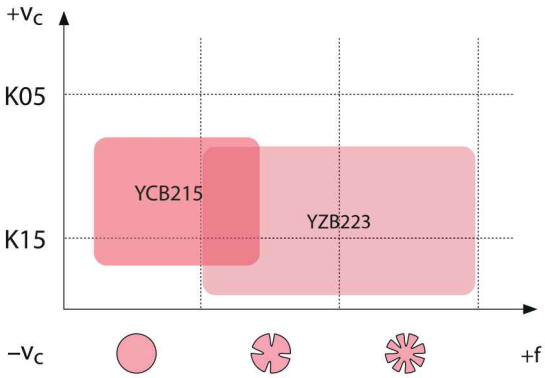
PVD coated carbide grades for stainless steel



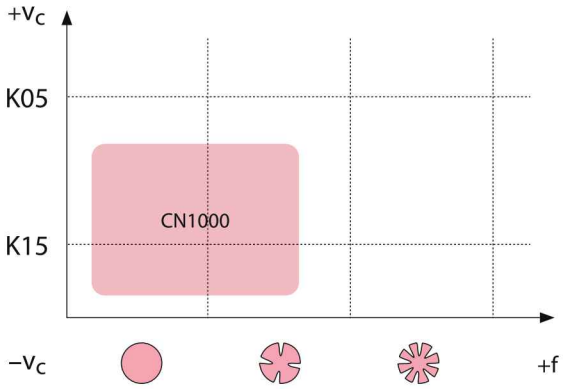
CVD coated carbide grades for cast iron



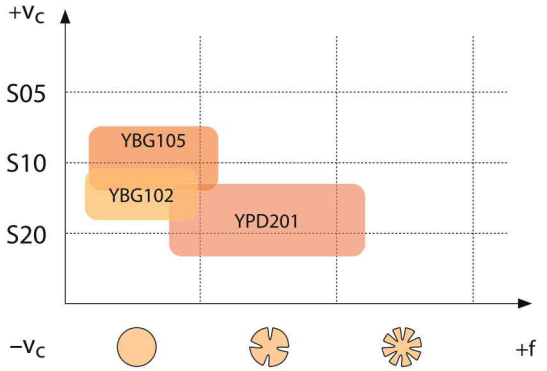
CBN grades for cast iron

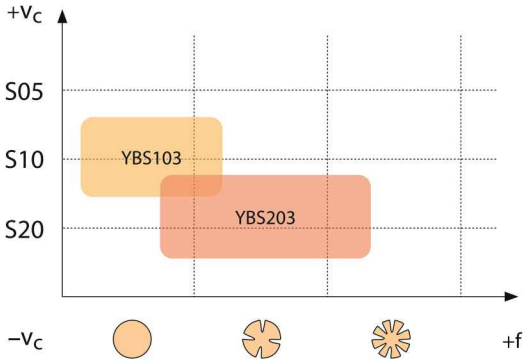


Ceramic grades for cast iron

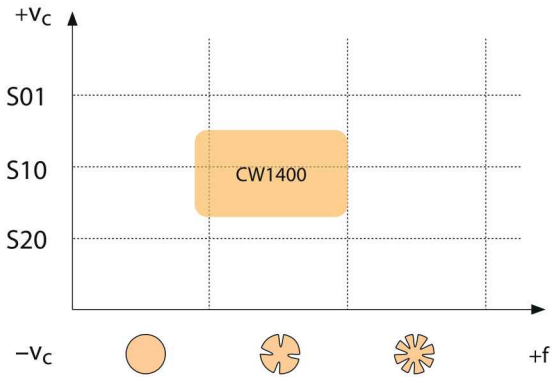


PVD coated carbide grades for superalloys

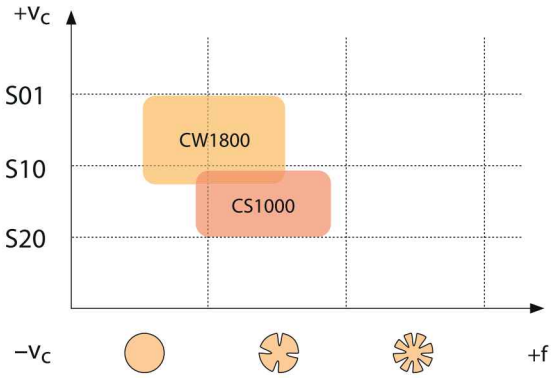




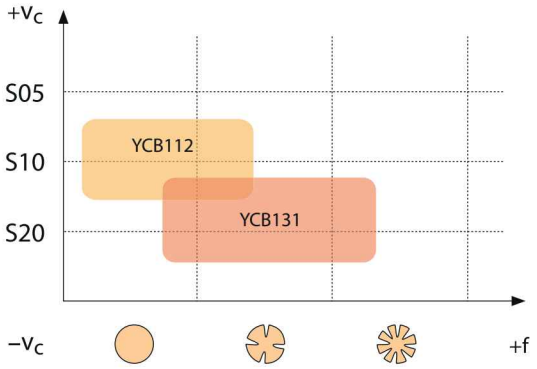
Ceramic grades for cobalt base alloys/HSS



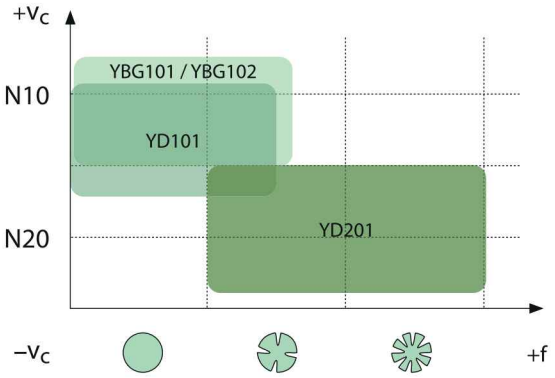
Ceramic grades for nickel base alloys



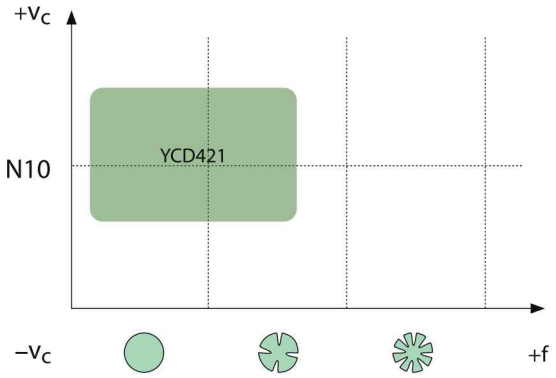
CBN grades for superalloys



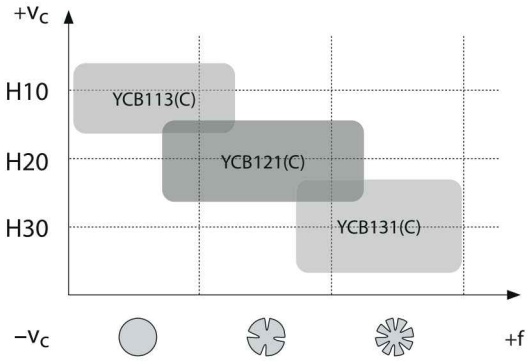
Carbide grades for non-ferrous metals



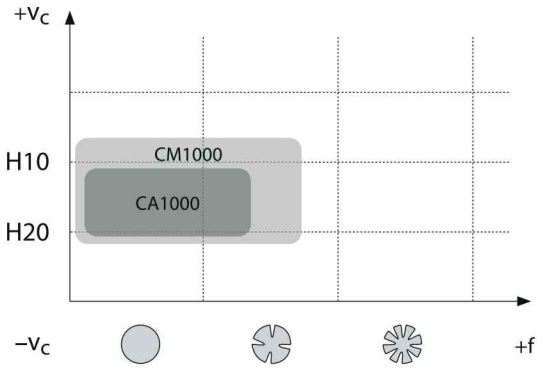
PCD grades for non-ferrous metals



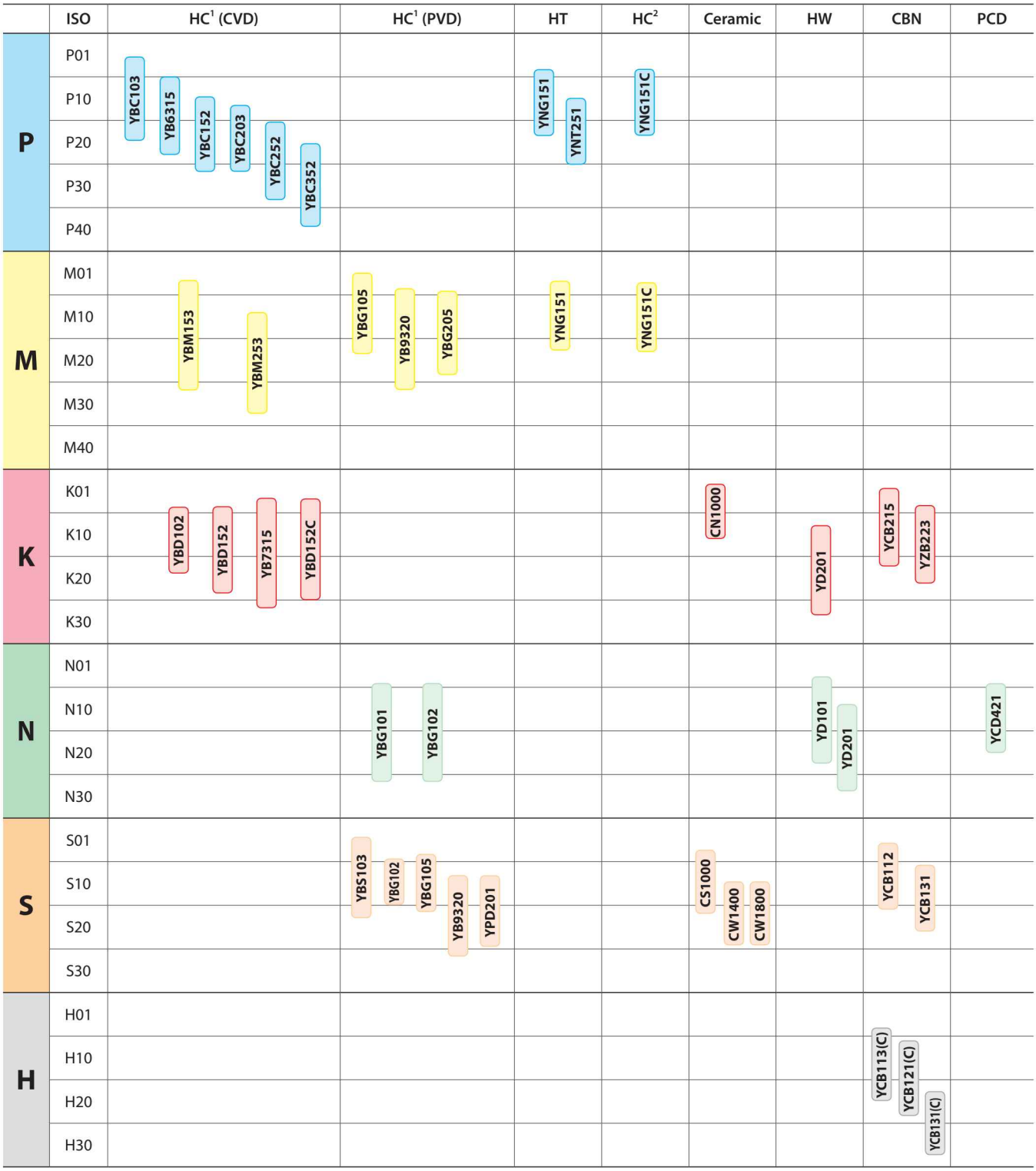
CBN grades for hardened steel



Ceramic grades for hardened steel



Application fields of grades – general turning



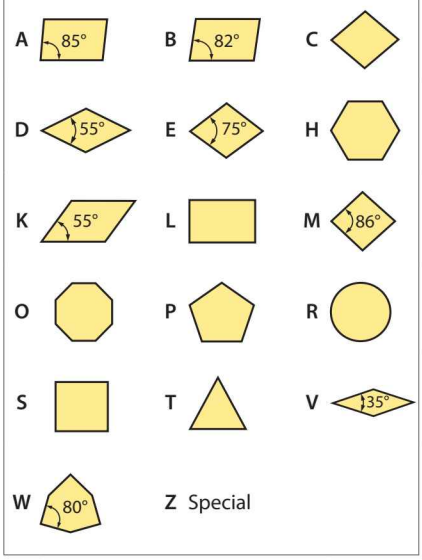
P	Steel	N	Non-ferrous metals
M	Stainless steel	S	Heat-resistant alloys
K	Cast iron	H	Hardened materials

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

ISO standard

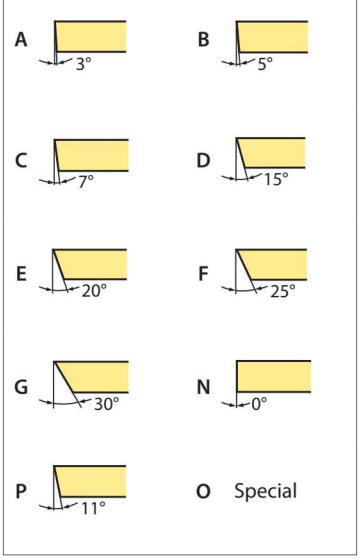
T	N	M	G	22	04	08	(N)	–	DM
1	2	3	4	5	6	7	8		9

Insert shape



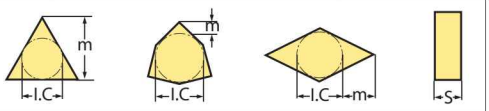
1

Clearance angle



2

Tolerance class

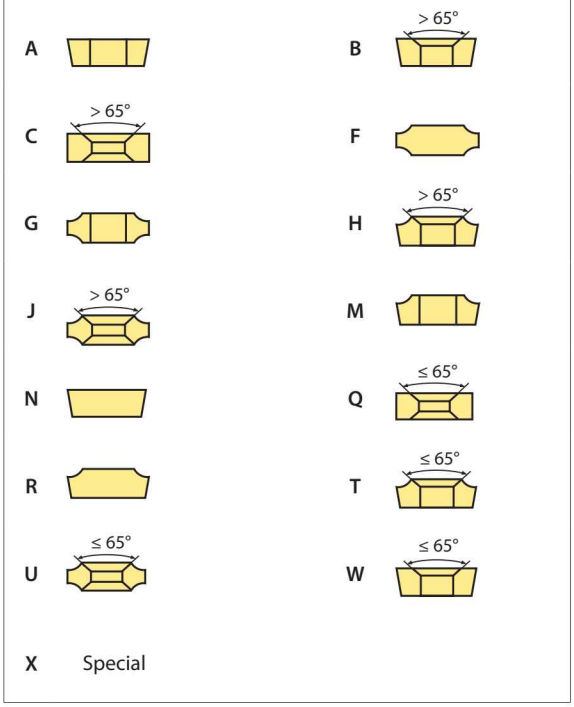


Code	I.C [mm]	m [mm]	S [mm]
A	±0,025	±0,005	±0,025
C	±0,025	±0,013	±0,025
E	±0,025	±0,025	±0,025
F	±0,013	±0,005	±0,025
G	±0,025	±0,025	±0,130
H	±0,013	±0,013	±0,025
J	±0,05–0,15	±0,005	±0,025
K	±0,05–0,15	±0,013	±0,025
L	±0,05–0,15	±0,025	±0,025
M	±0,05–0,15	±0,08–0,20	±0,130
N	±0,05–0,15	±0,08–0,20	±0,025
U	±0,08–0,25	±0,13–0,38	±0,130

3

Fastening features (metric)

Insert shape

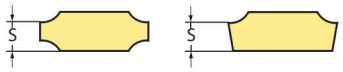


4

Cutting edge length l [mm]

I.C [mm]	Insert shape C	D	R	S	T	V	W	K
3,97					06			
5,0			05					
5,56					09			
6,0			06					
6,35	06	07			11	11		
8,0			08					
9,525	09	11	09	09	16	16	06	16
10,0			10					
12,0			12					
12,7	12	15	12	12	22	22	08	
15,875	16		15	15	27			
16,0		19	16					
19,05	19		19	19	33			
20,0			20					
25,0	25	25	25					
25,4			25	25				
31,75			31					
32			32					

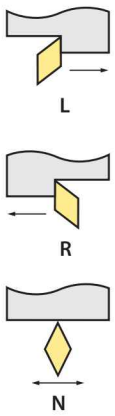
5

Insert thickness S [mm]			
			
Code	S	Code	S
00	0,79	**T5**	5,95
T0	0,99	**06**	6,35
01	1,59	**T6**	6,75
T1	1,98	**07**	7,94
02	2,38	**09**	9,52
T2	2,58	**T9**	9,72
03	3,18	**11**	11,11
T3	3,97	**12**	12,70
04	4,76		
T4	4,96		
05	5,56		

6

Nose radius r [mm]	
	
Code	r
00	–
02	0,2
04	0,4
08	0,8
12	1,2
16	1,6
20	2,0
24	2,4
32	3,2
X	Special
MO	Round inserts

7

Cutting direction

L
R
N

8

Chip breaker overview (on page A16)

9

ANSI standard

T	N	M	G	4	3	2	(N)	–	DM
1	2	3	4	5	6	7	8		9

Inner circle		
Code	[mm]	Pouce
2	6.35	0.250
3	9.525	0.375
4	12.7	0.500
5	15.875	0.625
6	19.05	0.750
8	25.4	1.000

5

Insert thickness		
Code	[mm]	Pouce
2	3.18	0.125
3	4.76	0.187
4	6.35	0.250
5	7.94	0.313
6	9.52	0.375

6

Nose radius		
Code	[mm]	Pouce
0	0.2	0.008
1	0.4	0.016
2	0.8	0.031
3	1.2	0.047
4	1.6	0.063
5	2.0	0.079
6	2.4	0.094

7

Conversion table for general turning inserts (metric/imperial system)

Negative angle/insert

Insert shape C	ISO	Inch
	090304	321
	090308	322
	120404	431
	120408	432
	120412	433
	120416	434
	160608	542
	160612	543
	160616	544
	190608	642
	190612	643
	190616	644
	190624	646
	250724	856
	250732	858
	250924	866
	250932	868

Insert shape D	ISO	Inch
	110404	331
	110408	332
	110412	333
	150404	431
	150408	432
	150412	433
	150604	441
	150608	442
	150612	443
	150616	444
	190608	542
	190612	543

Insert shape V	ISO	Inch
	160404	331
	160408	332
	160412	333

Insert shape R	ISO	Inch
	0903MO	32
	1204MO	43

Insert shape W	ISO	Inch
	06T304	3(2.5)1
	06T308	3(2.5)2
	06T312	3(2.5)3
	060404	331
	060408	332
	060412	333
	080404	431
	080408	432
	080412	433

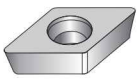
Insert shape T	ISO	Inch
	113304	221
	110308	222
	160404	331
	160408	332
	160412	333
	220404	431
	220408	432
	220412	433
	220416	434
	270608	542
	270612	543
	270616	544

Insert shape S	ISO	Inch
	090304	321
	090308	322
	090312	323
	120404	431
	120408	432
	120412	433
	120416	434
	150608	542
	150612	543
	150616	544
	190412	633
	190424	636
	190612	643
	190616	644
	250724	856
	250732	858
	250924	866
	250932	868

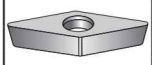
Positive angle/insert

Insert shape C	ISO	Inch
	060202	2(1.5)0
	060204	2(1.5)1
	060208	2(1.5)2
	09T302	3(2.5)0
	09T304	3(2.5)1
	09T308	3(2.5)2
	120404	431
	120408	432
	120412	433

Inserts shape T	ISO	Inch
	06T102	1.2(1.2)0
	06T104	1.2(1.2)1
	06T108	1.2(1.2)2
	090202	1.8(1.5)0
	090204	1.8(1.5)1
	090208	1.8(1.5)2
	110202	2(1.5)0
	110204	2(1.5)1
	110208	2(1.5)2
	110302	220
	110304	221
	110308	222
	16T302	30
	16T304	31
	16T308	32
	16T312	33
	160400	330
	220408	432
	220412	433
	220416	434
	270408	532
	27041 2	533
	330612	643
	330616	644

Insert shape D	ISO	Inch
	070202	2(1.5)0
	070204	2(1.5)1
	070208	2(1.5)2
	11T302	3(2.5)0
	11T304	3(2.5)1
	11T308	3(2.5)2
	11T312	3(2.5)3

Insert shape S	ISO	Inch
	060204	2(1.5)1
	09T302	3(2.5)0
	09T304	3(2.5)1
	09T308	3(2.5) 2
	120404	431
	120408	432
	120412	433
	150404	531
	150408	532
	150412	533
	190408	632
	190412	633
	190416	634

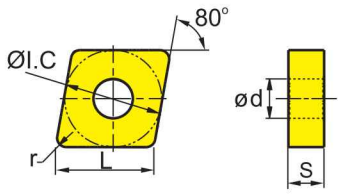
Inserts shape V	ISO	Inch
	110202	2(1.5)0
	110204	2(1.5)1
	110208	2(1.5)2
	110302	220
	110304	221
	110308	222
	160402	330
	160404	331
	160408	332
	160412	333

Turning inserts

● Ideal machining conditions
✲ Normal machining conditions
✲ Unfavourable machining conditions

CNMG	L	I.C	S	d
09 03	9.7	9.525	3.18	3.81
12 04	12.9	12.7	4.76	5.16

CN** negative insert

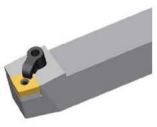


	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YB5103	YNG151	YNT251	YNG151C	YD101	YD201
					HC¹ (CVD)												HC¹ (PVD)							HT		HC²	HW	
P					●	●	●	✲	✲	✲										✲	✲			●	✲	●		
M											●	✲					●	●	✲	✲	✲	●	✲	●	✲	●		
K													✲	✲	✲	✲												
N																	●	●									●	✲
S																	●	●	✲	✲	✲	●					●	✲
H																												
WG	**CNMG120404-WG**	0.4	0.25-3.00	0.05-0.25			○																					
	CNMG120408-WG	0.8	0.5-5.0	0.15-0.70			●		●						○													
	CNMG120412-WG	1.2	0.8-6.0	0.20-0.75			●																					
Wiper																												
ADF	**CNMG120404-ADF**	0.4	0.5-3.0	0.05-0.30		●														●	●							
	CNMG120408-ADF	0.8	0.5-3.0	0.1-0.4		●														○	●			●				
	CNMG120412-ADF	1.2	0.8-3.0	0.15-0.50		○															●			●				
Finishing																												
DF	**CNMG090304-DF**	0.4	0.25-1.50	0.07-0.30			●		●																			
	CNMG090308-DF	0.8	0.3-1.5	0.1-0.3			●		○																			
	CNMG120404-DF	0.4	0.25-1.50	0.07-0.30			●		●																			
	CNMG120408-DF	0.8	0.3-1.5	0.1-0.4			●		●																			
Finishing	**CNMG120412-DF**	1.2	0.35-1.50	0.10-0.35			●		●																			
EF	**CNMG090304-EF**	0.4	0.5-2.0	0.05-0.20							○									●								
	CNMG090308-EF	0.8	0.5-2.0	0.05-0.25							○									●								
	CNMG120404-EF	0.4	0.5-2.5	0.05-0.20							●									●								
	CNMG120408-EF	0.8	0.5-2.5	0.05-0.25							●									●								
Finishing	**CNMG120412-EF**	1.2	0.5-2.5	0.10-0.35							○									○								
SF	**CNMG090304-SF**	0.4	0.05-0.50	0.05-0.30																						●		
	CNMG120404-SF	0.4	0.1-1.5	0.05-0.30																						●		
	CNMG120408-SF	0.8	0.1-1.5	0.10-0.35																						●		
Finishing																												

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

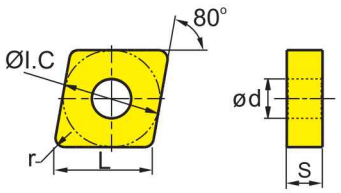
DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	A***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CN**	L	I.C	S	d
12 04	12.9	12.7	4.76	5.16

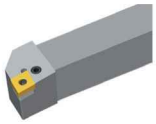
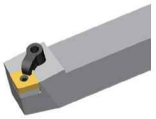
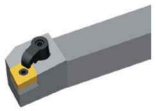


CN** negative insert					HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
				P																						
				M																						
				K																						
				N																						
				S																						
				H																						
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
NF	**CNEG120404-NF**	0.4	0.2-2.5	0.05-0.30													○	●								○	
	CNEG120408-NF	0.8	0.2-2.5	0.10-0.35													○	●								○	
	CNEG120412-NF	1.2	0.2-2.5	0.13-0.40													○	●								○	
Finishing																											
XF	**CNMG120404-XF**	0.4	0.5-2.5	0.1-0.25	●		●																				
	CNMG120408-XF	0.8	0.5-2.5	0.1-0.30	●		●																				
	CNMG120412-XF	1.2	0.5-2.5	0.1-0.35	●		●																				
Finishing																											

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

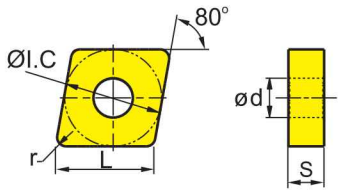
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CNMG	L	I.C	S	d
09 03	9.7	9.525	3.18	3.81
12 04	12.9	12.7	4.76	5.16
16 06	16.1	15.875	6.35	6.35
19 06	19.3	19.05	6.35	7.94

