Catalogue

Version 2019

2019

EN

ZCC-CT

ZCC Cutting Tools Europe GmbH

your Partner \ your Value

Welcome to **ZCC Cutting Tools Europe!**

You now have the 2019 main catalogue of ZCC Cutting Tools in your hands. The entire ZCC-CT team are pleased that you are giving us an opportunity to present our continually growing portfolio of tools, which can make your production more cost-efficient.

Just one year after the previous version of the catalogue, we again have many newly available important and well-engineered products and product upgrades for you to discover.

Added value through partnership is and remains both our standard and our promise to our customers. Our services therefore go far beyond the content of this catalogue and include, in addition to the development and testing of individual special solutions in the new Technical & Development Centre of our European head office in Düsseldorf, a comprehensive range of services such as tool management and provision of tool data, tool reconditioning and customised customer training. Please contact us about these services at any time.

You will find in Part A of this catalogue tools for turning, in Part B tools for milling and in Part C tools for drilling. We have created separate catalogues for tool systems and boring tools. If you need additional catalogues and further information, get in touch with your personal contact or our internal sales team at any time.

We would like to thank you for the confidence you place in us and look forward to a very good working relationship with you.
The team from ZCC Cutting Tools Europe will support you as your partner at any time.

Your ZCC Cutting Tools Europe GmbH

ZCC·CT

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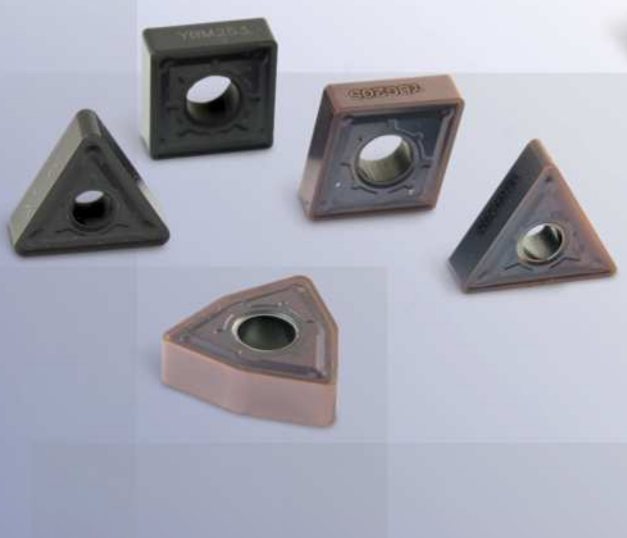
Member of Minmetals Group


C·CT


MC 734/MT
STAMA


BLUEBIRD
CTD
-1.5


QEGD2020L13
DCLNR2525M12


YBM253

General turning

Carbide and cermet inserts

Double sided, negative – Finishing

					
CNEG-NF	**CNMG-ADF**	**CNMG-DF**	**CNMG-EF**	**CNMG-SF**	
12	12	09 12	09 12	09 12	Edge length
A46	A45	A45	A45	A45	Page

							
DNEG-NF	**DNEG-NGF**	**DNMG-ADF**	**DNMG-DF**	**DNMG-EF**	**DNMG-FM**	**DNMG-SF**	
15	15	15	11 15	11 15	15	11 15	Edge length
A58	A58	A55	A55	A58	A58	A55	Page

				
SNMG-ADF	**SNMG-DF**	**SNMG-EF**	**SNMG-SF**	
12	12	09 12 15	09 12	Edge length
A63	A63	A64	A63	Page

					
TNMG-ADF	**TNMG-DF**	**TNMG-EF**	**TNMG-FM**	**TNMG-SF**	
16	16 22	11 16 22	16	11 16 22	Edge length
A78	A78	A80	A80	A79	Page

						
VNEG-NF	**VNEG-NGF**	**VNMG-ADF**	**VNMG-DF**	**VNMG-EF**	**VNMG-SF**	
16	16	16	16	16	16	Edge length
A90	A91	A90	A90	A90	A91	Page

						
WNEG-NF	**WNMG-ADF**	**WNMG-DF**	**WNMG-EF**	**WNMG-NF**	**WNMG-SF**	
08	08	06 08	06 08	06	06 08	Edge length
A95	A94	A94	A95	A95	A94	Page

Double sided, negative, Wiper – Finishing

				
CNMG-WG	**DNMX-WG**	**TNMX-WG**	**WNMG-WG**	
12	11 15	16	08	Edge length
A45	A55	A78	A95	Page

Carbide and cermet inserts

Double sided, negative – Medium machining

								
CNMG	**CNMG-DM**	**CNMG-EG**	**CNMG-EM**	**CNMG-NM**	**CNMG-PM**	**CNMG-TC**	**CNMG-ZM**	
12 16 19	09 12 16 19	12	12 16	12	09 12 16 19	12 16	12	Edge length
A54	A47	A47	A47	A49	A46	A49	A48	Page

							
DNMG-DM	**DNMG-EG**	**DNMG-EM**	**DNMG-NM**	**DNMG-PM**	**DNMG-TC**	**DNMG-ZM**	
11 15	15	11 15	15	11 15	15	15	Edge length
A56	A59	A59	A59	A56	A59	A57	Page

								
RNMG	**SNMG**	**SNMG-DM**	**SNMG-EG**	**SNMG-EM**	**SNMG-NM**	**SNMG-PM**	**SNMG-TC**	
12	12 25	09 12 15 19	12	12 15	12	09 12 15 19	12 15	Edge length
A99	A74	A66	A66	A67	A68	A65	A67	Page

							
TNMG	**TNMG-DM**	**TNMG-EG**	**TNMG-EM**	**TNMG-PM**	**TNMG-TC**	**TNMG-ZM**	
16 22 27 33	11 16 22	16	16 22	11 16 22	16 22	16	Edge length
A88	A81	A83	A83	A81	A83	A82	Page

								
VNMG	**VNMG-DM**	**VNMG-PM**	**VNMG-EM**	**VNMG-NM**	**VNMG-TC**	**VNMG-SNR**	**VNMG-ZM**	
16	16	16	16	16	16	16	16	Edge length
A92	A92	A93	A92	A92	A93	A93	A93	Page

							
WNMG-DM	**WNMG-EG**	**WNMG-EM**	**WNMG-NM**	**WNMG-PM**	**WNMG-TC**	**WNMG-ZM**	
06 08	08	06 08	08	06 08	08	08	Edge length
A96	A96	A96	A98	A97	A98	A97	Page

Double sided, negative – Medium machining to roughing

						
CNMA	**DNMA**	**SNMA**	**SNUN**	**TNMA**	**WNMA**	
12 16 19	15	12 15 19	12 19 25	16 22	06 08	Edge length
A54	A61	A75	A77	A89	A98	Page

Carbide and cermet inserts

Double sided, negative – Roughing

								
CNMG-DR	**CNMG-ER**	**CNMG-SNR**	**DNMG-DR**	**DNMG-ER**	**DNMG-SNR**	**SNMG-DR**	**SNMG-ER**	
12 16 19 25	12 16 19	12 16 19	15	15	15	12 15 19 25	12 15 19	Edge length
A49	A51	A50	A60	A61	A60	A68	A69	Page

			
TNMG-DR	**TNMG-ER**	**WNMG-DR**	
16 22 27	16 22	06 08	Edge length
A84	A85	A98	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
A53	A51	A51	A53	A53	A52	Page

				
DNMM-DR	**DNMM-ER**	**DNMM-HDR**	**DNMM-LR**	
15	15	15	15	Edge length
A62	A62	A62	A62	Page

						
SNMM	**SNMM-DR**	**SNMM-ER**	**SNMM-HDR**	**SNMM-HPR**	**SNMM-LR**	
12 19 25	15 19 25	25	12 15 19 25	19 25	12 15 19 25	Edge length
A74	A70	xxx	A72	A73	A71	Page

				
TNMM	**TNMM-DR**	**TNMM-HDR**	**TNMM-LR**	
16 22 27	16 22 27	22 27	16	Edge length
A89	A85	A87	A85	Page

Special form – Roughing

					
175.32-22 · 227	**175.32-24**	**175.32-25**	**175.32-28 · 31**	**KNUX**	
				16	Edge length
A101	A101	A101	A101	A100	Page

Carbide and cermet inserts

Positive – Fine-finishing

						
CCGT-SF	**CCGT-USF**	**CPGT-SF**	**DCGT-SF**	**DPGT-SF**	**DCGT-USF**	
06 09	09	06 09	07 11	07 11	07 11	Edge length
A102	A102	A110	A111	A117	A112	Page

					
TBGH	**TCGT-SF**	**TCGT-USF**	**TPGH**	**TPGT-SF**	
06	06 09 11	11	09 11	09 11	Edge length
A125	A126	A126	A132	A133	Page

				
VBGT-SF	**VCGT-SF**	**VCGT-USF**	**VPGT-USF**	
11	11 16	11	11	Edge length
A141	A134	A135	A139	Page

Positive – Finishing

					
CCMT-AHF	**CCMT-EF**	**CCMT-HF**	**CPGT**	**CPMT-HF**	
06 09 12	06 09 12	06 09 12	05	06	Edge length
A103	A105	A103	A104	A110	Page

						
DCMT-AHF	**DCMT-EF**	**DCMT-HF**	**SCMT-AHF**	**SCMT-EF**	**SCMT-HF**	
07 11	07 11	07 11	09	09	09	Edge length
A111	A113	A113	A120	A120	A121	Page

			
TCMT-AHF	**TCMT-EF**	**TCMT-HF**	
11 16	09 11 16	09 11 16	Edge length
A127	A128	A127	Page

					
VBET-NF	**VBET-NGF**	**VBMT-AHF**	**VBMT-EF**	**VBMT-HF**	
16	16	16	11 16	11	Edge length
A140	A142	A140	A140	A140	Page

A Turning
B Milling
C Drilling
D Technical Information
E Index

Carbide and cermet inserts

Positive – Finishing




VCGT	VCGT-HF	VCGT-NF	VCMT-EF	
13	11	16	16	Edge length
A135	A134	A134	A138	Page

Positive – Medium machining





CCMT-EM	CCMT-HM	CCMW	CPGW	CPMT-HM	
06 09 12	06 09 12	09 12	06	09	Edge length
A105	A106	A107	A110	A110	Page



DCMT-EM	DCMT-HM	DCMW	
07 11	07 11	11	Edge length
A113	A114	A115	Page



SCMT-EM	SCMT-HM	SPMW	
09 12	09 12	09 12	Edge length
A120	A121	A124	Page







TCMT	TCMT-EM	TCMT-HM	TCMW	VBMT-EM	VBMT-HM	VCMT-EM	
22	09 11 16	09 11 16	16	11 16	16	16	Edge length
A130	A128	A129	A129	A142	A142	A138	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
A107	A107	A115	A118	A119	A119	A122	A129	Page

Carbide and cermet inserts

Positive – Roughing

		
VBMT-HR	**VBMT-SNR**	
16	16	Edge length
A143	A143	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
A108	A108	A115	A116	A118	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
A122	A123	A131	A131	A136	A137	Page

PCBN & PCD

Negative

						
CNGA	**DNGA**	**SNGA**	**TNGA**	**VNGA**	**WNGA**	
12	15	12	16	16	08	Edge length
A148	A149	A150	A151	A152	A153	Page

				
CNGN	**RNGN**	**SNGN**	**WNGN**	
12	12	12 15	08	Edge length
A159	A162	A160	A161	Page

Positive

					
CCGW	**DCGW**	**TCGW**	**VBGW**	**VCGW**	
06 09 12	07 11	11 16	16	16	Edge length
A164	A166	A156	A170	A172	Page

A Turning
B Milling
C Drilling
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E Index

PCBN & PCD

Positive

				
CCGT	**DCGT**	**TCGT**	**VCGT**	
06 09 12	07 11	11 16	16	Edge length
A163	A165	A167	A171	Page

Ceramic inserts

Negative

						
CNGA	**CNGN**	**CNGX**	**DNGA**	**DNGN**	**DNGX**	
12 16	12 16	12	15	15	15	Edge length
A176	A177	A178	A179	A180	A181	Page

							
RNGN	**SNGA**	**SNGN**	**SNGX**	**TNGA**	**TNGN**	**WNGA**	
09 12 15 19 25	12	12 15 19	12	16 22	16 22	08	Edge length
A187	A182	A184	A183	A185	A186	A188	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
A197	A198	A199	A200	A202	A201	A203	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
A204	A205	A206	A207	A208	A210	A211	A212	Page

 **PTFNR/L**	 **PTGNR/L**	 **PTTNR/L**	 **PWLNR/L**	
91°	90°	60°	95°	Angle
A213	A215	A214	A217	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
A218	A219	A220	A221	A233	A234	A222	A225	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
A224	A223	A229	A226	A227	A228	A231	A230	Page

 **MWLNR/L**	
95°	Angle
A232	Page

General turning
Product overview

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
A235	A236	A237	A238	A239	A254	A255	A245	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
A246	A247	A248	A249	A250	A251	A252	A241	Page

					
SVJBR/L	**SVJCR/L**	**SVVBN**	**SVVCN**	**SWACR/L**	
93°	93°	72.5°	72.5°	90°	Angle
A240	A244	A242	A243	A253	Page

Holder with top clamping

		
CKJNR/L	**CKNNR/L**	
93°	63°	Angle
A256	A257	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
A258	A260	A264	A265	A262	A263	A259	A261	Page

			
JCLNR/L	**JDJNR/L**	**JSDNN**	
95°	93°	45°	Angle
A266	A267	A268	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
A272	A273	A274	A275	A276	A277	A278	A279	Page

Boring bars

Steel boring bars with knee lever clamping






PCLNR/L	PDSNR/L	PDUNR/L	PSKNR/L	PTFNR/L	PWLNR/L	
95°	45°	93°	75°	90°	95°	Angle
A284	A286	A287	A289	A290	A291	Page

Steel boring bars with screw clamping








SCFCR/L	SCLCR/L	SCLPR/L	SDQCR/L	SDQPR/L	SDUCR/L	SDUPR/L	SDZCR/L	
90°	95°	95°	107.5°	107.5°	93°	93°	95°	Angle
A310	A293	A306	A295	A307	A296	A308	A297	Page







SSKCR/L	STFCR/L	STUPR/L	SVQBR/L	SVQCR/L	SVUBR/L	SVUCR/L	
75°	90°	93°	107.5°	107.5°	93°	93°	Angle
A298	A300	A309	A304	A302	A305	A303	Page

Solid carbide boring bars with screw clamping








SCLCR/L	SCLPR/L	SDQCR/L	SDQPR/L	SDUCR/L	SDUPR/L	STFCR/L	STFPR/L	
95°	95°	107.5°	107.5°	93°	93°	90°	90°	Angle
A313	A312	A315	A314	A317	A316	A319	A320	Page



STUPR/L	SVQCR/L	SVUCR/L	
93°	107.5°	93°	Angle
A318	A321	A322	Page

New

ADF & AHF

Chip breaker

Optimised geometry series especially for machining of steel and stainless steel.

-ADF

Negative inserts

e.g. **CNMG ...**

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

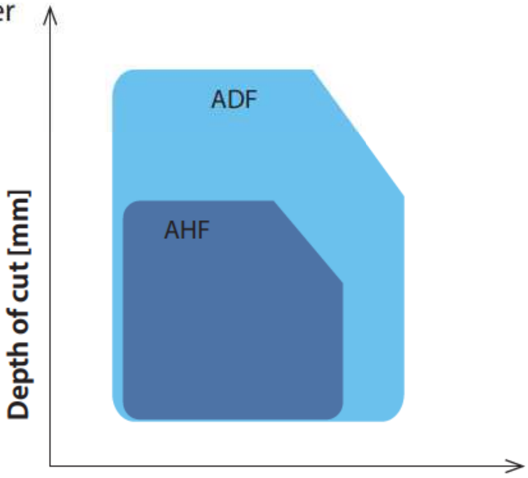
-AHF

Positive inserts

e.g. **CCMT ...**

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

Range of chip breaker



Feed rate [mm]
Finishing to medium machining

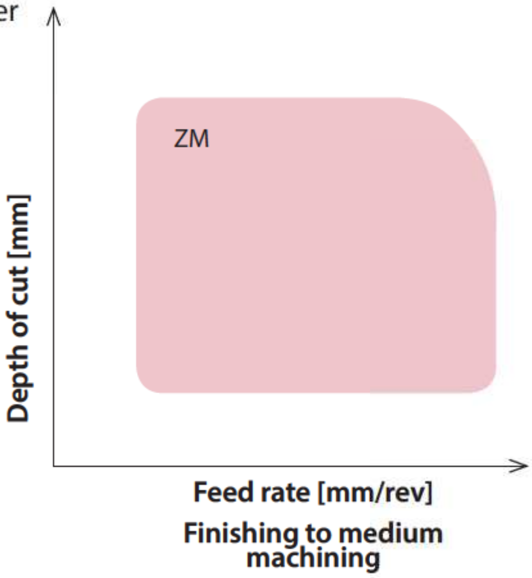
New

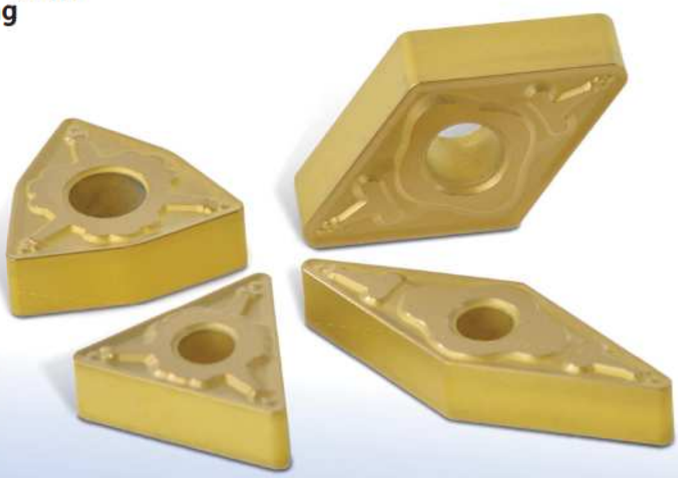
ZM Chip breaker

-ZM

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.

Range of chip breaker



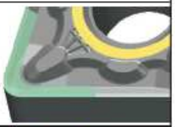
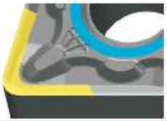


Simply coloured

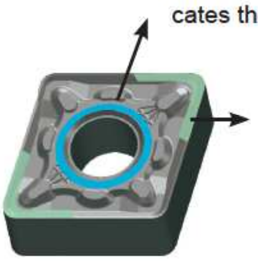
The revolution in wear identification

Ⓟ YBC
Ⓜ YBM F SERIES

Easy choice on the basis of the table without any further knowledge and without looking at the insert box.

	P	M
	○	○
05	**YBC052F** 	
15	**YBC152F** 	**YBM153F** 
25	**YBC252F** 	**YBM253F** 
35	**YBC352F** 	

Recommended for wet machining



The colour of the inner ring indicates the application range.(P/M)

The colour of the cutting edge indicates the grade, such as P15.

New

NGF & SNR

Chip breaker

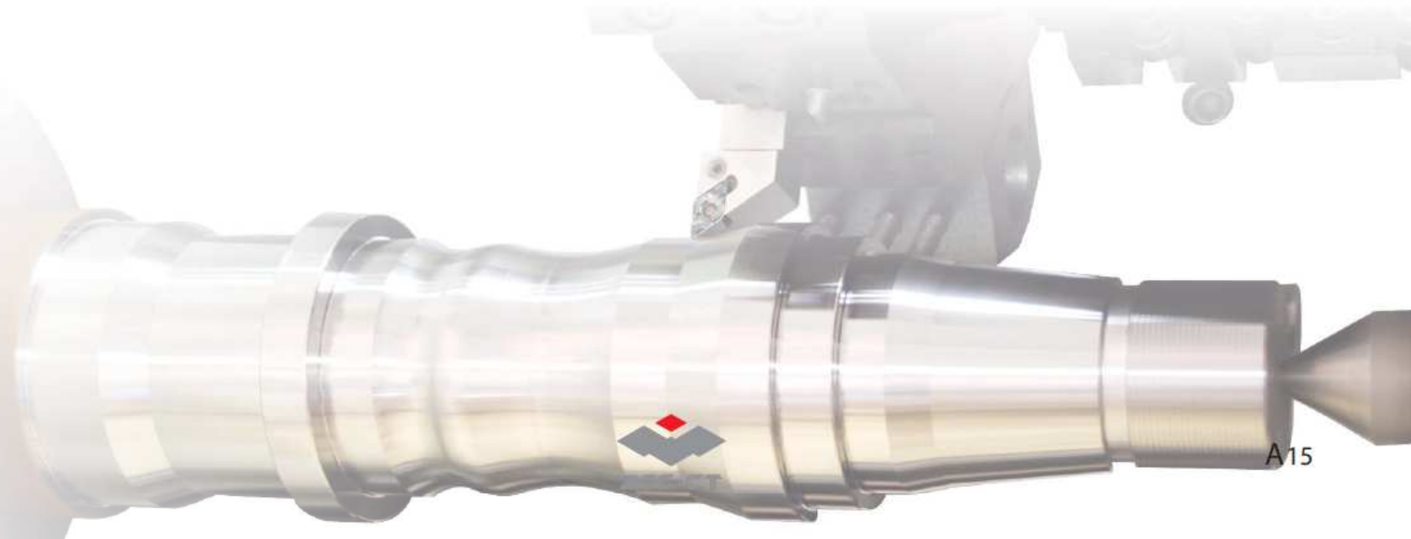
Special chip breaker series for machining of heat-resistant alloys.

-NGF

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

-SNR

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



Negative inserts

Finishing

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.

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.

Negative inserts

Finishing

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

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.

Negative inserts

Medium machining

TC **K** **P**

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

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.

Negative inserts

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.

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.

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** **M**

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 **S** **M**

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

HF P K

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

AHF P M

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.

NGF M S

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

Positive inserts

Medium machining

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.

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.

Positive inserts

Roughing

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.

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.

Positive inserts

PCBN & PCD inserts

Flat **N** **H**

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

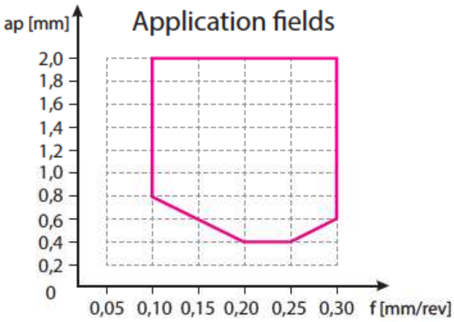
Notes

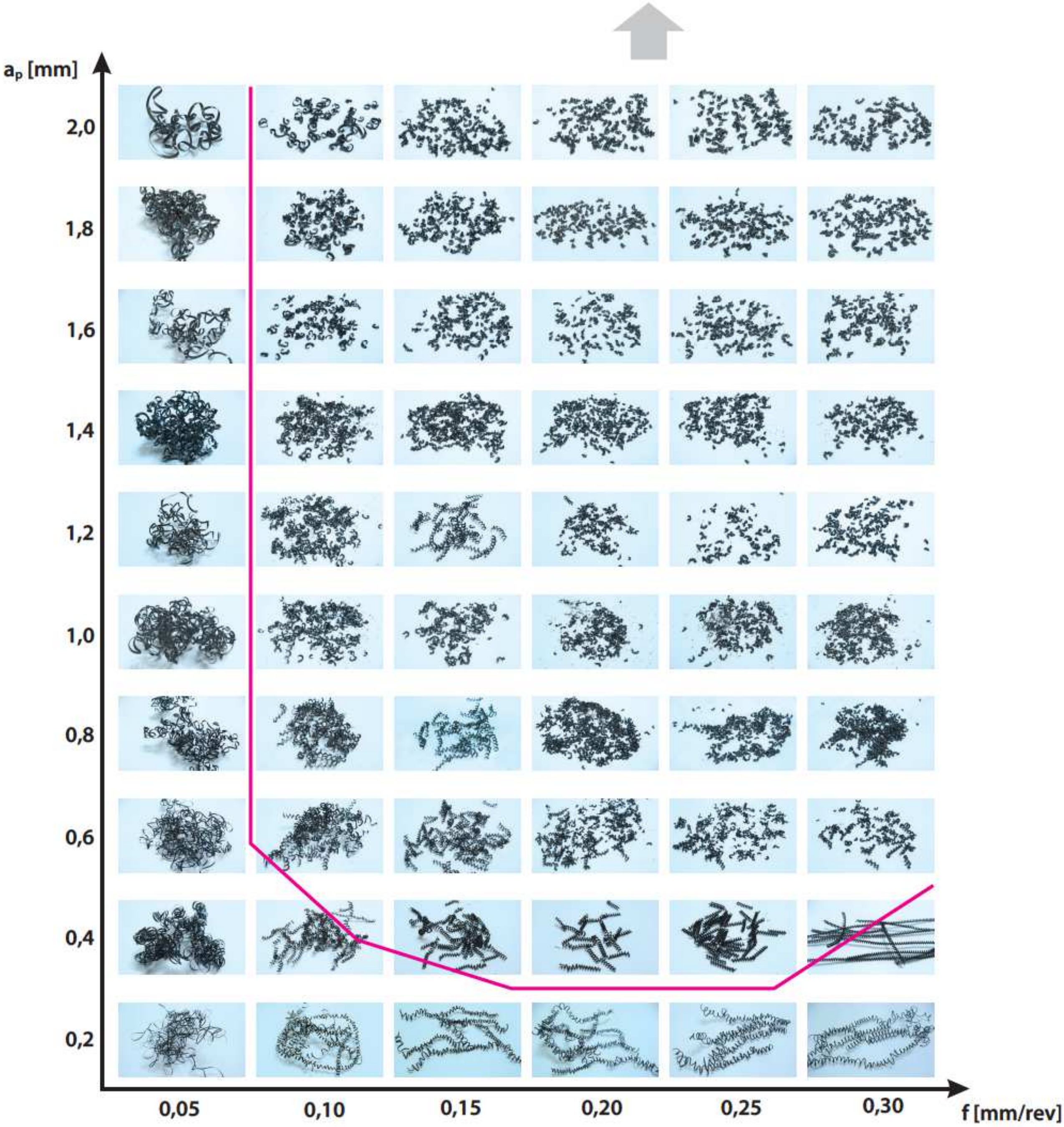
General turning

Application fields of chip breakers determination

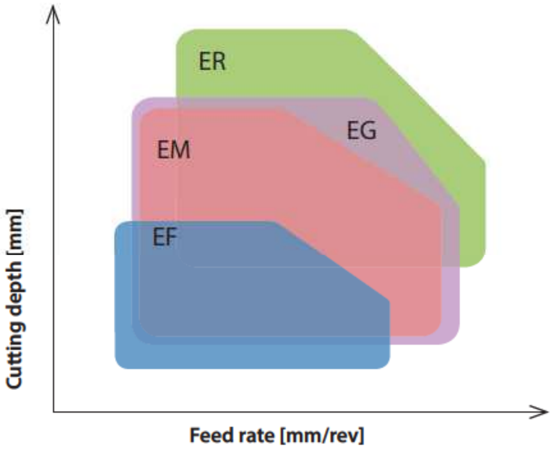
Example

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

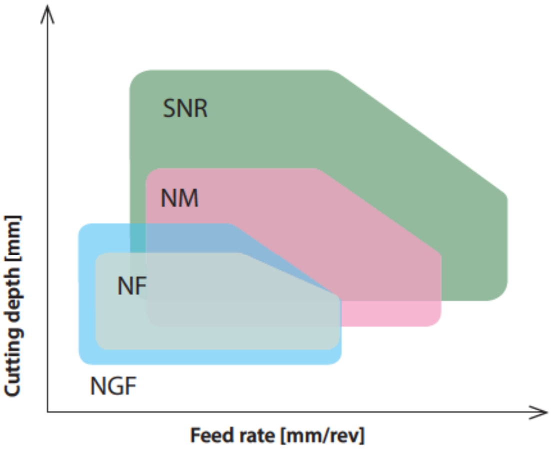




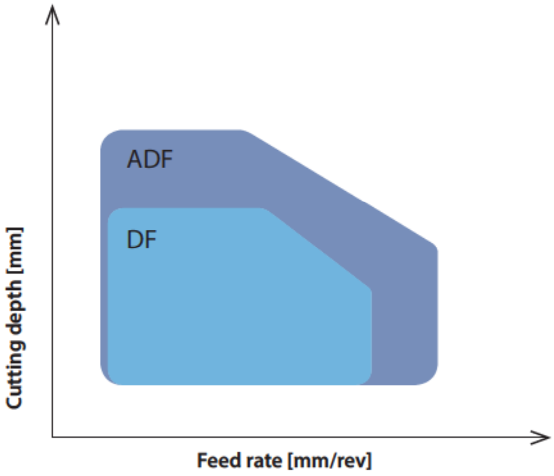
Negative inserts



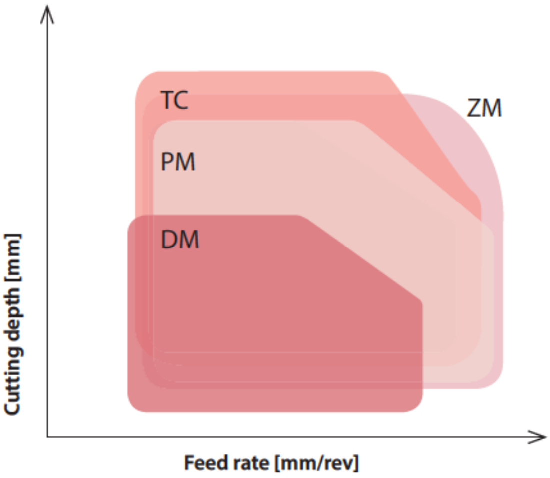
Finishing to medium machining



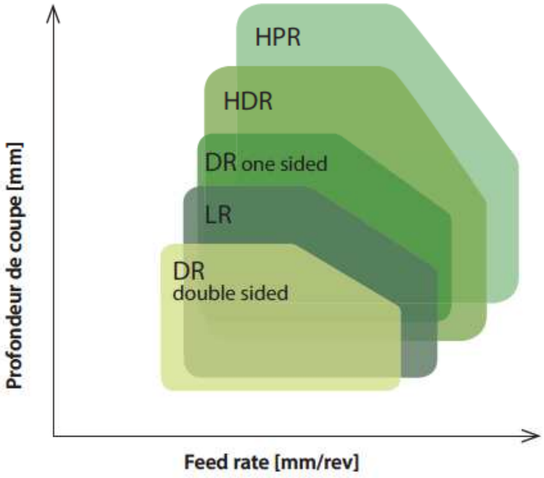
Finishing to roughing



Finishing to roughing

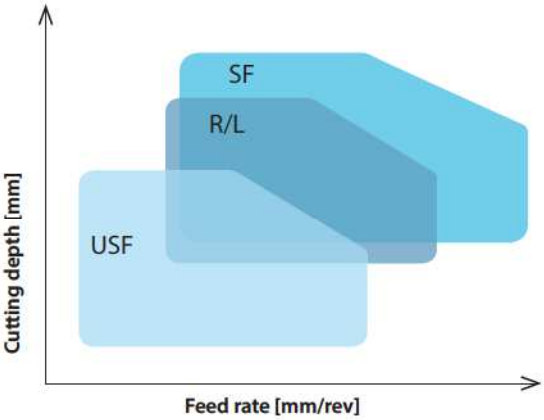


Medium machining

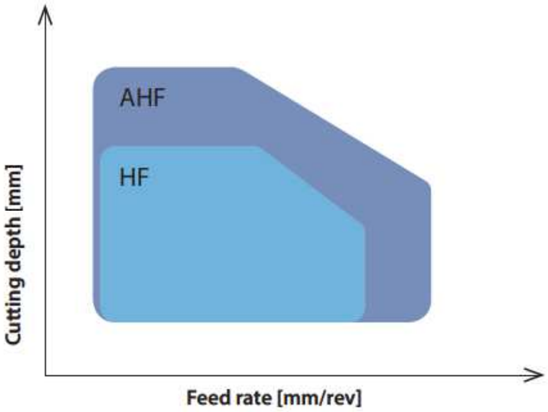


Roughing

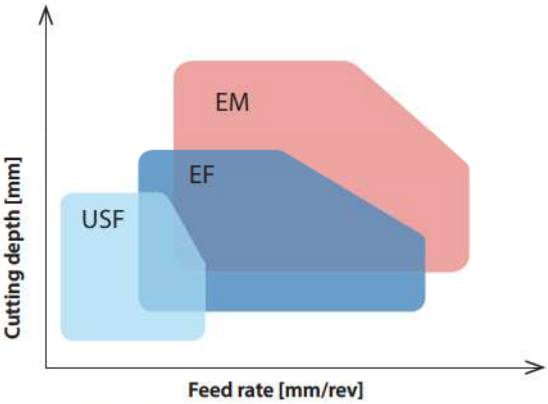
Positive inserts



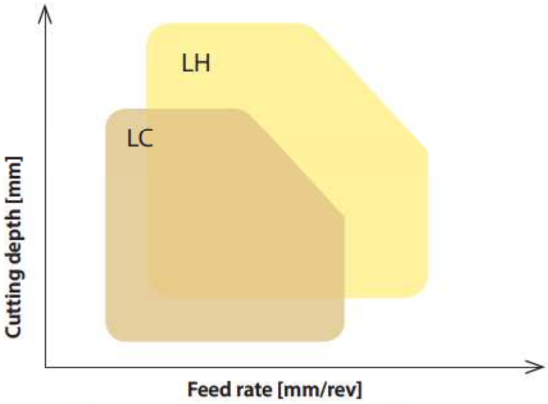
Fine-finishing



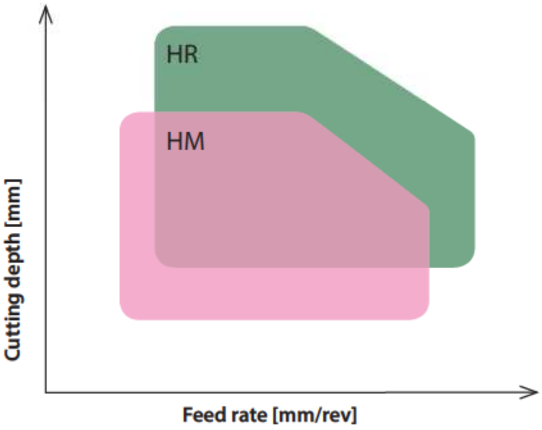
Finishing to medium machining



Finishing to medium machining



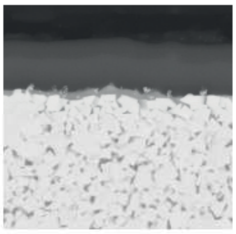
Finishing to medium machining



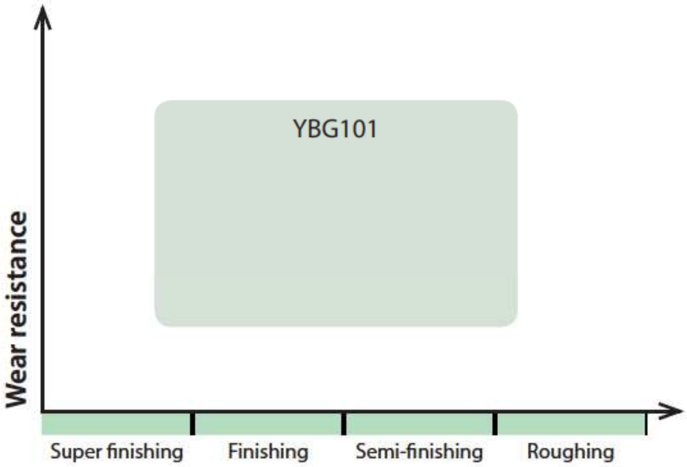
Medium machining to roughing

New YBG101

Turning grades for aluminum

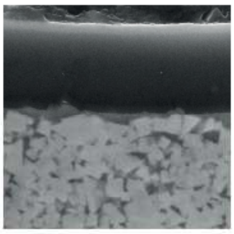


PVD coated N05–N20 carbide substrate for finishing to medium application in aluminum material. Coating only on the top face, in combination with the aluminum chip breaker, prevents build up edges and gives a smooth cut.

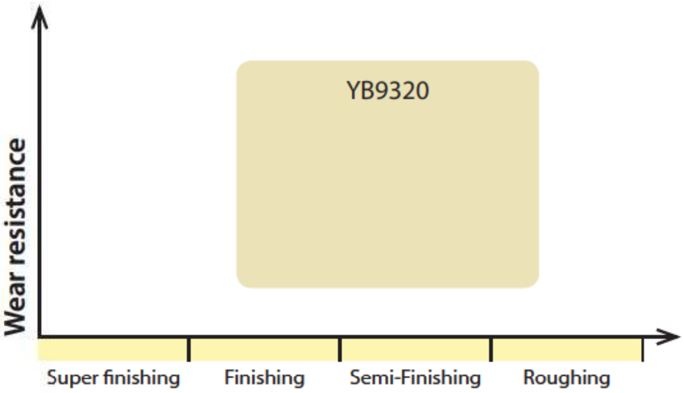


New YB9320

PVD coated cemented carbide

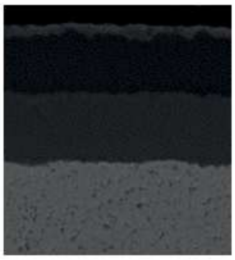


PVD multilayer coated M10–M25/P10–P30 carbide substrate for finishing to medium application of stainless steel, super alloy and steel (grooving/ milling). Optimized coating stability for higher wear resistance and thermal stability in a wide application field.

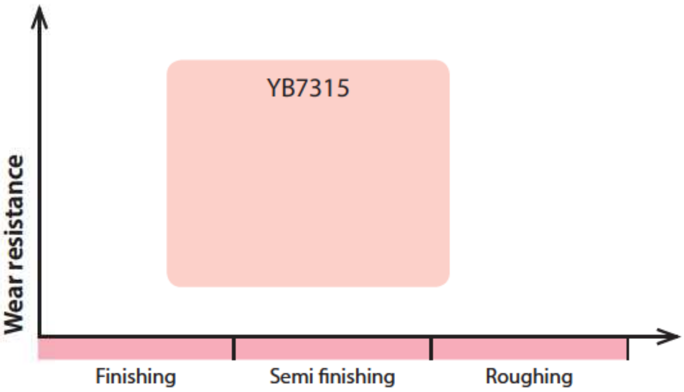


New YB7315

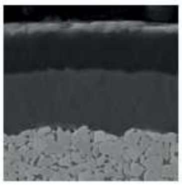
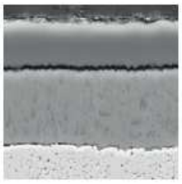
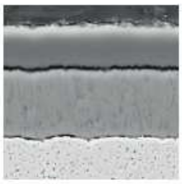
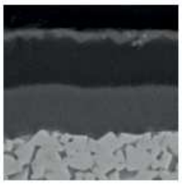
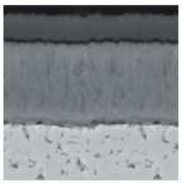
For high efficient machining of cast irons



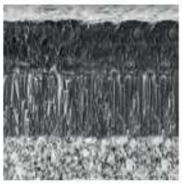
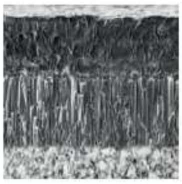
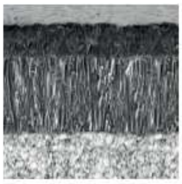
CVD coated K10–K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Improved wear resistance and toughness at high cutting speed.



Coated cemented carbide CVD

Grade	ISO	Micro structure	Grade description
YB6315	P10 – 20		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 – 20		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.
YBC251	P20 - P35		CVD coated P20–P35 carbide grade for medium operation to roughing of steel and casting steel in lower cutting speed.
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.
YBC351	P20 - P40		CVD coated P20–P40 carbide grade for roughing operation of steel and casting steel in lower cutting speed.
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
YBD052	K05 - K15		CVD coated K05–K15 carbide grade for cast iron material, special grey cast iron. Excellent wear resistance in higher cutting speed and dry machining.
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
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.

A Turning
B Milling
C Drilling
D Technical Information
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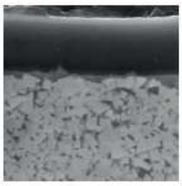
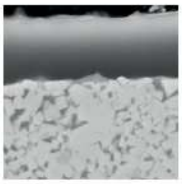
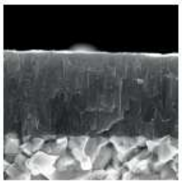
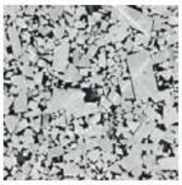
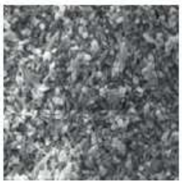
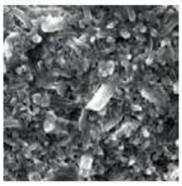
Coated cemented carbide PVD

Grade	ISO	Micro structure	Grade description
YBG202	P10 - P30 M10 - M25		PVD coated M10–M25/P10–P30 carbide substrate for finishing to medium application of stainless steel and steel (milling). Good wear resistance in a wide application field.
YBG205	P10 - P30 M20 - M40 S15-S25		PVD multilayer coated M20–M40/S15–S25/P10–P30 carbide substrate for finishing to medium application of stainless steel, super alloy and steel (milling). Good wear resistance and thermal stability in a wide application field.
YB9320	P10 - P30 M10 - M25		PVD multilayer coated M10–M25/P10–P30 carbide substrate for finishing to medium application of stainless steel, super alloy and steel (grooving/milling). Optimized coating stability for higher wear resistance and thermal stability in a wide application fi
YBG302	P15 - P30 M25 - M40		PVD coated M25–M40/P15–P30 carbide substrate for medium roughing application of stainless steel and steel (milling). Good wear resistance and toughness.
YBG101	N05 - N20		PVD coated N05–N20 carbide substrate for finishing to medium application in aluminum material. Coating only on the top face, in combination with the aluminum chip breaker, prevents build up edges and gives a smooth cut.

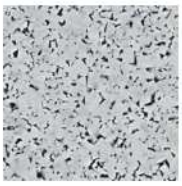
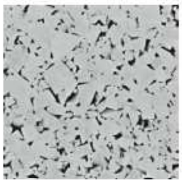
Ceramic

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.
CN1000	K05 - K15		Uncoated K05-K15 Si3N4 ceramic grade for finishing to medium operation in grey cast iron. Good wear resistance and thermal stability.

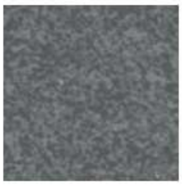
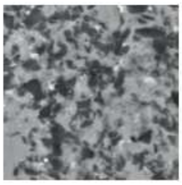
Ceramic

Grade	ISO	Micro structure	Grade description
CN2000	K10 - K30		Uncoated K10–K30 Si3N4 Ceramic grade for medium operation in grey cast iron also with interrupted cut. Good wear resistance, toughness and thermal stability.