CN** negative insert



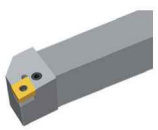
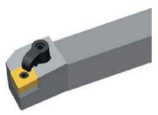
	ISO	r	a_p	f	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
PM Medium Cut	**CNMG090304-PM**	0.4	0.4-4.0	0.1-0.3					●																		
	CNMG090308-PM	0.8	0.5-4.0	0.15-0.50					●																		
	CNMG120404-PM	0.4	0.4-5.5	0.1-0.3			●		●				●		●												
	CNMG120408-PM	0.8	0.5-5.5	0.15-0.50			●		●	●			●		●												
	CNMG120412-PM	1.2	0.8-5.5	0.18-0.60			●		●				●		●												
	CNMG120416-PM	1.6	1.0-5.5	0.23-0.65			●		●				●		●												
	CNMG160608-PM	0.8	0.5-7.2	0.15-0.50			○		●				○		○												
	CNMG160612-PM	1.2	0.8-7.2	0.18-0.60			●		●				●		●												
	CNMG160616-PM	1.6	1.0-7.2	0.23-0.65					●				●		○												
	CNMG190608-PM	0.8	0.5-8.6	0.15-0.50					●																		
	CNMG190612-PM	1.2	0.8-8.6	0.18-0.60					●				○		●												
	CNMG190616-PM	1.6	1.0-8.6	0.23-0.65					○						○												
XM Medium Cut	**CNMG120404-XM**	0.4	1-4.2	0.2-0.3	●			○																			
	CNMG120408-XM	0.8	1-4.2	0.2-0.4	●			●																			
	CNMG120412-XM	1.2	1-4.2	0.2-0.6	●			●																			
	CNMG120416-XM	1.6	1-4.2	0.2-0.65	●			●																			
	CNMG160608-XM	0.8	1-5.6	0.2-0.4	●			●																			
	CNMG160612-XM	1.2	1-5.6	0.2-0.6	●			●																			
	CNMG160616-XM	1.6	1-5.6	0.2-0.65	○			●																			
	CNMG190608-XM	0.8	1-6.65	0.2-0.4	●			●																			
	CNMG190612-XM	1.2	1-6.65	0.2-0.6	○			●																			
	CNMG190616-XM	1.6	1-6.65	0.2-0.65	○			●																			

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

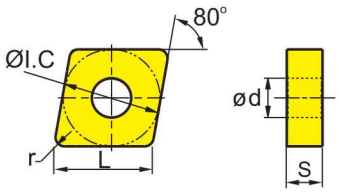
DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	A***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

CNMG	L	I.C	S	d
09 03	9.7	9.525	3.18	3.81
12 04	12.9	12.7	4.76	5.16
16 06	16.1	15.875	6.35	6.35
19 06	19.3	19.05	6.35	7.94

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions



CN** negative insert					HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW		
					P																							
					M																							
					K																							
					N																							
					S																							
					H																							
	ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DM	**CNMG090304-DM**		0.4	0.4-4.0	0.1-0.3			●		●																		
	CNMG090308-DM		0.8	0.5-4.0	0.15-0.50			●		●																		
	CNMG090312-DM		1.2	0.5-3.0	0.1-0.4					○																		
	CNMG120404-DM		0.4	0.4-5.5	0.1-0.3			●		●																		
	CNMG120408-DM		0.8	0.5-5.5	0.15-0.50		○	●		●	●	○	●															
	CNMG120412-DM		1.2	0.8-5.5	0.18-0.60		○	●		●		○	○															
	CNMG120416-DM		1.6	1.0-5.5	0.23-0.65			○		●																		
	CNMG160608-DM		0.8	0.5-7.2	0.15-0.50			○		●																		
	CNMG160612-DM		1.2	0.8-7.2	0.18-0.60			●		●																		
	CNMG160616-DM		1.6	1.0-7.2	0.23-0.65			●		●																		
	CNMG190608-DM		0.8	0.5-8.6	0.15-0.50			●		●																		
	CNMG190612-DM		1.2	0.8-8.6	0.18-0.60			●		●																		
	CNMG190616-DM		1.6	1.0-8.6	0.23-0.65					●																		
EG	**CNMG120404-EG**		0.4	0.5-4.0	0.05-0.30							●	●							○	●							
	CNMG120408-EG		0.8	0.5-4.0	0.1-0.4							●	●							●	●							
	CNMG120412-EG		1.2	0.5-4.0	0.2-0.5								●							●	●							
EM	**CNMG120404-EM**		0.4	0.5-4.0	0.05-0.30							●	●							●								
	CNMG120408-EM		0.8	0.5-5.7	0.15-0.45							●	●							●								
	CNMG120412-EM		1.2	0.5-5.7	0.25-0.60							●	●							●								
	CNMG160608-EM		0.8	0.5-7.2	0.15-0.45							●	●							●								
	CNMG160612-EM		1.2	0.5-7.2	0.25-0.60							●	●							●								


Medium Cut


Medium Cut

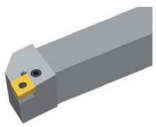
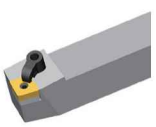

Medium Cut

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

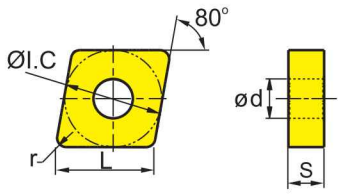
DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	A***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CNMG	L	I.C	S	d
12 04	12.9	12.7	4.76	5.16

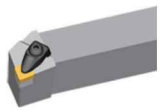
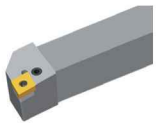
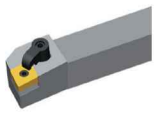


CN** negative insert					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
					P																						
					M																						
					K																						
					N																						
					S																						
					H																						
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
ZM	**CNMG120404-ZM**	0.4	0.5-3.0	0.05-0.30	●																						
	CNMG120408-ZM	0.8	0.5-4.0	0.1-0.5	○																						
Medium Cut																											

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

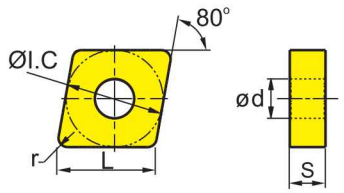
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

CNMG	L	I.C	S	d
12 04	12.9	12.7	4.76	5.16
16 06	16.1	15.875	6.35	6.35

CN** negative insert

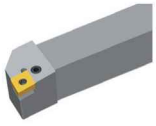
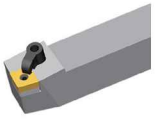
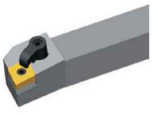


					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					●	●	●	◉	◉	◉										◉	◉			◉	◉	●		
M											○	◉						○	○	◉	◉	◉	○	◉	◉	○		
K													○	◉	◉	◉												
N																	●	●									●	◉
S																	○	○	◉	◉	◉	○					○	◉
H																												
ISO			r	a_p	f																							
NM	**CNMG120404-NM**		0.4	0.2-3.0	0.05-0.30													○	●									
	CNMG120408-NM		0.8	0.2-4.0	0.1-0.5													○	●	●	●						○	
	CNMG120412-NM		1.2	0.2-4.0	0.2-0.6													○	●									
Medium Cut																												
TC	**CNMG120404-TC**		0.4	0.5-5.0	0.08-0.40									●		●												
	CNMG120408-TC		0.8	0.5-5.0	0.15-0.50									●		●												
	CNMG120412-TC		1.2	0.5-5.0	0.2-0.6									●		●												
	CNMG120416-TC		1.6	0.5-5.0	0.20-0.65									●		○												
	CNMG160608-TC		0.8	1-7	0.15-0.50									●		●												
	CNMG160612-TC		1.2	1-7	0.2-0.6									●		●												
	CNMG160616-TC		1.6	1-7	0.20-0.65									●		○												
TK	**CNMG120408-TK**		0.8	0.2-0.4	0.2-0.4									○														
	CNMG120412-TK		1.2	0.2-0.4	0.2-0.45									○														
	CNMG120416-TK		1.6	0.2-0.4	0.2-0.5									●														
Medium Cut																												

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

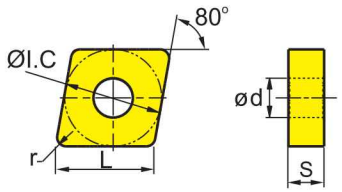
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CNMG	L	I.C	S	d
12 04	12.9	12.7	4.76	5.16
16 06	16.1	15.875	6.35	6.35
19 06	19.3	19.05	6.35	7.94
25 09	25.79	25.4	9.525	9.12

CN** negative insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW		
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	○	❁	❁	❁										❁	❁			○	❁	○		
M							○	❁						○	○	❁	❁			○	❁	○		
K									●	❁	❁	❁												
N													○	○									○	❁
S														○	○	❁	❁						○	❁
H																								

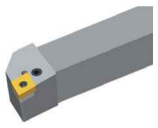
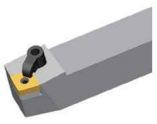
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DR Roughing	**CNMG120408-DR**	0.8	0.7-7.0	0.2-0.5		○	●		●	●			●		●													
	CNMG120412-DR	1.2	1-7	0.25-0.70		○	●		●	●			●		●													
	CNMG120416-DR	1.6	1.5-7.0	0.32-0.75			○		●				○		●													
	CNMG160608-DR	0.8	0.7-8.0	0.2-0.5					●				●		○													
	CNMG160612-DR	1.2	1-8	0.25-0.70		○	●		●	○			●		●													
	CNMG160616-DR	1.6	1.5-8.0	0.3-0.8		○	●		●	●			○		○													
	CNMG190608-DR	0.8	0.7-10.0	0.2-0.5			●		●				○		●													
	CNMG190612-DR	1.2	1-10	0.25-0.70		○	●		●	●			○		●													
	CNMG190616-DR	1.6	1.5-10.0	0.3-0.8			●	●	●	●			○		●													
	CNMG190624-DR	2.4	2-10	0.32-0.90		○			●						○													
	CNMG250924-DR	2.4	2-15	0.4-1.0					●																			
SNR Roughing	**CNMG120408-SNR**	0.8	1-3	0.1-0.4															●			●	●					
	CNMG120412-SNR	1.2	1-3	0.2-0.6															●			●	●					
	CNMG160608-SNR	0.8	2-6	0.1-0.4															●			●	●				○	
	CNMG190616-SNR	1.6	2-7	0.2-0.6															○				●				○	

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

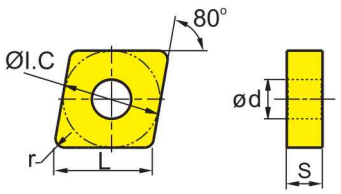
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

CN**	L	I.C	S	d
12 04	12.9	12.7	4.76	5.16
16 06	16.1	15.875	6.35	6.35
19 06	19.3	19.05	6.35	7.94
25 07	25.79	25.4	7.94	9.12
25 09	25.79	25.4	9.525	9.12

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

CN** negative insert

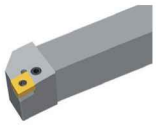
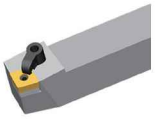
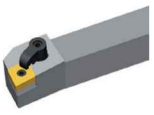


	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
					P	P	P	P	P	P	P	P	P	P	P	P	N	N	N	N	N	N	N	HT	HT	HC²	HW	HW
					M	M	M	M	M	M	M	M	M	M	M	M	S	S	S	S	S	S	S	HT	HT	HC²	HW	HW
					K	K	K	K	K	K	K	K	K	K	K	K	H	H	H	H	H	H	H					
DR Roughing	**CNMM120412-DR**	1.2	1.0-7.5	0.25-0.70		○	●		●	●	○	○																
	CNMM160612-DR	1.2	1.0-9.5	0.25-0.70			●		●																			
	CNMM160616-DR	1.6	1.5-9.5	0.32-0.90			●		●	○																		
	CNMM190612-DR	1.2	1-12	0.25-0.70		○	●		●	●		●																
	CNMM190616-DR	1.6	1.5-12.0	0.32-0.90			●		●	●																		
	CNMM190624-DR	2.4	2-12	0.35-1.20		○	●		●																			
	CNMM250924-DR	2.4	2.0-12.5	0.2-1.2			●		●	○																		
ER Roughing	**CNMG120408-ER**	0.8	2.0-7.6	0.15-0.55								○																
	CNMG120412-ER	1.2	2.0-7.6	0.25-0.80								○																
	CNMG160612-ER	1.2	2-10	0.35-0.80								○																
	CNMG160616-ER	1.6	2-10	0.45-1.00								○																
	CNMG190612-ER	1.2	2.0-11.4	0.35-1.00					○			○								○								
	CNMG190616-ER	1.6	2.0-11.4	0.45-1.10								○																
ER Roughing	**CNMM250724-ER**	2.4	2.0-12.5	0.3-1.4					●																			
	CNMM250732-ER	3.2	2.0-12.5	0.45-1.80					○																			
	CNMM250924-ER	2.4	2.0-12.5	0.3-1.4					●			○																
	CNMM250932-ER	3.2	2.0-12.5	0.45-1.80					●																			

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

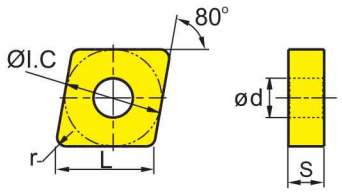
DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

System code A48 Grade selection A42 Technical info A501 Cutting data A366

CNMM	L	I.C	S	d
12 04	12.9	12.7	4.76	5.16
16 06	16.1	15.875	6.35	6.35
19 06	19.3	19.05	6.35	7.94
25 09	25.79	25.4	9.525	9.12

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions



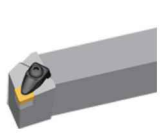
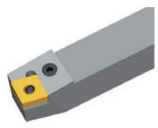
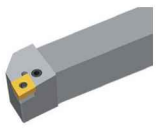
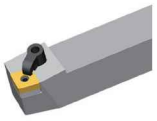
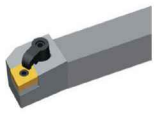
CN** negative insert					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW		
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201	
	ISO		r	a_p	f																								
LR	**CNMM120408-LR**		0.8	1-5	0.1-0.5			●		●																			
	CNMM120412-LR		1.2	2-6	0.2-0.7			●		●			●																
	CNMM120416-LR		1.6	2.0-6.5	0.25-0.80					●																			
	CNMM160608-LR		0.8	1-7	0.2-0.6			●		●			○																
	CNMM160612-LR		1.2	1.0-7.5	0.2-0.7			●		●			●																
	CNMM160616-LR		1.6	1.0-8.5	0.25-0.80	○		●	○	●																			
Roughing	**CNMM190612-LR**		1.2	2.0-10.5	0.2-0.7			●		●																			
	CNMM190616-LR		1.6	2.0-10.5	0.3-1.0			●		●			●																
	CNMM190624-LR		2.4	2.0-10.5	0.3-1.1			●		○																			
	CNMM250924-LR		2.4	2.0-12.5	0.3-1.2			○		●																			

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

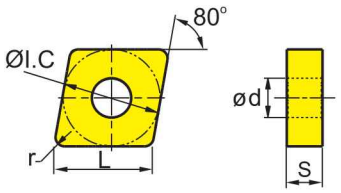
DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

CNMM	L	I.C	S	d
12 04	12.9	12.7	4.76	5.16
16 06	16.1	15.875	6.35	6.35
19 06	19.3	19.05	6.35	7.94
25 09	25.79	25.4	9.525	9.12

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

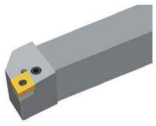
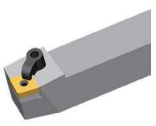


CN** negative insert					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
					P																						
					M																						
					K																						
					N																						
					S																						
					H																						
	ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Basic	**CNMM120404**		0.4	0.5-7.0	0.1-0.5																						
	CNMM190612		1.2	0.5-10.5	0.1-0.8																						
	CNMM190616		1.6	0.5-10.5	0.1-1.0																						
Medium Cut																											
HDR	**CNMM120408-HDR**		0.8	1-7	0.2-0.6			●		●																	
	CNMM120412-HDR		1.2	1-7	0.3-0.8			○		●																	
	CNMM120416-HDR		1.6	1-7	0.4-1.0			●		●																	
	CNMM160612-HDR		1.2	1.5-7.5	0.3-0.8			●		●																	
	CNMM160616-HDR		1.6	1.5-8.5	0.4-1.0			○		●																	
	CNMM160624-HDR		2.4	1.5-10.5	0.8-1.2			○		○																	
	CNMM190608-HDR		0.8	2.0-12.5	0.3-0.7			○																			
	CNMM190612-HDR		1.2	2.0-12.5	0.35-0.80			○		●																	
	CNMM190616-HDR		1.6	2.0-12.5	0.5-1.1			○	●	●						○											
	CNMM190624-HDR		2.4	2.0-12.5	0.8-1.2			●		●																	
	CNMM250924-HDR		2.4	2.0-12.5	0.8-1.4			○		●																	
HPR	**CNMM190616-HPR**		1.6	2.0-10.5	0.5-1.0					○																	
	CNMM190624-HPR		2.4	2.0-10.5	0.7-1.4			●		○																	
	CNMM250924-HPR		2.4	2.0-12.5	0.7-1.4					●	●																
Roughing																											

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

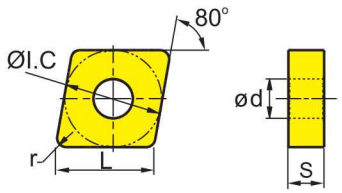
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CN**	L	I.C	S	d
12 04	12.9	12.7	4.76	5.16
16 06	16.1	15.875	6.35	6.35
19 06	19.3	19.05	6.35	7.94

CN** negative insert



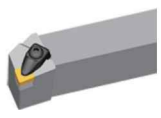
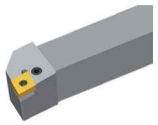
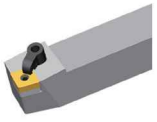
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
					HC¹ (CVD)												HC¹ (PVD)							HT		HC²	HW	
P					○	○	○	◉	◉	◉										◉	◉			◉	◉	○		
M											○	◉					○	○	◉	◉	◉	○	○	○	◉	○		
K													◉	◉	◉	◉												
N																	◉	◉									◉	◉
S																	○	○	◉	◉	◉	○					○	◉
H																												
Flat	**CNMA120404**	0.4	0.2-5.0	0.05-0.40									○															
	CNMA120408	0.8	0.2-5.0	0.05-0.50									●	●	●	●												
	CNMA120412	1.2	0.2-5.0	0.1-0.6									●	●	●	●											○	
	CNMA120416	1.6	0.2-5.0	0.10-0.65									●		●	○												
	CNMA160608	0.8	0.2-7.0	0.1-0.5									○															
	CNMA160612	1.2	0.2-7.0	0.1-0.6									●		●													
	CNMA160616	1.6	0.2-7.0	0.15-0.65									○		●													
	CNMA190612	1.2	0.2-8.0	0.15-0.70									○		●													
	CNMA190616	1.6	0.2-8.0	0.15-0.70									●		●													
Basic	**CNMG120404**	0.4	0.1-5.0	0.05-0.50					○																			
	CNMG120408	0.8	0.1-5.0	0.1-0.6					○						○													
	CNMG120412	1.2	0.1-5.0	0.1-0.7			○		○																			
	CNMG160612	1.2	0.1-7.0	0.1-0.7																								
	CNMG190608	0.8	0.1-8.0	0.1-0.7																								
	CNMG190612	1.2	0.1-8.0	0.1-0.8																								
	CNMG190616	1.6	0.1-8.0	0.1-1.0																								

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

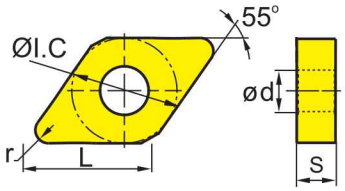
DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A230	A237	A238	A252	A253	A324

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DN**	L	I.C	S	d
11 04	11.6	9.525	4.76	3.81
15 04	15.5	12.7	4.76	5.16
15 06	15.5	12.7	6.35	5.16



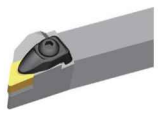
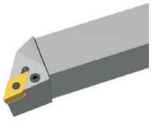
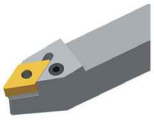
					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
					P																						
					M																						
					K																						
					N																						
					S																						
					H																						
	ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
WG	**DNMX110404-WG**		0.4	0.2-1.5	0.08-0.30			○																			
	DNMX110408-WG		0.8	0.5-3.5	0.15-0.50			●		●																	
	DNMX150408-WG		0.8	0.5-5.0	0.15-0.70			○																			
	DNMX150608-WG		0.8	0.5-5.0	0.15-0.70			○		○																	
Wiper	**DNMX150612-WG**		1.2	0.8-6.0	0.20-0.75			○																			
ADF	**DNMG150604-ADF**		0.4	0.5-6.0	0.15-0.50		○															●			○			
	DNMG150608-ADF		0.8	0.1-4.0	0.08-0.50		○														●	●			○			
	DNMG150612-ADF		1.2	0.5-4.0	0.15-0.50		○															●						
Finishing																												
DF	**DNMG110404-DF**		0.4	0.15-2.00	0.08-0.25			●		●																	
	DNMG110408-DF		0.8	0.15-2.00	0.1-0.3			●		●																	
	DNMG110412-DF		1.2	0.35-1.50	0.15-0.50			○																			
	DNMG150404-DF		0.4	0.15-2.00	0.08-0.25			●		●																	
	DNMG150408-DF		0.8	0.15-2.00	0.1-0.3			●		●																	
	DNMG150412-DF		1.2	0.35-1.50	0.15-0.50					○																	
Finishing	**DNMG150604-DF**		0.4	0.8-6.0	0.18-0.60			●		●																	
	DNMG150608-DF		0.8	0.15-2.00	0.1-0.3			●		●																	
	DNMG150612-DF		1.2	0.2-2.5	0.10-0.35			●																			
SF	**DNMG110404-SF**		0.4	0.05-0.50	0.05-0.25																					●	
	DNMG150404-SF		0.4	0.05-0.50	0.05-0.25																					●	
	DNMG150408-SF		0.8	0.05-0.50	0.10-0.35																					●	
	DNMG150604-SF		0.4	0.05-0.50	0.05-0.25																					●	
Finishing	**DNMG150608-SF**		0.8	0.05-0.50	0.10-0.35																					●	

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	A***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

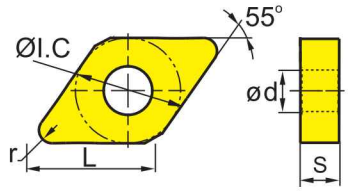
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DNMG	L	I.C	S	d
11 04	11.6	9.525	4.76	3.81
15 06	15.5	12.7	6.35	5.16

DN** negative insert



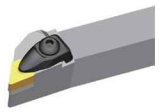
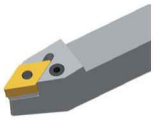
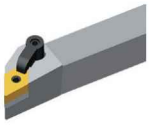
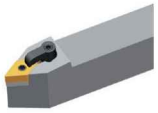
	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
P	○	○	○	◎	◎	◎								◎	◎					○	◎	○		
M								○	◎				○	○	◎	◎	◎	○		○	◎	○		
K										○	◎	◎	◎											
N													○	○									○	◎
S													○	○	◎	◎	◎	○					○	◎
H																								

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
XF Finishing	**DNMG110404-XF**	0.4	0.5-2.0	0.1-0.25	●																							
	DNMG110408-XF	0.8	0.5-2.0	0.1-0.30	○																							
	DNMG150604-XF	0.4	0.5-2.5	0.1-0.25	●			●																				
	DNMG150608-XF	0.8	0.5-2.5	0.1-0.30	●			●																				
	DNMG150612-XF	1.2	0.5-2.5	0.1-0.35	●			●																				
XM Medium Cut	**DNMG110404-XM**	0.4	1-3.85	0.2-0.4	●			○																				
	DNMG110408-XM	0.8	1-3.85	0.2-0.4	●			○																				
	DNMG110412-XM	1.2	1-3.85	0.2-0.6	●			○																				
	DNMG150604-XM	0.4	1-5.25	0.2-0.4	●			●																				
	DNMG150608-XM	0.8	1-5.25	0.2-0.4	●			●																				
	DNMG150612-XM	1.2	1-5.25	0.2-0.6	●			●																				
	DNMG150616-XM	1.6	1-5.25	0.2-0.65	●			●																				

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	A***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

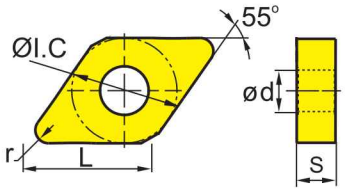
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

DNMG	L	I.C	S	d
11 04	11.6	9.525	4.76	3.81
15 04	15.5	12.7	4.76	5.16
15 06	15.5	12.7	6.35	5.16

DN** negative insert



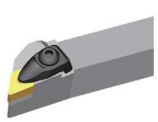
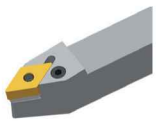
	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
M							○	◉					○	○	◉	◉	◉	○	○	◉	○		
K									○	◉	◉	◉											
N													○	○								○	◉
S													○	○	◉	◉	◉	○				○	◉
H																							

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DM Medium Cut	**DNMG110404-DM**	0.4	0.4-5.0	0.1-0.3			●		●																			
	DNMG110408-DM	0.8	0.5-5.0	0.15-0.50			●		●																			
	DNMG110412-DM	1.2	0.8-5.0	0.18-0.50			●		●																			
	DNMG150404-DM	0.4	0.4-6.0	0.1-0.3			●		●																			
	DNMG150408-DM	0.8	0.5-6.0	0.15-0.50			●		●																			
	DNMG150412-DM	1.2	0.8-6.0	0.18-0.60			○		●																			
	DNMG150604-DM	0.4	1-6	0.23-0.65			●		●																			
	DNMG150608-DM	0.8	0.5-6.0	0.15-0.50		○	●		●			●																
	DNMG150612-DM	1.2	0.8-6.0	0.18-0.60		○	●		●																			
	DNMG150616-DM	1.6	1-6	0.23-0.65		○	●		●																			
PM Medium Cut	**DNMG110404-PM**	0.4	0.4-5.0	0.1-0.3					●				○															
	DNMG110408-PM	0.8	0.5-5.0	0.15-0.50			○		●				●															
	DNMG110412-PM	1.2	0.8-5.0	0.18-0.50					○				●															
	DNMG150404-PM	0.4	0.4-6.0	0.1-0.3			○																					
	DNMG150408-PM	0.8	0.5-6.0	0.15-0.50			●		●				●		●													
	DNMG150412-PM	1.2	0.8-6.0	0.18-0.60					○						○													
	DNMG150416-PM	1.6	1-6	0.23-0.65					○																			
	DNMG150604-PM	0.4	0.4-6.0	0.1-0.3			●		●				●		○													
	DNMG150608-PM	0.8	0.5-6.0	0.15-0.50			●		●	●			●		●													
	DNMG150612-PM	1.2	0.8-6.0	0.18-0.60			●		●				●		●													
	DNMG150616-PM	1.6	1-6	0.23-0.65					●																			