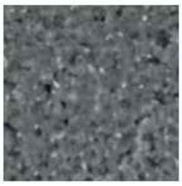
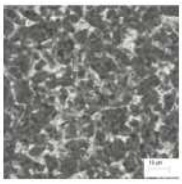
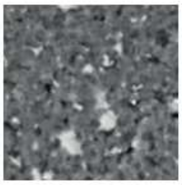
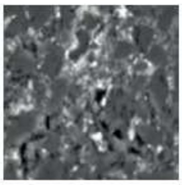
Uncoated cemented carbide

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
YCB111	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.

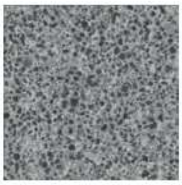
CBN

Grade	ISO	Micro structure	Grade description
YCB211	K10 - K25		Uncoated, brazed K10–K25 CBN grade for fine to medium machining of cast iron. Good wear resistance and thermal conductivity.
YZB121	H10 - H25		Uncoated H10–H25 solid CBN grade for medium application in hardened steel, HSS or bearing steel also in light interrupted cut. Good wear resistance and toughness.
YZB221	K10 - K25		Uncoated K10–K25 solid CBN grade for medium application in grey cast iron, nodular cast iron and Ni/Cr basic alloy., also in light interrupted cut. Good wear resistance and thermal conductivity.
YZB231	K20 - K30		Uncoated K20–K30 solid CBN grade for medium to roughing application in grey cast iron and nodular cast iron in interrupted cut. Good wear resistance, toughness and thermal conductivity.

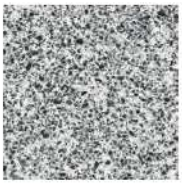
PCD

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.

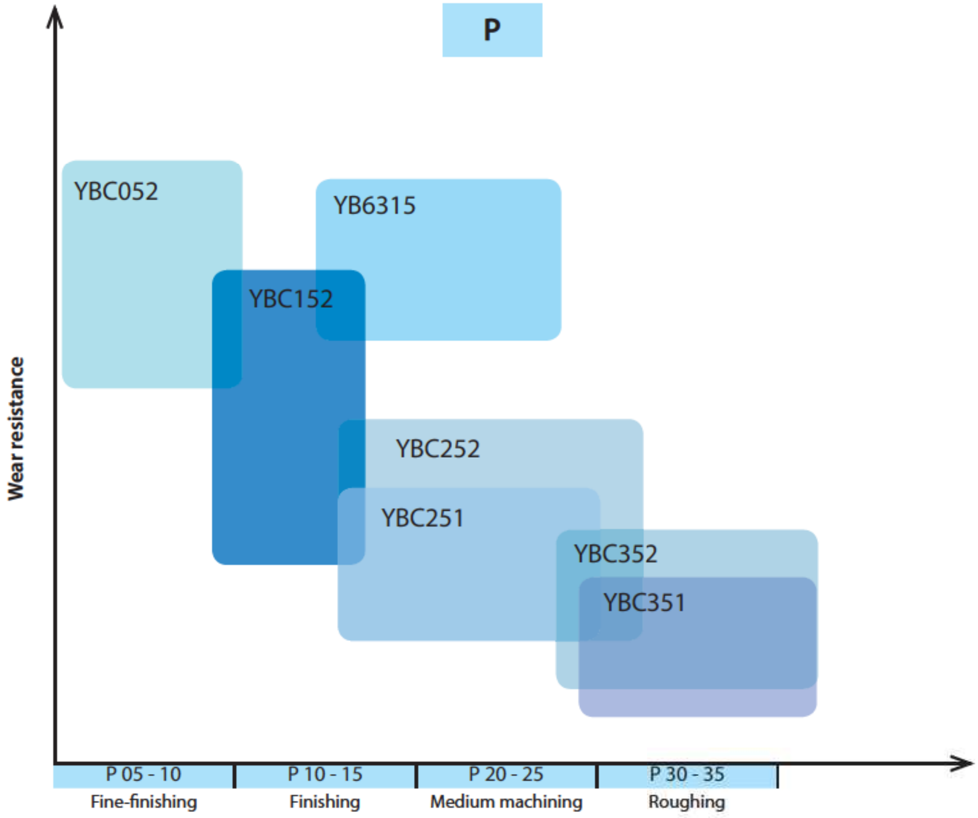
Cermet

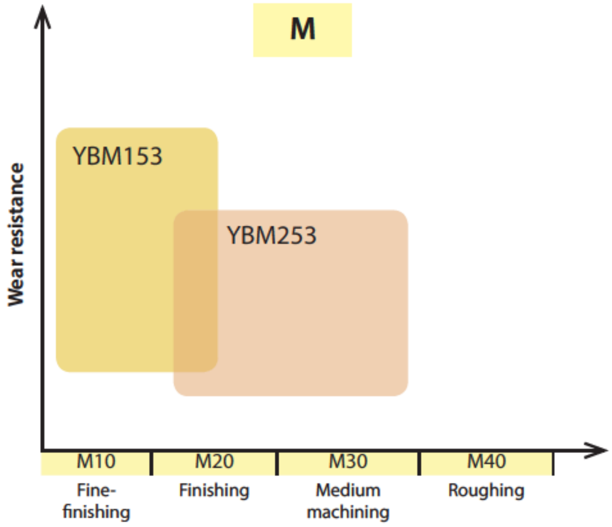
Grade	ISO	Micro structure	Grade description
YNG151	P05 – P15		Uncoated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good resistance against plastic deformation for good surface finishing.

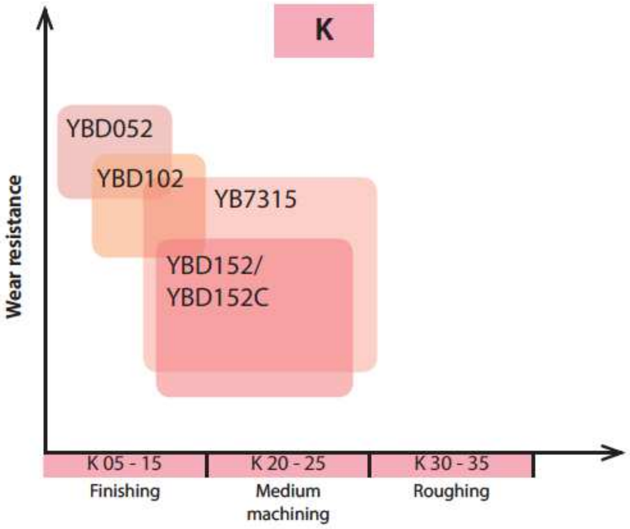
Cermet

Grade	ISO	Micro structure	Grade description
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.

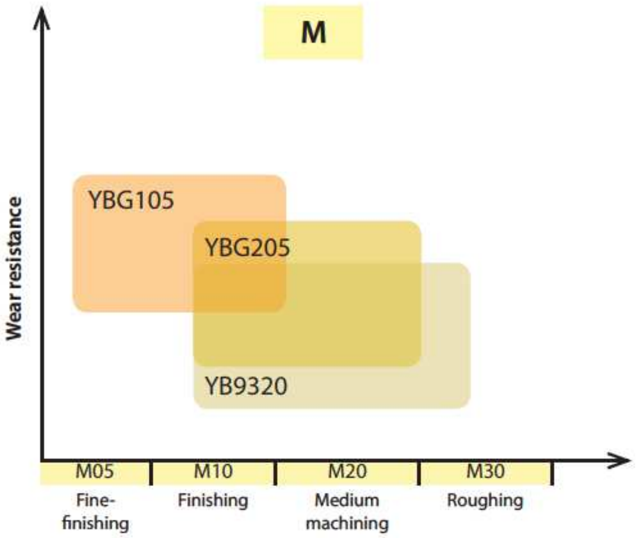
CVD grades for steel, stainless steel and cast iron

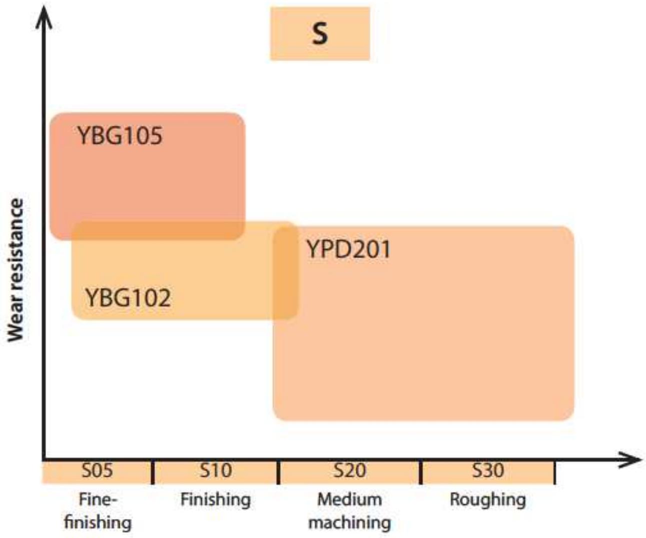




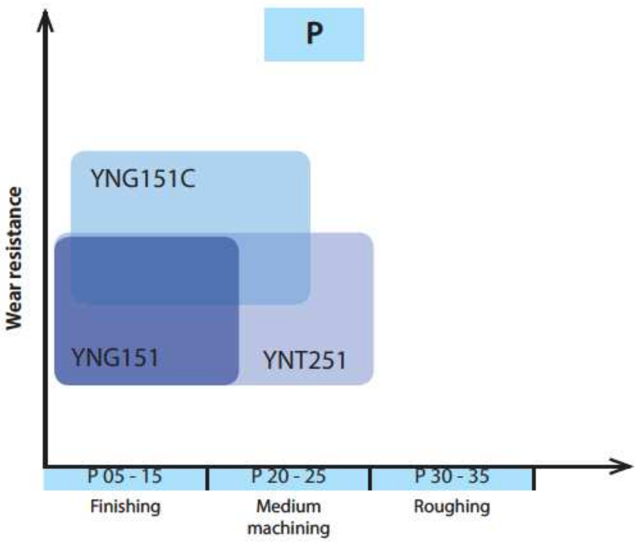


PVD grade for stainless steel and heat-resistant alloys

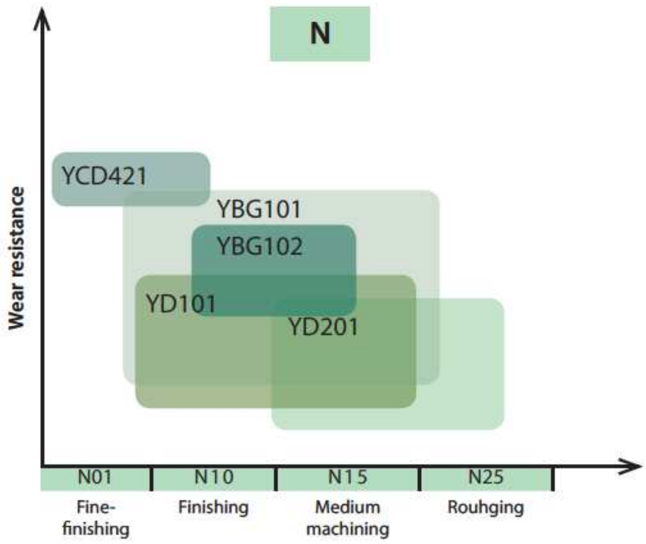




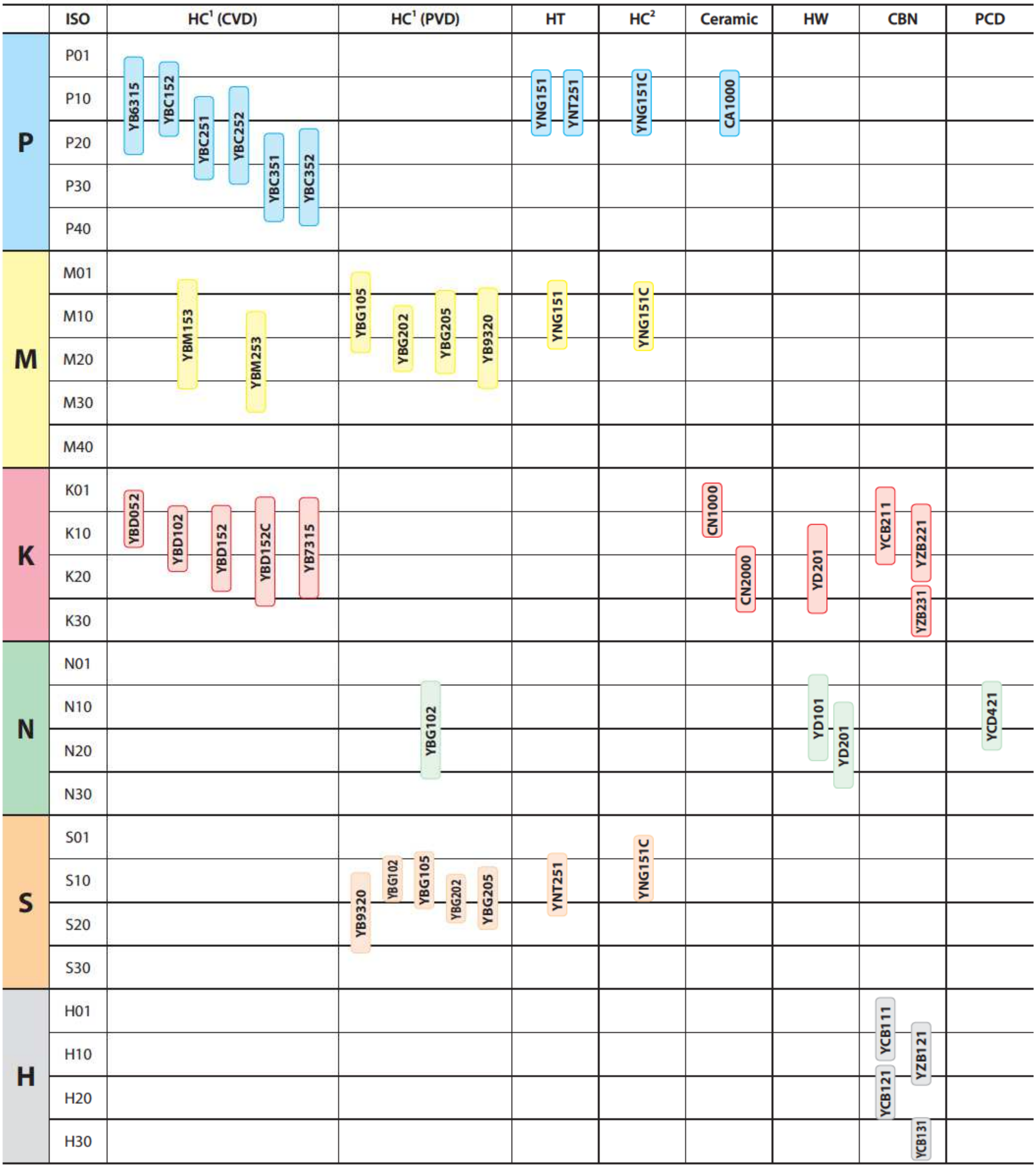
Cermet grades for steel



Turning grades for non-ferrous metals



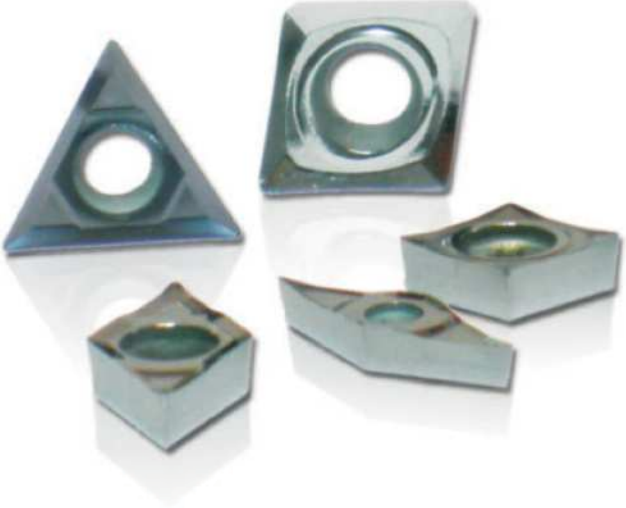
Application fields of grades – general turning



	ISO	HC^{1} (CVD)	HC^{1} (PVD)	HT	HC^{2}	Ceramic	HW	CBN	PCD
P	P01 P10 P20 P30 P40	YB6315 YBC152 YBC251 YBC252 YBC351 YBC352		YNG151 YNT251	YNG151C	CA1000			
M	M01 M10 M20 M30 M40	YBM153 YBM253	YBG105 YBG202 YBG205 YB9320	YNG151	YNG151C				
K	K01 K10 K20 K30	YBD052 YBD102 YBD152 YBD152C YB7315				CN1000 CN2000	YD201	YCB211 YZB221 YZB231	
N	N01 N10 N20 N30		YBG102				YD101 YD201		YCD421
S	S01 S10 S20 S30		YB9320 YBG102 YBG105 YBG202 YBG205	YNT251	YNG151C				
H	H01 H10 H20 H30							YCB111 YCB121 YZB121 YCB131	

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

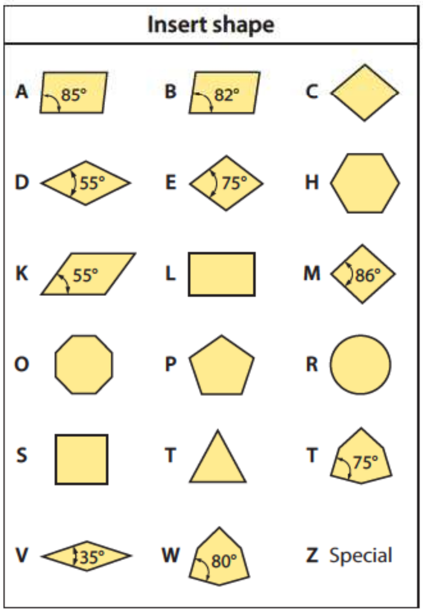
HC^{1} Coated carbide
HT Uncoated cermet
HC^{2} Coated cermet
HW Uncoated carbide



ISO standard

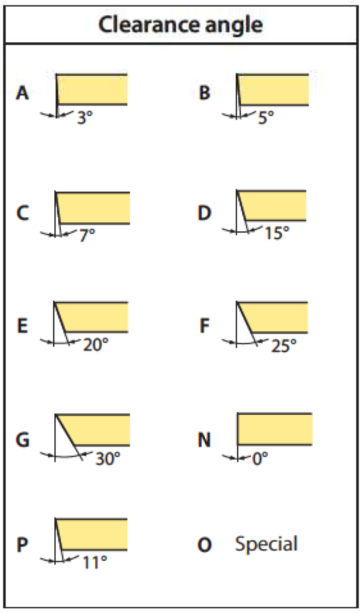
T	N	M	G	22	04	08	(N)	–	DM
1	2	3	4	5	6	7	8		9

Insert shape



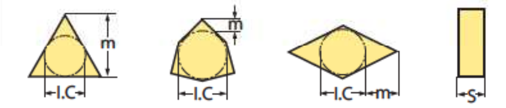
1

Clearance angle



2

Tolerance class

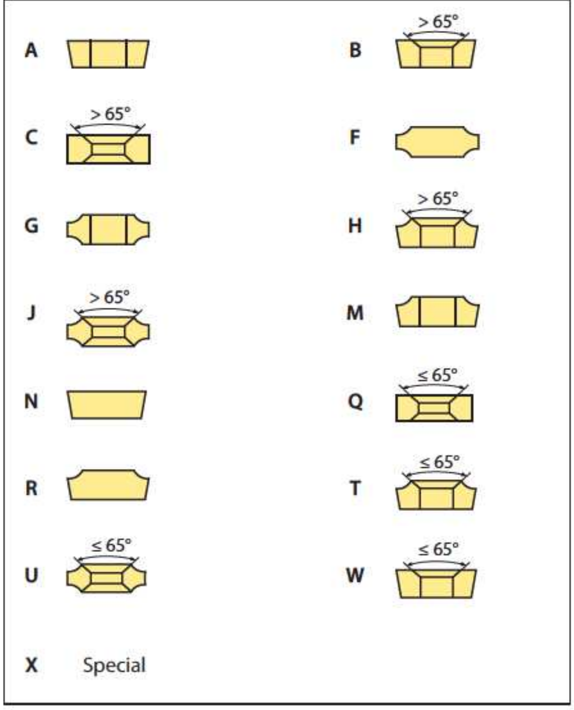


Code	I.C [mm]	m [mm]	S [mm]
A	±0,025	±0,005	±0,025
C	±0,025	±0,013	±0,025
E	±0,025	±0,025	±0,025
F	±0,013	±0,005	±0,025
G	±0,025	±0,025	±0,130
H	±0,013	±0,013	±0,025
J	±0,05–0,15	±0,005	±0,025
K	±0,05–0,15	±0,013	±0,025
L	±0,05–0,15	±0,025	±0,025
M	±0,05–0,15	±0,08–0,20	±0,130
N	±0,05–0,15	±0,08–0,20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

3

Fastening features (metric)

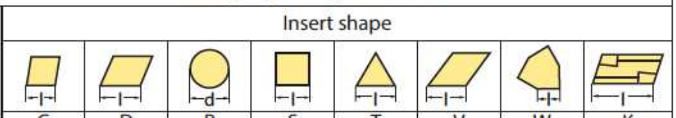
Insert shape



4

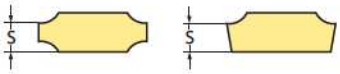
Cutting edge length l [mm]

Insert shape



I.C [mm]	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

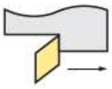
Insert thickness S [mm]			
			
Code	S	Code	S
00	0,79	**T5**	5,95
T0	0,99	**06**	6,35
01	1,59	**T6**	6,75
T1	1,98	**07**	7,94
02	2,38	**09**	9,52
T2	2,58	**T9**	9,72
03	3,18	**11**	11,11
T3	3,97	**12**	12,70
04	4,76		
T4	4,96		
05	5,56		