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

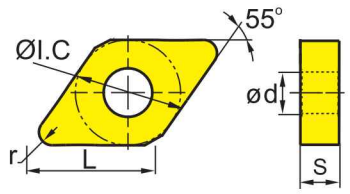
DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	A***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DNMG	L	I.C	S	d
15 06	15.5	12.7	6.35	5.16



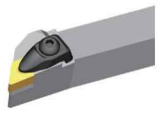
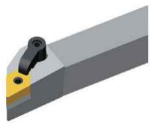
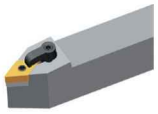
DN** negative insert					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉											◉	◉		◉	◉	○		
M											○	◉					○	○	◉	◉	◉	○		○	◉	○		
K													●	◉	◉	◉												
N																	●	●									●	◉
S																	○	○	◉	◉	◉	○					○	◉
H																												
ISO		r	a_p	f																								
ZM	**DNMG150612-ZM**	1.2	1.0-5.5	0.15-0.60		○			●																			
Medium Cut																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	S***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

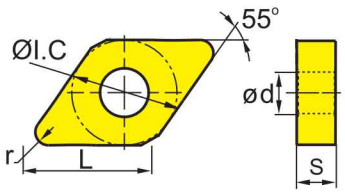
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DN**	L	I.C	S	d
11 04	11.6	9.525	4.76	3.81
15 04	15.5	12.7	4.76	5.16
15 06	15.5	12.7	6.35	5.16

DN** negative insert



	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	●	●	●	◉	◉	◉									◉	◉		●	◉	●		
M							○	◉					○	○	◉	◉	◉	○	◉	○		
K									●	◉	◉	◉										
N													●	●							●	◉
S													●	●	◉	◉	◉	●			●	◉
H																						

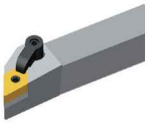
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EF	**DNMG110404-EF**	0.4	0.1-1.5	0.05-0.20							○								●									
	DNMG110408-EF	0.8	0.1-1.5	0.1-0.4							○								●									
	DNMG150404-EF	0.4	0.1-1.5	0.05-0.30															●									
	DNMG150408-EF	0.8	0.1-1.5	0.1-0.4															●									
	DNMG150604-EF	0.4	0.1-1.5	0.05-0.30							●								●									
	DNMG150608-EF	0.8	0.1-1.5	0.1-0.4							●								●									
Finishing	**DNMG150612-EF**	1.2	0.1-1.5	0.15-0.50															●									
FM	**DNMG150604L-FM**	0.4	0.5-3.0	0.05-0.30					●										●									
	DNMG150604R-FM	0.4	0.5-3.0	0.05-0.30			●		●										●									
	DNMG150608L-FM	0.8	0.5-3.0	0.1-0.5			○		●										●									
Finishing	**DNMG150608R-FM**	0.8	0.5-3.0	0.1-0.5			●		●										●									
NF	**DNEG150404-NF**	0.4	0.2-3.0	0.05-0.30														○										
	DNEG150408-NF	0.8	0.2-3.0	0.1-0.4														○										
	DNEG150604-NF	0.4	0.2-3.0	0.05-0.30													○	●									○	
Finishing	**DNEG150608-NF**	0.8	0.2-3.0	0.1-0.4													○	●									○	
NGF	**DNEG150608-NGF**	0.8	0.2-3.0	0.05-0.40															●									
	DNEG150612-NGF	1.2	0.2-3.0	0.1-0.5															●									
Finishing																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	A***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

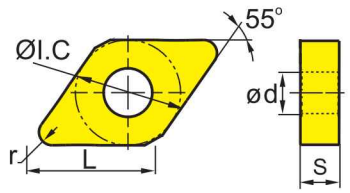
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DNMG	L	I.C	S	d
11 04	11.6	9.525	4.76	3.81
15 04	15.5	12.7	4.76	5.16
15 06	15.5	12.7	6.35	5.16

DN** negative insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
M							○	◉					○	○	◉	◉	◉	○	○	◉	○		
K									◉	◉	◉	◉											
N													○	○								◉	◉
S													○	○	◉	◉	◉	○				○	◉
H																							

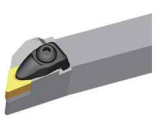
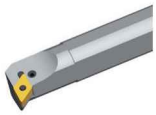
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EG	**DNMG150604-EG**	0.4	1-3	0.05-0.30							●										●							
	DNMG150608-EG	0.8	1-3	0.1-0.4							●	○								●	●							
	DNMG150612-EG	1.2	1-3	0.2-0.6							●	●								●	●							
Medium Cut																												
EM	**DNMG110404-EM**	0.4	0.5-4.4	0.05-0.30							●									●								
	DNMG110408-EM	0.8	0.5-4.4	0.10-0.45							●									●								
	DNMG150404-EM	0.4	0.5-6.4	0.05-0.30							○									○								
	DNMG150408-EM	0.8	0.5-6.4	0.10-0.45							○									●								
	DNMG150412-EM	1.2	0.5-6.4	0.1-0.6							○																	
Medium Cut	**DNMG150604-EM**	0.4	0.2-6.4	0.05-0.30							●	●								●								
	DNMG150608-EM	0.8	0.5-6.4	0.10-0.45							●	●								●								
	DNMG150612-EM	1.2	0.5-6.4	0.1-0.6							●	●								●								
NM	**DNMG150412-NM**	1.2	0.2-4.0	0.2-0.6														○										
	DNMG150608-NM	0.8	0.2-4.0	0.1-0.4															●									
	DNMG150612-NM	1.2	0.2-4.0	0.2-0.6														○	●									
Medium Cut																												
TC	**DNMG150608-TC**	0.8	0.5-5.0	0.15-0.40										●		●												
	DNMG150612-TC	1.2	0.5-5.0	0.2-0.6										●		○												
Medium Cut																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

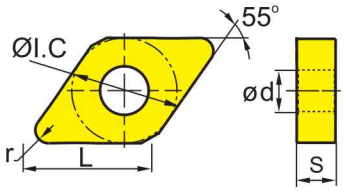
DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	A***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DNMG	L	I.C	S	d
15 06	15.5	12.7	6.35	5.16



DN** negative insert		HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
		YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P		●	●	●	◉	◉	◉										◉	◉			◉	◉	●		
M								○	◉						○	○	◉	◉			◉	◉	○		
K										●		◉	◉												
N														●	●									◉	◉
S															○	○	◉	◉						◉	◉
H																									

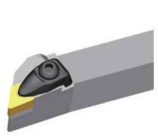
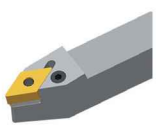
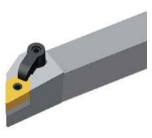
	ISO	r	a_p	f
TK	**DNMG150608-TK**	0.8	0.2-0.4	0.2-0.4
	DNMG150612-TK	1.2	0.2-0.4	0.2-0.45
Medium Cut				
DR	**DNMG150608-DR**	0.8	1-6	0.2-0.5
	DNMG150612-DR	1.2	1-6	0.25-0.70
	DNMG150616-DR	1.6	1-6	0.32-0.75
Roughing				
SNR	**DNMG150608-SNR**	0.8	0.2-6.0	0.1-0.5
	DNMG150612-SNR	1.2	0.2-6.0	0.2-0.6
Roughing				

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

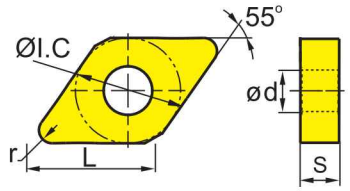
DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	S***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

DN**	L	I.C	S	d
15 06	15.5	12.7	6.35	5.16



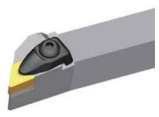
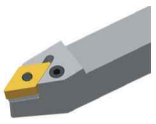
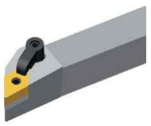
DN** negative insert					HC¹ (CVD)										HC¹ (PVD)							HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉										◉	◉			◉	◉	○		
M											○	◉						○	○	◉	◉	◉	○	○	◉	○		
K													●	◉	◉	◉												
N																	●	●									●	◉
S																		○	○	◉	◉	◉	○				○	◉
H																												
ISO		r	a_p	f																								
Flat	**DNMA150604**	0.4	0.2-6.0	0.1-0.3									●		○													
	DNMA150608	0.8	0.2-6.0	0.1-0.6									●		●													
	DNMA150612	1.2	0.2-6.0	0.15-0.70									●		●													
Medium Cut	**DNMA150616**	1.6	0.2-6.0	0.2-0.8											○													
ER	**DNMG150608-ER**	0.8	2-6	0.15-0.55								○																
	DNMG150612-ER	1.2	2-6	0.25-0.80								○																
Roughing																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

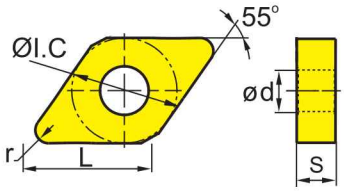
DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	S***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DNMM	L	I.C	S	d
15 06	15.5	12.7	6.35	5.16

Turning inserts



DN** negative insert	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	●	●	●	◉	◉	◉									◉	◉		◉	◉	●		
M							○	◉				○	○	◉	◉	◉	○	◉	◉	○		
K									●	◉	◉	◉										
N												●	●								●	◉
S												○	○	◉	◉	◉	○				○	◉
H																						

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DR	**DNMM150608-DR**	0.8	0.7-6.0	0.20-0.55			●		●																			
	DNMM150612-DR	1.2	1-6	0.25-0.70			●		●	●																		
	DNMM150616-DR	1.6	1.5-6.0	0.32-0.90			●		●																			
Roughing																												
ER	**DNMM150608-ER**	0.8	0.7-6.0	0.20-0.55							○																	
	DNMM150612-ER	1.2	1-6	0.25-0.70								○																
Roughing																												
HDR	**DNMM150608-HDR**	0.8	1-7	0.25-0.60			●		○																			
	DNMM150612-HDR	1.2	1-7	0.3-0.8			○																					
	DNMM150616-HDR	1.6	1.5-7.0	0.4-1.0			○																					
Roughing																												
LR	**DNMM150608-LR**	0.8	2-6	0.1-0.6			●		●			●																
	DNMM150612-LR	1.2	2-6	0.2-0.8					●			○																
	DNMM150616-LR	1.6	2-6	0.25-1.00			●		●																			
Roughing																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	S***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A231	A240	A241	A254	A255	A326	A327

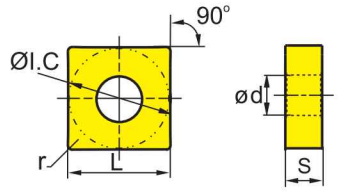
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

SNMG	L	I.C	S	d
09 03	9.525	9.525	3.18	3.81
12 04	12.7	12.7	4.76	5.16

SN** negative insert

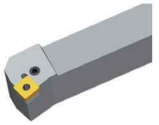


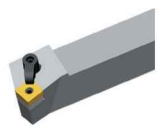
	ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)							HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
ADF	**SNMG120404-ADF**	0.4	0.5-5.0	0.1-0.3	●																●							
	SNMG120408-ADF	0.8	0.5-5.0	0.12-0.50	●																●							
	SNMG120412-ADF	1.2	1-5	0.2-0.6	●																●							
Finishing																												
DF	**SNMG120408-DF**	0.8	0.3-1.5	0.1-0.4			●		●																			
	SNMG120412-DF	1.2	0.35-1.50	0.15-0.50			●		●																			
Finishing																												
SF	**SNMG090304-SF**	0.4	0.05-0.50	0.05-0.20																					●			
	SNMG090308-SF	0.8	0.05-0.50	0.10-0.35																					○			
	SNMG120404-SF	0.4	0.05-0.50	0.05-0.20																					○			
	SNMG120408-SF	0.8	0.05-0.50	0.10-0.35																					○			
Finishing																												

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

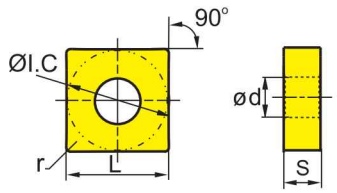
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNMG	L	I.C	S	d
09 03	9.525	9.525	3.18	3.81
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35

SN** negative insert



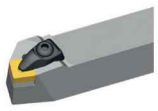
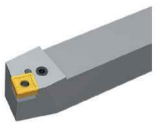
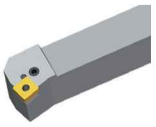
	ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EF	**SNMG090304-EF**	0.4	0.5-2.0	0.05-0.30							●									●								
	SNMG090308-EF	0.8	0.5-2.0	0.05-0.40							●									●								
	SNMG090312-EF	1.2	0.5-2.0	0.05-0.45							○																	
	SNMG120404-EF	0.4	0.8-3.0	0.05-0.30																●								
	SNMG120408-EF	0.8	0.8-3.0	0.1-0.4																●								
Finishing	**SNMG120412-EF**	1.2	0.8-3.0	0.15-0.45							○									●								
	SNMG150608-EF	0.8	1-4	0.1-0.4							○																	
	SNMG150612-EF	1.2	1-4	0.15-0.45							○																	

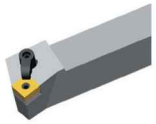
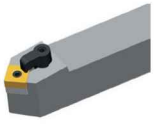
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

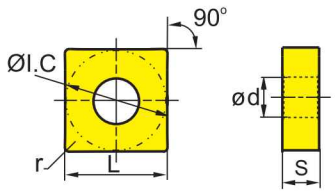
MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNMG	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94

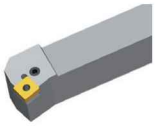
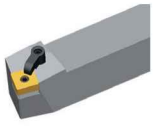


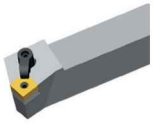
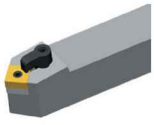
					HC¹ (CVD)												HC¹ (PVD)							HT		HC²	HW	
					P																							
					M																							
					K																							
					N																							
					S																							
					H																							
	ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
XF	**SNMG120404-XF**		0.4	0.5-2.5	0.1-0.25	●			●																			
	SNMG120408-XF		0.8	0.5-2.5	0.1-0.30	●			●																			
Finishing																												
XM	**SNMG120404-XM**		0.4	1-4.2	0.2-0.4	○			○																			
	SNMG120408-XM		0.8	1-4.2	0.2-0.4	●			●																			
	SNMG120412-XM		1.2	1-4.2	0.2-0.6	●			●																			
	SNMG120416-XM		1.6	1-4.2	0.2-0.65	○			○																			
	SNMG150608-XM		0.8	1-5.25	0.2-0.4	●			●																			
	SNMG150612-XM		1.2	1-5.25	0.2-0.6	●			●																			
	SNMG150616-XM		1.6	1-5.25	0.2-0.65	○			●																			
	SNMG190608-XM		0.8	1-6.65	0.2-0.4	○			○																			
	SNMG190612-XM		1.2	1-6.65	0.2-0.6	○			○																			
	SNMG190616-XM		1.6	1-6.65	0.2-0.65	○			○																			
Medium Cut	**SNMG190624-XM**		2.4	1-6.65	0.2-1.2	○			○																			

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

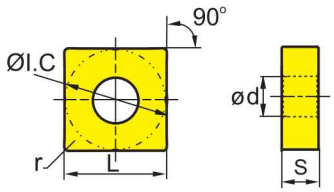
MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

SNMG	L	I.C	S	d
09 03	9.525	9.525	3.18	3.81
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

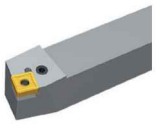
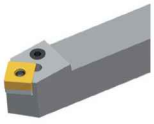
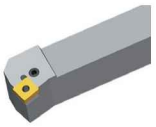
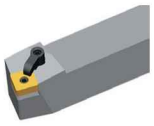


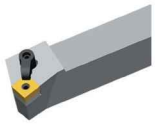
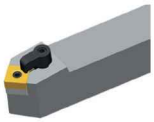
SN** negative insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					P																				
					M																				
					K																				
					N																				
					S																				
					H																				
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
PM Medium Cut	**SNMG090304-PM**	0.4	0.4-4.5	0.1-0.3					○																		
	SNMG090308-PM	0.8	0.5-4.5	0.15-0.50					○				●		●												
	SNMG090312-PM	1.2	0.6-4.5	0.2-0.6					○																		
	SNMG120404-PM	0.4	0.4-6.0	0.1-0.3			●		○						○												
	SNMG120408-PM	0.8	0.5-6.0	0.15-0.50			●		●				○		●												
	SNMG120412-PM	1.2	0.8-6.0	0.18-0.60			●		●				○		●												
	SNMG120416-PM	1.6	1-6	0.23-0.65			○		○				○		○												
	SNMG150608-PM	0.8	0.7-7.5	0.14-0.50			○		○																		
	SNMG150612-PM	1.2	0.8-7.5	0.18-0.60			○		●				●		●												
	SNMG190612-PM	1.2	1.0-7.5	0.20-0.65			○		●				●		●												

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

System code A48 Grade selection A42 Technical info A501 Cutting data A366

SNMG	L	I.C	S	d
09 03	9.525	9.525	3.18	3.81
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

SN** negative insert					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
				P																								
				M																								
				K																								
				N																								
				S																								
				H																								
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DM Medium Cut	**SNMG090304-DM**	0.4	0.4-4.5	0.1-0.3			●	●																				
	SNMG090308-DM	0.8	0.5-4.5	0.15-0.50			●	●																				
	SNMG120404-DM	0.4	0.4-6.0	0.1-0.3			●	●																				
	SNMG120408-DM	0.8	0.5-6.0	0.15-0.50			●	●	○																			
	SNMG120412-DM	1.2	0.8-6.0	0.18-0.60			●	●																				
	SNMG120416-DM	1.6	1-6	0.23-0.65			○	●																				
	SNMG150608-DM	0.8	0.8-7.5	0.1-0.5			●	●																				
	SNMG150612-DM	1.2	0.8-7.5	0.18-0.60			●	●																				
	SNMG190612-DM	1.2	1-9	0.18-0.60			●	●																				
	SNMG190616-DM	1.6	1-9	0.23-0.65			○	●																				
EG Medium Cut	**SNMG120408-EG**	0.8	0.5-4.0	0.1-0.5								●									●	●						
	SNMG120412-EG	1.2	0.5-4.0	0.2-0.6								●									●							

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
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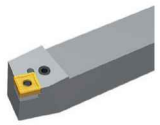
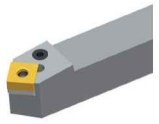
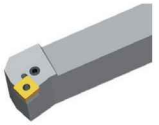
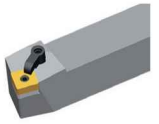
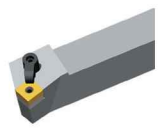
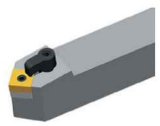
						
A232	A242	A244	A245	A246	A256	A257

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

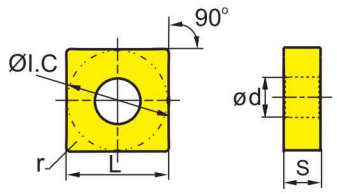
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNMG	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35

SN** negative insert



	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
M							○	◉				○	○	◉	◉	◉	○	○	◉	○			
K									○	◉	◉	◉											
N												○	○								○	◉	
S												○	○	◉	◉	◉	○				○	◉	
H																							

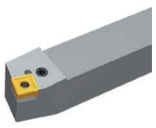
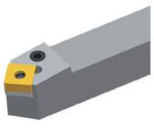
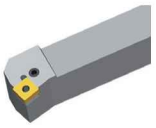
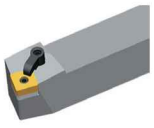
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EM	**SNMG120404-EM**	0.4	0.50-6.35	0.05-0.30								○								●								
	SNMG120408-EM	0.8	0.50-6.35	0.20-0.45							●	●								●								
	SNMG120412-EM	1.2	0.50-6.35	0.25-0.60							●	●								●								
	SNMG120416-EM	1.6	0.50-6.35	0.30-0.75								○																
Medium Cut	**SNMG150612-EM**	1.2	0.5-8.0	0.25-0.60							○	●								●								
	SNMG150616-EM	1.6	0.5-8.0	0.30-0.75								○								●								
TC	**SNMG120404-TC**	0.4	0.5-5.0	0.08-0.25										●														
	SNMG120408-TC	0.8	0.5-5.0	0.15-0.40										●		●												
	SNMG120412-TC	1.2	0.5-5.0	0.2-0.5										●		●												
Medium Cut	**SNMG150616-TC**	1.6	1-7	0.2-0.7										●														
TK	**SNMG120412-TK**	1.2	0.2-0.4	0.2-0.45										●														
Medium Cut																												

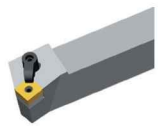
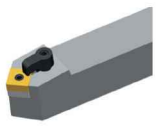
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

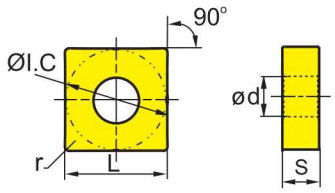
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNMG	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94
25 09	25.4	25.4	9.525	9.12

SN** negative insert



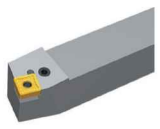
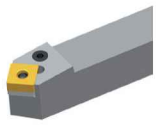
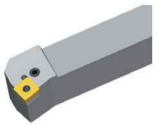
	ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)							HT		HC²	HW		
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201	
NM	**SNMG120408-NM**	0.8	0.5-5.0	0.1-0.4													○	●									○		
	SNMG120412-NM	1.2	0.5-5.0	0.15-0.50														○											
Medium Cut																													
DR	**SNMG120408-DR**	0.8	0.7-7.0	0.2-0.5			○		●				●		●														
	SNMG120412-DR	1.2	1-7	0.25-0.70			●		●	●			○		●														
	SNMG120416-DR	1.6	1.5-7.0	0.32-0.75			○		●				●		●														
	SNMG150612-DR	1.2	1-8	0.25-0.70					●				○		●														
	SNMG150616-DR	1.6	1.5-8.0	0.3-0.8			○		●				○		○														
	SNMG190612-DR	1.2	1-10	0.25-0.70			●		●	●					●														
Roughing	**SNMG190616-DR**	1.6	1.5-10.0	0.3-0.8	○		●	●	●	●			○		●														
	SNMG190624-DR	2.4	2-10	0.32-0.90					●	○																			
	SNMG250924-DR	2.4	2-15	0.4-1.2					●	○																			

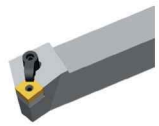
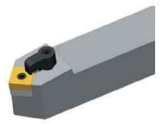
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

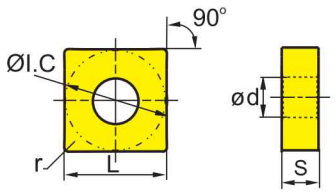
MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

SNMG	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

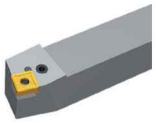
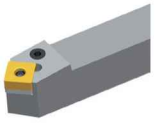
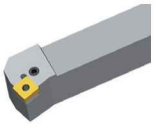
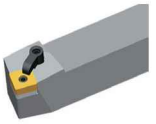
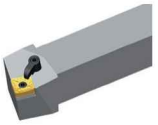


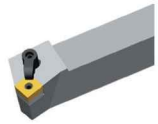
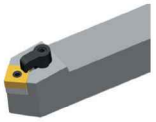
SN** negative insert					HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M											○	◉						○		◉	◉	◉		○	◉	○		
K													●	◉	◉	◉												
N																	●	●									●	◉
S																		●		◉	◉	◉					●	◉
H																												
ISO			r	a_p	f																							
ER	**SNMG120408-ER**		0.8	2.0-7.6	0.20-0.55						○	○																
	SNMG120412-ER		1.2	2.0-7.6	0.3-0.6						○	○																
	SNMG150612-ER		1.2	2.0-9.6	0.3-0.6						○	○																
	SNMG190612-ER		1.2	2.0-11.4	0.3-0.6							○																
	SNMG190616-ER		1.6	2.0-11.4	0.35-0.80						○	○																
SNR	**SNMG120408-SNR**		0.8	1-4	0.2-0.6														●			●						
Roughing																												
Roughing																												

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

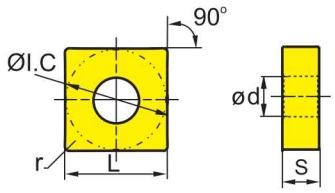
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNMM	L	I.C	S	d
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94
25 07	25.4	25.4	7.94	9.12
25 09	25.4	25.4	9.525	9.12

SN** negative insert



					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
					P																						
					M																						
					K																						
					N																						
					S																						
					H																						
	ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DR	**SNMM150612-DR**		1.2	1-7	0.25-0.60					●																	
	SNMM150616-DR		1.6	1.5-9.0	0.32-0.90			○		●	●																
	SNMM190608-DR		0.8	2.0-10.5	0.25-0.50					○																	
	SNMM190612-DR		1.2	2.0-10.5	0.25-0.60			●		●	●																
	SNMM190616-DR		1.6	2.0-10.5	0.35-0.90			●		●	●																
	SNMM190624-DR		2.4	2.0-10.5	0.4-1.1			●	●	●																	
	SNMM250716-DR		1.6	2.5-12.5	0.4-1.0					●																	
	SNMM250724-DR		2.4	2.5-12.5	0.5-1.2			○		●																	
	SNMM250924-DR		2.4	2.5-12.5	0.5-1.2					●	●																
ER	**SNMM250724-ER**		2.4	2.8-18.0	0.45-1.40					●		○	●														
	SNMM250732-ER		3.2	2.8-18.0	0.32-1.40					●																	
	SNMM250924-ER		2.4	2.8-18.0	0.45-1.40					●	○		○														
	SNMM250932-ER		3.2	2.8-18.0	0.55-1.80					●																	

Roughing

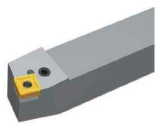
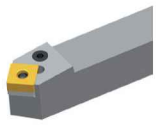
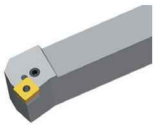
Roughing