6

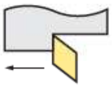
Nose radius r [mm]	
	
Code	r
00	–
02	0,2
04	0,4
08	0,8
12	1,2
16	1,6
20	2,0
24	2,4
32	3,2
X	Special
MO	Round inserts

7

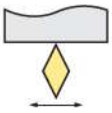
Cutting direction



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

	ISO	Inch
Insert shape C 	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 	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 	160404	331
	160408	332
	160412	333
Insert shape R 	0903MO	32
	1204MO	43

	ISO	Inch
Insert shape W 	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 	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 	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

	ISO	Inch
Insert shape C 	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 	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

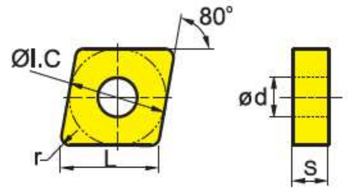
	ISO	Inch
Insert shape D 	070202	2(1.5)0
	070204	2(1.5)1
	070208	2(1.5)2
	11T302	3(2.5)0
	11T304	3(2.5)1
	11T308	3(2.5)2
	11T312	3(2.5)3
Insert shape S 	060204	2(1.5)1
	09T302	3(2.5)0
	09T304	3(2.5)1
	09T308	3(2.5) 2
	120404	431
	120408	432
	120412	433
	150404	531
	150408	532
	150412	533
	190408	632
	190412	633
	190416	634
Inserts shape V 	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



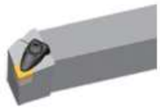
	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✹	✹											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
WG  Wiper	**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		●																						
ADF  Finishing	**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	○																●				●			
DF  Finishing	**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		●	●	○																				
	CNMG120412-DF	1.2	0.35-1.50	0.10-0.35		●	●																					
EF  Finishing	**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				○			●								○			●	○					
	CNMG120412-EF	1.2	0.5-2.5	0.10-0.35							○											○	○					
SF  Finishing	**CNMG090304-SF**	0.4	0.05-0.50	0.05-0.30																						●		
	CNMG090308-SF	0.8	0.05-0.50	0.10-0.35																						●		
	CNMG120404-SF	0.4	0.1-1.5	0.05-0.30																						●		
	CNMG120408-SF	0.8	0.1-1.5	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

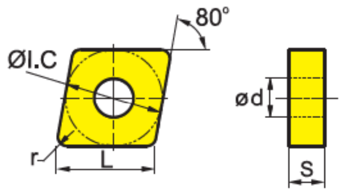
DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	S***-PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A197	A204	A205	A218	A219	A284

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

Turning inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❃ Unfavourable machining conditions

CN**	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					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
				**P**	◯	◯	✿	✿	❃	❃											✿	✿	✿	◯	✿	◯		
				M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯		
				K									◯	◯	✿	✿	✿											
				N														◯	◯								◯	✿
				S															◯	◯	✿	✿	✿				◯	✿
				H																								
ISO		r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
NF  Finishing	**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															○	○							○	
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			○	●						○		○												

● 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°
					
A197	A204	A205	A218	A219	A284

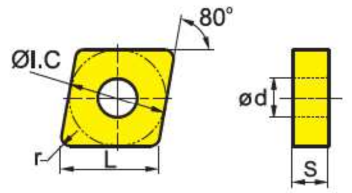
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✽	✽											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
DM  Medium Cut	**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  Medium Cut	**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  Medium Cut	**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							●	●										●	○					

● 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°
					
A197	A204	A205	A218	A219	A284

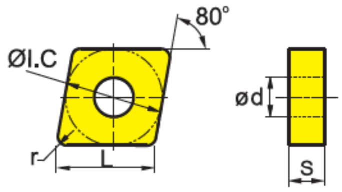
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

Turning inserts

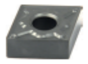
◯ Ideal machining conditions
❂ Normal machining conditions
✺ Unfavourable machining conditions

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
ZM  Medium Cut	**CNMG120404-ZM**	0.4	0.5-3.0	0.05-0.30	●																							
	CNMG120408-ZM	0.8	0.5-4.0	0.1-0.5	○																							

● 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°
					
A197	A204	A205	A218	A219	A284

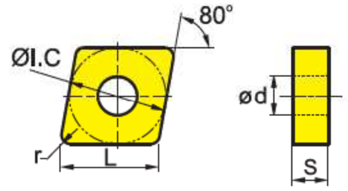
System code A42 Grade selection A40 Technical info A447 Cutting data A324

Turning inserts

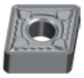
◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✿	✿	❋	❋											✿	✿	✿	◯	✿	◯		
M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯		
K									◯	◯	✿	✿	✿											
N														◯	◯								◯	✿
S															◯	◯	✿	✿	✿				◯	✿
H																								

	ISO	r	aa_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
NM  Medium Cut	**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															○	●								
TC  Medium Cut	**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											●		○											
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			○			○																		

● 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°
					
A197	A204	A205	A218	A219	A284

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

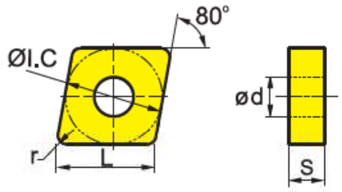
General turning Negative inserts

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

CN** negative insert



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❁	❁	❃	❃											❁	❁	❁	◯	❁	◯		
M							◯	❁							◯	◯	❁	❁	❁	◯	❁	◯		
K									◯	◯	❁	❁	❁											
N														◯	◯								◯	❁
S															◯	◯	❁	❁	❁				◯	❁
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
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

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°
					
A197	A204	A205	A218	A219	A284

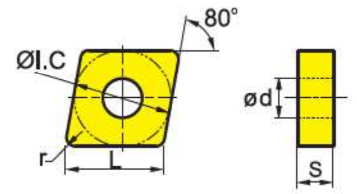
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

◯ Ideal machining conditions
❁ Normal machining conditions
✱ Unfavourable machining conditions

Turning inserts

CN** negative insert



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❁	❁	✱	✱											❁	❁	❁	◯	❁	◯		
M							◯	❁							◯	◯	❁	❁	❁	◯	❁	◯		
K									◯	◯	❁	❁	❁											
N														◯	◯								◯	❁
S															◯	◯	❁	❁	❁				◯	❁
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
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

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°
					
A197	A204	A205	A218	A219	A284

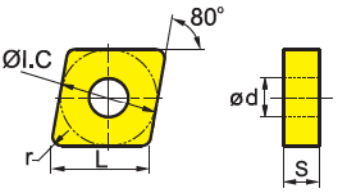
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

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

◯ Ideal machining conditions
✿ Normal machining conditions
✽ Unfavourable machining conditions

Turning inserts



CN** negative insert					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
				P	◯	◯	✿	✿	✽	✽											✿	✿	✿	◯	✿	◯		
				M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯		
				K									◯	◯	✿	✿	✿											
				N														◯	◯								◯	✿
				S															◯	◯	✿	✿	✿				◯	✿
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
LR  Roughing	**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		●	●																					
	CNMM160624-LR	2.4	2.0-8.5	0.25-0.70		○	○																					
	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°
					
A197	A204	A205	A218	A219	A284

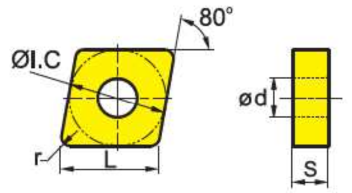
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

◯ Ideal machining conditions
✽ Normal machining conditions
❋ Unfavourable machining conditions

Turning inserts

CN** negative insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✽	✽	❋	❋											✽	✽	✽	◯	✽	◯		
M							◯	✽							◯	◯	✽	✽	✽	◯	✽	◯		
K									◯	◯	✽	✽	✽											
N														◯	◯								◯	✽
S															◯	◯	✽	✽	✽				◯	✽
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic  Medium Cut	**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				○																				
HDR  Roughing	**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  Roughing	**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			●		●																			

● 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°
					
A197	A204	A205	A218	A219	A284

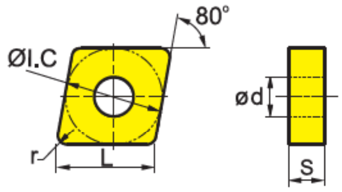
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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

Turning inserts

◯ Ideal machining conditions
⊕ Normal machining conditions
✱ Unfavourable machining conditions

CN** negative insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊕	⊕	✱	✱											⊕	⊕	⊕	◯	⊕	◯		
M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
K									◯	◯	⊕	⊕	⊕											
N														◯	◯								◯	⊕
S															◯	◯	⊕	⊕	⊕				◯	⊕
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
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°
					
A197	A204	A205	A218	A219	A284

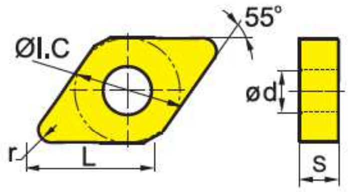
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	❋	❋											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

ISO		r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
WG  Wiper	**DNMX110404-WG**	0.4	0.2-1.5	0.08-0.30		○																						
	DNMX110408-WG	0.8	0.5-3.5	0.15-0.50		●	●																					
	DNMX150608-WG	0.8	0.5-5.0	0.15-0.70		○	○																					
	DNMX150612-WG	1.2	0.8-6.0	0.20-0.75		○																						
ADF  Finishing	**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	○																●							
DF  Finishing	**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			○																					
	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  Finishing	**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																						●		
	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	S***-PDUNR/L
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A198	A206	A207	A220	A221	A286	A287

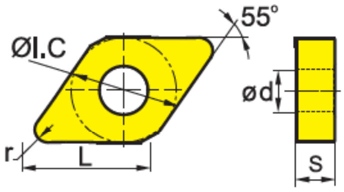
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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



	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
					HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
				P	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
				M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
				K									◯	◯	⊛	⊛	⊛											
				N														◯	◯								◯	⊛
				S															◯	◯	⊛	⊛	⊛				◯	⊛
				H																								
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

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	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°
						
A198	A206	A207	A220	A221	A286	A287

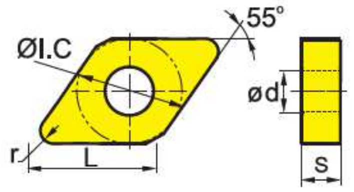
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	⊛	⊛	✲	✲											⊛	⊛	⊛	○	⊛	○		
M							○	⊛							○	○	⊛	⊛	⊛	○	⊛	○		
K									○	○	⊛	⊛	⊛											
N														○	○								○	⊛
S															○	○	⊛	⊛	⊛				○	⊛
H																								

ISO		r	a$_p$	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
ZM  Medium Cut	**DNMG150612-ZM**	1.2	1.0-5.5	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

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°
						
A198	A206	A207	A220	A221	A286	A287

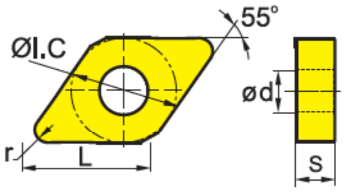
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

General turning
Negative inserts

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	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
EF  Finishing	**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				○			●											●						
	DNMG150612-EF	1.2	0.1-1.5	0.15-0.50																		●						
FM  Finishing	**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		○	●															●						
	DNMG150608R-FM	0.8	0.5-3.0	0.1-0.5		●	●															●						
NF  Finishing	**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															○	○							○	
	DNEG150608-NF	0.8	0.2-3.0	0.1-0.4															●	○							○	
NGF  Finishing	**DNEG150608-NGF**	0.8	0.2-3.0	0.05-0.40																○								
	DNEG150612-NGF	1.2	0.2-3.0	0.1-0.5																●								

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

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

Tool holder

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°
						
A198	A206	A207	A220	A221	A286	A287

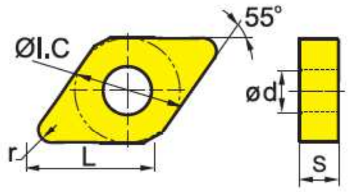
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
EG  Medium Cut	**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							●	●									●	●						
EM  Medium Cut	**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							○																	
	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  Medium Cut	**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															○	●								
TC  Medium Cut	**DNMG150608-TC**	0.8	0.5-5.0	0.15-0.40											●		●											
	DNMG150612-TC	1.2	0.5-5.0	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

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°
						
A198	A206	A207	A220	A221	A286	A287

System code A42 Grade selection A40 Technical info A447 Cutting data A324

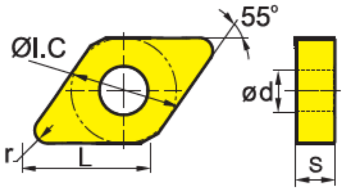
A Turning
B Milling
C Drilling
D Technical Information
E Index

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊕	⊕	✲	✲											⊕	⊕	⊕	◯	⊕	◯		
M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
K									◯	◯	⊕	⊕	⊕											
N														◯	◯								◯	⊕
S															◯	◯	⊕	⊕	⊕				◯	⊕
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
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°
						
A198	A206	A207	A220	A221	A286	A287

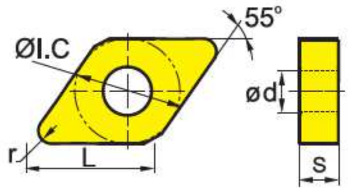
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✽	✽											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Flat  Medium Cut	**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										●		●	○											
	DNMA150616	1.6	0.2-6.0	0.2-0.8									●	○		○												
ER  Roughing	**DNMG150608-ER**	0.8	2-6	0.15-0.55								●																
	DNMG150612-ER	1.2	2-6	0.25-0.80								●																

● 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°
						
A198	A206	A207	A220	A221	A286	A287

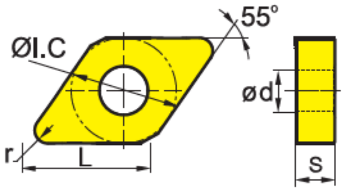
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

Turning inserts

◯ 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

DN** negative insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✱	✱											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
DR  Roughing	**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		●	●																					
ER  Roughing	**DNMM150608-ER**	0.8	0.7-6.0	0.20-0.55							●																	
	DNMM150612-ER	1.2	1-6	0.25-0.70								●																
HDR  Roughing	**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		○		○		○																		
LR  Roughing	**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		●	●					○																

● 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°
						
A198	A206	A207	A220	A221	A286	A287

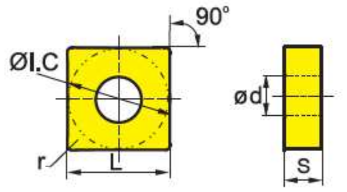
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²		HW				
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C		YD101	YD201			
P	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯						
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯						
K									◯	◯	⊛	⊛	⊛															
N														◯	◯									◯	⊛			
S															◯	◯	⊛	⊛	⊛					◯	⊛			
H																												

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C		YD101	YD201
ADF  Finishing	**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	●																●								
DF  Finishing	**SNMG120408-DF**	0.8	0.3-1.5	0.1-0.4		●	●	○																					
	SNMG120412-DF	1.2	0.35-1.50	0.15-0.50		●	●	○																					
SF  Finishing	**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																						○			

● 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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A224	A225	A289

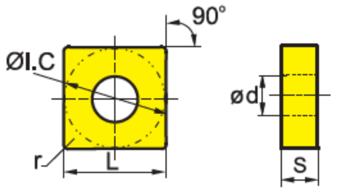
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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



SN** negative insert					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
P					◯	◯	⊛	⊛	❁	❁											⊛	⊛	⊛	◯	⊛	◯		
M											◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K													◯	◯	⊛	⊛	⊛											
N																		◯	◯								◯	⊛
S																			◯	◯	⊛	⊛	⊛				◯	⊛
H																												
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
EF  Finishing	**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							●											●	○					
	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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 75°	Kr: 75°
		
A224	A225	A289

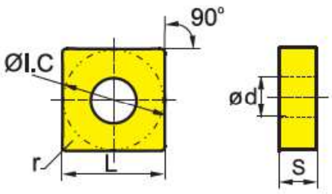
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✽	✽											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	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		○	●	●		●			○	●		●												
	SNMG190616-PM	1.6	1.0-7.5	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

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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 75°	Kr: 75°
		
A224	A225	A289

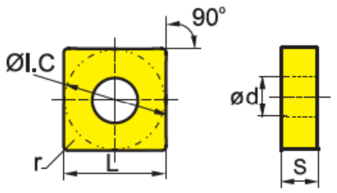
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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



SN** negative insert					HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
P					◯	◯	⊛	⊛	✽	✽											⊛	⊛	⊛	◯	⊛	◯		
M											◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K													◯	◯	⊛	⊛	⊛											
N																		◯	◯								◯	⊛
S																			◯	◯	⊛	⊛	⊛				◯	⊛
H																												
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	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

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A224	A225	A289

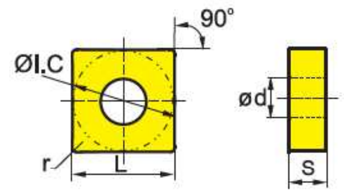
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✲	✲	❋	❋											✲	✲	✲	◯	✲	◯		
M							◯	✲							◯	◯	✲	✲	✲	◯	✲	◯		
K									◯	◯	✲	✲	✲											
N														◯	◯								◯	✲
S															◯	◯	✲	✲	✲				◯	✲
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
EM  Medium Cut	**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								○																
	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  Medium Cut	**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											●		●											
	SNMG150616-TC	1.6	1-7	0.2-0.7											●													

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

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

Tool holder

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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 75°	Kr: 75°
		
A224	A225	A289

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

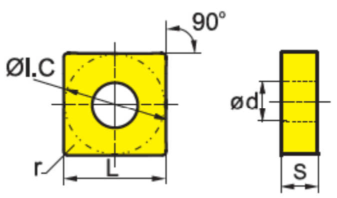
A Turning
B Milling
C Drilling
D Technical Information
E Index

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❁	❁	✺	✺											❁	❁	❁	◯	❁	◯		
M							◯	❁							◯	◯	❁	❁	❁	◯	❁	◯		
K									◯	◯	❁	❁	❁											
N														◯	◯								◯	❁
S															◯	◯	❁	❁	❁				◯	❁
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
NM  Medium Cut	**SNMG120408-NM**	0.8	0.5-5.0	0.1-0.4															●	●							○	
	SNMG120412-NM	1.2	0.5-5.0	0.15-0.50																○								
DR  Roughing	**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		●	●	●	●	●						●												
	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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A224	A225	A289

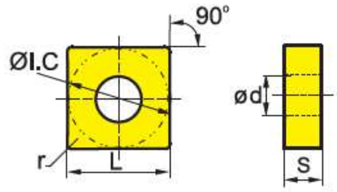
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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

SN** negative insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✲	✲											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
ER  Roughing	**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							○	●																

● 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°
						
A199	A208	A210	A211	A212	A222	A223

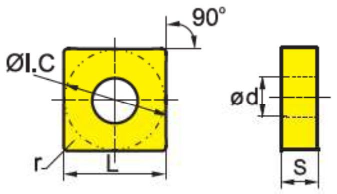
MSKNR/L	**MSDNN**	**S***-PSKNR/L**
Kr: 75°	Kr: 45°	Kr: 75°
		
A224	A225	A289

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

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	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
DR  Roughing	**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			●		●	●																		

● 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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN
Kr: 75°	Kr: 45°
	
A224	A225

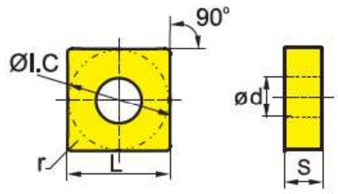
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

◯ Ideal machining conditions
✿ Normal machining conditions
❁ Unfavourable machining conditions

Turning inserts

SN** negative insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✿	✿	❁	❁											✿	✿	✿	◯	✿	◯		
M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯		
K									◯	◯	✿	✿	✿											
N														◯	◯								◯	✿
S															◯	◯	✿	✿	✿				◯	✿
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A224	A225	A289

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

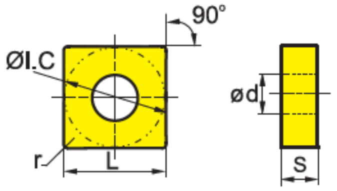
General turning Negative inserts

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



	HC^{1} (CVD)													HC^{1} (PVD)						HT		HC^{2}	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✽	✽											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HDR  Roughing	**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			○	●		○																		
	SNMM150624-HDR	2.4	1.5-9.0	0.4-1.2			○																					
	SNMM190612-HDR	1.2	2.0-10.5	0.25-0.70		○	○	●																				
	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

HC^{1}	Coated carbide
HT	Uncoated cermet
HC^{2}	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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A224	A225	A289

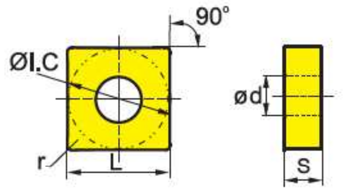
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

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



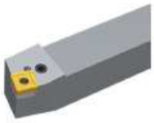
	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HPR  Roughing	**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		○	●		●																			

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

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

Tool holder

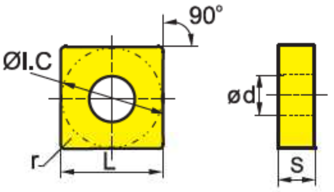
PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L	MSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°	Kr: 75°
						
A208	A210	A211	A212	A222	A223	A224

Turning inserts

◯ Ideal machining conditions
❂ Normal machining conditions
✺ Unfavourable machining conditions