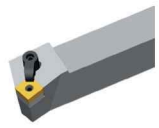
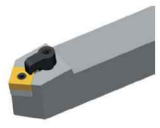
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

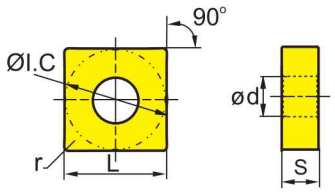
MSKNR/L	MSDNN
Kr: 75°	Kr: 45°
	
A258	A259

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

SNMM	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94
25 09	25.4	25.4	9.525	9.12

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

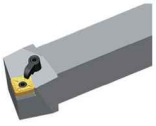


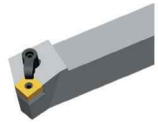
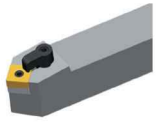
SN** negative insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M											○	◉					○	○	◉	◉	◉	◉	○	○	◉	○		
K													●	◉	◉	◉												
N																	○	○									○	◉
S																	○	○	◉	◉	◉	◉	○				○	◉
H																												
LR  Roughing	**SNMM120408-LR**	0.8	1-6	0.1-0.5			○		●																			
	SNMM120412-LR	1.2	1-6	0.2-0.6			○		●																			
	SNMM120416-LR	1.6	1-6	0.25-0.70					○																			
	SNMM150612-LR	1.2	1.5-7.0	0.1-0.5					●																			
	SNMM150616-LR	1.6	1.5-7.0	0.1-0.5			○		○																			
	SNMM190612-LR	1.2	2-10	0.25-0.70			○		●																			
	SNMM190616-LR	1.6	2-10	0.3-1.0			○		●																			
	SNMM190624-LR	2.4	2-10	0.3-1.1			○		●																			
	SNMM250924-LR	2.4	3.0-12.5	0.3-1.2			○		●	○																		

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

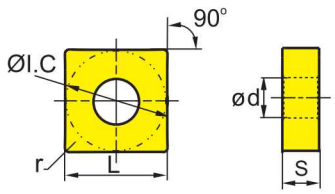
MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

System code A48 Grade selection A42 Technical info A501 Cutting data A366

SNMM	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94
25 07	25.4	25.4	7.94	9.12
25 09	25.4	25.4	9.525	9.12

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

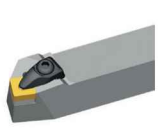
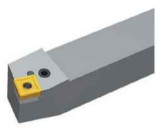
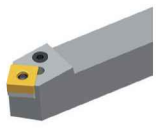
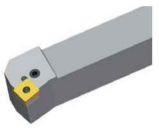


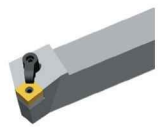
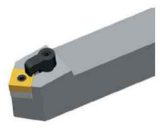
SN** negative insert					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW		
					P																							
					M																							
					K																							
					N																							
					S																							
					H																							
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201		
HDR	**SNMM120408-HDR**	0.8	1-6	0.1-0.6					●																			
	SNMM120412-HDR	1.2	1.5-6.0	0.2-0.7					○																			
	SNMM150608-HDR	0.8	1-7	0.2-0.6						○																		
	SNMM150612-HDR	1.2	1-7	0.25-0.70			●		●																			
	SNMM150616-HDR	1.6	1.5-9.0	0.32-1.00					○																			
	SNMM190612-HDR	1.2	2.0-10.5	0.25-0.70			○		○																			
Roughing	**SNMM190616-HDR**	1.6	2.0-10.5	0.35-1.00			●		●			○																
	SNMM190624-HDR	2.4	2.0-10.5	0.4-1.2			●		●																			
	SNMM250724-HDR	2.4	2.5-12.5	0.5-1.4					●																			
	SNMM250924-HDR	2.4	2.5-12.5	0.5-1.4			●		●	●																		

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

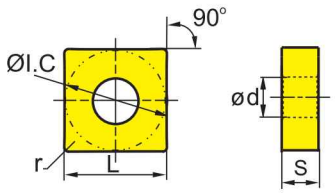
MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNMM	L	I.C	S	d
19 06	19.05	19.05	6.35	7.94
25 09	25.4	25.4	9.525	9.12



					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					●	●	●	◉	◉	◉										◉	◉			◉	◉	●		
M											○	◉					○	○	◉	◉	◉	◉	○	◉	◉	○		
K													●	◉	◉	◉												
N																	●	●									●	◉
S																	○	○	◉	◉	◉	◉	○				○	◉
H																												
ISO			r	a_p	f																							
HPR	**SNMM190616-HPR**		1.6	2.0-10.5	0.35-1.00				●																			
	SNMM190624-HPR		2.4	2.0-10.5	0.4-1.2			○	●																			
	SNMM250924-HPR		2.4	2.0-12.5	0.5-1.4			○	●	●																		
Roughing																												

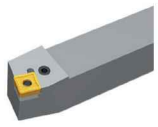
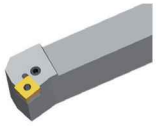
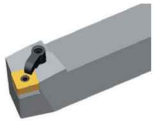
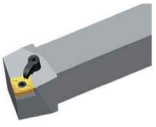
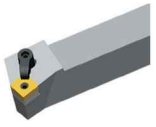
SN** negative insert

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L	MSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°	Kr: 75°
						
A242	A244	A245	A246	A256	A257	A258

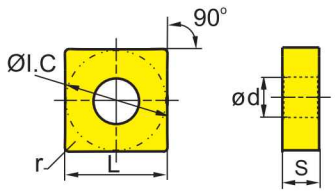
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNMG	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
25 07	25.4	25.4	7.94	9.12
25 09	25.4	25.4	9.525	9.12

SN** negative insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
P	○	○	○	◎	◎	◎									◎	◎			○	◎	○		
M							○	◎				○	○	◎	◎	◎	○		○	◎	○		
K									◎	◎	◎	◎											
N												○	○									◎	◎
S												○	○	◎	◎	◎	○					◎	◎
H																							

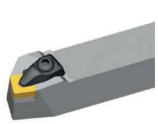
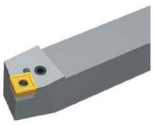
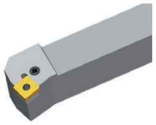
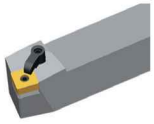
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Basic	**SNMG120408**	0.8	0.5-6.0	0.1-0.6			●		●																			
	SNMG120412	1.2	0.5-6.0	0.1-0.7			○		○																			
	SNMG250724	2.4	1-9	0.1-1.1																								
Medium Cut	**SNMG250924**	2.4	1-9	0.1-1.1																								

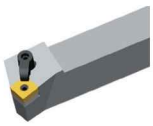
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

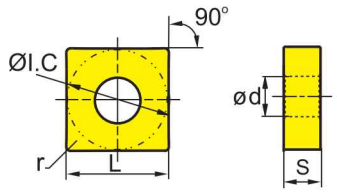
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

SN**	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94
25 07	25.4	25.4	7.94	9.12

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

SN** negative insert

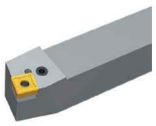
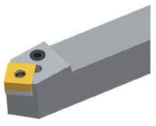
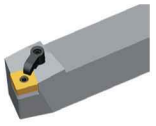


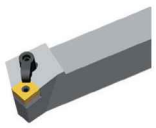
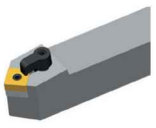
		ISO	r	a_p	f	HC¹ (CVD) YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	HC¹ (PVD) YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	HT YNG151	YNT251	HC² YNG151C	HW YD101	YD201
	P																												
	M																												
	K																												
	N																												
	S																												
	H																												
Flat		**SNMA120408**	0.8	0.5-5.0	0.1-0.5									●	●	●													
		SNMA120412	1.2	0.5-5.0	0.2-0.7									○	○	●	○												
		SNMA120416	1.6	0.5-5.0	0.2-1.0									○	●	○													
		SNMA150608	0.8	0.8-7.0	0.1-0.5											○													
		SNMA150612	1.2	0.8-7.0	0.2-0.7											●													
		SNMA190612	1.2	0.8-7.0	0.2-0.7									○		●													
		SNMA190616	1.6	0.8-7.0	0.3-0.8									○		●													
Basic		**SNMM250724-1**	2.4	2.0-12.5	0.3-1.2					●	●																		

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DSBNR/L	PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L
Kr: 75°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°
						
A232	A242	A244	A245	A246	A256	A257

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A258	A259	A329

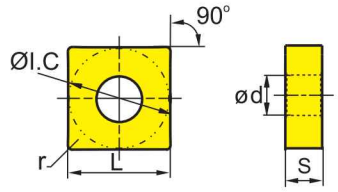
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

SNMM	L	I.C	S	d
19 06	19.05	19.05	6.35	7.94
25 09	25.4	25.4	9.525	9.12

SN** negative insert

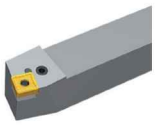
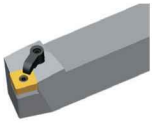
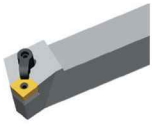


					HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P		ISO	r	a_p	f																							
Basic	**SNMM190612**		1.2	1.5-10.5	0.2-0.7					○																		
	SNMM190616		1.6	0.5-10.5	0.2-1.0					○																		
	SNMM250924		2.4	2.0-12.5	0.3-1.2					●																		
M																												
K																												
N																												
S																												
H																												

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L	MSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°	Kr: 75°
						
A242	A244	A245	A246	A256	A257	A258

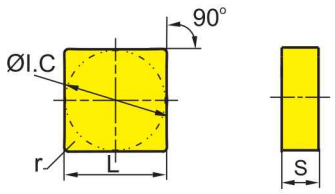
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SNUN	L	I.C	S
12 04	12.7	12.7	4.76
19 04	19.05	19.05	4.76

SN** negative insert



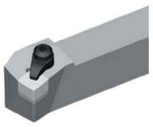
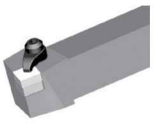
	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	●	●	●	◉	◉	◉									◉	◉		◉	◉	●		
M							○	◉				○	○	◉	◉	◉	○	◉	◉	○		
K									●	◉	◉	◉										
N												●	●								●	◉
S												○	○	◉	◉	◉	○				○	◉
H																						

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Flat	**SNUN120408**	0.8	0.7-6.0	0.2-0.5											●													
	SNUN120412	1.2	0.7-6.0	0.25-0.60									○		○													
	SNUN190412	1.2	0.9-6.0	0.25-0.60																							○	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

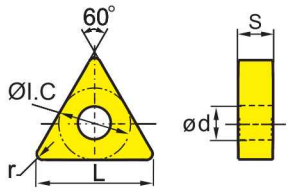
CSKNR/L	CSRNR/L	CSDNN
Kr: 75°	Kr: 75°	Kr: 45°
		
A296	A297	A299

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TN**	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16



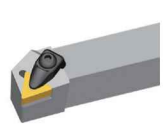
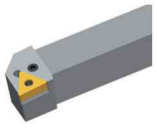
TN** negative insert					HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
WG	**TNMX160408-WG**	0.8	0.5-5.0	0.15-0.70			●																					
	**TNMX160412-WG**	1.2	0.8-6.0	0.20-0.75			○																					
Wiper																												
ADF	**TNMG160404-ADF**	0.4	0.5-5.0	0.05-0.30		●															●				●			
	**TNMG160408-ADF**	0.8	0.5-5.0	0.1-0.4		●														○	●				●			
	TNMG160412-ADF	1.2	0.5-5.0	0.2-0.5		●															●							
Finishing																												
DF	**TNMG160404-DF**	0.4	0.15-2.00	0.08-0.25			●		●																			
	**TNMG160408-DF**	0.8	0.15-2.00	0.1-0.3			●		●																			
	TNMG160412-DF	1.2	0.35-1.50	0.15-0.50			●		●																			
	TNMG220408-DF	0.8	0.3-1.5	0.1-0.4			●		●																			
Finishing	**TNMG220412-DF**	1.2	0.35-1.50	0.15-0.50			●																					

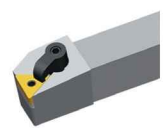
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TNMG	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81

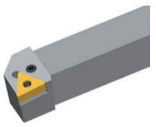
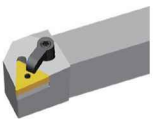
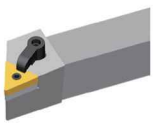
Turning inserts

TN** negative insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW		
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M											○	◉					○	○	◉	◉	◉	◉	○	○	◉	○		
K													○	◉	◉	◉												
N																	○	○									○	◉
S																	○	○	◉	◉	◉	◉	○				○	◉
H																												
ISO			r	a_p																								
SF	**TNMG160404-SF**		0.4	0.05-1.00																			○	●			
	TNMG160408-SF		0.8	0.05-1.00																				●			
Finishing																												

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

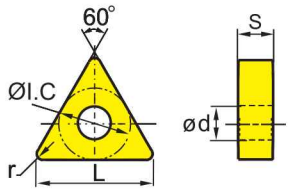
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TNMG	L	I.C	S	d
11 03	11	6.35	3.18	2.26
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16

TN** negative insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW		
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○			
M							○	◉					○	○	◉	◉	◉	○	○	◉	○			
K									●	◉	◉	●												
N													●	●								●	◉	
S													○	○	◉	◉	◉	○				○	◉	
H																								

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EF	**TNMG110304-EF**	0.4	0.1-1.0	0.05-0.20																●								
	TNMG110308-EF	0.8	0.1-1.0	0.05-0.40																●								
	TNMG160404-EF	0.4	0.1-1.5	0.05-0.30							●									●								
	TNMG160408-EF	0.8	0.1-1.5	0.1-0.4							●									●								
	TNMG160412-EF	1.2	0.2-2.5	0.15-0.40							○									●								
	TNMG220404-EF	0.4	0.5-2.5	0.05-0.25							○									●								
	TNMG220408-EF	0.8	0.5-2.5	0.1-0.4							○									●								

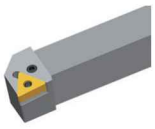
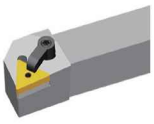
Finishing

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

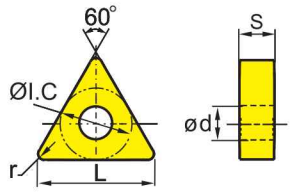
MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TNMG	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16



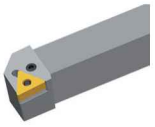
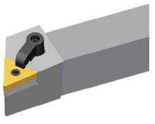
TN** negative insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M											○	◉					○	○	◉	◉	◉	○	○	◉	◉	○		
K													◉	◉	◉	◉												
N																	○	○									○	◉
S																	○	○	◉	◉	◉	◉	○				○	◉
H																												
	ISO		r	a_p	f																							
FM	**TNMG160404L-FM**		0.4	0.5-3.0	0.1-0.3				●											●								
	TNMG160404R-FM		0.4	0.5-3.0	0.1-0.3			○	●											●								
	TNMG160408L-FM		0.8	0.5-3.0	0.15-0.50			○	●											●								
	TNMG160408R-FM		0.8	0.5-3.0	0.15-0.50			●	●											●								
Finishing																												
XM	**TNMG160404-XM**		0.4	1-5.6	0.2-0.4	●			○																			
	TNMG160408-XM		0.8	1-5.6	0.2-0.4	●			●																			
	TNMG160412-XM		1.2	1-5.6	0.2-0.6	●			●																			
	TNMG160416-XM		1.6	1-5.6	0.2-0.65	○			●																			
	TNMG220408-XM		0.8	1-7.7	0.2-0.4	●			●																			
	TNMG220412-XM		1.2	1-7.7	0.2-0.6	●			●																			
Medium Cut	**TNMG220416-XM**		1.6	1-7.7	0.2-0.65	○			●																			

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

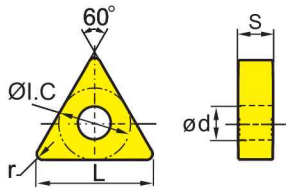
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TNMG	L	I.C	S	d
11 03	11	6.35	3.18	2.26
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16

TN** negative insert

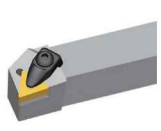
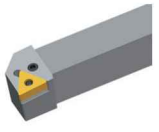
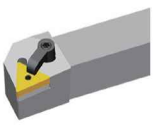


		ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)							HT		HC²	HW		
						YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DM	Medium Cut	**TNMG110308-DM**	0.8	0.3-3.0	0.1-0.4			○		●																			
		TNMG160404-DM	0.4	0.4-5.0	0.1-0.3			●		●			●																
		TNMG160408-DM	0.8	0.5-5.0	0.15-0.50			●		●			○																
		TNMG160412-DM	1.2	0.8-5.0	0.18-0.60			●		●																			
		TNMG220404-DM	0.4	0.4-6.6	0.1-0.3			●		●																			
		TNMG220408-DM	0.8	0.5-6.6	0.15-0.50			●		●																			
		TNMG220412-DM	1.2	0.8-6.6	0.18-0.60			●		●																			
		TNMG220416-DM	1.6	1.0-6.6	0.23-0.65			●		●																			
PM	Medium Cut	**TNMG110304-PM**	0.4	0.4-3.0	0.1-0.3					●																			
		TNMG110308-PM	0.8	0.4-3.0	0.15-0.40					●																			
		TNMG160404-PM	0.4	0.4-5.0	0.1-0.3			●		●				●		●													
		TNMG160408-PM	0.8	0.5-5.0	0.15-0.50			●		●				●		●													
		TNMG160412-PM	1.2	0.8-5.0	0.18-0.60			●		●				○		○													
		TNMG220408-PM	0.8	0.5-6.6	0.15-0.50			○		●				●		●													
		TNMG220412-PM	1.2	0.8-6.6	0.18-0.60			○		●				●		●													
		TNMG220416-PM	1.6	1.0-6.6	0.23-0.65					○						○													

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

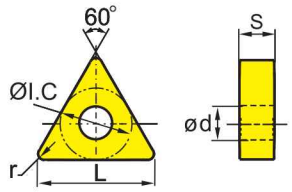
MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TNMG	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81

Turning inserts

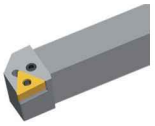


TN** negative insert					HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M											○	◉					○	○	◉	◉	◉			○	◉	○		
K													◉	◉	◉	◉												
N																	○	○									○	◉
S																	○	○	◉	◉	◉						○	◉
H																												
ISO			r	a_p																								
ZM	**TNMG160404-ZM**		0.4	0.5-5.0	0.08-0.30		●																					
	TNMG160408-ZM		0.8	0.5-5.0	0.1-0.4		●																					
	TNMG160412-ZM		1.2	0.5-5.0	0.1-0.6		●																					
Medium Cut																												
SNR	**TNMG160408-SNR**		0.8	1-5.6	0.1-0.5																	●						
Roughing																												

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

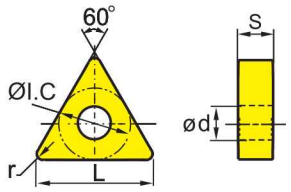
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TNMG	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16

TN** negative insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
M							○	◉				○	○	◉	◉	◉	○		○	◉	○		
K									◉	◉	◉	◉											
N												●	●									◉	◉
S													○	○	◉	◉	◉	○				○	◉
H																							

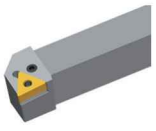
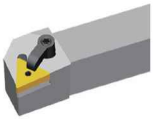
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EG	**TNMG160404-EG**	0.4	0.5-4.0	0.1-0.3																	●							
	TNMG160408-EG	0.8	0.5-4.0	0.1-0.4							●	●								●	●							
	TNMG160412-EG	1.2	0.5-4.0	0.15-0.50								●								●								
Medium Cut																												
EM	**TNMG160404-EM**	0.4	0.5-4.8	0.05-0.30							●	○								●								
	TNMG160408-EM	0.8	0.5-4.8	0.10-0.45							●	●								●								
	TNMG160412-EM	1.2	0.5-4.8	0.1-0.6							●	●								●								
	TNMG220408-EM	0.8	0.5-6.6	0.10-0.45							●	●								●								
Medium Cut	**TNMG220412-EM**	1.2	0.5-6.6	0.1-0.6							○	●								●								
	TNMG220416-EM	1.6	0.5-6.6	0.10-0.65								●								●								
TC	**TNMG160404-TC**	0.4	0.5-3.0	0.05-0.20										●		●												
	TNMG160408-TC	0.8	0.5-3.0	0.08-0.25										●		●												
	TNMG160412-TC	1.2	1-3	0.1-0.3										●		●												
	TNMG220412-TC	1.2	1-6	0.15-0.40										●		●												
Medium Cut	**TNMG220416-TC**	1.6	1-6	0.2-0.5										●														

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

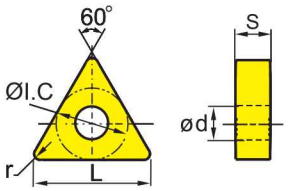
MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

TNMG	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16
27 06	27.5	15.875	6.35	6.35



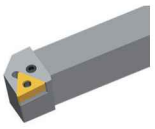
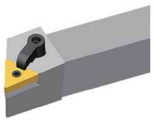
TN** negative insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					P																				
					M																				
					K																				
					N																				
					S																				
					H																				
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DR	**TNMG160408-DR**	0.8	0.7-6.0	0.20-0.55			●		●				●		●												
	TNMG160412-DR	1.2	1-6	0.25-0.65			●		●				○		●												
	TNMG220408-DR	0.8	0.7-7.0	0.20-0.55					●						○												
	TNMG220412-DR	1.2	1-7	0.25-0.65			○		●						●												
	TNMG220416-DR	1.6	1.5-7.0	0.32-0.75					●				○		●												
	TNMG270608-DR	0.8	1.5-12.0	0.35-0.55																							
	TNMG270612-DR	1.2	2-12	0.35-0.75					○																		

Roughing

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

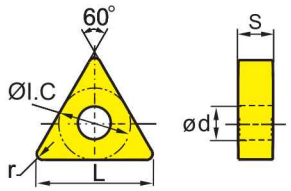
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TN**	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16
27 06	27.5	15.875	6.35	5.16

TN** negative insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	●	●	●	◉	◉	◉										◉	◉			●	◉	●		
M							○	◉						○	○	◉	◉	◉	○	○	◉	○		
K									◉	◉	◉	◉												
N													●	●									◉	◉
S														○	○	◉	◉	◉	○				◉	◉
H																								

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DR	**TNMM160408-DR**	0.8	0.7-6.0	0.20-0.55			○		●																			
	TNMM160412-DR	1.2	1-6	0.25-0.70			○																					
	TNMM220408-DR	0.8	0.7-8.0	0.20-0.55			○		○																			
	TNMM220412-DR	1.2	1-8	0.25-0.70					●																			
	TNMM220416-DR	1.6	1.5-8.0	0.32-0.90					○																			
	TNMM270612-DR	1.2	2.5-11.0	0.25-0.70					○																			
	TNMM270616-DR	1.6	2.5-11.0	0.3-0.9					○																			
ER	**TNMG160408-ER**	0.8	2.0-5.6	0.15-0.55								○																
	TNMG160412-ER	1.2	2.0-5.6	0.15-0.60								○																
	TNMG220408-ER	0.8	2.0-7.7	0.15-0.55								○																
	TNMG220412-ER	1.2	2.0-7.7	0.15-0.60								○																
LR	**TNMM160408-LR**	0.8	1-5	0.1-0.5			●		●			●																
	TNMM160412-LR	1.2	1.5-6.0	0.1-0.6			○		○			○																

Roughing

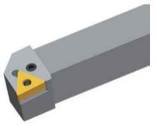
● Ex stock ○ On demand

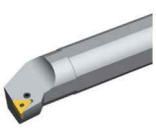
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

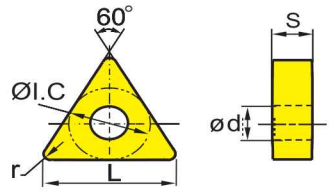
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TNMM	L	I.C	S	d
22 04	22	12.7	4.76	5.16
27 06	27.5	15.875	6.35	6.35

TN** negative insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
P	●	●	●	◉	◉	◉									◉	◉			●	◉	●		
M							○	◉				○	○	◉	◉	◉	◉	○	○	◉	○		
K									◉	◉	◉	◉											
N												●	●									◉	◉
S												●	●	◉	◉	◉	◉	●				●	◉
H																							

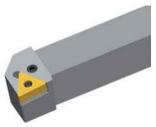
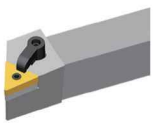
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
HDR	**TNMM220412-HDR**	1.2	2-9	0.25-0.80			○																					
	TNMM220416-HDR	1.6	2-9	0.35-1.00					○																			
	TNMM270616-HDR	1.6	2-6	0.35-1.00					●																			
Heavy Turning	**TNMM270624-HDR**	2.4	2-7	0.4-1.2					●			○																

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

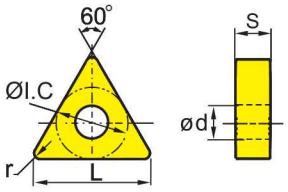
PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L	MTFNR/L
Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°	Kr: 91°
						
A247	A248	A249	A260	A261	A262	A263

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

TNMG	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16
27 06	27.5	15.875	6.35	6.35
33 09	33	19.05	9.525	7.94

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

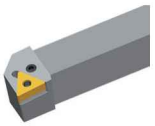
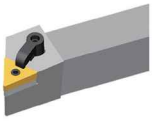


TN** negative insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					P																				
					M																				
					K																				
					N																				
					S																				
					H																				
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Basic	**TNMG160404**	0.4	0.2-4.0	0.05-0.20					○																		
	TNMG160408	0.8	0.2-4.0	0.08-0.30			●		●																		
	TNMG160412	1.2	0.2-4.0	0.1-0.4			●																				
	TNMG220404	0.4	0.2-6.0	0.05-0.20					○																		
	TNMG220408	0.8	0.2-6.0	0.1-0.3																							
	TNMG220416	1.6	0.2-6.0	0.1-0.5					○																		
Medium Cut	**TNMG270612**	1.2	0.2-9.0	0.1-0.5					○																		
	TNMG270616	1.6	0.2-9.0	0.1-0.5					○																		
	TNMG330916	1.6	0.2-11.0	0.1-0.5					○																		
	TNMG330924	2.4	0.2-11.0	0.1-0.7																							

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

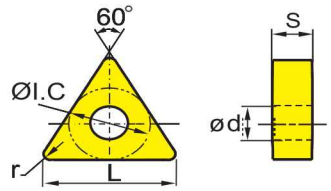
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TN**	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16
27 06	27.5	15.875	6.35	6.35

TN** negative insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
P	○	○	○	◉	◉	◉									◉	◉				○	◉	○		
M							○	◉					○	○	◉	◉	◉	○	○	◉	○			
K									●	◉	◉	◉												
N													●	●									●	◉
S													●	○	◉	◉	◉	○					●	◉
H																								

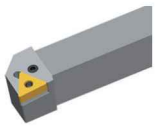
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Flat	**TNMA160404**	0.4	0.2-4.0	0.05-0.20									○		●													
	TNMA160408	0.8	0.2-4.0	0.08-0.30									●	●	●													
	TNMA160412	1.2	0.2-4.0	0.1-0.4									○		●													
	TNMA160416	1.6	0.5-4.0	0.05-0.50									○		○													
	TNMA220404	0.4	0.2-6.0	0.05-0.20											●													
	TNMA220408	0.8	0.2-6.0	0.1-0.3									●		●													
	TNMA220412	1.2	0.2-6.0	0.1-0.4											●	●												
	TNMA220416	1.6	0.2-6.0	0.1-0.5												○												
Basic	**TNMM160404**	0.4	0.2-7.0	0.05-0.60					○																			
	TNMM160408	0.8	0.5-7.0	0.05-0.60					○																			
	TNMM220408	0.8	0.5-7.0	0.05-0.60					○																			
	TNMM220412	1.2	1-7	0.1-0.6																								
	TNMM220416	1.6	0.5-7.0	0.05-0.60					○																			
	TNMM270616	1.6	0.5-6.5	0.05-0.70					○																			

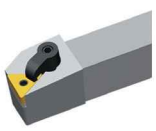
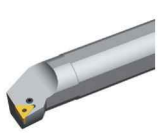
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

DTGNR/L	PTFNR/L	PTTNR/L	PTGNR/L	MTGNR/L	MTJNR/L	MTJNR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A233	A247	A248	A249	A260	A261	A262

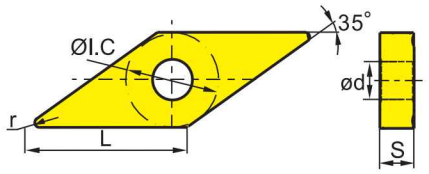
MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A263	A330

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VN**	L	I.C	S	d
16 04	16.6	9.525	4.76	3.81

Turning inserts



VN** negative insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					P																				
					M																				
					K																				
					N																				
					S																				
					H																				
	ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
ADF	**VNMG160404-ADF**		0.4	0.5-2.5	0.1-0.3		●															●						
	VNMG160408-ADF		0.8	0.5-2.5	0.1-0.5		●															●						
Finishing																												
DF	**VNMG160404-DF**		0.4	0.25-1.50	0.07-0.30			○		●																		
	VNMG160408-DF		0.8	0.3-1.5	0.1-0.4			●		●																		
Finishing																												
EF	**VNMG160404-EF**		0.4	0.1-1.5	0.05-0.25							●								●								
	VNMG160408-EF		0.8	0.2-2.5	0.08-0.35							●								●								
	VNMG160412-EF		1.2	0.2-2.5	0.10-0.45							○																
Finishing																												
NF	**VNEG160404-NF**		0.4	0.2-4.0	0.05-0.30															●							○	
	VNEG160408-NF		0.8	0.2-4.0	0.05-0.50															●							○	
Finishing																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

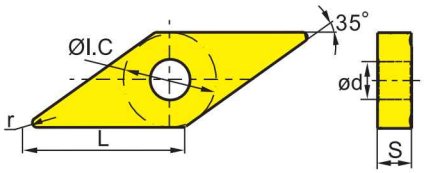
DVVNN	DVJNR/L	MVVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A234	A235	A264	A265

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VN**	L	I.C	S	d
16 04	16.6	9.525	4.76	3.81



VN** negative insert		HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
		YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P		○	○	○	◎	◎	◎										◎	◎			○	◎	○		
M								○	◎						○	○	◎	◎	◎	○	○	◎	○		
K										○	◎	◎	◎												
N														○	○									○	◎
S														○	○	◎	◎	◎	◎	○				○	◎
H																									
	ISO	r	a_p	f																					
NGF	**VNEG160408-NGF**	0.8	0.2-3.0	0.1-0.3												●									
	VNEG160412-NGF	1.2	0.2-3.0	0.1-0.5												○									
Finishing																									
SF	**VNMG160404-SF**	0.4	0.05-3.00	0.05-0.20																			●		
	VNMG160408-SF	0.8	0.05-3.00	0.05-0.35																			○		
Finishing																									

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

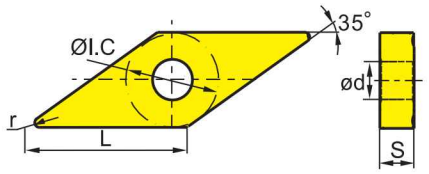
DVVNN	DVJNR/L	MVVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A234	A235	A264	A265

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VNMG	L	I.C	S	d
16 04	16.6	9.525	4.76	3.81

Turning inserts



	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	●	●	●	◉	◉	◉									◉	◉		◉	◉	●		
M							●	◉				●	●	◉	◉	◉	●	◉	◉	●		
K									●	◉	◉	◉										
N												●	●								●	◉
S												●	●	◉	◉	◉	●				●	◉
H																						

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
XF	**VNMG160404-XF**	0.4	0.5-2.5	0.1-0.25	●																							
	VNMG160408-XF	0.8	0.5-2.5	0.1-0.30	●																							
	VNMG160412-XF	1.2	0.5-2.5	0.1-0.35	●																							
Finishing																												
XM	**VNMG160404-XM**	0.4	1-5.6	0.2-0.4	●			○																				
	VNMG160408-XM	0.8	1-5.6	0.2-0.4	●			●																				
	VNMG160412-XM	1.2	1-5.6	0.2-0.6	●			●																				
	VNMG160416-XM	1.6	1-5.6	0.2-0.65	○			○																				
Medium Cut																												

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DVVNN	DVJNR/L	MVVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A234	A235	A264	A265

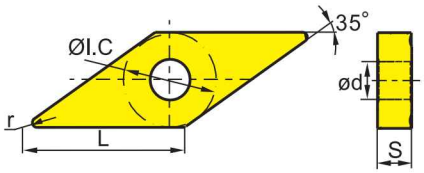
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VNMG	L	I.C	S	d
16 04	16.6	9.525	4.76	3.81

VN** negative insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M							○	◉					○	○	◉	◉	◉	○		○	◉	○		
K									◉	◉	◉	◉												
N													○	○									◉	◉
S													○	○	◉	◉	◉	○					○	◉
H																								

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Basic	**VNMG160404**	0.4	0.2-6.0	0.05-0.60			○																					
	VNMG160408	0.8	0.2-6.0	0.08-0.60			○																					
Medium Cut																												
DM	**VNMG160408-DM**	0.8	0.5-4.0	0.15-0.50			●		●																			
	VNMG160412-DM	1.2	0.8-4.0	0.18-0.60			●		●																			
Medium Cut																												
EM	**VNMG160404-EM**	0.4	0.2-3.0	0.05-0.30							●									●								
	VNMG160408-EM	0.8	0.5-4.0	0.10-0.45							●									●								
Medium Cut																												
NM	**VNMG160412-NM**	1.2	0.2-4.0	0.05-0.40															●									
Medium Cut																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DVVNN	DVJNR/L	MVVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A234	A235	A264	A265

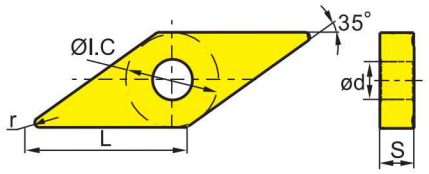
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VNMG	L	I.C	S	d
16 04	16.6	9.525	4.76	3.81

Turning inserts

VN** negative insert



	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	○	○	○	◉	◉	◉									◉	◉		○	◉	○		
M							○	◉				○	○	◉	◉			○	◉	○		
K									○	◉	◉	◉										
N													○	○							○	◉
S													○	○	◉	◉					○	◉
H																						

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
PM	**VNMG160404-PM**	0.4	0.4-4.0	0.13-0.40			●		●				●		○													
	VNMG160408-PM	0.8	0.5-4.0	0.15-0.50			●		●				●		●													
	VNMG160412-PM	1.2	0.8-4.0	0.18-0.60					●				●															
Medium Cut																												
TC	**VNMG160404-TC**	0.4	0.5-2.0	0.05-0.20										●		●												
	VNMG160408-TC	0.8	0.5-2.0	0.08-0.25										●		●												
	VNMG160412-TC	1.2	0.5-3.0	0.08-0.30										●		●												
Medium Cut																												
ZM	**VNMG160404-ZM**	0.4	0.5-3.0	0.08-0.30		○																						
	VNMG160408-ZM	0.8	0.5-3.0	0.1-0.4		●																						
Medium Cut																												
SNR	**VNMG160408-SNR**	0.8	0.2-2.0	0.1-0.4															●		○	●						
	VNMG160412-SNR	1.2	0.2-2.0	0.1-0.5															●		○	●						
Roughing																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

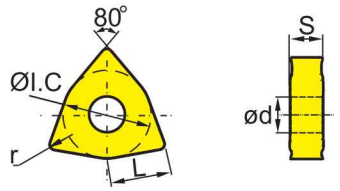
DVVNN	DVJNR/L	MVVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A234	A235	A264	A265

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

WNMG	L	I.C	S	d
06 T3	6.5	9.525	3.97	3.81
06 04	6.5	9.525	4.76	3.81
08 04	8.7	12.7	4.76	5.16



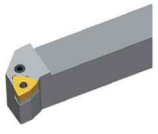
WN** negative insert					HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW		
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201	
	ISO		r	a_p	f																								
ADF	**WNMG080404-ADF**		0.4	0.2-2.5	0.05-0.30	●															●			●					
	WNMG080408-ADF		0.8	0.5-2.5	0.05-0.40	●														○	●			●					
	WNMG080412-ADF		1.2	0.5-2.5	0.05-0.50	●															●								
Finishing																													
DF	**WNMG060404-DF**		0.4	0.15-2.00	0.08-0.25		●		●																				
	WNMG060408-DF		0.8	0.15-2.00	0.1-0.3		●		●																				
	WNMG080404-DF		0.4	0.15-2.00	0.08-0.25		●		●																				
	WNMG080408-DF		0.8	0.15-2.00	0.1-0.3		●		○																				
Finishing	**WNMG080412-DF**		1.2	0.2-2.5	0.10-0.35		●		●																				
SF	**WNMG060404-SF**		0.4	0.05-0.50	0.05-0.20																					●			
	WNMG060408-SF		0.8	0.05-0.50	0.05-0.35																					●			
	WNMG06T304-SF		0.4	0.05-0.50	0.05-0.20																					●			
	WNMG06T308-SF		0.8	0.05-0.50	0.05-0.35																					●			
	WNMG080404-SF		0.4	0.05-0.50	0.05-0.20																					●			
Finishing	**WNMG080408-SF**		0.8	0.05-0.50	0.05-0.35																					●			

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

DWLNR/L	PWLNR/L	MWLNR/L	S***-PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A236	A251	A266	A332

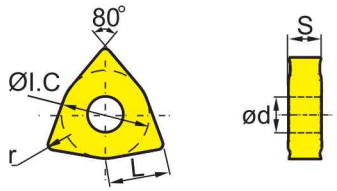
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

WN**	L	I.C	S	d
06 T3	6.5	9.525	3.97	3.81
06 04	6.5	9.525	4.76	3.81
08 04	8.7	12.7	4.76	5.16

WN** negative insert



		ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
						YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
WG		**WNMG080408-WG**	0.8	0.5-5.0	0.15-0.70			●		●																		
		WNMG080412-WG	1.2	0.8-6.0	0.20-0.75			●		○																		
Wiper																												
EF		**WNMG060404-EF**	0.4	0.1-1.5	0.05-0.30							○								●								
		WNMG060408-EF	0.8	0.1-1.5	0.1-0.4							○								●								
		WNMG06T308-EF	0.8	0.1-1.5	0.1-0.4															●								
		WNMG080404-EF	0.4	0.1-1.5	0.05-0.30							●								●								
Finishing		**WNMG080408-EF**	0.8	0.1-1.5	0.1-0.4							●							○		●								
NF		**WNEG080404-NF**	0.4	0.2-3.0	0.05-0.30														○	●								
		WNEG080408-NF	0.8	0.2-2.5	0.05-0.30															●								
Finishing																												
NF		**WNMG060408-NF**	0.8	0.2-2.5	0.05-0.30															●								
Finishing																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

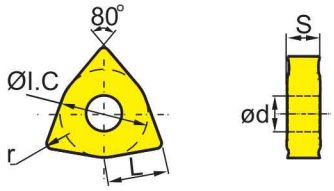
DWLNR/L	PWLNR/L	MWLNR/L	S***-PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A236	A251	A266	A332

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

WNMG	L	I.C	S	d
06 04	6.5	9.525	4.76	3.81
08 04	8.7	12.7	4.76	5.16

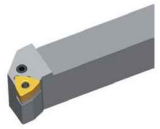
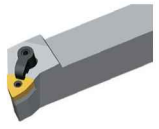


WN** negative insert					HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◍	◍	◍											◍	◍		○	◍	○		
M											○	◍					○	○	◍	◍	◍	◍	○	○	◍	○		
K													○	◍	◍	◍												
N																	○	○									○	◍
S																	○	○	◍	◍	◍	◍	○				○	◍
H																												
	ISO		r	a_p	f																							
XF	**WNMG060404-XF**		0.4	0.5-2.0	0.1-0.25	●																						
	WNMG060408-XF		0.8	0.5-2.0	0.1-0.30	●																						
	WNMG080408-XF		0.8	0.5-2.5	0.1-0.30	●																						
	WNMG080412-XF		1.2	0.5-2.5	0.1-0.35	●																						
Finishing																												
XM	**WNMG060404-XM**		0.4	1-2.1	0.2-0.4	●		○																				
	WNMG060408-XM		0.8	1-2.1	0.2-0.4	●		●																				
	WNMG060412-XM		1.2	1-2.1	0.2-0.6	●		●																				
	WNMG080404-XM		0.4	1-2.8	0.2-0.4	●		●																				
	WNMG080408-XM		0.8	1-2.8	0.2-0.4	●		●																				
	WNMG080412-XM		1.2	1-2.8	0.2-0.6	●		●																				
Medium Cut	**WNMG080416-XM**		1.6	1-2.8	0.2-0.65	○		○																				

● Ex stock ○ On demand

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

DWLNR/L	PWLNR/L	MWLNR/L	S***-PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A236	A251	A266	A332

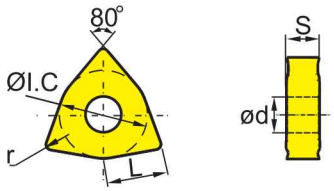
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

WNMG	L	I.C	S	d
06 T3	6.5	9.525	3.97	3.81
06 04	6.5	9.525	4.76	3.81
08 04	8.7	12.7	4.76	5.16

WN** negative insert



	ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
DM Medium Cut	**WNMG060408-DM**	0.8	0.5-3.0	0.15-0.50			●		●																		
	WNMG060412-DM	1.2	0.8-3.0	0.18-0.60		○	●		●																		
	WNMG06T308-DM	0.8	0.5-3.0	0.15-0.15					○																		
	WNMG080404-DM	0.4	0.5-4.0	0.1-0.4			●		●																		
	WNMG080408-DM	0.8	0.5-4.0	0.15-0.50		○	●		●	●		●															
	WNMG080412-DM	1.2	0.8-4.0	0.18-0.60		○	●		●																		
	WNMG080416-DM	1.6	1-4	0.23-0.65			●		●																		
EG Medium Cut	**WNMG080408-EG**	0.8	0.5-4.0	0.05-0.40							○	●								●	●						
	WNMG080412-EG	1.2	0.5-4.0	0.05-0.60							○	●								●	●						
EM Medium Cut	**WNMG060404-EM**	0.4	0.5-3.0	0.05-0.30							○	●								●							
	WNMG060408-EM	0.8	0.5-3.0	0.1-0.5							●	●								●							
	WNMG06T304-EM	0.4	0.5-3.0	0.05-0.30							●																
	WNMG06T308-EM	0.8	0.5-3.0	0.1-0.5							●																
	WNMG06T312-EM	1.2	0.5-3.0	0.1-0.7							○									○							
	WNMG080404-EM	0.4	1-4	0.05-0.30							●	●								●							
	WNMG080408-EM	0.8	1-4	0.1-0.5							●	●								●							
	WNMG080412-EM	1.2	1-4	0.1-0.7							●	●								●							

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DWLNR/L	PWLNR/L	MWLNR/L	S***-PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A236	A251	A266	A332

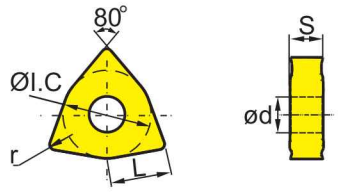
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

WNMG	L	I.C	S	d
06 04	6.5	9.525	4.76	3.81
08 04	8.7	12.7	4.76	5.16

WN** negative insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
M							○	◉				○			◉	◉	◉		○	◉	○		
K									◉	◉	◉	◉											
N												○	○									○	◉
S												○			◉	◉	◉					○	◉
H																							

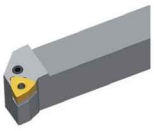
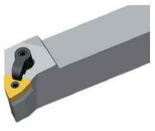
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
PM	**WNMG060408-PM**	0.8	0.5-3.0	0.15-0.50			●		●				●		●													
	WNMG060412-PM	1.2	0.8-3.0	0.18-0.60			●		○				○															
	WNMG080404-PM	0.4	0.4-4.0	0.12-0.40			●		●				●		●													
	WNMG080408-PM	0.8	0.5-4.0	0.15-0.50			●		●	●			●		●													
Medium Cut	**WNMG080412-PM**	1.2	0.8-4.0	0.18-0.60			●		●				●		●													
	WNMG080416-PM	1.6	1-4	0.23-0.65					●				●		●													
ZM	**WNMG080408-ZM**	0.8	0.5-4.0	0.1-0.5		●																						
	WNMG080412-ZM	1.2	1.0-5.5	0.15-0.60		●																						
Medium Cut																												
SNR	**WNMG080408-SNR**	0.8	1-3	0.1-0.5															○			●	○					
	WNMG080412-SNR	1.2	1-3	0.2-0.6																			●					
Roughing																												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

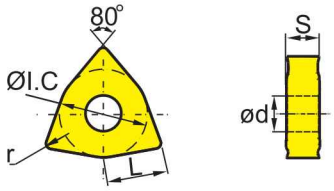
DWLNR/L	PWLNR/L	MWLNR/L	S***-PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A236	A251	A266	A332

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

WNMG	L	I.C	S	d
08 04	8.7	12.7	4.76	5.16

Turning inserts



WN** negative insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
				P																					
				M																					
				K																					
				N																					
				S																					
				H																					
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
NM	**WNMG080404-NM**	0.4	0.2-3.0	0.05-0.30															●								
	WNMG080408-NM	0.8	0.2-3.0	0.1-0.3														●	●	○							
	WNMG080412-NM	1.2	0.2-4.0	0.1-0.4														●	●								
Medium Cut																											
TC	**WNMG080404-TC**	0.4	0.5-3.0	0.08-0.25										●		○											
	WNMG080408-TC	0.8	0.5-4.0	0.15-0.40										●		●											
	WNMG080412-TC	1.2	0.5-4.0	0.2-0.6										●		●											
Medium Cut																											
TK	**WNMG080408-TK**	0.8	0.2-0.4	0.2-0.4										●													
	WNMG080412-TK	1.2	0.2-0.4	0.2-0.45										○													
	WNMG080416-TK	1.6	0.2-0.4	0.2-0.5										○													
Medium Cut																											

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DWLNR/L	PWLNR/L	MWLNR/L	S***-PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A236	A251	A266	A332

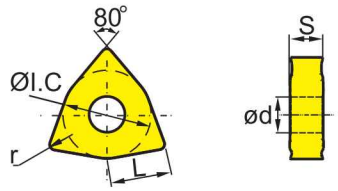
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

WN**	L	I.C	S	d
06 T3	6.5	9.525	3.97	3.81
06 04	6.5	9.525	4.76	3.81
08 04	8.7	12.7	4.76	5.16

WN** negative insert



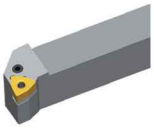
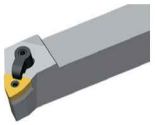
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
					HC¹ (CVD)												HC¹ (PVD)							HT		HC²	HW	
P					●	●	●	◐	◐	◐										◐	◐			◐	◐	●		
M											○	◐					○	○	◐	◐	◐	◐	○	○	◐	○		
K													○	◐	◐	◐												
N																	●	●									●	◐
S																	○	○	◐	◐	◐	◐	○				○	◐
H																												
DR	**WNMG060408-DR**	0.8	0.7-3.5	0.20-0.45			●		●				●		●													
	WNMG060412-DR	1.2	0.8-3.5	0.25-0.55			●		●				○		○													
	WNMG080408-DR	0.8	0.7-5.0	0.20-0.55			●		●	●			●		●													
	WNMG080412-DR	1.2	1-5	0.25-0.70		○	●		●	●			●		●													
	WNMG080416-DR	1.6	1.5-5.0	0.32-0.75			○		●				●		○													
Roughing																												
Flat	**WNMA060408**	0.8	0.5-3.0	0.1-0.3									●		●													
	WNMA060412	1.2	0.5-3.0	0.15-0.30											●													
	WNMA06T308	0.8	0.5-3.0	0.1-0.3																								
	WNMA080404	0.4	0.5-4.0	0.08-0.25									○		●	○												
	WNMA080408	0.8	0.5-4.0	0.15-0.30									●		●	●												
	WNMA080412	1.2	0.5-5.0	0.15-0.30									●	○	●	●												
	WNMA080416	1.6	0.5-5.0	0.2-0.5									○	○		○												

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

DWLNR/L	PWLNR/L	MWLNR/L	S***-PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A236	A251	A266	A332

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

RNMG	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16

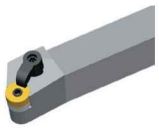
Turning inserts

RN** negative insert				HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
			P	●	●	●	◉	◉	◉								◉	◉			●	◉	●		
			M							○	◉						○	○	◉	◉	◉	○	◉	○		
			K									●	◉	◉	◉											
			N														●	●							●	◉
			S														○	○	◉	◉	◉	○			○	◉
			H																							
ISO		a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Basic	**RNMG120400**	0.5-7.0	0.1-1.8											○	○											
Medium Cut																										

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

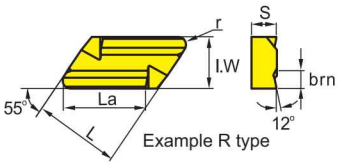
MRDNN	MRGNR/L
	
A267	A268

System code A48 Grade selection A42 Technical info A501 Cutting data A366

KNUX	L	I.W	S
16 04		9.525	4.76

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

Turning inserts



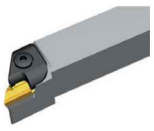
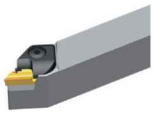
KN** negative insert		HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
		YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P		○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M								○	◉					○	○	◉	◉	◉	○		○	◉	○		
K										◉	◉	◉	◉												
N														○	○									◉	◉
S														○	○	◉	◉	◉	○					○	◉
H																									

	ISO	La	brn	r	a_p	f																				
KNUX	**KNUX160405L11**	16	2.2	0.5	0.2-6.0	0.05-0.70					●														○	
	KNUX160405L12	16	2.2	0.5	0.2-6.0	0.05-0.70																				
	KNUX160405R11	16	2.2	0.5	0.2-6.0	0.05-0.70					●														○	
	KNUX160405R12	16	2.2	0.5	0.2-6.0	0.05-0.70																				
	KNUX160410L11	16	2.2	1	0.2-6.0	0.05-0.70																				
Finishing	**KNUX160410L12**	16	2.2	1	0.2-6.0	0.05-0.70			○																	
	KNUX160410R11	16	2.2	1	0.2-6.0	0.05-0.70					●															
	KNUX160410R12	16	2.2	1	0.2-6.0	0.05-0.70																				

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

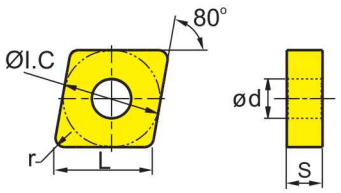
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder	
CKJNR/L	**CKNNR/L**
Kr: 93°	Kr: 63°
	
A290	A291

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CN**	L	I.C	S	d
19 07	19.3	19.05	7.94	7.93
19 11	19.3	19.05	11	7.8



					HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
	ISO	r	a_p	f																							
RF	**CNMG191140-RF**	4	1.0-5.5	0.20-0.60			●																				
Finishing																											
RF	**CNMM190740-RF**	4	1.0-5.5	0.20-0.60			●																				
	CNMM191140-RF	4	1.0-5.5	0.20-0.60			●																				
Finishing																											
RH	**CNMM190740-RH**	4	1.5-7.0	0.35-1.20			●		●																		
	CNMM191140-RH	4	1.5-7.0	0.35-1.20			●		●																		
Roughing																											

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

PCLNR/L

Kr: 95°

A318

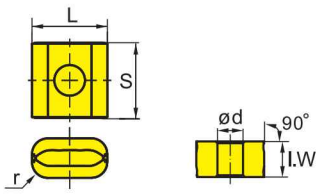
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