SN**	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



	ISO	r	a_p	f	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
					YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
	P				◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
	M										◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
	K												◯	◯	❂	❂	❂											
	N																	◯	◯								◯	❂
	S																		◯	◯	❂	❂	❂				◯	❂
	H																											
Basic  Medium Cut	**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						●																		
	SNMG250924	2.4	1-9	0.1-1.1						○																		
Basic 	**SNMM120408**	0.8	0.5-5.0	0.1-0.5				●																				
	SNMM120412	1.2	1.5-7.0	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

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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 75°	Kr: 75°
		
A224	A225	A289

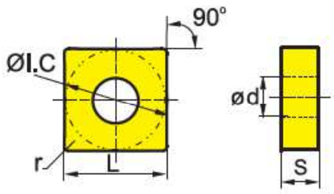
System code › A42 Grade selection › A40 Technical info › A447 Cutting data › A324

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	MSDNN	S***-PSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°
		
A224	A225	A289

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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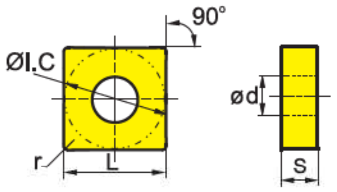
Turning inserts

◯ 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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	◍	◍	✺	✺											◍	◍	◍	◯	◍	◯		
M							◯	◍							◯	◯	◍	◍	◍	◯	◍	◯		
K									◯	◯	◍	◍	◍											
N														◯	◯								◯	◍
S															◯	◯	◍	◍	◍				◯	◍
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic 	**SNMM190608**	0.8	1.0-10.5	0.15-0.50				○																				
	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			●	○		●																		

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

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

Tool holder

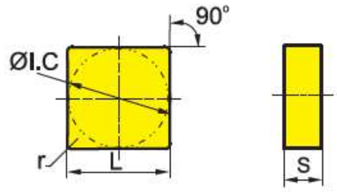
PSBNR/L	PSDNN	PSKNR/L	PSSNR/L	MSBNR/L	MSRNR/L	MSKNR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°	Kr: 75°	Kr: 75°
						
A208	A210	A211	A212	A222	A223	A224

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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
25 07	25.4	25.4	7.94



SN** negative insert					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
ISO		r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
				P	◯	◯	✲	✲	✹	✹											✲	✲	✲	◯	✲	◯		
				M							◯	✲							◯	◯	✲	✲	✲	◯	✲	◯		
				K									◯	◯	✲	✲	✲											
				N														◯	◯								◯	✲
				S															◯	◯	✲	✲	✲				◯	✲
				H																								
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																							○	
	SNUN190416	1.6	0.9-6.0	0.3-0.7																								○
	SNUN250724	2.4	1-9	0.5-1.0						○																		

● 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°
		
A262	A263	A265

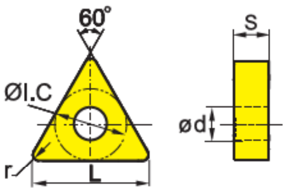
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✱	✱											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
WG  Wiper	**TNMX160408-WG**	0.8	0.5-5.0	0.15-0.70		●																						
	TNMX160412-WG	1.2	0.8-6.0	0.20-0.75		○																						
ADF  Finishing	**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	●																●							
DF  Finishing	**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		●	●	○																				
	TNMG220412-DF	1.2	0.35-1.50	0.15-0.50		●		●																				

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

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

Tool holder

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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

System code A42 Grade selection A40 Technical info A447 Cutting data A324

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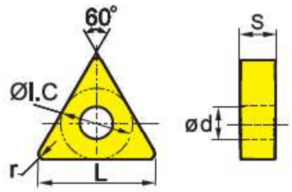
Turning inserts

◯ 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



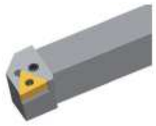
	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
SF  Finishing	**TNMG110304-SF**	0.4	0.05-0.50	0.05-0.30																						○		
	TNMG160404-SF	0.4	0.05-1.00	0.05-0.30																				○		●		
	TNMG160408-SF	0.8	0.05-1.00	0.05-0.40																						●		
	TNMG220408-SF	0.8	0.05-1.50	0.05-0.40																						○		
	TNMG220412-SF	1.2	0.05-1.50	0.10-0.45																						○		

● 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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

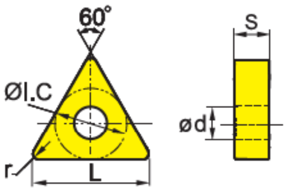
System code A42 Grade selection A40 Technical info A447 Cutting data A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

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

Turning inserts

◯ Ideal machining conditions
⊕ Normal machining conditions
✲ Unfavourable machining conditions



TN** negative insert					HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
				P	◯	◯	⊕	⊕	✲	✲											⊕	⊕	⊕	◯	⊕	◯		
				M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
				K									◯	◯	⊕	⊕	⊕											
				N														◯	◯								◯	⊕
				S															◯	◯	⊕	⊕	⊕				◯	⊕
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
EF  Finishing	**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							○											●	○					
	TNMG220412-EF	1.2	0.5-2.5	0.1-0.5																			○					
FM  Finishing	**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		●	●															●						

● 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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

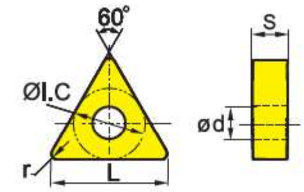
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	❋	❋											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	aa_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

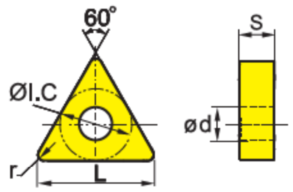
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

TN** negative insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✳	✳	❋	❋											✳	✳	✳	◯	✳	◯		
M							◯	✳							◯	◯	✳	✳	✳	◯	✳	◯		
K									◯	◯	✳	✳	✳											
N														◯	◯								◯	✳
S															◯	◯	✳	✳	✳				◯	✳
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
ZM  Medium Cut	**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	●																							

● 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°
						
A200	A213	A214	A215	A226	A227	A228

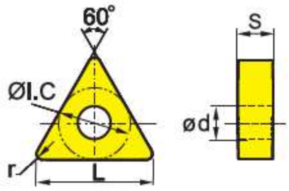
MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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	
				P	◯	◯	❂	❂	✲	✲											❂	❂	❂	◯	❂	◯		
				M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
				K									◯	◯	❂	❂	❂											
				N														◯	◯								◯	❂
				S															◯	◯	❂	❂	❂				◯	❂
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
EG  Medium Cut	**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							●	●									●	●						
EM  Medium Cut	**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							●	●										●	○					
	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  Medium Cut	**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											●		●											
	TNMG220416-TC	1.6	1-6	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

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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

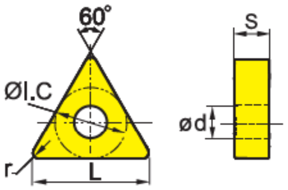
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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	
		YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P		◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
M								◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K										◯	◯	❂	❂	❂											
N															◯	◯								◯	❂
S																◯	◯	❂	❂	❂				◯	❂
H																									

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
DR  Roughing	**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						●																		

● 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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

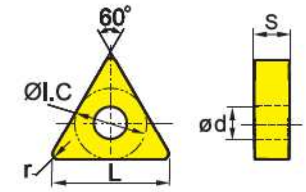
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

Turning inserts

◯ Ideal machining conditions
⊕ Normal machining conditions
❋ Unfavourable machining conditions

TN** negative insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊕	⊕	❋	❋											⊕	⊕	⊕	◯	⊕	◯		
M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
K									◯	◯	⊕	⊕	⊕											
N														◯	◯								◯	⊕
S															◯	◯	⊕	⊕	⊕				◯	⊕
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
DR  Roughing	**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  Roughing	**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  Roughing	**TNMM160408-LR**	0.8	1-5	0.1-0.5		●	●					●																
	TNMM160412-LR	1.2	1.5-6.0	0.1-0.6		●	●					●																

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

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

System code A42 Grade selection A40 Technical info A447 Cutting data A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

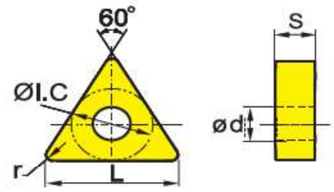
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	❂	❂	✺	✺											❂	❂	❂	○	❂	○		
M							○	❂							○	○	❂	❂	❂	○	❂	○		
K									○	○	❂	❂	❂											
N														○	○								○	❂
S															○	○	❂	❂	❂				○	❂
H																								

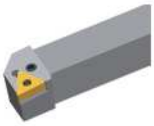
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HDR  Heavy Turning	**TNMM220412-HDR**	1.2	2-9	0.25-0.80		○																						
	TNMM220416-HDR	1.6	2-9	0.35-1.00			○																					
	TNMM270616-HDR	1.6	2-6	0.35-1.00			●																					
	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°
						
A213	A214	A215	A226	A227	A228	A229

System code A42 Grade selection A40 Technical info A447 Cutting data A324

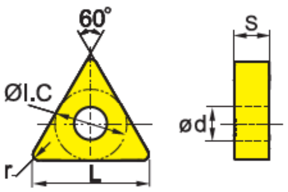
General turning Negative inserts

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✲	✲	❋	❋											✲	✲	✲	◯	✲	◯		
M							◯	✲							◯	◯	✲	✲	✲	◯	✲	◯		
K									◯	◯	✲	✲	✲											
N														◯	◯								◯	✲
S															◯	◯	✲	✲	✲				◯	✲
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic  Medium Cut	**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			○	●																				
	TNMG220412	1.2	0.2-6.0	0.1-0.4			○																					
	TNMG220416	1.6	0.2-6.0	0.1-0.5			○																					
	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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

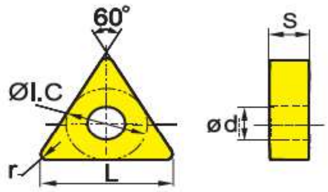
System code › A42
Grade selection › A40
Technical info › A447
Cutting data › A324

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

◯ Ideal machining conditions
❂ Normal machining conditions
❃ Unfavourable machining conditions

Turning inserts

TN** negative insert



					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
				P	◯	◯	❂	❂	❃	❃											❂	❂	❂	◯	❂	◯		
				M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
				K									◯	◯	❂	❂	❂											
				N														◯	◯								◯	❂
				S															◯	◯	❂	❂	❂				◯	❂
				H																								
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			○	○																				
	TNMM160412	1.2	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

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°
						
A200	A213	A214	A215	A226	A227	A228

MTFNR/L	S***-PTFNR/L
Kr: 91°	Kr: 90°
	
A229	A290

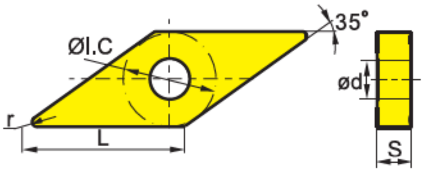
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

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



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❁	❁	✽	✽											❁	❁	❁	◯	❁	◯		
M							◯	❁							◯	◯	❁	❁	❁	◯	❁	◯		
K									◯	◯	❁	❁	❁											
N														◯	◯								◯	❁
S															◯	◯	❁	❁	❁				◯	❁
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
ADF  Finishing	**VNMG160404-ADF**	0.4	0.5-2.5	0.1-0.3	●																●							
	VNMG160408-ADF	0.8	0.5-2.5	0.1-0.5	●																●							
DF  Finishing	**VNMG160404-DF**	0.4	0.25-1.50	0.07-0.30		○	●	●																				
	VNMG160408-DF	0.8	0.3-1.5	0.1-0.4		●	●	●																				
EF  Finishing	**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							○																	
NF  Finishing	**VNEG160404-NF**	0.4	0.2-4.0	0.05-0.30															○	●							○	
	VNEG160408-NF	0.8	0.2-4.0	0.05-0.50															○	●							○	

● 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

DVVNN	DVJNR/L	MVVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A201	A202	A230	A231

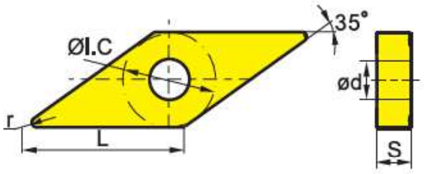
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	⊛	⊛	✲	✲											⊛	⊛	⊛	○	⊛	○		
M							○	⊛							○	○	⊛	⊛	⊛	○	⊛	○		
K									○	○	⊛	⊛	⊛											
N														○	○								○	⊛
S															○	○	⊛	⊛	⊛				○	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
NGF  Finishing	**VNEG160408-NGF**	0.8	0.2-3.0	0.1-0.3																●								
	VNEG160412-NGF	1.2	0.2-3.0	0.1-0.5																○								
SF  Finishing	**VNMG160404-SF**	0.4	0.05-3.00	0.05-0.20																						●		
	VNMG160408-SF	0.8	0.05-3.00	0.05-0.35																						○		

● 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°
			
A201	A202	A230	A231

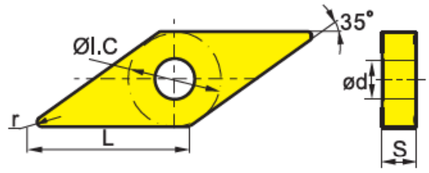
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

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



VN** negative insert					HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
				P	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
				M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
				K									◯	◯	⊛	⊛	⊛											
				N														◯	◯								◯	⊛
				S															◯	◯	⊛	⊛	⊛				◯	⊛
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic  Medium Cut	**VNMG160404**	0.4	0.2-6.0	0.05-0.60		○																						
	VNMG160408	0.8	0.2-6.0	0.08-0.60		○																						
DM  Medium Cut	**VNMG160408-DM**	0.8	0.5-4.0	0.15-0.50		●	●	●																				
	VNMG160412-DM	1.2	0.8-4.0	0.18-0.60		●	●	●																				
EM  Medium Cut	**VNMG160404-EM**	0.4	0.2-3.0	0.05-0.30							●											●	○					
	VNMG160408-EM	0.8	0.5-4.0	0.10-0.45							●											●	○					
NM  Medium Cut	**VNMG160412-NM**	1.2	0.2-4.0	0.05-0.40																●								

● 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

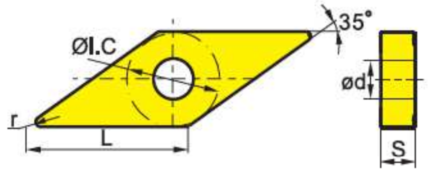
DVVNN	DVJNR/L	MVVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A201	A202	A230	A231

System code A42 Grade selection A40 Technical info A447 Cutting data A324

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					HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
				**P**	◯	◯	❀	❀	✺	✺											❀	❀	❀	◯	❀	◯		
				M							◯	❀							◯	◯	❀	❀	❀	◯	❀	◯		
				K									◯	◯	❀	❀	❀											
				N														◯	◯								◯	❀
				S															◯	◯	❀	❀	❀				◯	❀
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
PM  Medium Cut	**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		●	●	●					○	●														
TC  Medium Cut	**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											●		●											
ZM  Medium Cut	**VNMG160404-ZM**	0.4	0.5-3.0	0.08-0.30	●																							
	VNMG160408-ZM	0.8	0.5-3.0	0.1-0.4	●																							
SNR  Roughing	**VNMG160408-SNR**	0.8	0.2-2.0	0.1-0.4																●								
	VNMG160412-SNR	1.2	0.2-2.0	0.1-0.5																●								

● 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

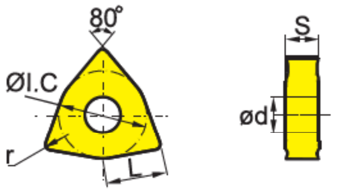
DVVNN	DVJNR/L	MVVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A201	A202	A230	A231

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
				**P**	◯	◯	⊛	⊛	❋	❋											⊛	⊛	⊛	◯	⊛	◯		
				M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
				K									◯	◯	⊛	⊛	⊛											
				N														◯	◯								◯	⊛
				S															◯	◯	⊛	⊛	⊛				◯	⊛
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
ADF  Finishing	**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	●																●							
DF  Finishing	**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		●	○	●																				
	WNMG080412-DF	1.2	0.2-2.5	0.10-0.35		●	●	○																				
SF  Finishing	**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																						●		
	WNMG080408-SF	0.8	0.05-0.50	0.05-0.35																						●		
	WNMG080412-SF	1.2	0.05-0.50	0.05-0.40																						○		

● 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°
			
A203	A217	A232	A291

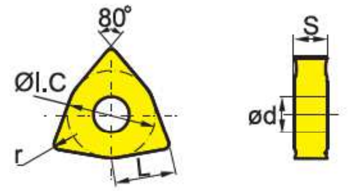
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

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

◯ Ideal machining conditions
⊛ Normal machining conditions
❁ Unfavourable machining conditions

Turning inserts

WN** negative insert



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	❁	❁											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a$_p$	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
WG  Wiper	**WNMG080408-WG**	0.8	0.5-5.0	0.15-0.70		●	●																					
	WNMG080412-WG	1.2	0.8-6.0	0.20-0.75		●	○																					
EF  Finishing	**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				○			●											●	●					
	WNMG080408-EF	0.8	0.1-1.5	0.1-0.4				○			●								○			●	○					
NF  Finishing	**WNEG080404-NF**	0.4	0.2-3.0	0.05-0.30															○	●								
	WNEG080408-NF	0.8	0.2-2.5	0.05-0.30																○								
NF  Finishing	**WNMG060408-NF**	0.8	0.2-2.5	0.05-0.30															○	●								

● 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°
			
A203	A217	A232	A291

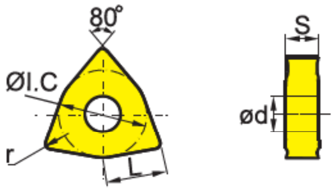
System code A42 Grade selection A40 Technical info A447 Cutting data A324

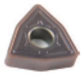
Turning inserts

◯ 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



					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
				P	◯	◯	⊕	⊕	⊛	⊛											⊕	⊕	⊕	◯	⊕	◯		
				M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
				K									◯	◯	⊕	⊕	⊕											
				N														◯	◯								◯	⊕
				S															◯	◯	⊕	⊕	⊕				◯	⊕
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	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°
			
A203	A217	A232	A291

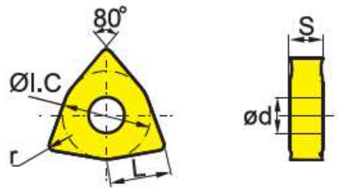
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✲	✲	✱	✱											✲	✲	✲	◯	✲	◯		
M							◯	✲							◯	◯	✲	✲	✲	◯	✲	◯		
K									◯	◯	✲	✲	✲											
N														◯	◯								◯	✲
S															◯	◯	✲	✲	✲				◯	✲
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
PM  Medium Cut	**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		●	●	●	●	●			○	●		●												
	WNMG080412-PM	1.2	0.8-4.0	0.18-0.60		●	●	●		●			○	●		●												
	WNMG080416-PM	1.6	1-4	0.23-0.65			●						○	●		●												
ZM  Medium Cut	**WNMG080408-ZM**	0.8	0.5-4.0	0.1-0.5	●																							
	WNMG080412-ZM	1.2	1.0-5.5	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

DWLNR/L	PWLNR/L	MWLNR/L	S***-PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A203	A217	A232	A291

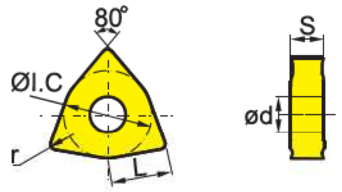
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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



					HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
				P	◯	◯	⊛	⊛	❋	❋											⊛	⊛	⊛	◯	⊛	◯		
				M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
				K									◯	◯	⊛	⊛	⊛											
				N														◯	◯								◯	⊛
				S															◯	◯	⊛	⊛	⊛				◯	⊛
				H																								
	ISO	r	a$_p$	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
NM  Medium Cut	**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															●	●								
TC  Medium Cut	**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											●		●											
DR  Roughing	**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		○	●	●						●		○												
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

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°
			
A203	A217	A232	A291

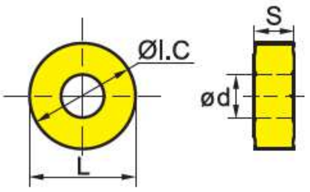
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

Turning inserts

○ 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

RN** negative insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	⊛	⊛	✻	✻											⊛	⊛	⊛	○	⊛	○		
M							○	⊛							○	○	⊛	⊛	⊛	○	⊛	○		
K									○	○	⊛	⊛	⊛											
N														○	○								○	⊛
S															○	○	⊛	⊛	⊛				○	⊛
H																								

	ISO	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic  Medium Cut	**RNMG120400**	0.5-7.0	0.1-1.8				●								○	○											

● Ex stock ○ On demand

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

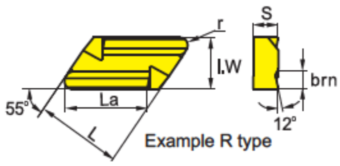
Tool holder

MRDNN	MRGNR/L
	
A233	A234

Turning inserts

◯ Ideal machining conditions
❁ Normal machining conditions
✽ Unfavourable machining conditions

KNUX	L	I.W	S
16 04	16.15	9.525	4.76



KN** negative insert							HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
P							◯	◯	❁	❁	✽	✽											❁	❁	❁	◯	❁	◯		
M													◯	❁							◯	◯	❁	❁	❁	◯	❁	◯		
K															◯	◯	❁	❁	❁											
N																				◯	◯								◯	❁
S																					◯	◯	❁	❁	❁				◯	❁
H																														
ISO		La	brn	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
KNUX  Finishing	**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				●																				
	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

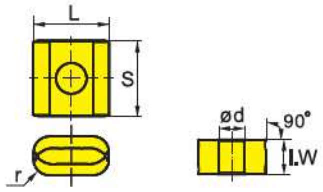
Tool holder	
CKJNR/L	**CKNNR/L**
Kr: 93°	Kr: 63°
	
A256	A257

Turning inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❁ Unfavourable machining conditions

175	L	I.C	S	d
32 -3	30	10	19.05	6.35
32 -1	19.05	10	19.05	6.35

Railway wheel machining



ISO	r	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	P	◯	◯	✿	✿	❁	❁											✿	✿	✿	◯	✿	◯		
	M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯		
	K									◯	◯	✿	✿	✿											
	N														◯	◯								◯	✿
	S															◯	◯	✿	✿	✿				◯	✿
	H																								
ISO	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
 **175.32-191940-22**	4				○																				
 **175.32-191940-24**	4				●																				
175.32-301940-24	4		○		●																				
 **175.32-191940-25**	4				○																				
 **175.32-191940-28**	4		●	●	●																				
 **175.32-301940-31**	4				○																				

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

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

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

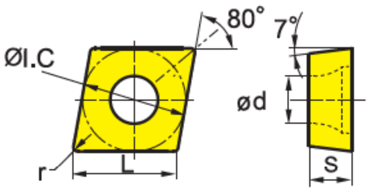
General turning Positive inserts

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



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
SF  Finishing	**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																				●	●	●		
USF  Finishing	**CCGT09T301L-USF**	0.1	0.2-2.0	0.01-0.08																	○		○					
	CCGT09T302L-USF	0.2	0.2-2.0	0.05-0.18																		○	●					
	CCGT09T304L-USF	0.4	0.2-2.0	0.05-0.20																		○	○					
USF  Finishing	**CCGT09T301R-USF**	0.1	0.2-2.0	0.01-0.08																			○					
	CCGT09T302R-USF	0.2	0.2-2.0	0.05-0.18																			●					
	CCGT09T304R-USF	0.4	0.2-2.0	0.05-0.20																		○						

● Ex stock ○ On demand

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	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°
						
A235	A236	A272	A273	A293	A310	A311

E***-SCLCR/L
Kr: 95°

A313

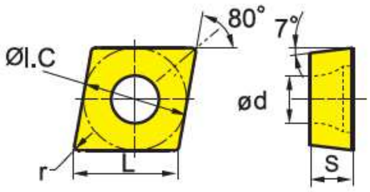
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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

Turning inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
❁ Unfavourable machining conditions

CC** positive insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	❁	❁											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
AHF  Finishing	**CCMT060204-AHF**	0.4	0.2-2.5	0.05-0.20	○																●				●			
	CCMT060208-AHF	0.8	0.3-2.5	0.05-0.30	○																●							
	CCMT09T304-AHF	0.4	0.2-3.0	0.05-0.30	○																●	○			●			
	CCMT09T308-AHF	0.8	0.3-3.0	0.05-0.40	●																●	○			●			
	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  Finishing	**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		●	●	●		●				○		●							●					
	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	S***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A235	A236	A272	A273	A293	A310	A311

E***-SCLCR/L
Kr: 95°

A313

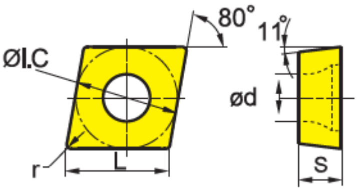
System code A42 Grade selection A40 Technical info A447 Cutting data A324

Turning inserts

◯ Ideal machining conditions
❂ Normal machining conditions
✺ Unfavourable machining conditions

CPGT	L	I.C	S	d
05 02	5.6	5.56	2.38	2.8

CP** positive insert



ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
				HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
P				◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
M										◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K												◯	◯	❂	❂	❂											
N																	◯	◯								◯	❂
S																		◯	◯	❂	❂	❂				◯	❂
H																											
 **CPGT050204**	0.4	0.5-2.0	0.08-0.40				○																				

● Ex stock ○ On demand

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	Coated cermet
HW	Uncoated carbide

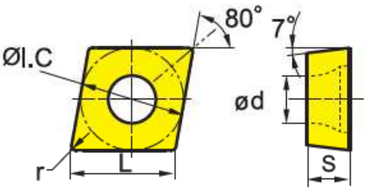
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

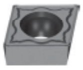
◯ Ideal machining conditions
⊗ Normal machining conditions
✱ Unfavourable machining conditions

Turning inserts

CC** positive insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊗	⊗	✱	✱											⊗	⊗	⊗	◯	⊗	◯		
M							◯	⊗							◯	◯	⊗	⊗	⊗	◯	⊗	◯		
K									◯	◯	⊗	⊗	⊗											
N														◯	◯								◯	⊗
S															◯	◯	⊗	⊗	⊗				◯	⊗
H																								

	ISO	r	a$_p$	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	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							●											●	○					
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								○																

● 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	S***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A235	A236	A272	A273	A293	A310	A311

E***-SCLCR/L
Kr: 95°

A313

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

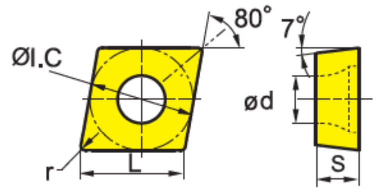
A Turning
B Milling
C Drilling
D Technical information
E Index

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HM  Medium Cut	**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		●	○	●		○				○														

● 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	S***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A235	A236	A272	A273	A293	A310	A311

E***-SCLCR/L
Kr: 95°

A313

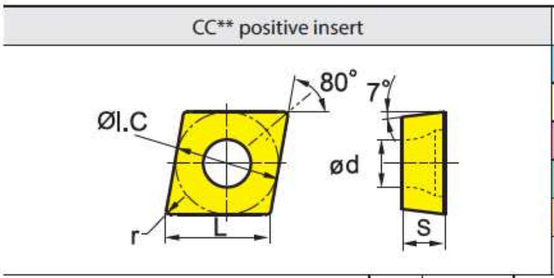
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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

◯ Ideal machining conditions
✲ Normal machining conditions
❋ Unfavourable machining conditions

Turning inserts

CC** positive insert



	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	P				◯	◯	✲	✲	❋	❋											✲	✲	✲	◯	✲	◯		
	M										◯	✲							◯	◯	✲	✲	✲	◯	✲	◯		
	K												◯	◯	✲	✲	✲											
	N																	◯	◯								◯	✲
	S																		◯	◯	✲	✲	✲				◯	✲
	H																											
Basic  Medium Cut	**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												○												
TC  Medium Cut	**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											●		●											
	CCMT120408-TC	0.8	1-4	0.1-0.4											●		●											
HR  Roughing	**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		●	●	●		●			●	●		●												
	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	S***-SCLCR/L	S***-SCFCR/L	S***-SCLCR
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A235	A236	A272	A273	A293	A310	A311

E***-SCLCR/L
Kr: 95°

A313

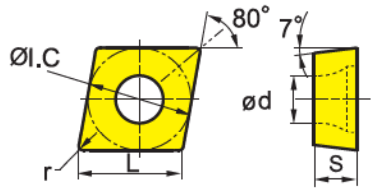
System code › A42   Grade selection › A40   Technical info › A447   Cutting data › A324

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



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	⊛	⊛	✹	✹											⊛	⊛	⊛	○	⊛	○		
M							○	⊛							○	○	⊛	⊛	⊛	○	⊛	○		
K									○	○	⊛	⊛	⊛											
N														○	○								○	⊛
S															○	○	⊛	⊛	⊛				○	⊛
H																								

	ISO	r	a$_p$	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
LC  Aluminium Machining	**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														●									●	
	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  Aluminium Machining	**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															●								●	
	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

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	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°
						
A235	A236	A272	A273	A293	A310	A311

E*-SCLCR/L**
Kr: 95°

A313

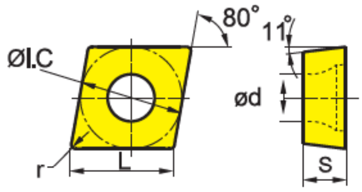
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❁	❁	✺	✺											❁	❁	❁	◯	❁	◯		
M							◯	❁							◯	◯	❁	❁	❁	◯	❁	◯		
K									◯	◯	❁	❁	❁											
N														◯	◯								◯	❁
S															◯	◯	❁	❁	❁				◯	❁
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HF  Finishing	**CPMT060204-HF**	0.4	0.1-1.5	0.04-0.18		●										○						○						
	CPMT060208-HF	0.8	0.1-1.5	0.05-0.25												○						●						
SF  Finishing	**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																				●		●		
Flat  Medium Cut	**CPGW060204**	0.4	0.5-1.5	0.05-0.40																							○	
HM  Medium Cut	**CPMT09T304-HM**	0.4	0.2-3.5	0.05-0.35			○							●						○		●						
	CPMT09T308-HM	0.8	0.2-3.5	0.10-0.55			○	●						●								●						

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

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

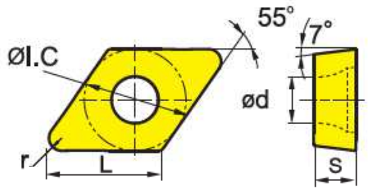
Tool holder	
S*-SCLPR/L**	**C***-SCLPR/L**
Kr: 95°	Kr: 95°
	
A306	A312

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			
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C		YD101	YD201		
P	◯	◯	✿	✿	❋	❋											✿	✿	✿	◯	✿	◯					
M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯					
K									◯	◯	✿	✿	✿														
N														◯	◯									◯	✿		
S															◯	◯	✿	✿	✿					◯	✿		
H																											

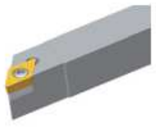
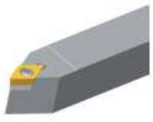
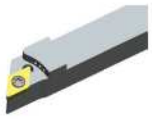
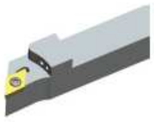
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C		YD101	YD201		
AHF  Finishing	**DCMT070204-AHF**	0.4	0.2-2.5	0.05-0.20	○																●	○			●						
	DCMT11T302-AHF	0.2	0.5-3.0	0.05-0.15	○																●	●			●						
	DCMT11T304-AHF	0.4	0.5-3.0	0.05-0.30	●																●	●			●						
	DCMT11T308-AHF	0.8	0.5-3.0	0.05-0.40	●																●										
SF  Finishing	**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																				●	●	●					
	DCGT11T308-SF	0.8	0.05-2.00	0.05-0.30																				●		●					

● 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'
						
A237	A238	A239	A274	A275	A276	A277

S***-SDQCR/L	S***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

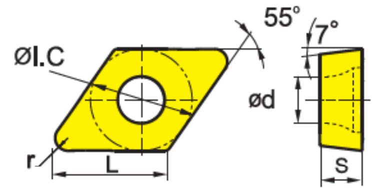
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

Turning inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
❋ Unfavourable machining conditions

DCGT	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



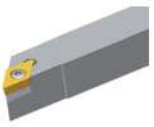
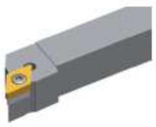
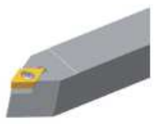
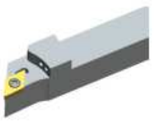
	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	❋	❋											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
USF  Finishing	**DCGT070201L-USF**	0.1	0.1-2.0	0.03-0.08																			●					
	DCGT070202L-USF	0.2	0.1-2.0	0.05-0.18																			●					
	DCGT11T302L-USF	0.2	0.2-2.0	0.05-0.18																			○					
USF  Finishing	**DCGT0702005R-USF**	0.05	0.1-2.0	0.01-0.04																			●					
	DCGT070201R-USF	0.1	0.1-2.0	0.03-0.08																			●					
	DCGT070202R-USF	0.2	0.1-2.0	0.05-0.18																			●					
	DCGT11T302R-USF	0.2	0.2-2.0	0.05-0.18																			●					

● 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'
						
A237	A238	A239	A274	A275	A276	A277

S***-SDQCR/L	S***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

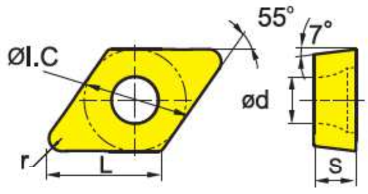
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

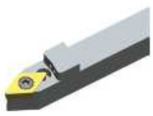


	ISO	r	a_p	f	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
					YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P					◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
M											◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K													◯	◯	⊛	⊛	⊛											
N																		◯	◯								◯	⊛
S																			◯	◯	⊛	⊛	⊛				◯	⊛
H																												
EF  Finishing	**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							●											●	○					
	DCMT11T308-EF	0.8	0.15-2.00	0.08-0.30							●											●	○					
HF  Finishing	**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		○	●	●														○	●					
	DCMT11T304-HF	0.4	0.11-2.00	0.06-0.23		●	●	●		○				○		●							●					
	DCMT11T308-HF	0.8	0.15-2.00	0.08-0.30		●	●	●						●									●					
EM  Medium Cut	**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							●	●										●	○					
	DCMT11T308-EM	0.8	0.5-3.0	0.1-0.3							●	●										●	○					

● 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'
						
A237	A238	A239	A274	A275	A276	A277

S***-SDQCR/L	S***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

General turning

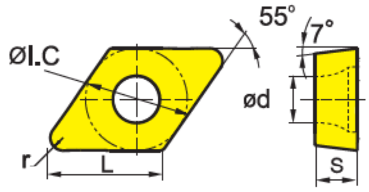
Positive inserts

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✽	✽											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

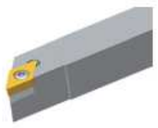
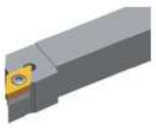
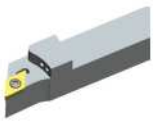
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HM  Medium Cut	**DCMT070204-HM**	0.4	0.19-2.25	0.06-0.17		●	●	●		○				●		●						●	●					
	DCMT070208-HM	0.8	0.38-2.25	0.08-0.23		●	●	●		○				●		●							●					
	DCMT11T304-HM	0.4	0.25-3.00	0.08-0.23		●	●	●		○				●		●					●		●					
	DCMT11T308-HM	0.8	0.5-3.0	0.1-0.3		●	●	●		○				●		●					●		●					
	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'
						
A237	A238	A239	A274	A275	A276	A277

S***-SDQCR/L	S***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

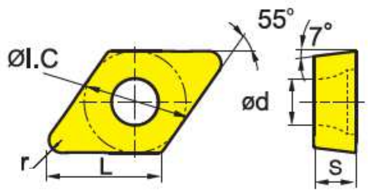
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

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



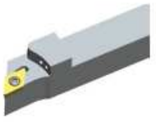
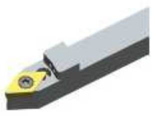
	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✪	✪	✲	✲											✪	✪	✪	◯	✪	◯		
M							◯	✪							◯	◯	✪	✪	✪	◯	✪	◯		
K									◯	◯	✪	✪	✪											
N														◯	◯								◯	✪
S															◯	◯	✪	✪	✪				◯	✪
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Flat  Medium Cut	**DCMW11T304**	0.4	0.5-5.0	0.05-0.20										○														
	DCMW11T308	0.8	0.4-5.0	0.1-0.4										○														
HR  Roughing	**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		○	●	○						○														
LC  Aluminium Machining	**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														●									●	
	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

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'
						
A237	A238	A239	A274	A275	A276	A277

S***-SDQCR/L	S***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

System code › A42 Grade selection › A40 Technical info › A447 Cutting data › A324

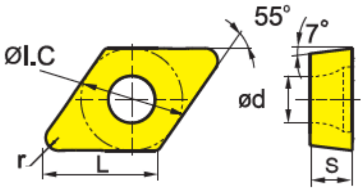
General turning Positive inserts

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



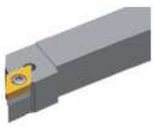
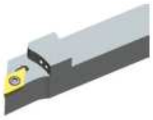
	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	◎	◎	✺	✺											◎	◎	◎	◯	◎	◯		
M							◯	◎							◯	◯	◎	◎	◎	◯	◎	◯		
K									◯	◯	◎	◎	◎											
N														◯	◯								◯	◎
S															◯	◯	◎	◎	◎				◯	◎
H																								

	ISO	r	a_p	f	YBG102	YBG202	YD101
LH  Aluminium Machining	**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	●	●	●
	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'
						
A237	A238	A239	A274	A275	A276	A277

S***-SDQCR/L	S***-SDUCR/L	S***-SDZCR/L	E***-SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

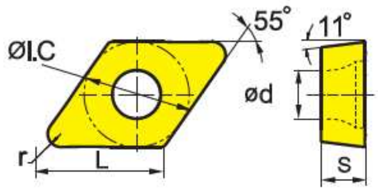
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✻	✻											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YNG151	YNG151C
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	●	●
Finishing	**DPGT11T308-SF**	0.8	0.05-2.00	0.1-0.4	○	○

● Ex stock ○ On demand

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

Tool holder

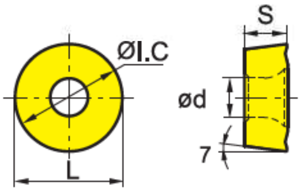
S***-SDQPR/L	S***-SDUPR/L	C***-SDQPR/L
Kr: 107°30'	Kr: 93°	Kr: 107°30'
		
A307	A308	A314

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

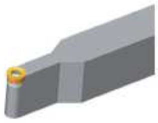
◯ Ideal machining conditions
✽ Normal machining conditions
❋ Unfavourable machining conditions

Turning inserts

RC** positive insert				HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
			**P**	◯	◯	✽	✽	❋	❋											✽	✽	✽	◯	✽	◯		
			M							◯	✽							◯	◯	✽	✽	✽	◯	✽	◯		
			K									◯	◯	✽	✽	✽											
			N														◯	◯								◯	✽
			S															◯	◯	✽	✽	✽				◯	✽
			H																								
	ISO	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic  Medium Cut	**RCGT1204MO**	0.5-5.0	0.1-0.4				○																				
Basic  Medium Cut	**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		●	●	●		●		○	○	●														
	RCMT2006MO	1.2-8.0	0.1-1.0		●	●	●																				
	RCMT2507MO	1.4-10.0	0.1-1.2		○	●	●																				
LH  Aluminium Machining	**RCGX0803MO-LH**	1-4	0.2-0.5																							●	
	RCGX1204MO-LH	1.2-5.0	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	
SRDCN	**SRGCR/L**
	
A254	A255

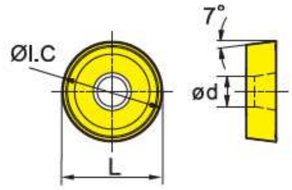
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	❋	❋											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic  Light Roughing	**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		●	●	●		●						●												
	RCMX2507MO	2-10	0.25-1.20		○	●			●																		
	RCMX3209MO	2-13	0.25-1.40		○	●	●		○																		
Basic  Light Roughing	**RCMX2507MO-1**	2-9	0.1-0.4		○		○																				
Basic  Light Roughing	**RCMX3209MO-PV**	3-12	0.1-0.4		○	●	●																				

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

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	Coated cermet
HW	Uncoated carbide

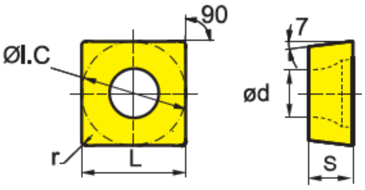
System code A42
Grade selection A40
Technical info A447
Cutting data A324

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✲	✲											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
AHF  Finishing	**SCMT09T304-AHF**	0.4	0.5-3.0	0.05-0.30	●																●							
	SCMT09T308-AHF	0.8	0.5-3.0	0.05-0.40	●																●				●			
EF  Finishing	**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																		●						
EM  Finishing	**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							○	○										●						
	SCMT120412-EM	1.2	0.72-3.60	0.14-0.43								○										●						

● 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°
				
A245	A246	A247	A248	A298

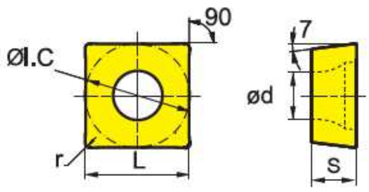
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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



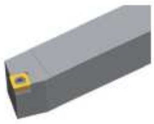
	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	❋	❋											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HF  Finishing	**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		●	●	○															●					
HM  Medium Cut	**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		○	●	●		●				●		●							○					
	SCMT120412-HM	1.2	0.72-3.60	0.14-0.43			●	●																				

● 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°
				
A245	A246	A247	A248	A298

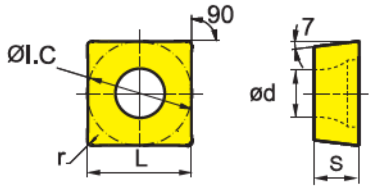
System code A42 Grade selection A40 Technical info A447 Cutting data A324

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	5.565.5

SC** positive insert



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✿	✿	❋	❋											✿	✿	✿	◯	✿	◯		
M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯		
K									◯	◯	✿	✿	✿											
N														◯	◯								◯	✿
S															◯	◯	✿	✿	✿				◯	✿
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HR  Roughing	**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		○	○	●		○																		
	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  Aluminium Machining	**SCGX09T304-LC**	0.4	0.5-5.0	0.1-0.5																							●	
	SCGX09T308-LC	0.8	0.5-5.0	0.15-0.60																							●	
	SCGX120408-LC	0.8	1-7	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

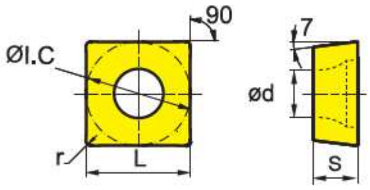
SSBCR/L	SSDCN	SSKCR/L	SSSCR/L	S***-SSKCR/L
Kr: 75°	Kr: 45°	Kr: 75°	Kr: 45°	Kr: 75°
				