LNUX	L	l.C	S	d
19 19	19.05	10	19.05	6.35
30 19	30	10	19.05	6.35

LN** negative insert



	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
					HC¹ (CVD)												HC¹ (PVD)							HT		HC²	HW	
P					○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M											○	◉					○	○	◉	◉	◉	○	○	○	◉	○		
K													◉	◉	◉	◉												
N																	○	○									◉	◉
S																	○	○	◉	◉	◉	○					○	◉
H																												
RF	**LNUX191940-RF**	4	1,0-5,5	0,20-0,60			●		●																			
	LNUX301940-RF	4	1,0-6,0	0,20-0,70			●		○																			
Heavy Turning																												
RH	**LNUX191940-RH**	4	1,5-7,0	0,35-1,20			●		●																			
	LNUX301940-RH	4	1,5-8,0	0,35-1,40			●		●																			
Heavy Turning																												

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

PLANR/L	PLFNR/L
Kr: 90°	Kr: 90°
	
A316	A317

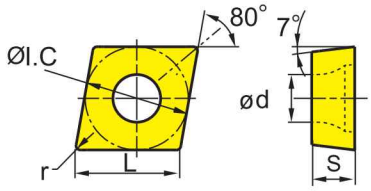
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CCGT	L	I.C	S	d
06 02	6.4	6.35	2.38	2.8
09 T3	9.7	9.525	3.97	4.4

CC** positive insert



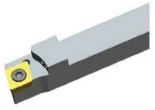
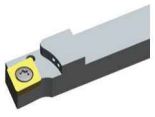
	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	●	●	●	◉	◉	◉											◉			●	◉	●		
M							○	◉						○	○		◉	◉	○	○	◉	○		
K									○	◉	◉	◉												
N													●	●									●	◉
S														○	○		◉	◉	○				○	◉
H																								

	ISO	r	a_p	f
SF	**CCGT060202-SF**	0.2	0.05-2.00	0.05-0.18
	CCGT060204-SF	0.4	0.05-2.00	0.05-0.35
	CCGT09T304-SF	0.4	0.05-2.00	0.05-0.35
Finishing				
USF	**CCGT060202L-USF**	0.2	0.05-2.00	0.05-0.18
	CCGT060204L-USF	0.4	0.05-2.00	0.05-0.35
	CCGT09T301L-USF	0.1	0.2-2.0	0.01-0.08
	CCGT09T302L-USF	0.2	0.2-2.0	0.05-0.18
Finishing	**CCGT09T304L-USF**	0.4	0.2-2.0	0.05-0.20
USF	**CCGT09T304R-USF**	0.4	0.2-2.0	0.05-0.20
Finishing				

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SCACR/L	SCLCR/L	SCACR/L-SC	SCLCR/L-SC	S***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A269	A270	A306	A307	A334	A352	A353

E***-SCLCR/L
Kr: 95°

A355

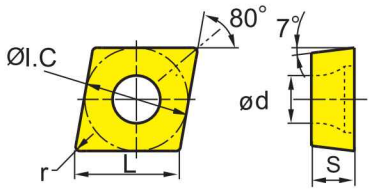
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CCMT	L	I.C	S	d
06 02	6.4	6.35	2.38	2.8
09 T3	9.7	9.525	3.97	4.4
12 04	12.9	12.7	4.76	5.56

CC** positive insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW		
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	○	◉	◉	◉										◉	◉			○	◉	○	○	
M							○	◉					○	○	◉	◉	◉	◉	○	○	◉	○		
K									◉	◉	◉	◉												
N													○	○									○	◉
S													○	○	◉	◉	◉	◉	○				○	◉
H																								

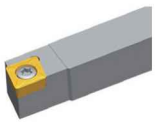
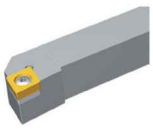
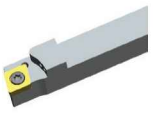
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
AHF	**CCMT060204-AHF**	0.4	0.2-2.5	0.05-0.20		●															●		●	●				
	CCMT060208-AHF	0.8	0.3-2.5	0.05-0.30		○															●							
	CCMT09T302-AHF	0.2	0.08-2.00	0.04-0.15																						●		
	CCMT09T304-AHF	0.4	0.2-3.0	0.05-0.30		●														○	●		○		●			
	CCMT09T308-AHF	0.8	0.3-3.0	0.05-0.40		●														○	●				●			
Finishing	**CCMT120404-AHF**	0.4	0.5-4.0	0.05-0.30		○														○	●							
	CCMT120408-AHF	0.8	0.8-4.0	0.08-0.40		●															●							
HF	**CCMT060202-HF**	0.2	0.06-1.70	0.03-0.11			●		●																			
	CCMT060204-HF	0.4	0.1-1.7	0.05-0.17			●		●						○													
	CCMT060208-HF	0.8	0.1-1.7	0.05-0.30			○		●																	●		
	CCMT09T302-HF	0.2	0.08-2.00	0.04-0.15			●		●															○				
	CCMT09T304-HF	0.4	0.11-2.00	0.06-0.23			●		●				○		●													
Finishing	**CCMT09T308-HF**	0.8	0.15-2.00	0.08-0.30			●		●				○		●													
	CCMT120404-HF	0.4	0.14-2.40	0.07-0.27			●		●																			
	CCMT120408-HF	0.8	0.2-3.0	0.08-0.30			●		○																			

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SCACR/L	SCLCR/L	SCACR/L-SC	SCLCR/L-SC	A***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A269	A270	A306	A307	A334	A352	A353

E***-SCLCR/L
Kr: 95°

A355

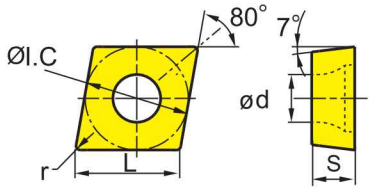
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CCMT	L	I.C	S	d
06 02	6.4	6.35	2.38	2.8
09 T3	9.7	9.525	3.97	4.4
12 04	12.9	12.7	4.76	5.56

CC** positive insert



	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	○	○	○	◎	◎	◎								◎	◎			○	◎	○		
M							○	◎				○	○	◎	◎	◎	○	○	◎	○		
K									●	◎	◎	◎										
N												●	●								●	◎
S												●	●	◎	◎	◎	●				●	◎
H																						

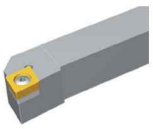
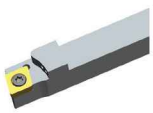
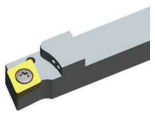
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EF Finishing	**CCMT060202-EF**	0.2	0.06-1.70	0.03-0.11							●									●								
	CCMT060204-EF	0.4	0.1-1.7	0.05-0.17							●									●								
	CCMT09T302-EF	0.2	0.08-2.00	0.04-0.15							○									●								
	CCMT09T304-EF	0.4	0.11-2.00	0.06-0.23							●								○	●								
	CCMT09T308-EF	0.8	0.15-2.00	0.08-0.30							●								○	●								
	CCMT120404-EF	0.4	0.14-2.40	0.07-0.27							●									●								
	CCMT120408-EF	0.8	0.2-3.0	0.1-0.3							●									●								
XF Finishing	**CCMT060202-XF**	0.2	0.5-1.5	0.08-0.15				●																				
	CCMT060208-XF	0.8	0.5-1.5	0.08-0.20	●																							
	CCMT09T302-XF	0.2	0.5-2.0	0.08-0.15	●			●																				
	CCMT09T308-XF	0.8	0.5-2.0	0.08-0.25	●			○																				

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SCACR/L	SCLCR/L	SCACR/L-SC	SCLCR/L-SC	A***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A269	A270	A306	A307	A334	A352	A353

E***-SCLCR/L
Kr: 95°

A355

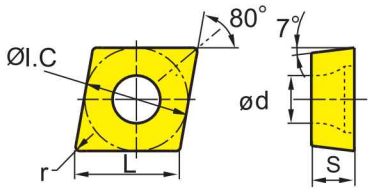
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

● Ideal machining conditions
◔ Normal machining conditions
◔ Unfavourable machining conditions

CCMT	L	I.C	S	d
06 02	6.4	6.35	2.38	2.8
09 T3	9.7	9.525	3.97	4.4
12 04	12.9	12.7	4.76	5.56

CC** positive insert



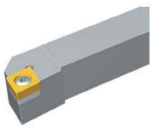
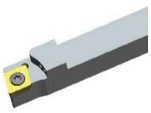
	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
P	●	●	●	◔	◔	◔									◔	◔			●	◔	●		
M						●	◔						●	●	◔	◔	◔	●	●	◔	●		
K								◔	◔	◔	◔												
N												●	●									●	◔
S													●	●	◔	◔	◔	●				●	◔
H																							

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EM  Medium Cut	**CCMT060204-EM**	0.4	0.2-2.4	0.06-0.17							●	●								●								
	CCMT060208-EM	0.8	0.4-2.4	0.08-0.23							●	○								●								
	CCMT09T304-EM	0.4	0.25-3.00	0.08-0.23							●	●								●								
	CCMT09T308-EM	0.8	0.5-3.0	0.1-0.3							●	●								●								
	CCMT120404-EM	0.4	0.3-3.6	0.09-0.27								●								●								
	CCMT120408-EM	0.8	0.6-3.6	0.12-0.36							●	●								●								
	CCMT120412-EM	1.2	0.72-3.60	0.14-0.43								○																
XM  Medium Cut	**CCMT09T304-XM**	0.4	1-2.5	0.15-0.3	●			○																				
	CCMT09T308-XM	0.8	1-2.5	0.15-0.35	●			●																				
	CCMT09T312-XM	1.2	1-2.5	0.15-0.4	●			●																				
	CCMT120404-XM	0.4	1-3.0	0.15-0.3	○			○																				
	CCMT120408-XM	0.8	1-3.0	0.15-0.35	○			○																				
	CCMT120412-XM	1.2	1-3.0	0.15-0.4	○			○																				

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SCACR/L	SCLCR/L	SCACR/L-SC	SCLCR/L-SC	A***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A269	A270	A306	A307	A334	A352	A353

E***-SCLCR/L
Kr: 95°

A355

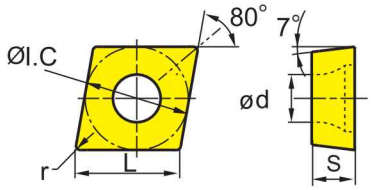
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

CCMT	L	I.C	S	d
06 02	6.4	6.35	2.38	2.8
09 T3	9.7	9.525	3.97	4.4
12 04	12.9	12.7	4.76	5.56

CC** positive insert



	HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M							○	◉						○	○	◉	◉	◉	○	○	◉	○		
K									○	◉	◉	◉												
N													○	○									○	◉
S													○	○	◉	◉	◉	◉	○				○	◉
H																								

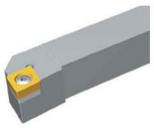
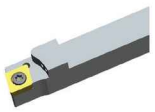
	ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
HM	**CCMT060204-HM**	0.4	0.2-2.4	0.06-0.17			●		●			●	●		●												
	CCMT060208-HM	0.8	0.2-3.0	0.08-0.20			●		●				●		●												
	CCMT09T304-HM	0.4	0.25-3.00	0.08-0.23			●		●			●	●		●												
	CCMT09T308-HM	0.8	0.5-3.0	0.1-0.3			●		●			●	●		●												
	CCMT120404-HM	0.4	0.3-3.6	0.09-0.27			●		●				○		●												
	CCMT120408-HM	0.8	0.6-3.6	0.12-0.36			●		●				●		●												
	CCMT120412-HM	1.2	0.72-3.60	0.14-0.43			●		○				○														

Medium Cut

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SCACR/L	SCLCR/L	SCACR/L-SC	SCLCR/L-SC	A***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A269	A270	A306	A307	A334	A352	A353

E***-SCLCR/L
Kr: 95°

A355

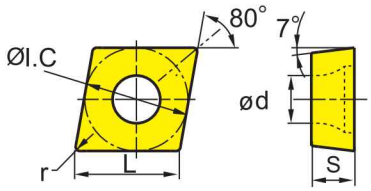
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CC**	L	I.C	S	d
06 02	6.4	6.35	2.38	2.8
09 T3	9.7	9.525	3.97	4.4
12 04	12.9	12.7	4.76	5.56

CC** positive insert



	HC¹ (CVD)										HC¹ (PVD)							HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	●	●	●	❁	❁	❁										❁	❁			●	❁	●		
M							○	❁					○	○	❁	❁	❁	○	❁	○	❁	○		
K									❁	❁	❁	❁												
N													●	●									●	❁
S													●	●	❁	❁	❁	●					●	❁
H																								

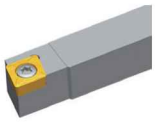
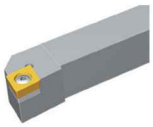
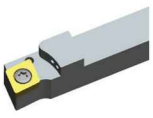
	ISO	r	a_p	f																				
Basic	**CCMW09T304**	0.4	0.1-5.0	0.05-0.50																				○
	CCMW120404	0.4	0.2-5.0	0.05-0.50																			○	○
	CCMW120408	0.8	0.5-5.0	0.08-0.50									○											
Medium Cut																								
TC	**CCMT060204-TC**	0.4	0.5-3.0	0.1-0.3								○	●											
	CCMT09T304-TC	0.4	0.5-3.0	0.1-0.3								○	●											
	CCMT09T308-TC	0.8	0.5-3.0	0.1-0.4								●	●											
	CCMT120404-TC	0.4	1-4	0.1-0.3								●	●											
Medium Cut	**CCMT120408-TC**	0.8	1-4	0.1-0.4								●	●											
HR	**CCMT060204-HR**	0.4	0.5-3.0	0.05-0.24			●	●																
	CCMT060208-HR	0.8	0.8-3.2	0.09-0.26			●	○				●												
	CCMT09T304-HR	0.4	0.2-4.0	0.05-0.30			●	●				●												
	CCMT09T308-HR	0.8	1-4	0.12-0.35			●	●			●	●												
Roughing	**CCMT120408-HR**	0.8	1.2-4.8	0.14-0.42			●	●			●	●												
	CCMT120412-HR	1.2	1.44-4.80	0.17-0.50			●	●			○													

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SCACR/L	SCLCR/L	SCACR/L-SC	SCLCR/L-SC	A***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A269	A270	A306	A307	A334	A352	A353

E***-SCLCR/L
Kr: 95°

A355

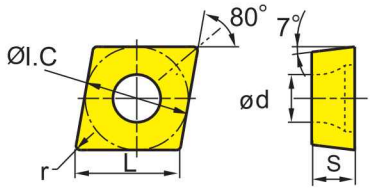
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CCGX	L	I.C	S	d
06 02	6.4	6.35	2.38	2.8
09 T3	9.7	9.525	3.97	4.4
12 04	12.9	12.7	4.76	5.56

CC** positive insert



	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	●	●	●	◉	◉	◉									◉	◉		●	◉	●		
M							●	◉					●	●	◉	◉	◉	●	◉	◉		
K									●	◉	◉	◉										
N													●	●							●	◉
S													●	●	◉	◉	◉	●			●	◉
H																						

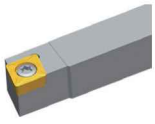
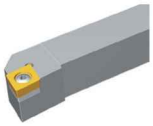
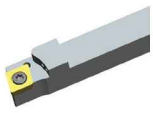
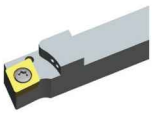
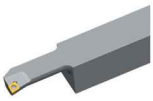
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
LC	**CCGX060202-LC**	0.2	0.3-3.0	0.05-0.15													●										●	
	CCGX060204-LC	0.4	0.5-3.0	0.1-0.3													●										●	
	CCGX09T302-LC	0.2	0.5-4.0	0.1-0.2													●										●	
	CCGX09T304-LC	0.4	0.5-5.0	0.1-0.3													●										●	
	CCGX09T308-LC	0.8	0.5-5.0	0.15-0.60													●										●	
Alum Machining	**CCGX120404-LC**	0.4	0.5-7.0	0.1-0.3													●										●	
	CCGX120408-LC	0.8	0.5-7.0	0.15-0.60													●										●	
LH	**CCGX060202-LH**	0.2	0.3-3.0	0.05-0.15														●									●	
	CCGX060204-LH	0.4	0.5-3.0	0.1-0.3														●									●	
	CCGX060208-LH	0.8	0.6-3.0	0.15-0.40																							●	
	CCGX09T302-LH	0.2	0.4-5.0	0.05-0.15														●									●	
	CCGX09T304-LH	0.4	0.5-5.0	0.1-0.3														●									●	
	CCGX09T308-LH	0.8	0.5-5.0	0.15-0.60														●									●	
Alum Machining	**CCGX120402-LH**	0.2	0.4-7.0	0.05-0.15														○									○	
	CCGX120404-LH	0.4	0.5-7.0	0.1-0.3														●									●	
	CCGX120408-LH	0.8	0.5-7.0	0.15-0.60														●									●	
	CCGX120412-LH	1.2	0.5-7.0	0.15-0.80														○									●	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > A48 Grade selection > A42 Technical info > A501 Cutting data > A366

Tool holder

SCACR/L	SCLCR/L	SCACR/L-SC	SCLCR/L-SC	A***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A269	A270	A306	A307	A334	A352	A353

E***-SCLCR/L
Kr: 95°

A355

A Turning
B Milling
C Drilling
D Technical Information
E Index

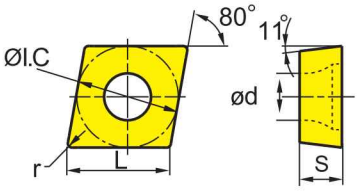
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

CP**	L	I.C	S	d
06 02	6.4	6.35	2.38	2.8
09 T3	9.7	9.525	3.97	4.4

CP** positive insert



	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	●	●	●	❁	❁	❁										❁	❁			●	❁	●		
M							○	❁						○	○	❁	❁	❁	○	○	❁	○		
K									●	❁	❁	❁												
N													●	●									●	❁
S													○	○	❁	❁	❁	❁	○				○	❁
H																								

	ISO	r	a_p	f
HF	**CPMT060204-HF**	0.4	0.1-1.5	0.04-0.18
	CPMT060208-HF	0.8	0.1-1.5	0.05-0.25
Finishing				
SF	**CPGT060202-SF**	0.2	0.05-2.00	0.05-0.25
	CPGT060204-SF	0.4	0.05-2.00	0.05-0.35
	CPGT09T304-SF	0.4	0.05-2.00	0.05-0.35
Finishing				
Flat	**CPGW060204**	0.4	0.5-1.5	0.05-0.40
Medium Cut				
HM	**CPMT09T304-HM**	0.4	0.2-3.5	0.05-0.35
	CPMT09T308-HM	0.8	0.2-3.5	0.10-0.55
Medium Cut				

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

S***-SCLPR/L	C***-SCLPR/L
Kr: 95°	Kr: 95°
	
A348	A354

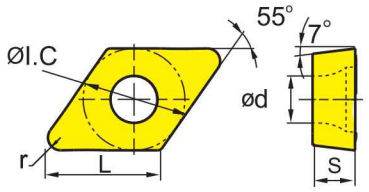
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

DC**	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

DC** positive insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M							○	◉						○	○	◉	◉	◉	○	○	◉	○		
K									●	◉	◉	◉												
N													●	●									●	◉
S														○	○	◉	◉	◉	○				○	◉
H																								

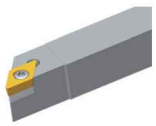
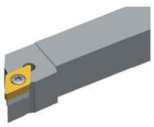
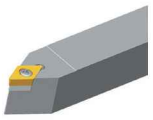
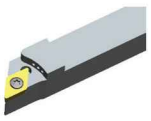
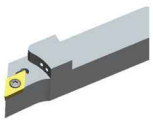
	ISO	r	a_p	f
AHF	**DCMT070204-AHF**	0.4	0.2-2.5	0.05-0.20
	DCMT11T302-AHF	0.2	0.5-3.0	0.05-0.15
	DCMT11T304-AHF	0.4	0.5-3.0	0.05-0.30
	DCMT11T308-AHF	0.8	0.5-3.0	0.05-0.40
Finishing				
SF	**DCGT070202-SF**	0.2	0.05-1.50	0.05-0.15
	DCGT070204-SF	0.4	0.05-1.50	0.05-0.20
	DCGT070208-SF	0.8	0.05-1.50	0.05-0.30
	DCGT11T302-SF	0.2	0.05-2.00	0.05-0.15
	DCGT11T304-SF	0.4	0.05-2.00	0.05-0.20
Finishing	**DCGT11T308-SF**	0.8	0.05-2.00	0.05-0.30

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SDACR/L	SDJCR/L	SDNCN	SDACR/L-SC	SDHCR/L-SC	SDJCR/L-SC	SDNCN-SC
Kr: 90°	Kr: 93°	Kr: 62°30'	Kr: 90°	Kr: 107°30'	Kr: 93°	Kr: 62°30'
						
A271	A272	A273	A308	A309	A310	A311

S***-SDQCR/L	A***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A336	A337	A338	A357

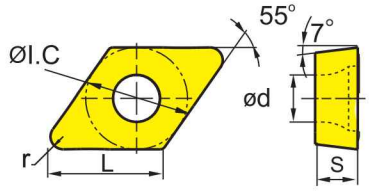
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DCMT	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

DC** positive insert



	HC¹ (CVD)						HC¹ (PVD)						HT		HC²	HW	
P	○	○	○	◉	◉	◉				◉	◉		○	◉	○		
M						○	◉								○		
K							◉	◉	◉	◉							
N																○	◉
S																○	◉
H																	

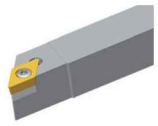
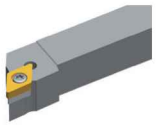
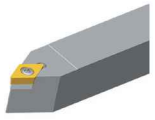
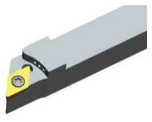
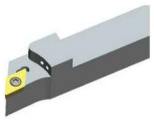
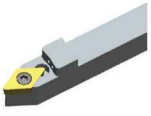
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EF	**DCMT070202-EF**	0.2	0.06-1.50	0.03-0.11							○									○								
	DCMT070204-EF	0.4	0.08-1.50	0.05-0.17							●									●								
	DCMT11T302-EF	0.2	0.08-2.00	0.04-0.15							○									●								
	DCMT11T304-EF	0.4	0.11-2.00	0.06-0.23							●									●								
Finishing	**DCMT11T308-EF**	0.8	0.15-2.00	0.08-0.30							●								●	●								
HF	**DCMT070202-HF**	0.2	0.06-1.50	0.03-0.11			○		●																			
	DCMT070204-HF	0.4	0.08-1.50	0.05-0.17			●		●																			
	DCMT070208-HF	0.8	0.08-1.50	0.05-0.30			●		○																			
	DCMT11T302-HF	0.2	0.08-2.00	0.04-0.15			○		●											○								
Finishing	**DCMT11T304-HF**	0.4	0.11-2.00	0.06-0.23			●		●				○		●													
	DCMT11T308-HF	0.8	0.15-2.00	0.08-0.30			●		●				●															
XF	**DCMT070202-XF**	0.2	0.5-1.5	0.08-0.15				○																				
	DCMT070204-XF	0.4	0.5-1.5	0.08-0.15	○																							
	DCMT070208-XF	0.8	0.5-1.5	0.08-0.25	○																							
	DCMT11T304-XF	0.4	0.5-2.0	0.08-0.15	○																							
Finishing	**DCMT11T308-XF**	0.8	0.5-2.0	0.08-0.25	○																							

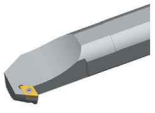
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SDACR/L	SDJCR/L	SDNCN	SDACR/L-SC	SDHCR/L-SC	SDJCR/L-SC	SDNCN-SC
Kr: 90°	Kr: 93°	Kr: 62°30'	Kr: 90°	Kr: 107°30'	Kr: 93°	Kr: 62°30'
						
A271	A272	A273	A308	A309	A310	A311

S***-SDQCR/L	A***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A336	A337	A338	A357

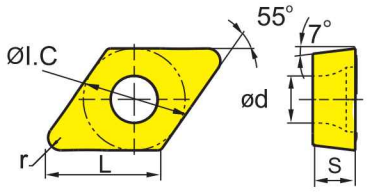
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DCMT	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

DC** positive insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
P	○	○	○	◎	◎	◎									◎	◎			○	◎	○		
M							○	◎				○	○	◎	◎	◎	○		○	◎	○		
K									◎	◎	◎	◎											
N												○	○									○	◎
S												○	○	◎	◎	◎	○					○	◎
H																							

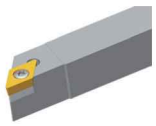
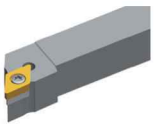
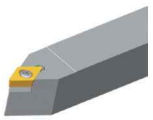
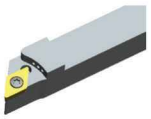
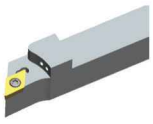
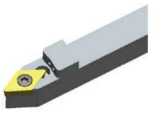
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
EM	**DCMT070204-EM**	0.4	0.19-2.25	0.06-0.17							●	●								●								
	DCMT070208-EM	0.8	0.38-2.25	0.08-0.23							●	○								●								
	DCMT11T304-EM	0.4	0.25-3.00	0.08-0.23							●	●								●								
Medium Cut	**DCMT11T308-EM**	0.8	0.5-3.0	0.1-0.3							●	●								●								
XM	**DCMT11T304-XM**	0.4	1-2.5	0.15-0.3	●			○																				
	DCMT11T308-XM	0.8	1-2.5	0.15-0.35	●			●																				
Medium Cut	**DCMT11T312-XM**	1.2	1-2.5	0.15-0.4	●			●																				

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

SDACR/L	SDJCR/L	SDNCN	SDACR/L-SC	SDHCR/L-SC	SDJCR/L-SC	SDNCN-SC
Kr: 90°	Kr: 93°	Kr: 62°30'	Kr: 90°	Kr: 107°30'	Kr: 93°	Kr: 62°30'
						
A271	A272	A273	A308	A309	A310	A311

S***-SDQCR/L	A***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A336	A337	A338	A357

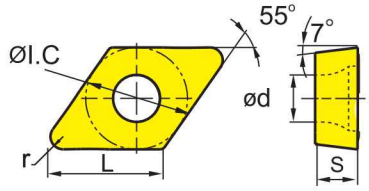
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DCMT	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

DC** positive insert



	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	●	●	●	◉	◉	◉										◉	◉			◉	◉	●		
M							○	◉							○	○	◉	◉	◉	○	◉	○		
K									◉	◉	◉	◉												
N													●	●									●	◉
S													○	○	◉	◉	◉	◉	○				○	◉
H																								

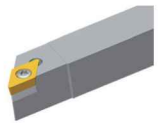
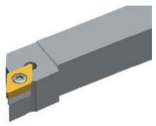
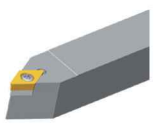
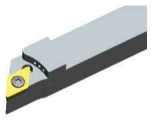
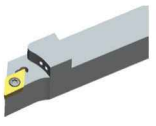
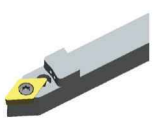
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
HM	**DCMT070204-HM**	0.4	0.19-2.25	0.06-0.17		○	●		●				●		●					●								
	DCMT070208-HM	0.8	0.38-2.25	0.08-0.23			●		●				●		●													
	DCMT11T304-HM	0.4	0.25-3.00	0.08-0.23		○	●		●				●		●						●							
	DCMT11T308-HM	0.8	0.5-3.0	0.1-0.3			●		●				●		●						●							
Medium Cut	**DCMT11T312-HM**	1.2	0.6-3.0	0.12-0.36					○				○		○													

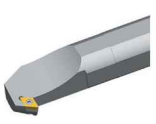
● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SDACR/L	SDJCR/L	SDNCN	SDACR/L-SC	SDHCR/L-SC	SDJCR/L-SC	SDNCN-SC
Kr: 90°	Kr: 93°	Kr: 62°30'	Kr: 90°	Kr: 107°30'	Kr: 93°	Kr: 62°30'
						
A271	A272	A273	A308	A309	A310	A311

S***-SDQCR/L	A***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A336	A337	A338	A357

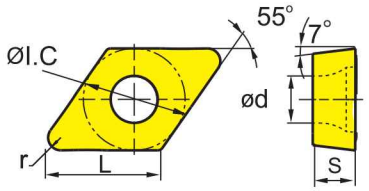
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DC**	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

DC** positive insert



	HC[1] (CVD)										HC[1] (PVD)							HT		HC[2]	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	●	●	●	◉	◉	◉										◉	◉			●	◉	●		
M							○	◉					○	○	◉	◉	◉	◉	○	○	◉	○		
K									◉	◉	◉	◉												
N													●	●									◉	◉
S													○	○	◉	◉	◉	◉	○				○	◉
H																								

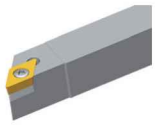
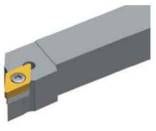
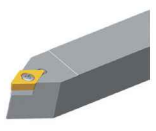
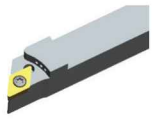
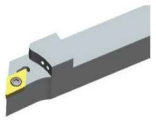
	ISO	r	a_p	f
Flat	**DCMW11T304**	0.4	0.5-5.0	0.05-0.20
	DCMW11T308	0.8	0.4-5.0	0.1-0.4
Medium Cut				
HR	**DCMT11T304-HR**	0.4	1-4	0.1-0.3
	DCMT11T308-HR	0.8	1-4	0.12-0.35
	DCMT11T312-HR	1.2	1.2-4.0	0.14-0.42
Roughing				
LC	**DCGX070201-LC**	0.1	0.3-4.0	0.05-0.10
	DCGX070202-LC	0.2	0.3-4.0	0.05-0.15
	DCGX070204-LC	0.4	0.5-4.0	0.1-0.3
	DCGX11T302-LC	0.2	0.3-5.5	0.05-0.15
Alum Machining	**DCGX11T304-LC**	0.4	0.5-5.5	0.1-0.3
	DCGX11T308-LC	0.8	0.5-5.5	0.15-0.60

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

SDACR/L	SDJCR/L	SDNCN	SDACR/L-SC	SDHCR/L-SC	SDJCR/L-SC	SDNCN-SC
Kr: 90°	Kr: 93°	Kr: 62°30'	Kr: 90°	Kr: 107°30'	Kr: 93°	Kr: 62°30'
						
A271	A272	A273	A308	A309	A310	A311

S***-SDQCR/L	A***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A336	A337	A338	A357

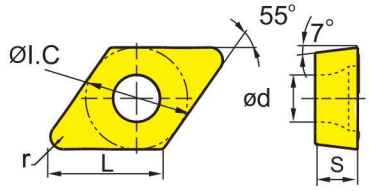
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DCGX	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

DC** positive insert



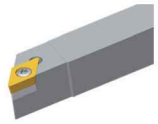
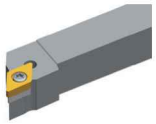
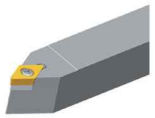
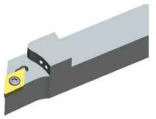
	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	●	●	●	◉	◉	◉									◉	◉		◉	◉	●		
M							◐	◉				◐	◐	◉	◉	◉	◐	◐	◉	◐		
K									◉	◉	◉											
N												●	●								●	◉
S												◐	◐	◉	◉	◉	◐				◐	◉
H																						

ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
LH	**DCGX070202-LH**	0.2	0.3-4.0	0.05-0.15														●									●	
	DCGX070204-LH	0.4	0.5-4.0	0.1-0.3														●									●	
	DCGX070208-LH	0.8	0.5-4.0	0.15-0.60														○									●	
	DCGX11T302-LH	0.2	0.3-5.5	0.05-0.15														●									●	
Alum Machining	**DCGX11T304-LH**	0.4	0.5-5.5	0.1-0.3														●									●	
	DCGX11T308-LH	0.8	0.5-5.5	0.15-0.60														●									●	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SDACR/L	SDJCR/L	SDNCN	SDACR/L-SC	SDHCR/L-SC	SDJCR/L-SC	SDNCN-SC
Kr: 90°	Kr: 93°	Kr: 62°30'	Kr: 90°	Kr: 107°30'	Kr: 93°	Kr: 62°30'
						
A271	A272	A273	A308	A309	A310	A311

S***-SDQCR/L	A***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A336	A337	A338	A357

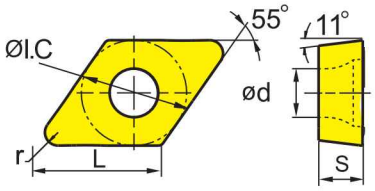
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

DPGT	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

DP** positive insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW		
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M							○	◉						○	○	◉	◉	◉	○	○	◉	○		
K									◉	◉	◉	◉												
N													○	○									○	◉
S														○	○	◉	◉	◉	○				○	◉
H																								

	ISO	r	a_p	f	HC[1]	HT	HC[2]
SF	**DPGT070202-SF**	0.2	0.05-2.00	0.05-0.15		○	●
	DPGT070204-SF	0.4	0.05-2.00	0.05-0.30		●	●
	DPGT11T304-SF	0.4	0.05-2.00	0.1-0.3		●	●
	DPGT11T308-SF	0.8	0.05-2.00	0.1-0.4		○	○
Finishing							

● Ex stock ○ On demand

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

S***-SDQPR/L	S***-SDUPR/L	C***-SDQPR/L
Kr: 107°30'	Kr: 93°	Kr: 107°30'
		
A349	A350	A356

A Turning
B Milling
C Drilling
D Technical Information
E Index

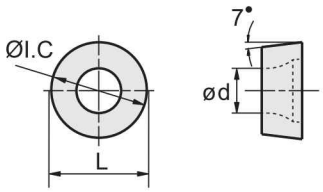
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

RC**	L	I.C	S	d
08 03	8	8	3.18	3.36
10 T3	10	10	3.97	3.6
12 04	12	12	4.76	44.4
16 06	16	16	6.35	5.5
20 06	20	20	6.35	6.5
25 07	25	25	7.94	7.7

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

Turning inserts

RC** positive insert

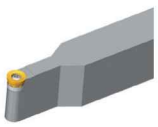
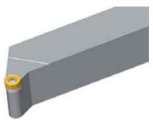


				HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
				P																						
				M																						
				K																						
				N																						
				S																						
				H																						
	ISO		a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Basic		**RCMT0803MO**	0.5-3.0	0.1-0.4					●				●															
		RCMT10T3MO	0.5-4.0	0.1-0.5					○				●															
		RCMT1204MO	0.8-5.0	0.1-0.6			○		●				●		●													
		RCMT1606MO	1-6	0.1-0.8			●		●			○	●															
Medium Cut		**RCMT2006MO**	1.2-8.0	0.1-1.0			○		●																			
		RCMT2507MO	1.4-10.0	0.1-1.2			○		○																			
LH		**RCGX0803MO-LH**	1-4	0.2-0.5																							●	
		RCGX1204MO-LH	1.2-5.0	0.2-0.6																							●	
Alum Machining																												

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

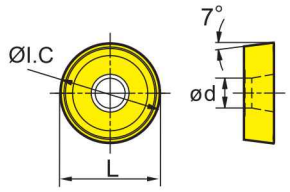
SRDCN	SRGCR/L
	
A288	A289

System code A48 Grade selection A42 Technical info A501 Cutting data A366

RCMX	L	I.C	S	d
08 03	8	8	3.18	3.36
10 03	10	10	3.18	4.4
12 04	12	12	4.76	4.4
16 06	16	16	6.35	5.5
20 06	20	20	6.35	6.5
25 07	25	25	7.94	7.2
32 09	32	32	9.52	10.2

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions



RC** positive insert		HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
	P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
	M							○	◉					○	○	◉	◉	◉	○	○	◉	○		
	K									◉	◉	◉	◉											
	N													○	○								◉	◉
	S													○	○	◉	◉	◉	○				◉	◉
	H																							

	ISO	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Basic	**RCMX0803MO**	0.5-4.0	0.1-0.5					●																			
	RCMX1003MO	0.5-5.0	0.1-0.6					●																			
	RCMX1204MO	1-6	0.1-0.8			○		●																			
	RCMX1606MO	1-7	0.2-0.9			○		●			○								○								
	RCMX2006MO	1-9	0.2-1.0			●		●						●													
Light Roughing	**RCMX2507MO**	2-10	0.25-1.20					●																			
	RCMX3209MO	2-13	0.25-1.40			○		●																			
Basic	**RCMX2507MO-1**	2-9	0.1-0.4			○																					
Light Roughing																											
Basic	**RCMX3209MO-PV**	3-12	0.1-0.4			○		●																			
Light Roughing																											

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

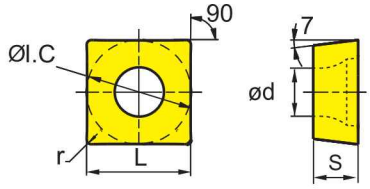
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SCMT	L	I.C	S	d
09 T3	9.525	9.525	3.97	4.4
12 04	12.7	12.7	4.76	5.56



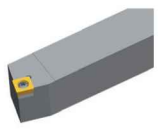
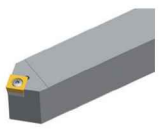
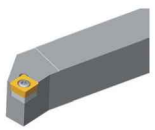
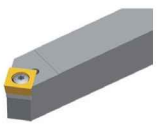
	ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
AHF	**SCMT09T304-AHF**	0.4	0.5-3.0	0.05-0.30		●															●			○			
	SCMT09T308-AHF	0.8	0.5-3.0	0.05-0.40		●															●			●			
Finishing																											
EF	**SCMT09T302-EF**	0.2	0.07-2.00	0.05-0.15																●							
	SCMT09T304-EF	0.4	0.11-2.00	0.06-0.23																●							
	SCMT09T308-EF	0.8	0.15-2.00	0.08-0.30																●							
Finishing																											
EM	**SCMT09T304-EM**	0.4	0.25-3.00	0.08-0.23							○	○								●							
	SCMT09T308-EM	0.8	0.5-3.0	0.1-0.3							●	●								●							
	SCMT120404-EM	0.4	0.3-3.6	0.09-0.27							○	○								●							
	SCMT120408-EM	0.8	0.6-3.6	0.12-0.36							○	○								●							
Finishing	**SCMT120412-EM**	1.2	0.72-3.60	0.14-0.43								○								●							
XF	**SCMT09T304-XF**	0.4	0.5-2.0	0.08-0.25	●																						
	SCMT09T308-XF	0.8	0.5-2.0	0.08-0.30	●			○																			
Finishing																											

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SSBCR/L	SSDCN	SSKCR/L	SSSCR/L	S***-SSKCR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°
				
A279	A280	A281	A282	A339

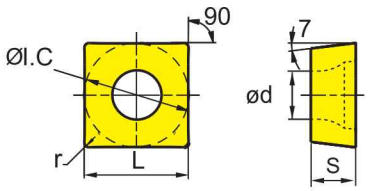
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SCMT	L	I.C	S	d
09 T3	9.525	9.525	3.97	4.4
12 04	12.7	12.7	4.76	5.56

SC** positive insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
P	○	○	○	⊛	⊛	⊛									⊛	⊛			○	⊛	○		
M							○	⊛				○	○	⊛	⊛	⊛	○		○	⊛	○		
K									●	⊛	⊛	⊛											
N												●	●									●	⊛
S												●	○	⊛	⊛	⊛	○					○	⊛
H																							

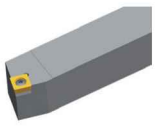
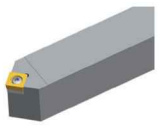
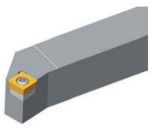
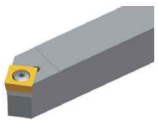
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
HF	**SCMT09T302-HF**	0.2	0.15-2.00	0.05-0.15																								
	SCMT09T304-HF	0.4	0.11-2.00	0.05-0.23					●																			
	SCMT09T308-HF	0.8	0.15-2.00	0.05-0.30			●		●																			
Finishing																												
HM	**SCMT09T304-HM**	0.4	0.25-3.00	0.08-0.23			●		●				●		●													
	SCMT09T308-HM	0.8	0.5-3.0	0.1-0.3			●		●				●		●													
	SCMT120404-HM	0.4	0.3-3.6	0.09-0.27			●		●																			
	SCMT120408-HM	0.8	0.6-3.6	0.12-0.36			○		●				●		●													
Medium Cut	**SCMT120412-HM**	1.2	0.72-3.60	0.14-0.43					●																			
XM	**SCMT09T304-XM**	0.4	1-2.5	0.15-0.3	○			○																				
	SCMT09T308-XM	0.8	1-2.5	0.15-0.35	○			○																				
	SCMT09T312-XM	1.2	1-2.5	0.15-0.4	○			○																				
	SCMT120408-XM	0.8	1-3.0	0.15-0.35	○			○																				
Medium Cut	**SCMT120412-XM**	1.2	1-3.0	0.15-0.4	○			○																				

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

SSBCR/L	SSDCN	SSKCR/L	SSSCR/L	S***-SSKCR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°
				
A279	A280	A281	A282	A339

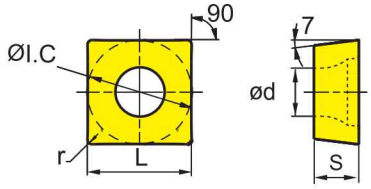
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

SC**	L	I.C	S	d
09 T3	9.525	9.525	3.97	4.4
12 04	12.7	12.7	4.76	5.55.56

SC** positive insert



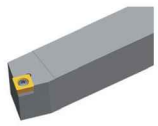
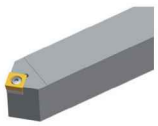
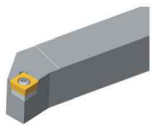
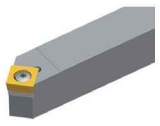
	ISO	r	a_p	f	HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
HR	**SCMT09T304-HR**	0.4	0.2-4.0	0.05-0.40			○		●						○												
	SCMT09T308-HR	0.8	1-4	0.12-0.35			●		●				●		●												
	SCMT09T312-HR	1.2	1.2-4.0	0.14-0.42					○																		
	SCMT120404-HR	0.4	0.5-4.0	0.05-0.50			○		○																		
Roughing	**SCMT120408-HR**	0.8	1.2-4.8	0.14-0.42			●		●				●		●												
	SCMT120412-HR	1.2	1.44-4.80	0.17-0.50			●		●				●		○												
LC	**SCGX09T304-LC**	0.4	0.5-5.0	0.1-0.5																						●	
	SCGX09T308-LC	0.8	0.5-5.0	0.15-0.60																						●	
Alum Machining	**SCGX120408-LC**	0.8	1-7	0.15-0.60													●									●	

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SSBCR/L	SSDCN	SSKCR/L	SSSCR/L	S***-SSKCR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°
				
A279	A280	A281	A282	A339

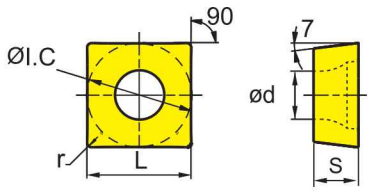
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SCGX	L	I.C	S	d
09 T3	9.525	9.525	3.97	4.4
12 04	12.7	12.7	4.76	5.56

SC** positive insert



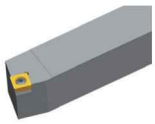
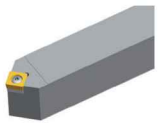
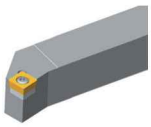
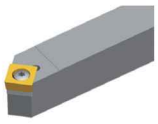
	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
M							○	◉				○	○	◉	◉	◉	○		○	◉	○		
K									◉	◉	◉	◉											
N												○	○									○	◉
S												○	○	◉	◉	◉	○					○	◉
H																							

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
LH	**SCGX09T302-LH**	0.2	0.5-4.0	0.05-0.15														○									●	
	SCGX09T304-LH	0.4	0.5-4.0	0.1-0.3																							●	
	SCGX09T308-LH	0.8	0.5-4.0	0.15-0.60																							●	
	SCGX120408-LH	0.8	0.5-5.0	0.15-0.60														○									●	
Alum Machining																												

● Ex stock ○ On demand

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

SSBCR/L	SSDCN	SSKCR/L	SSSCR/L	S***-SSKCR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°
				
A279	A280	A281	A282	A339

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SPMW	L	I.C	S	d
09 T3	9.525	9.525	3.97	4.4
12 04	12.7	12.7	4.76	5.56

SP** positive insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW		
				P	●	●	●	❁	❁	❁									❁	❁			●	❁	●			
				M							○	❁							○	○	❁	❁	❁	○	❁	○			
				K									●	❁	❁	❁													
				N																						●	❁		
				S															○	○	❁	❁	❁	○			○	❁		
				H																									
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201		
Flat	**SPMW09T304**	0.4	0.5-4.0	0.1-0.4											○														
	SPMW09T308	0.8	0.5-4.0	0.2-0.4											○														
	SPMW120408	0.8	1-6	0.3-0.6											○														

● Ex stock ○ On demand

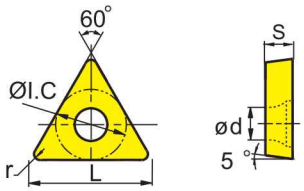
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TBGH	L	I.C	S	d
06 01	6.87	3.97	1.59	2.2



TB** positive insert		HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
	P	○	○	○	◎	◎	◎									◎	◎			○	◎	○		
	M							○	◎					○	○	◎	◎	◎	○	○	◎	○		
	K									○	◎	◎	◎											
	N													○	○								○	◎
	S													○	○	◎	◎	◎	○				○	◎
	H																							

ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
	**TBGH060102L**	0.2	0.5-3.5	0.05-0.40														●						●				
	TBGH060104L	0.4	0.5-3.5	0.05-0.40														○						●				

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

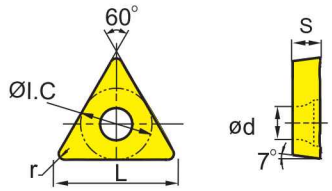
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TCGT	L	I.C	S	d
06 T1	6.87	3.97	1.98	2.2
09 02	9.63	5.56	2.38	2.5
11 03	11	6.35	3.18	2.8

TC** positive insert

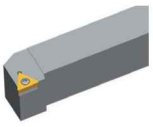


					HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
	ISO		r	a_p	f																						
SF	**TCGT06T102-SF**		0.2	0.05-2.00	0.05-0.15																				●		
	TCGT090202-SF		0.2	0.05-2.00	0.05-0.15																			○	○		
	TCGT090204-SF		0.4	0.05-2.00	0.1-0.3																				●		
	TCGT090208-SF		0.8	0.05-2.00	0.10-0.35																				●		
	TCGT110302-SF		0.2	0.05-2.00	0.05-0.15																				○		
Finishing	**TCGT110304-SF**		0.4	0.05-2.00	0.1-0.3																			●	●		
	TCGT110308-SF		0.8	0.05-2.00	0.10-0.35																				○		

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

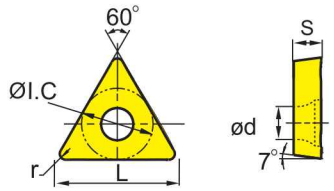
Tool holder

STGCR/L	E***-STFCR/L
Kr: 91°	Kr: 90°
	
A285	A361

TCMT	L	I.C	S	d
09 02	9.63	5.56	2.38	2.5
11 02	11	6.35	2.38	2.8
16 T3	16.5	9.525	3.97	4.4

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

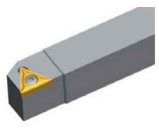
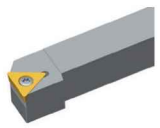
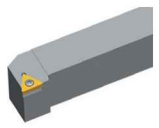
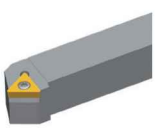


TC** positive insert		r	a_p	f	HC¹ (CVD)										HC¹ (PVD)							HT		HC²	HW	
	ISO				YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
AHF	**TCMT110204-AHF**	0.4	0.2-2.5	0.05-0.30		●															●						
	TCMT110208-AHF	0.8	0.2-2.5	0.1-0.4		●															●						
	TCMT16T304-AHF	0.4	0.5-3.0	0.05-0.30		●															●						
	TCMT16T308-AHF	0.8	0.5-3.5	0.1-0.4		●															●						
Finishing																											
HF	**TCMT090202-HF**	0.2	0.06-1.70	0.03-0.13			○		●															○				
	TCMT090204-HF	0.4	0.1-1.7	0.05-0.19			○		●																			
	TCMT090208-HF	0.8	0.15-1.70	0.10-0.25					○																			
	TCMT110202-HF	0.2	0.08-2.00	0.05-0.20					●																			
	TCMT110204-HF	0.4	0.1-2.0	0.05-0.30			○		●						○													
	TCMT110208-HF	0.8	0.1-2.0	0.05-0.35			●		●					●														
Finishing	**TCMT16T304-HF**	0.4	0.11-2.00	0.05-0.23			○		●																			
	TCMT16T308-HF	0.8	0.2-3.5	0.05-0.30																								
XF	**TCMT090202-XF**	0.2	0.5-1.5	0.08-0.15				○																				
	TCMT090204-XF	0.4	0.5-1.5	0.08-0.20	●																							
	TCMT110202-XF	0.2	0.5-2.0	0.08-0.15				○																				
	TCMT110204-XF	0.4	0.5-2.0	0.08-0.20	●																							
	TCMT110208-XF	0.8	0.5-2.5	0.08-0.25	●																							
Finishing	**TCMT16T304-XF**	0.4	0.5-2.5	0.08-0.20	●																							
	TCMT16T308-XF	0.8	0.5-2.5	0.08-0.25	●																							

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

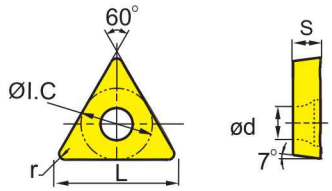
STACR/L	STFCR/L	STGCR/L	STTCR/L	S***-STFCR/L	E***-STFCR/L
Kr: 90°	Kr: 91°	Kr: 91°	Kr: 60°	Kr: 91°	Kr: 90°
					
A283	A284	A285	A286	A341	A361

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

TCMT	L	I.C	S	d
09 02	9.63	5.56	2.38	2.5
11 02	11	6.35	2.38	2.8
16 T3	16.5	9.525	3.97	4.4

Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

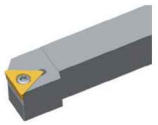
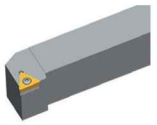
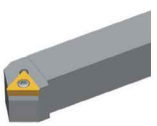


TC** positive insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉														○	◉	○		
M											○	◉												○	◉	○		
K													●	◉	◉	◉												
N																	○	○									○	◉
S																	○	○	◉	◉	◉	◉	○				○	◉
H																												
	ISO		r	a_p	f																							
EF	**TCMT090202-EF**		0.2	0.06-1.70	0.03-0.13																							
	TCMT090204-EF		0.4	0.1-1.7	0.05-0.19														●									
	TCMT110202-EF		0.2	0.2-2.0	0.05-0.13														○									
	TCMT110204-EF		0.4	0.2-2.0	0.05-0.20														●									
	TCMT16T304-EF		0.4	0.3-3.0	0.05-0.23														●									
Finishing	**TCMT16T308-EF**		0.8	0.3-3.0	0.1-0.4						●								●									
EM	**TCMT090204-EM**		0.4	0.19-2.25	0.06-0.17						○								●									
	TCMT110204-EM		0.4	0.2-2.7	0.05-0.30						○								●									
	TCMT110208-EM		0.8	0.8-2.7	0.08-0.30														●									
	TCMT16T304-EM		0.4	0.25-3.00	0.08-0.23						●								●									
Medium Cut	**TCMT16T308-EM**		0.8	0.5-3.0	0.1-0.3						●	●							●									
XM	**TCMT16T304-XM**		0.4	1-3.0	0.15-0.3	○		○																				
	TCMT16T308-XM		0.8	1-3.0	0.15-0.35	○		○																				
	TCMT16T312-XM		1.2	1-3.0	0.15-0.4	○		○																				
Medium Cut																												