A245	A246	A247	A248	A298

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



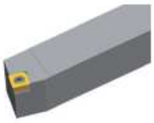
	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊕	⊕	❂	❂											⊕	⊕	⊕	◯	⊕	◯		
M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
K									◯	◯	⊕	⊕	⊕											
N														◯	◯								◯	⊕
S															◯	◯	⊕	⊕	⊕				◯	⊕
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
LH  Aluminium Machining	**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															○								●	

● Ex stock ○ On demand

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°
				
A245	A246	A247	A248	A298

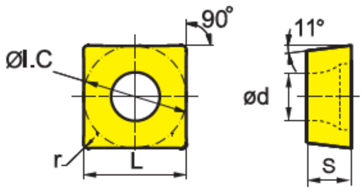
System code A42 | Grade selection A40 | Technical info A447 | Cutting data A324

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



	HC^{1} (CVD)													HC^{1} (PVD)						HT		HC^{2}	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	⬤	⬤	✲	✲	❋	❋											✲	✲	✲	⬤	✲	⬤		
M							⬤	✲							⬤	⬤	✲	✲	✲	⬤	✲	⬤		
K									⬤	⬤	✲	✲	✲											
N														⬤	⬤								⬤	✲
S															⬤	⬤	✲	✲	✲				⬤	✲
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	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

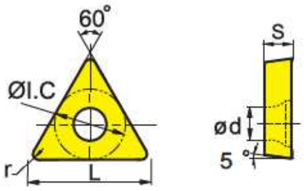
HC^{1} Coated carbide
HT Uncoated cermet
HC^{2} Coated cermet
HW Uncoated carbide

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



ISO		r	a$_p$	f	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
					YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P					○	○	⊛	⊛	✽	✽											⊛	⊛	⊛	○	⊛	○		
M											○	⊛							○	○	⊛	⊛	⊛	○	⊛	○		
K													○	○	⊛	⊛	⊛											
N																		○	○								○	⊛
S																			○	○	⊛	⊛	⊛				○	⊛
H																												
	**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

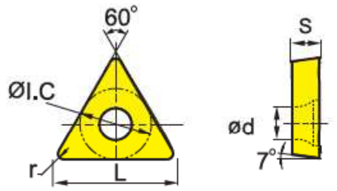
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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					HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
				**P**	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
				M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
				K									◯	◯	⊛	⊛	⊛											
				N														◯	◯								◯	⊛
				S															◯	◯	⊛	⊛	⊛				◯	⊛
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
SF  Finishing	**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																						○		
	TCGT110304-SF	0.4	0.05-2.00	0.1-0.3																				●		●		
	TCGT110308-SF	0.8	0.05-2.00	0.10-0.35																						○		
USF  Finishing	**TCGT110301L-USF**	0.1	0.2-2.0	0.03-0.08																			○					
	TCGT110302L-USF	0.2	0.2-2.0	0.05-0.18																			●					
USF  Finishing	**TCGT110301R-USF**	0.1	0.2-2.0	0.03-0.08																			●					
	TCGT110302R-USF	0.2	0.2-2.0	0.05-0.18																			●					

● Ex stock ○ On demand

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	Coated cermet
HW	Uncoated carbide

Tool holder	
STGCR/L	**E***-STFCR/L**
Kr: 91°	Kr: 90°
	
A251	A319

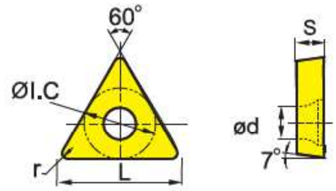
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	⊛	⊛	✻	✻											⊛	⊛	⊛	○	⊛	○		
M							○	⊛							○	○	⊛	⊛	⊛	○	⊛	○		
K									○	○	⊛	⊛	⊛											
N														○	○								○	⊛
S															○	○	⊛	⊛	⊛				○	⊛
H																								

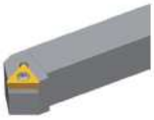
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C
AHF  Finishing	**TCMT110204-AHF**	0.4	0.2-2.5	0.05-0.30	●												
	TCMT110208-AHF	0.8	0.2-2.5	0.1-0.4	●												
	TCMT16T304-AHF	0.4	0.5-3.0	0.05-0.30	●												
	TCMT16T308-AHF	0.8	0.5-3.5	0.1-0.4	●												
HF  Finishing	**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		●	●	○		○				●			
	TCMT16T304-HF	0.4	0.11-2.00	0.05-0.23		○	●	●									
	TCMT16T308-HF	0.8	0.2-3.5	0.05-0.30		●		●									

ISO	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
TCMT110204-AHF				●							
TCMT110208-AHF				●							
TCMT16T304-AHF				●							
TCMT16T308-AHF				●							
TCMT090202-HF							○				
TCMT090204-HF							○				
TCMT090208-HF											
TCMT110202-HF						●					
TCMT110204-HF											
TCMT110208-HF											
TCMT16T304-HF						○					
TCMT16T308-HF											

● 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°
					
A249	A250	A251	A252	A300	A319

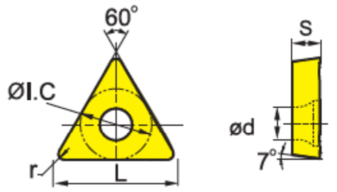
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

Turning inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✲ Unfavourable machining conditions

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

TC** positive insert

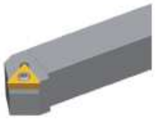


					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
				P	◯	◯	⊛	⊛	✲	✲											⊛	⊛	⊛	◯	⊛	◯		
				M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
				K									◯	◯	⊛	⊛	⊛											
				N														◯	◯								◯	⊛
				S															◯	◯	⊛	⊛	⊛				◯	⊛
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
EF  Finishing	**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																		●	○					
	TCMT110208-EF	0.8	0.2-2.0	0.05-0.30																			○					
	TCMT16T304-EF	0.4	0.3-3.0	0.05-0.23																		●	○					
	TCMT16T308-EF	0.8	0.3-3.0	0.1-0.4							●											●						
EM  Medium Cut	**TCMT090204-EM**	0.4	0.19-2.25	0.06-0.17							●											○	○					
	TCMT090208-EM	0.8	0.38-2.25	0.08-0.23							●																	
	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							●											●						
	TCMT16T308-EM	0.8	0.5-3.0	0.1-0.3							●	●										●						

● 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°
					
A249	A250	A251	A252	A300	A319

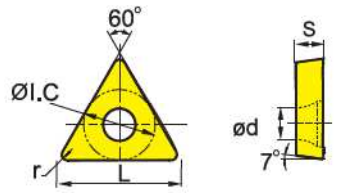
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

Turning inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

TC** positive insert

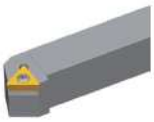


TC** positive insert					HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
				P	◯	◯	✿	✿	❋	❋											✿	✿	✿	◯	✿	◯		
				M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯		
				K									◯	◯	✿	✿	✿											
				N														◯	◯								◯	✿
				S															◯	◯	✿	✿	✿				◯	✿
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Flat  Medium Cut	**TCMW16T308**	0.8	0.5-5.0	0.05-0.60												○												
HM  Medium Cut	**TCMT090204-HM**	0.4	0.19-2.25	0.06-0.17		●	●	●						●		●												
	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  Roughing	**TCMT090204-HR**	0.4	0.5-3.0	0.1-0.3			○	●																				
	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

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	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°
					
A249	A250	A251	A252	A300	A319

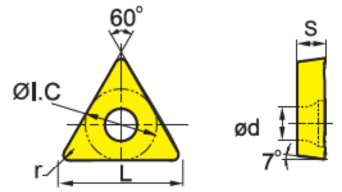
System code A42 Grade selection A40 Technical info A447 Cutting data A324

Turning inserts

○ Ideal machining conditions
⊕ Normal machining conditions
✻ Unfavourable machining conditions

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

TC** positive insert



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	⊕	⊕	✻	✻											⊕	⊕	⊕	○	⊕	○		
M							○	⊕							○	○	⊕	⊕	⊕	○	⊕	○		
K									○	○	⊕	⊕	⊕											
N														○	○								○	⊕
S															○	○	⊕	⊕	⊕				○	⊕
H																								

ISO		r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic 	**TCMT220408**	0.8	1.2-4.8	0.14-0.42				●						●														

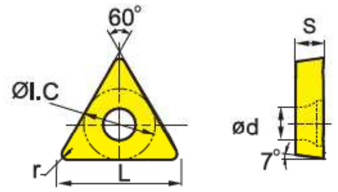
● Ex stock ○ On demand

HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

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

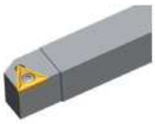


TC** positive insert					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
P					◯	◯	⊛	⊛	❋	❋											⊛	⊛	⊛	◯	⊛	◯		
M											◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K													◯	◯	⊛	⊛	⊛											
N																		◯	◯								◯	⊛
S																			◯	◯	⊛	⊛	⊛				◯	⊛
H																												
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
LC  Aluminium Machining	**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														●									●	
	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  Aluminium Machining	**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																							●	
	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°
					
A249	A250	A251	A252	A300	A319

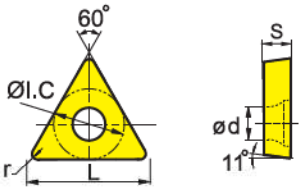
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✿	✿	❁	❁											✿	✿	✿	◯	✿	◯		
M							◯	✿							◯	◯	✿	✿	✿	◯	✿	◯		
K									◯	◯	✿	✿	✿											
N														◯	◯								◯	✿
S															◯	◯	✿	✿	✿				◯	✿
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	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

HC^1	Coated carbide
HT	Uncoated cermet
HC^2	Coated cermet
HW	Uncoated carbide

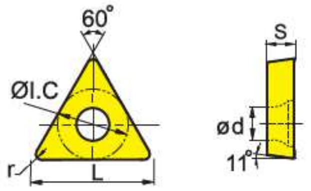
System code › A42 Grade selection › A40 Technical info › A447 Cutting data › A324

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	❂	❂	✺	✺											❂	❂	❂	◯	❂	◯		
M							◯	❂							◯	◯	❂	❂	❂	◯	❂	◯		
K									◯	◯	❂	❂	❂											
N														◯	◯								◯	❂
S															◯	◯	❂	❂	❂				◯	❂
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
SF  Finishing	**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																				●		●		
	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

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

Tool holder

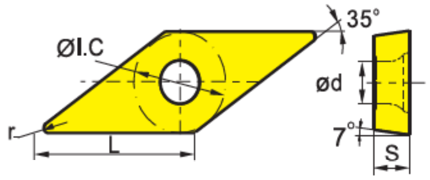
S***-STUPR/L	C***-STUPR/L	E***-STFPR/L
Kr: 93°	Kr: 93°	Kr: 90°
		
A309	A318	A320

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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

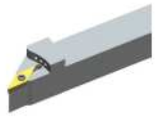


VC** positive insert					HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
				P	◯	◯	⊕	⊕	✳	✳											⊕	⊕	⊕	◯	⊕	◯		
				M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
				K									◯	◯	⊕	⊕	⊕											
				N														◯	◯								◯	⊕
				S															◯	◯	⊕	⊕	⊕				◯	⊕
				H																								
	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HF  Finishing	**VCGT110304-HF**	0.4	0.2-2.0	0.05-0.30				●														○						
NF  Finishing	**VCGT160408-NF**	0.8	0.2-2.0	0.1-0.4															○	●								
SF  Finishing	**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																						●		

● 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'
						
A243	A244	A278	A279	A302	A303	A321

C***-SVUCR/L
Kr: 93°

A322

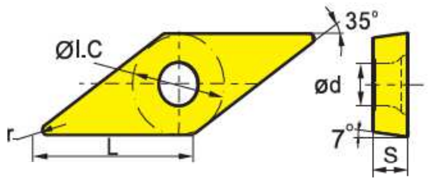
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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
13 03	13.8	7.94	3.175	3.4

VC** positive insert



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	⊛	⊛	❋	❋											⊛	⊛	⊛	○	⊛	○		
M							○	⊛							○	○	⊛	⊛	⊛	○	⊛	○		
K									○	○	⊛	⊛	⊛											
N														○	○								○	⊛
S															○	○	⊛	⊛	⊛				○	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
USF  Finishing	**VCGT110301L-USF**	0.1	0.05-2.00	0.03-0.08																			●					
	VCGT110302L-USF	0.2	0.05-2.00	0.05-0.18																			●					
USF  Finishing	**VCGT110301R-USF**	0.1	0.05-2.00	0.03-0.08																			●					
	VCGT110302R-USF	0.2	0.05-2.00	0.05-0.18																			●					
	**VCGT130304**	0.4	1-5	0.1-0.3				●																				

● Ex stock ○ On demand

HC^1 Coated carbide
HT Uncoated cermet
HC^2 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'
						
A243	A244	A278	A279	A302	A303	A321

C***-SVUCR/L
Kr: 93°

A322

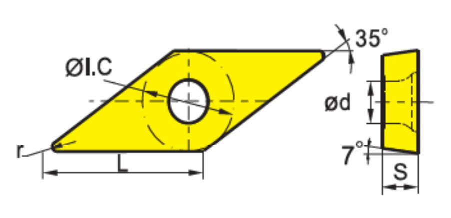
General turning
Positive inserts

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	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊕	⊕	✻	✻											⊕	⊕	⊕	◯	⊕	◯		
M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
K									◯	◯	⊕	⊕	⊕											
N														◯	◯								◯	⊕
S															◯	◯	⊕	⊕	⊕				◯	⊕
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
LC  Aluminium Machining	**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														●									●	
	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'
						
A243	A244	A278	A279	A302	A303	A321

C***-SVUCR/L
Kr: 93°

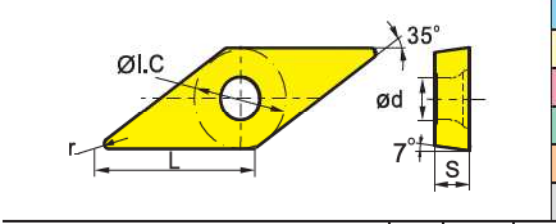
A322

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

◯ Ideal machining conditions
✲ Normal machining conditions
❋ Unfavourable machining conditions

Turning/Milling inserts

VC** turning/milling insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	✲	✲	❋	❋											✲	✲	✲	◯	✲	◯		
M							◯	✲							◯	◯	✲	✲	✲	◯	✲	◯		
K									◯	◯	✲	✲	✲											
N														◯	◯								◯	✲
S															◯	◯	✲	✲	✲				◯	✲
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
LH  Aluminium Machining	**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															○								●	○

● 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'
						
A243	A244	A278	A279	A302	A303	A321

C***-SVUCR/L
Kr: 93°

A322

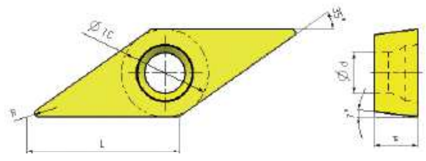
System code A42 Grade selection A40 Technical info A447 Cutting data A324

Turning inserts

- ◯ Ideal machining conditions
- ⊕ Normal machining conditions
- ❋ Unfavourable machining conditions

VCMT	L	I.C	S	d
16 04	16	9.525	4.76	4.4

VC** positive insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊕	⊕	❋	❋											⊕	⊕	⊕	◯	⊕	◯		
M							◯	⊕							◯	◯	⊕	⊕	⊕	◯	⊕	◯		
K									◯	◯	⊕	⊕	⊕											
N														◯	◯								◯	⊕
S															◯	◯	⊕	⊕	⊕				◯	⊕
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
EF  Medium Cut	**VCMT160404-EF**	0.4	0.5-2.5	0.05-0.20																		●						
EM  Medium Cut	**VCMT160404-EM**	0.4	0.5-2.5	0.05-0.35							○											●						
	VCMT160408-EM	0.8	0.5-2.5	0.10-0.45							○											●						

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

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

Tool holder

SVVCN	SVJCR/L	E***-SVUCR/L
Kr: 72°30'	Kr: 93°	Kr: 93°
		
A243	A244	A322

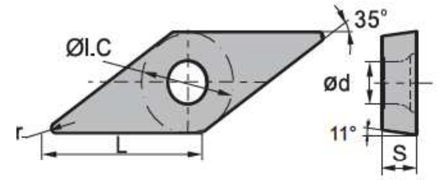
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

Turning inserts

○ Ideal machining conditions
⊛ Normal machining conditions
✲ Unfavourable machining conditions

VPGT	L	I.C	S	d
11 03	11	6.35	3.18	2.8

VP** positive insert



	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	○	○	⊛	⊛	✲	✲											⊛	⊛	⊛	○	⊛	○		
M							○	⊛							○	○	⊛	⊛	⊛	○	⊛	○		
K									○	○	⊛	⊛	⊛											
N														○	○								○	⊛
S															○	○	⊛	⊛	⊛				○	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
USF  Finishing	**VPGT110301R-USF**	0.1	0.2-2.5	0.03-0.08																			●					

● Ex stock ○ On demand

HC^1 Coated carbide
HT Uncoated cermet
HC^2 Coated cermet
HW Uncoated carbide

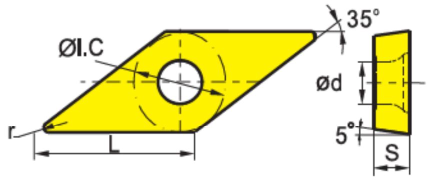
System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

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
11 03	11	6.35	3.18	2.8
16 04	16.5	9.525	4.76	4.4

VB** positive insert



VB** positive insert	HC^1 (CVD)													HC^1 (PVD)						HT		HC^2	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a$_p$	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
AHF  Finishing	**VBMT160404-AHF**	0.4	0.2-3.0	0.05-0.30	●																●							
	VBMT160408-AHF	0.8	0.8-3.5	0.08-0.40	●																●							
EF  Finishing	**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							●											●						
	VBMT160408-EF	0.8	0.14-1.80	0.07-0.27							●											●						
HF  Finishing	**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				●															●					
NF  Finishing	**VBET160404-NF**	0.4	0.2-3.0	0.05-0.30															○	●								
	VBET160408-NF	0.8	0.2-3.0	0.08-0.40															○	●								

● 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
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°
				
A240	A241	A242	A304	A305

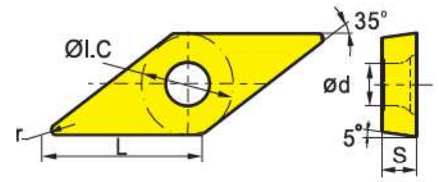
System code A42 Grade selection A40 Technical info A447 Cutting data A324

Turning inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✺ Unfavourable machining conditions

VBGT	L	I.C	S	d
11 03	11	6.35	3.18	2.8

VB** positive insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YNG151	YNT251	YNG151C
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

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

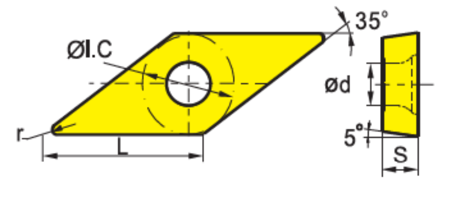
A Turning
B Milling
C Drilling
D Technical Information
E Index

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



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✺	✺											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
NGF  Finishing	**VBET160408-NGF**	0.8	0.2-3.0	0.08-0.30																●								
	VBET160412-NGF	1.2	0.2-3.0	0.1-0.4																●								
EM  Medium Cut	**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							●											●						
	VBMT160408-EM	0.8	0.45-2.70	0.09-0.27							●											●						
HM  Medium Cut	**VBMT160404-HM**	0.4	0.23-2.70	0.07-0.20		●	●	●		●	●			●									●					
	VBMT160408-HM	0.8	0.45-2.70	0.09-0.27		●	●	●			●	●		●		●							●					○
	VBMT160412-HM	1.2	0.54-2.70	0.11-0.32		●	●	●		○																		

● 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
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°
				
A240	A241	A242	A304	A305

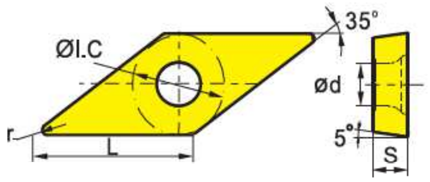
System code › A42 Grade selection › A40 Technical info › A447 Cutting data › A324

Turning inserts

◯ 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

VB** positive insert



	HC¹ (CVD)													HC¹ (PVD)						HT		HC²	HW	
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
P	◯	◯	⊛	⊛	✻	✻											⊛	⊛	⊛	◯	⊛	◯		
M							◯	⊛							◯	◯	⊛	⊛	⊛	◯	⊛	◯		
K									◯	◯	⊛	⊛	⊛											
N														◯	◯								◯	⊛
S															◯	◯	⊛	⊛	⊛				◯	⊛
H																								

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HR  Roughing	**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		○	●	○					○															
SNR  Roughing	**VBMT160408-SNR**	0.8	0.5-4.0	0.1-0.3																○								
	VBMT160412-SNR	1.2	0.5-4.0	0.3-0.6																●								

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

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

Tool holder

SVJBR/L	SVABR/L	SVVBN	S***-SVQBR/L	S***-SVUBR/L
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°
				
A240	A241	A242	A304	A305

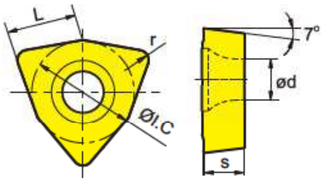
System code > A42
Grade selection > A40
Technical info > A447
Cutting data > A324

Turning inserts

○ Ideal machining conditions
⊕ Normal machining conditions
✱ Unfavourable machining conditions