● Ex stock ○ On demand
YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

STACR/L	STFCR/L	STGCR/L	STTCR/L	S***-STFCR/L	E***-STFCR/L
Kr: 90°	Kr: 91°	Kr: 91°	Kr: 60°	Kr: 91°	Kr: 90°
					
A283	A284	A285	A286	A341	A361

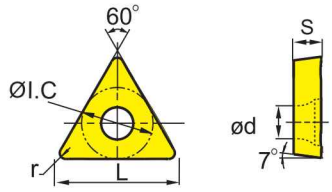
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TC**	L	I.C	S	d
09 02	9.63	5.56	2.38	2.5
11 02	11	6.35	2.38	2.8
16 T3	16.5	9.525	3.97	4.4
22 04	22	12.7	4.76	5.5

TC** positive insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW		
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○			
M							○	◉					○	○	◉	◉	◉	○	○	◉	○			
K									●	◉	◉	◉												
N													●	●									●	◉
S													●	●	◉	◉	◉	●					●	◉
H																								

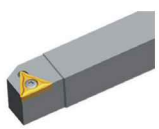
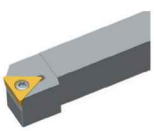
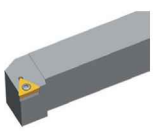
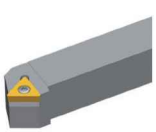
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Flat	**TCMW16T308**	0.8	0.5-5.0	0.05-0.60											○													
Medium Cut																												
HM	**TCMT090204-HM**	0.4	0.19-2.25	0.06-0.17			●	●					●		●													
Medium Cut	**TCMT090208-HM**	0.8	0.38-2.25	0.08-0.23			○	○							○													
	TCMT110204-HM	0.4	0.2-2.7	0.07-0.20			●	●					●		●													
	TCMT110208-HM	0.8	0.5-2.7	0.1-0.3			●	●							●													
	TCMT16T304-HM	0.4	0.25-3.00	0.08-0.23			●	●					●		●													
	TCMT16T308-HM	0.8	0.5-3.0	0.1-0.3			●	●					●		●													
	TCMT16T312-HM	1.2	0.6-3.0	0.12-0.36			○	●																				
HR	**TCMT090204-HR**	0.4	0.5-3.0	0.1-0.3				○																				
Roughing	**TCMT090208-HR**	0.8	0.5-3.5	0.08-0.50				○							○													
	TCMT110204-HR	0.4	0.5-3.0	0.1-0.4				●																				
	TCMT110208-HR	0.8	1-4	0.1-0.5				●																				
	TCMT16T304-HR	0.4	0.5-4.0	0.1-0.4				●					●															
	TCMT16T308-HR	0.8	1-4	0.12-0.35				●					●		●													
	TCMT16T312-HR	1.2	1.2-4.0	0.14-0.42			○						○		●													
	TCMT220408-HR	0.8	1.2-4.8	0.14-0.42			○	●							●													

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

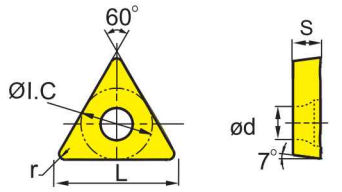
STACR/L	STFCR/L	STGCR/L	STTCR/L	S***-STFCR/L	E***-STFCR/L
Kr: 90°	Kr: 91°	Kr: 91°	Kr: 60°	Kr: 91°	Kr: 90°
					
A283	A284	A285	A286	A341	A361

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TCMT	L	I.C	S	d
22 04	22	12.7	4.76	5.5

Turning inserts

TC** positive insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
				P	○	○	○	◉	◉	◉								◉	◉		○	◉	○		
				M							○	◉						○	○	◉	◉	◉	○	◉	○		
				K									◉	◉	◉	◉											
				N																					◉	◉	
				S											○	○	◉	◉	◉	○					○	◉	
				H																							
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
Basic	**TCMT220408**	0.8	1.2-4.8	0.14-0.42									●															

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

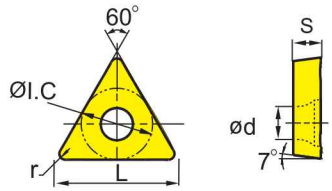
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TCGX	L	I.C	S	d
09 02	9.63	5.56	2.38	2.5
11 02	11	6.35	2.38	2.8
16 T3	16.5	9.525	3.97	4.4

TC** positive insert



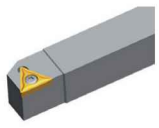
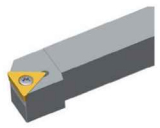
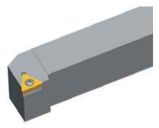
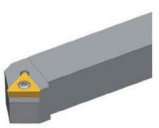
	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
M							○	◉				○	○	◉	◉	◉	○		○	◉	○		
K									◉	◉	◉	◉											
N												○	○									○	◉
S												○	○	◉	◉	◉	○					○	◉
H																							

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
LC	**TCGX090202-LC**	0.2	0.3-4.0	0.05-0.15													●										●	
	TCGX090204-LC	0.4	0.5-4.0	0.1-0.3													●										●	
	TCGX110202-LC	0.2	0.3-5.0	0.05-0.15													●										●	
	TCGX110204-LC	0.4	0.5-5.0	0.1-0.3													●										●	
	TCGX110208-LC	0.8	0.5-5.0	0.15-0.60													●										●	
Alum Machining	**TCGX16T304-LC**	0.4	0.5-7.0	0.1-0.3																							●	
	TCGX16T308-LC	0.8	0.5-7.0	0.15-0.60													●										●	
LH	**TCGX090202-LH**	0.2	0.3-4.0	0.05-0.15														○									●	
	TCGX090204-LH	0.4	0.5-4.0	0.1-0.3																							●	
	TCGX110202-LH	0.2	0.3-5.0	0.05-0.15														○									●	
	TCGX110204-LH	0.4	0.5-5.0	0.1-0.3														●									●	
	TCGX110208-LH	0.8	0.5-5.0	0.15-0.60																							●	
Alum Machining	**TCGX16T302-LH**	0.2	0.5-7.0	0.05-0.15																							●	
	TCGX16T304-LH	0.4	0.5-7.0	0.1-0.3														○									●	
	TCGX16T308-LH	0.8	0.5-7.0	0.15-0.60														○									●	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

STACR/L	STFCR/L	STGCR/L	STTCR/L	S***-STFCR/L	E***-STFCR/L
Kr: 90°	Kr: 91°	Kr: 91°	Kr: 60°	Kr: 91°	Kr: 90°
					
A283	A284	A285	A286	A341	A361

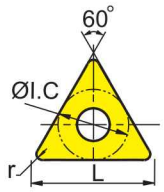
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

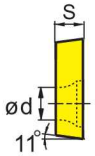
Turning inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

TPGH	L	I.C	S	d
09 02	9.63	5.56	2.38	2.8
11 03	11	6.35	3.18	3.18

TP** positive insert





	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	○	○	○	◉	◉	◉									◉	◉		○	◉	○		
M							○	◉				○	○	◉	◉	◉	○	○	◉	○		
K									○	◉	◉	◉										
N												○	○								○	◉
S												○	○	◉	◉	◉	○				○	◉
H																						

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
 Super Finishing	**TPGH090202L**	0.2	0.2-3.0	0.05-0.15														●						●	●			
	TPGH090204L	0.4	0.2-3.0	0.05-0.30														●						●	●			
	TPGH110302L	0.2	0.2-3.5	0.05-0.15														●						●	●			
	TPGH110304L	0.4	0.2-3.5	0.05-0.30														●						●	●			

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

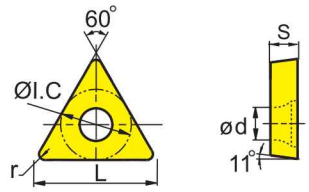
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TPGT	L	I.C	S	d
09 02	9.63	5.56	2.38	2.5
11 03	11	6.35	3.18	2.8

TP** positive insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW		
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○			
M							○	◉				○	○	◉	◉	◉	◉	○	◉		○			
K									○	◉	◉	◉												
N												○	○										○	◉
S												○	○	◉	◉	◉	◉	○					○	◉
H																								

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
SF	**TPGT090202-SF**	0.2	0.05-2.00	0.05-0.15																						●		
	TPGT090204-SF	0.4	0.05-2.00	0.05-0.25														○						●		●		
	TPGT090208-SF	0.8	0.05-2.00	0.05-0.35																				●				
	TPGT110302-SF	0.2	0.05-2.00	0.05-0.15																				●		●		
Finishing	**TPGT110304-SF**	0.4	0.05-2.00	0.05-0.25																				○		●		
	TPGT110308-SF	0.8	0.05-2.00	0.05-0.35																						●		

● Ex stock ○ On demand

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

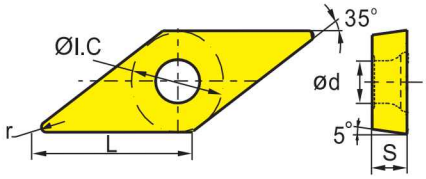
S***-STUPR/L	C***-STUPR/L	E***-STFPR/L
Kr: 93°	Kr: 93°	Kr: 90°
		
A351	A360	A362

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

VBMT	L	I.C	S	d
11 02	11	6.35	2.38	2.8
11 03	11	6.35	3.18	2.8
16 04	16.5	9.525	4.76	4.4

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions



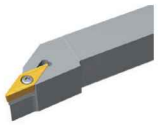
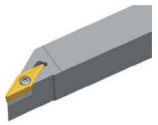
VB** positive insert					HC[1] (CVD)										HC[1] (PVD)						HT		HC[2]	HW	
				P																					
				M																					
				K																					
				N																					
				S																					
				H																					
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
AHF	**VBMT160404-AHF**	0.4	0.2-3.0	0.05-0.30		●															●						
	VBMT160408-AHF	0.8	0.8-3.5	0.08-0.40		●															●						
Finishing																											
EF	**VBMT110302-EF**	0.2	0.06-1.70	0.03-0.13																●							
	VBMT110304-EF	0.4	0.1-1.7	0.05-0.19							●									●							
	VBMT110308-EF	0.8	0.13-1.70	0.07-0.26							●									○							
	VBMT160404-EF	0.4	0.1-1.8	0.05-0.20							●									●							
Finishing	**VBMT160408-EF**	0.8	0.14-1.80	0.07-0.27							●									●							
XF	**VBMT110202-XF**	0.2	0.5-2.0	0.08-0.20				○																			
	VBMT110204-XF	0.4	0.5-2.0	0.08-0.20	●																						
	VBMT110302-XF	0.2	0.5-2.0	0.08-0.20				○																			
	VBMT110304-XF	0.4	0.5-2.0	0.08-0.20	●																						
Finishing	**VBMT160404-XF**	0.4	0.5-2.5	0.08-0.20	●																						
	VBMT160408-XF	0.8	0.5-2.5	0.08-0.25	●																						

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

SVJBR/L	SVABR/L	SVVBN	S***-SVQBR/L	S***-SVUBR/L	S***-SVXBR/L
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°	Kr: 93°
					
A274	A275	A276	A345	A346	A347

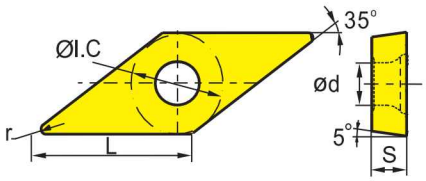
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VB**	L	I.C	S	d
11 02	11	6.35	2.38	2.8
16 04	16.5	9.525	4.76	4.4

VB** positive insert



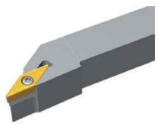
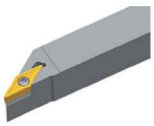
	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	●	●	●	◉	◉	◉										◉	◉			●	◉	●		
M							○	◉					○	○	◉	◉	◉	◉	○	○	◉	○		
K									◉	◉	◉	◉												
N													●	●									●	◉
S													●	●	◉	◉	◉	◉	●				●	◉
H																								

	ISO	r	a_p	f
HF	**VBMT110202-HF**	0.2	0.2-2.0	0.05-0.15
	VBMT110204-HF	0.4	0.2-2.0	0.05-0.35
	VBMT110208-HF	0.8	0.2-2.0	0.05-0.40
Finishing				
NF	**VBET160404-NF**	0.4	0.2-3.0	0.05-0.30
	VBET160408-NF	0.8	0.2-3.0	0.08-0.40
Finishing				

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

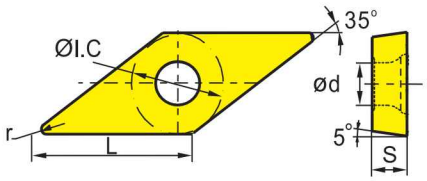
SVJBR/L	SVABR/L	SVVBN	S***-SVQBR/L	S***-SVUBR/L	S***-SVXBR/L
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°	Kr: 93°
					
A274	A275	A276	A345	A346	A347

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VBGT	L	I.C	S	d
11 03	11	6.35	3.18	2.8

Turning inserts

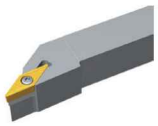
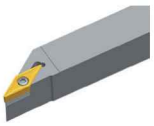


VB** positive insert					HC¹ (CVD)									HC¹ (PVD)						HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	○	◉	◉	◉										◉	◉			○	○	●		
M											○	◉					○	○	◉	◉	◉	◉	○	○	◉	○		
K													○	◉	◉	◉									○	●		
N																	○	○									○	◉
S																	○	○	◉	◉	◉	◉	○				○	◉
H																												
ISO		r	a_p	f																								
SF	**VBGT110302-SF**	0.2	0.05-2.00	0.05-0.15																			○	○	●		
	VBGT110304-SF	0.4	0.05-2.00	0.05-0.20																				○	●		
Finishing																												

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SVJBR/L	SVABR/L	SVVBN	S***-SVXBR/L
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 93°
			
A274	A275	A276	A347

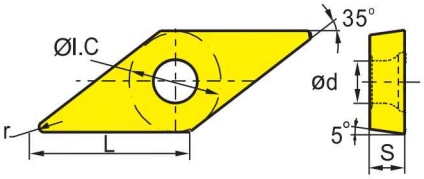
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VB**	L	I.C	S	d
11 03	11	6.35	3.18	2.8
16 04	16.5	9.525	4.76	4.4

VB** positive insert



	HC[1] (CVD)											HC[1] (PVD)							HT		HC[2]	HW	
P	○	○	○	◉	◉	◉									◉	◉				○	◉	○		
M							○	◉					○	○	◉	◉	◉	○	○	◉	○			
K									●	◉	◉	◉												
N													●	●									◉	◉
S													●	●	◉	◉	◉	●					●	◉
H																								

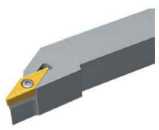
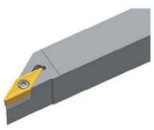
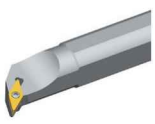
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YB5103	YNG151	YNT251	YNG151C	YD101	YD201
NGF	**VBET160408-NGF**	0.8	0.2-3.0	0.08-0.30															●									
	VBET160412-NGF	1.2	0.2-3.0	0.1-0.4															●									
Finishing																												
EM	**VBMT110304-EM**	0.4	0.15-2.00	0.07-0.20							●									●								
	VBMT110308-EM	0.8	0.2-2.0	0.09-0.27			○				●									●								
	VBMT160404-EM	0.4	0.23-2.70	0.07-0.20							●									●								
Medium Cut	**VBMT160408-EM**	0.8	0.45-2.70	0.09-0.27							●									●								
HM	**VBMT160404-HM**	0.4	0.23-2.70	0.07-0.20			●		●		●		●															
	VBMT160408-HM	0.8	0.45-2.70	0.09-0.27			●		●		●	●	●		●												○	
Medium Cut	**VBMT160412-HM**	1.2	0.54-2.70	0.11-0.32			●		●																			
XM	**VBMT160404-XM**	0.4	1-2.5	0.15-0.25	●			○																				
	VBMT160408-XM	0.8	1-2.5	0.15-0.3	●			○																				
Medium Cut	**VBMT160412-XM**	1.2	1-2.5	0.15-0.35	●			○																				

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC[1] Coated carbide
HT Uncoated cermet
HC[2] Coated cermet
HW Uncoated carbide

Tool holder

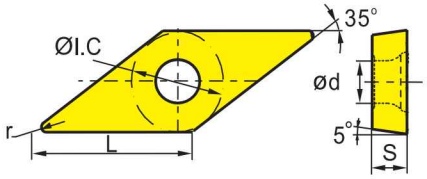
SVJBR/L	SVABR/L	SVVBN	S***-SVQBR/L	S***-SVUBR/L	S***-SVXBR/L
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°	Kr: 93°
					
A274	A275	A276	A345	A346	A347

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VBMT	L	I.C	S	d
16 04	16.5	9.525	4.76	4.4

Turning inserts



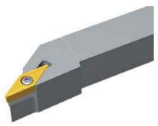
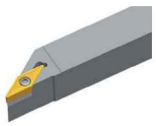
VB** positive insert		HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
		YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P		○	○	○	◉	◉	◉										◉	◉			◉	◉	○		
M								○	◉						○	○	◉	◉	◉	○	○	◉	○		
K										●	◉	◉	◉												
N														●	●									●	◉
S														○	○	◉	◉	◉	◉	○				○	◉
H																									
ISO		r	a_p	f																					
HR	**VBMT160404-HR**	0.4	0.5-3.0	0.1-0.3			●	●																	
	VBMT160408-HR	0.8	0.9-3.6	0.11-0.32			○	●																	
	VBMT160412-HR	1.2	1.08-3.60	0.13-0.38			○	●																	
Roughing																									
SNR	**VBMT160408-SNR**	0.8	0.5-4.0	0.1-0.3												●				○					
	VBMT160412-SNR	1.2	0.5-4.0	0.3-0.6												●			○	○					
Roughing																									

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SVJBR/L	SVABR/L	SVVBN	S***-SVQBR/L	S***-SVUBR/L	S***-SVXBR/L
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°	Kr: 93°
					
A274	A275	A276	A345	A346	A347

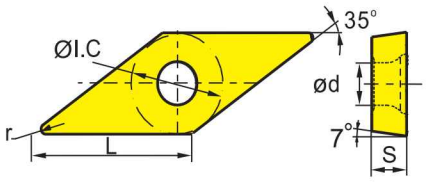
System code A48 Grade selection A42 Technical info A501 Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VCGT	L	I.C	S	d
11 03	11	6.35	3.18	2.8
16 04	16.5	9.525	4.76	4.4

VC** positive insert



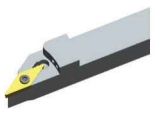
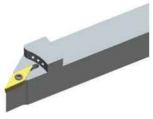
	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	○	◉	◉	◉										◉	◉			○	◉	○		
M							○	◉					○	○	◉	◉	◉	○		○	◉	○		
K									◉	◉	◉	◉												
N													○	○									◉	◉
S													○	○	◉	◉	◉	○					○	◉
H																								

ISO		r	a_p	f	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
					YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
HF	**VCGT110304-HF**	0.4	0.2-2.0	0.05-0.30																○								
Finishing																												
NF	**VCGT160408-NF**	0.8	0.2-2.0	0.1-0.4															●									
Finishing																												
SF	**VCGT110302-SF**	0.2	0.05-1.00	0.05-0.15																				●	●	●		
	VCGT110304-SF	0.4	0.05-1.00	0.05-0.25														○		●				●	○	●		
	VCGT160404-SF	0.4	0.05-1.50	0.05-0.25																						●		
Finishing																												

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SVVCN	SVJCR/L	SVACR/L-SC	SVJCR/L-SC	S***-SVQCR/L	S***-SVUCR/L	C***-SVQCR/L
Kr: 72°30'	Kr: 93°	Kr: 90°	Kr: 93°	Kr: 107°30'	Kr: 93°	Kr: 107°30'
						
A277	A278	A312	A313	A343	A344	A363

C***-SVUCR/L
Kr: 93°

A364

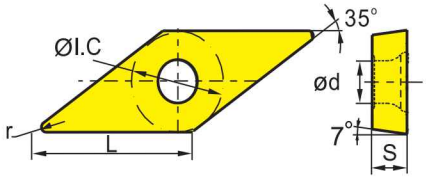
System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning/Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VCGX	L	I.C	S	d
11 03	11	6.35	3.18	2.8
16 04	16.6	9.525	4.76	4.4
22 05	22	12.7	5.56	5.5

VC** turning/milling insert



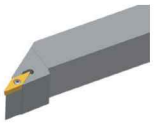
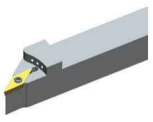
	HC¹ (CVD)											HC¹ (PVD)						HT		HC²	HW	
P	○	○	○	◉	◉	◉									◉	◉		◉	◉	○		
M							○	◉					○	○	◉	◉	○	○	◉	○		
K									○	◉	◉	◉										
N												○	○								○	◉
S													○	○	◉	◉	◉	○			○	◉
H																						

	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
LC	**VCGX110301-LC**	0.1	0.3-3.0	0.05-0.10													●			●							●	
	VCGX110302-LC	0.2	0.3-3.0	0.05-0.15													●			○							●	
	VCGX110304-LC	0.4	0.5-3.0	0.1-0.3													●										●	
	VCGX110308-LC	0.8	1-3	0.1-0.5													●										●	
Alum Machining	**VCGX160404-LC**	0.4	0.5-5.0	0.1-0.3													●										●	
	VCGX160408-LC	0.8	0.5-5.0	0.15-0.60													●										●	
	VCGX160412-LC	1.2	0.5-5.0	0.15-0.80													○										●	
	VCGX220530-LC	3	0.5-7.0	0.25-1.00													●										○	●

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SVVCN	SVJCR/L	SVACR/L-SC	SVJCR/L-SC	S***-SVQCR/L	S***-SVUCR/L	C***-SVQCR/L
Kr: 72°30'	Kr: 93°	Kr: 90°	Kr: 93°	Kr: 107°30'	Kr: 93°	Kr: 107°30'
						
A277	A278	A312	A313	A343	A344	A363

C***-SVUCR/L
Kr: 93°

A364

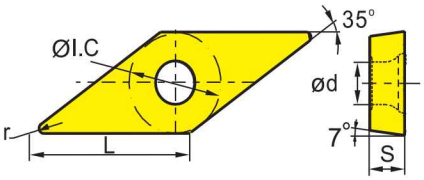
System code A48 Grade selection A42 Technical info A501 Cutting data A366

VCGX	L	I.C	S	d
11 02	11	6.35	2.38	2.8
11 03	11	6.35	3.18	2.8
16 04	16.6	9.525	4.76	4.4
22 05	22	12.7	5.56	5.5

Turning/Milling inserts

Ideal machining conditions
Normal machining conditions
Unfavourable machining conditions

VC** turning/milling insert



	HC¹ (CVD)											HC¹ (PVD)							HT		HC²	HW	
P	○	○	○	◉	◉	◉									◉	◉			○	◉	○		
M							○	◉					○	○	◉	◉	◉	○	○	◉	○		
K									●	◉	◉	◉											
N													●	●								●	◉
S													●	●	◉	◉	◉	●				●	◉
H																							

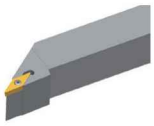
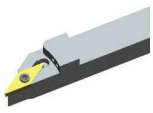
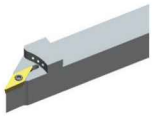
	ISO	r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
LH	**VCGX110204-LH**	0.4	0.5-3.0	0.1-0.3														●									●	
	VCGX110301-LH	0.1	0.5-3.0	0.05-0.10																							●	●
	VCGX110302-LH	0.2	0.3-3.0	0.05-0.15														●									●	○
	VCGX110304-LH	0.4	0.5-3.0	0.1-0.3														●									●	○
	VCGX110308-LH	0.8	0.5-3.0	0.15-0.60														○									●	
	VCGX160402-LH	0.2	0.5-5.0	0.05-0.10														●									●	
	VCGX160404-LH	0.4	0.5-5.0	0.1-0.3														●									●	
	VCGX160408-LH	0.8	0.5-5.0	0.15-0.60														●									●	
	VCGX160412-LH	1.2	0.5-5.0	0.15-0.80														○									●	
	VCGX220530-LH	3	0.5-7.0	0.25-1.00														○									●	○

Alum Machining

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

Tool holder

SVVCN	SVJCR/L	SVACR/L-SC	SVJCR/L-SC	S***-SVQCR/L	S***-SVUCR/L	C***-SVQCR/L
Kr: 72°30'	Kr: 93°	Kr: 90°	Kr: 93°	Kr: 107°30'	Kr: 93°	Kr: 107°30'
						
A277	A278	A312	A313	A343	A344	A363

C***-SVUCR/L
Kr: 93°

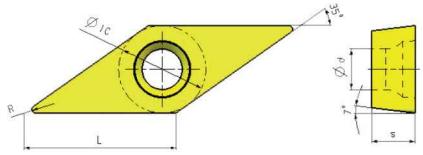
A364

System code A48 | Grade selection A42 | Technical info A501 | Cutting data A366

Turning inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

VCMT	L	I.C	S	d
11 03	11	6.35	3.18	2.8
16 04	16	9.525	4.76	4.4



VC** positive insert					HC¹ (CVD)										HC¹ (PVD)						HT		HC²	HW	
					P																				
					M																				
					K																				
					N																				
					S																				
					H																				
ISO		r	a_p	f	YBC103	YB6315	YBC152	YBC203	YBC252	YBC352	YBM153	YBM253	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YB9320	YPD201	YBS103	YNG151	YNT251	YNG151C	YD101	YD201
XF	**VCMT110302-XF**	0.2	0.5-2.0	0.08-0.20				○																			
	VCMT110304-XF	0.4	0.5-2.0	0.08-0.20	●																						
	VCMT110308-XF	0.8	0.5-2.0	0.08-0.25	●																						
	VCMT160404-XF	0.4	0.5-2.5	0.08-0.20	●																						
Finishing	**VCMT160408-XF**	0.8	0.5-2.5	0.08-0.25	●																						
EF	**VCMT160404-EF**	0.4	0.5-2.5	0.05-0.20																●							
Medium Cut																											
EM	**VCMT160404-EM**	0.4	0.5-2.5	0.05-0.35							○									●							
	VCMT160408-EM	0.8	0.5-2.5	0.10-0.45							○									●							
Medium Cut																											
XM	**VCMT160412-XM**	1.2	1-2.5	0.15-0.35	○			○																			
Medium Cut																											

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code A48 Grade selection A42 Technical info A501 Cutting data A366