WCMX	L	I.C	S	d
04 02	4.3	6.35	2.38	3.1
06 T3	6.5	9.525	3.97	3.7
08 04	8.7	12.7	4.76	4.3

WC** drilling insert



	HC¹ (CVD)													HC¹ (PVD)					HT		HC²	HW
	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YNG151	YNT251	YNG151C	YD101
P	○	○	⊕	⊕	✱	✱											⊕	⊕	○	⊕	○	
M							○	⊕							○	○	⊕	⊕	○	⊕	○	
K									○	○	⊕	⊕	⊕									
N														○	○							○
S															○	○	⊕	⊕				○
H																						

	ISO	r	a_p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YNG151	YNT251	YNG151C	YD101
 Medium Cut	**WCMX040208R-53**	0.8	0.05-2.00	0.05-0.60																						
	WCMX06T308R-53	0.8	0.1-3.0	0.05-0.60																						
	WCMX080412R-53	1.2	0.2-4.0	0.05-0.80																						

● Ex stock ○ On demand

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

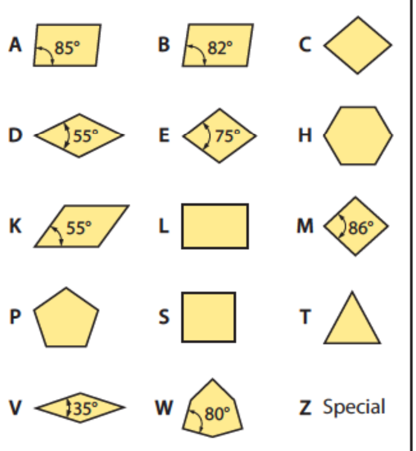
Tool holder
SWACR/L
Kr: 90°

A253

System code > A42 Grade selection > A40 Technical info > A447 Cutting data > A324

C	N	G	A	12	04	08	T	020	20	–	2	(W)
1	2	3	4	5	6	7	8	9	10		11	12

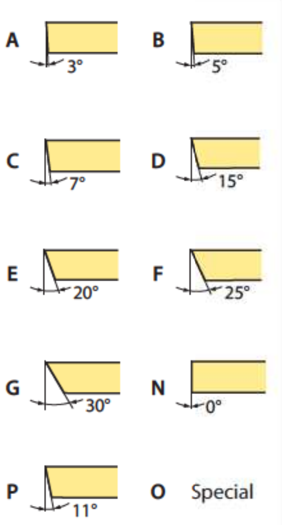
Insert shape



Z Special

1

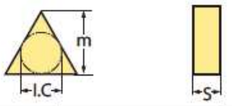
Clearance angle



O Special

2

Tolerance class

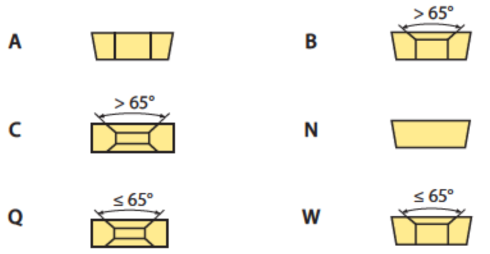


Code	I.C [mm]	m [mm]	S [mm]
A	±0,025	±0,005	±0,025
C	±0,025	±0,013	±0,025
E	±0,025	±0,025	±0,025
F	±0,013	±0,005	±0,025
G	±0,025	±0,025	±0,130
H	±0,013	±0,013	±0,025
J	±0,05–0,15	±0,005	±0,025
K	±0,05–0,15	±0,013	±0,025
L	±0,05–0,15	±0,025	±0,025
M	±0,05–0,15	±0,08–0,20	±0,130
N	±0,05–0,15	±0,08–0,20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

3

Fastening features (metric)

Insert shape

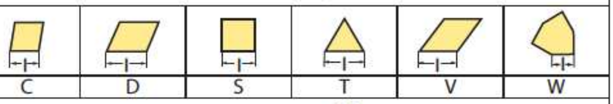


X Special

4

Cutting edge length l [mm]

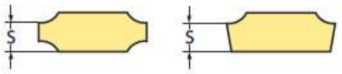
Insert shape



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

5

Insert thickness S [mm]



Code	S	Code	S
02	2,38	**06**	6,35
T2	2,58	**T6**	6,75
03	3,18	**07**	7,94
T3	3,97	**09**	9,52
04	4,76	**T9**	9,72
T4	4,96	**11**	11,11
05	5,56	**12**	12,70
T5	5,95		

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

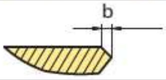
7

Cutting edge profile

Code	Cutting edge	Insert shape
E	Rounding	
F	Sharp edge	
T	Chamfer	
S	Chamfer + Rounding	

8

Chamfer width b [mm]



Code	b
010	0,10
015	0,15
020	0,20
025	0,25
030	0,30
035	0,35
040	0,40
045	0,45
050	0,50
100	1,00
200	2,00

9

Chamfer angle α

Code	α
05	5°
10	10°
15	15°
20	20°
25	25°
30	30°

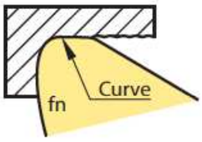
10

Cutting edges

Code	Form
1	
2	
3	
4	

11

Extra

Code	Description
W	Wiper 

12

Standard edge preparation

	CBN				Solid CBN			PCD
	YCB111	**YCB121**	**YCB131**	**YCB211**	**YZB121**	**YZB221**	**YZB231**	**YCD421**
Rayon = 0,4 mm	S01525	S01520	S01525	S01020	S01020	T02020	T02025	F
Rayon ≥ 0,8 mm	S01525	S02020	S02025	S01020	S01020	T02020	T02025	F

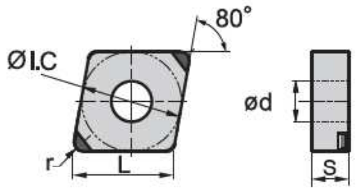
Other edge preparation on demand.

Turning CBN inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
❋ Unfavourable machining conditions

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

CN** negative insert



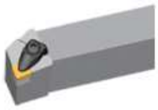
	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				◯
N				
H	◯	⊛	❋	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**CNGA120404-2**	0.4	0.08-0.50	0.05-0.20	○	●	○	○
	CNGA120408-2	0.8	0.08-0.50	0.05-0.25	●	●	●	●
	CNGA120412-2	1.2	0.08-0.50	0.05-0.30	○	●	●	●
	**CNGA120408-2W**	0.8	0.08-0.50	0.05-0.25	○	○		
	CNGA120412-2W	1.2	0.08-0.50	0.05-0.30	○	○		

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

DCLNR/L	PCBNR/L	PCLNR/L	MCBNR/L	MCLNR/L	PCLNR/L
Kr: 95°	Kr: 75°	Kr: 95°	Kr: 75°	Kr: 95°	Kr: 95°
					
A197	A204	A205	A218	A219	A284

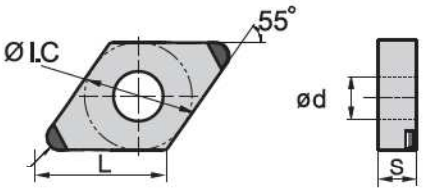
System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

○ Ideal machining conditions
⊛ Normal machining conditions
✺ Unfavourable machining conditions

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

Turning CBN inserts

DN** negative insert



	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				●
N				
H	○	⊛	✺	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**DNGA150604-2**	0.4	0.08-0.50	0.05-0.20	○	○	○	○
	DNGA150608-2	0.8	0.08-0.50	0.05-0.25	●	●	○	●
	DNGA150612-2	1.2	0.08-0.50	0.05-0.15	○	●	●	○

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

DDJNR/L	**PDJNR/L**	**PDNNR/L**	**MDJNR/L**	**MDPNN**	**PDSNR/L**	**PDUNR/L**
Kr: 93°	Kr: 93°	Kr: 63°	Kr: 93°	Kr: 62°30'	Kr: 62°30'	Kr: 93°
						
A198	A206	A207	A220	A221	A286	A287

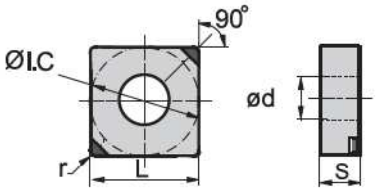
System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

Turning CBN inserts

○ Ideal machining conditions
⊛ Normal machining conditions
❁ Unfavourable machining conditions

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

SN** negative insert



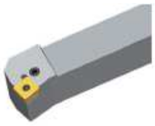
	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				●
N				
H	○	⊛	❁	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**SNGA120408-2**	0.8	0.08-0.50	0.05-0.25	○	○	○	○
	SNGA120412-2	1.2	0.08-0.50	0.05-0.30	○	○	○	○

● Ex stock ○ On demand

BL	CBN with a low CBN content
BH	CBN with a high CBN content

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°
						
A199	A208	A210	A211	A212	A222	A223

MSKNR/L	**MSDNN**	**PSKNR/L**
Kr: 75°	Kr: 45°	Kr: 75°
		
A224	A225	A289

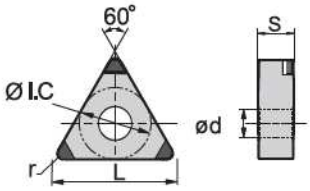
System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

Turning CBN inserts

◯ Ideal machining conditions
✿ Normal machining conditions
❋ Unfavourable machining conditions

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

TN** negative insert



	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				◯
N				
H	◯	✿	❋	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**TNGA160404-3**	0.4	0.08-0.50	0.05-0.20	○	○		
	TNGA160408-3	0.8	0.08-0.50	0.05-0.25	○	●	○	○
	TNGA160412-3	1.2	0.08-0.50	0.05-0.30	○	○	○	○

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

DTGNR/L	**PTFNR/L**	**PTTNR/L**	**PTGNR/L**	**MTGNR/L**	**MTJNR/L**	**MTJNR/L-Z**
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A200	A213	A214	A215	A226	A227	A228

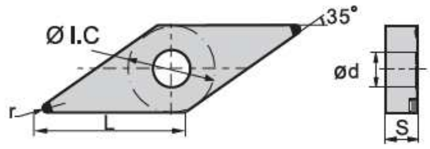
MTFNR/L	**PTFNR/L**
Kr: 91°	Kr: 90°
	
A229	A290

Turning CBN inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✺ Unfavourable machining conditions

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

VN** negative insert



	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				◯
N				
H	◯	⊛	✺	

ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
VNGA160404-2	0.4	0.08-0.50	0.05-0.20	○	○		
VNGA160408-2	0.8	0.08-0.50	0.05-0.25	○	●		

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

DVVNN	**DVJNR/L**	**MVVNN**	**MVJNR/L**
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
			
A201	A202	A230	A231

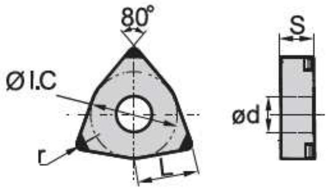
System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

Turning CBN inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✺ Unfavourable machining conditions

WNGA	L	I.C	S	d
08 04	8.69	12.7	4.76	5.16

WN** negative insert



	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				◯
N				
H	◯	⊛	✺	

ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
WNGA080404-3	0.4	0.08-0.50	0.05-0.20			○	
WNGA080408-3	0.8	0.08-0.50	0.05-0.25		●	○	

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

DWLNR/L	PWLNR/L	MWLNR/L	PWLNR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A203	A217	A232	A291

A Turning
B Milling
C Drilling
D Technical Information
E Index

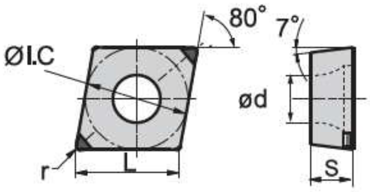
System code A40 Grade selection A146 Technical info A447 Cutting data A324

Turning CBN inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✲ Unfavourable machining conditions

CCGW	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	5.5

CC** positive insert



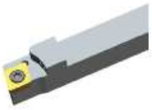
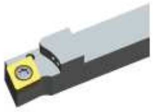
	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				◯
N				
H	◯	⊛	✲	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**CCGW060204-1**	0.4	0.08-0.50	0.05-0.20	○	○		
	CCGW060208-1	0.8	0.08-0.50	0.05-0.25	○	○		
	CCGW09T304-2	0.4	0.08-0.50	0.05-0.20	○	●	○	○
	CCGW09T308-2	0.8	0.08-0.50	0.05-0.25	●	●	○	○
	CCGW120404-2	0.4	0.08-0.50	0.05-0.20	○	●	○	○
	CCGW120408-2	0.8	0.08-0.50	0.05-0.25	○	●	○	●

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

SCACR/L	**SCLCR/L**	**SCACR/L-SC**	**SCLCR/L-SC**	**SCLCR/L**	**SCFCR/L**	**SCLCR/L**
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A235	A236	A272	A273	A293	A310	A311

SCLCR/L
Kr: 95°

A313

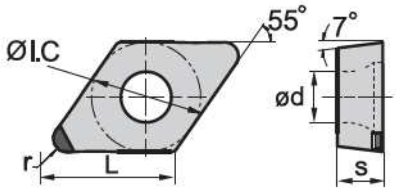
System code A40
Grade selection A146
Technical info A447
Cutting data A324

Turning CBN inserts

○ Ideal machining conditions
⊛ Normal machining conditions
✲ Unfavourable machining conditions

DCGW	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



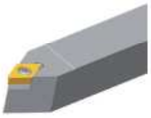
	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				○
N				
H	○	⊛	✲	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**DCGW070204-1**	0.4	0.08-0.50	0.05-0.20	○	○		
	DCGW070208-1	0.8	0.08-0.50	0.05-0.25	○	○		
	DCGW11T304-2	0.4	0.08-0.50	0.05-0.20	●	○	○	○
	DCGW11T308-2	0.8	0.08-0.50	0.05-0.25	●	●	●	●

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

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'
						
A237	A238	A239	A274	A275	A276	A277

SDQCR/L	SDUCR/L	SDZCR/L	SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

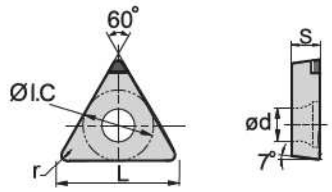
System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

Turning CBN inserts

- ● Ideal machining conditions
- ⊛ Normal machining conditions
- ✻ Unfavourable machining conditions

TCGW	L	I.C	S	d
11 02	11	6.35	2.38	2.5
16 T3	16.5	9.525	3.97	4.4

TC** positive insert



	BL (CBN)			BH (CBN)
P				
K				●
N				
H	○	⊛	✻	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**TCGW110204-1**	0.4	0.08-0.50	0.05-0.20	○	○	○	○
	TCGW110208-1	0.8	0.08-0.50	0.05-0.25	○	○	○	
	**TCGW16T304-3**	0.4	0.08-0.50	0.05-0.20	○	○	○	○
	TCGW16T308-3	0.8	0.08-0.50	0.05-0.25	○	○	○	○

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

STACR/L	STFCR/L	STGCR/L	STTCR/L	STFCR/L	STFCR/L
Kr: 90°	Kr: 91°	Kr: 91°	Kr: 60°	Kr: 91°	Kr: 90°
					
A249	A250	A251	A252	A300	A319

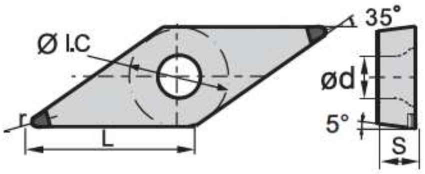
System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

Turning CBN inserts

○ Ideal machining conditions
⊛ Normal machining conditions
✽ Unfavourable machining conditions

VBGW	L	I.C	S	d
16 04	16.6	9.525	4.76	4.4

VB** positive insert



	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				○
N				
H	○	⊛	✽	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**VBGW160404-2**	0.4	0.08-0.50	0.05-0.20	○	○		
	VBGW160408-2	0.8	0.08-0.50	0.05-0.25	○	○		○

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

SVJBR/L	**SVABR/L**	**SVVBN**	**SVQBR/L**	**SVUBR/L**
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°
				
A240	A241	A242	A304	A305

System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

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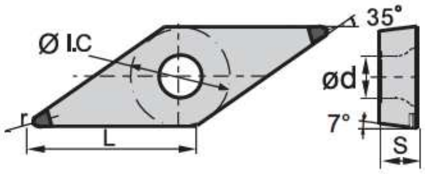
Turning CBN inserts

○ Ideal machining conditions
⊛ Normal machining conditions
❁ Unfavourable machining conditions

VCGW	L	I.C	S	d
16 04	16.6	9.525	4.76	4.4

VC** positive insert



	BL (CBN)			BH (CBN)
	YCB111	YCB121	YCB131	YCB211
P				
K				○
N				
H	○	⊛	❁	

	ISO	r	a_p	f	YCB111	YCB121	YCB131	YCB211
	**VCGW160404-2**	0.4	0.08-0.50	0.05-0.20	○	○		○
	VCGW160408-2	0.8	0.08-0.50	0.05-0.25	○	○		○

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

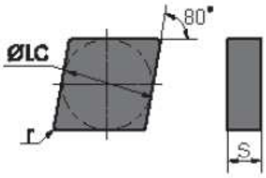
Tool holder		
SVVCN	**SVJCR/L**	**SVUCR/L**
Kr: 72°30'	Kr: 93°	Kr: 93°
		
A243	A244	A322

System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

Turning CBN inserts

🔵 Ideal machining conditions
⊕ Normal machining conditions
✱ Unfavourable machining conditions

CNGN	L	I.C	S
12 04	12.9	12.7	4.76

CN** negative insert		BL (CBN)	BH (CBN)	
	**P**			
	K		⊕	✱
	N			
	H	⊕		

	ISO	r	a_p	f	YZB121	YZB221	YZB231
 Medium Cut	**CNGN120404**	0.4	0.5-2.0	0.3-0.5		○	
	CNGN120408	0.8	0.5-2.0	0.3-0.5	○	○	○
	CNGN120412	1.2	0.5-2.0	0.3-0.5	○	○	○
	CNGN120416	1.6	0.5-2.0	0.3-0.5	○	○	○

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder
CCLNR/L
Kr: 95°

A258

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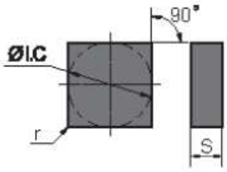
System code A40 Grade selection A146 Technical info A447 Cutting data A324

Turning CBN inserts

● Ideal machining conditions
⊛ Normal machining conditions
✺ Unfavourable machining conditions

SNGN	L	I.C	S
12 04	12.7	12.7	4.76
15 07	15.875	15.875	7.94



SN** negative insert	BL (CBN)	BH (CBN)	
	YZB121	YZB221	YZB231
P			
K		✺	✺
N			
H	⊛		

ISO	r	a_p	f	YZB121	YZB221	YZB231
SNGN120404	0.4	0.5-2.0	0.3-0.5		○	
SNGN120408	0.8	0.5-2.0	0.3-0.5	○	○	○
SNGN120412	1.2	0.5-2.0	0.3-0.5	○	○	○
SNGN120416	1.6	0.5-2.0	0.3-0.5	○	○	○
SNGN150716	1.6	0.5-2.0	0.3-0.5			○
SNGN150720	2	0.5-2.0	0.3-0.5			○

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder

CSKNR/L	CSRNR/L	CSDNN
Kr: 75°	Kr: 75°	Kr: 45°
		
A262	A263	A265

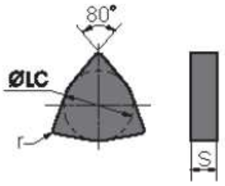
System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

Turning CBN inserts

○	Ideal machining conditions
⊛	Normal machining conditions
❃	Unfavourable machining conditions

WNGN	L	I.C	S
08 04	8.69	12.7	4.76

WN** negative insert



	BL (CBN)	BH (CBN)	
	YZB121	YZB221	YZB231
P			
K		⊛	❃
N			
H	⊛		

ISO	r	a_p	f	YZB121	YZB221	YZB231
WNGN080408	0.8	0.5-2.0	0.3-0.5	○	○	○
WNGN080412	1.2	0.5-2.0	0.3-0.5	○	○	○

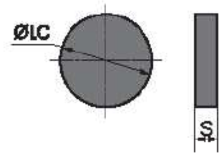
● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Turning CBN inserts

● Ideal machining conditions
⊛ Normal machining conditions
✿ Unfavourable machining conditions

RNGN	L	I.C	S
12 04	12.7	12.7	4.76
12 07	12.7	12.7	7.94

RN** negative insert		BL (CBN)	BH (CBN)	
	**P**			
	K		✿	✿
	N			
	H	⊛		

	ISO	a_p	f	YZB121	YZB221	YZB231
 Medium Cut	**RNGN120400**	0.5-2.0	0.3-0.5		○	○
	RNGN120700	0.5-2.0	0.3-0.5	○	○	○

● Ex stock ○ On demand

BL CBN with a low CBN content
BH CBN with a high CBN content

Tool holder
CRDNN

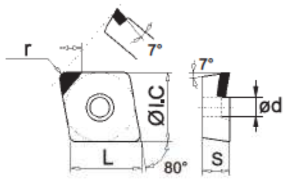
A264

System code › A40 Grade selection › A146 Technical info › A447 Cutting data › A324

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
12 04	12.9	12.7	4.76	5.56

○ Ideal machining conditions
◐ Normal machining conditions
● Unfavourable machining conditions

Turning PKD inserts

CC** positive insert		DP
	**P**	
	K	
	N	○
	H	

	ISO	r	a_p	f	YCD421
	**CCGT060202****	0.2	0.05-0.50	0.05-0.15	○
	CCGT060204**	0.4	0.08-0.50	0.05-0.20	●
	CCGT09T304**	0.4	0.08-0.50	0.05-0.20	○
	CCGT09T308**	0.8	0.08-0.50	0.05-0.25	○
	CCGT120404**	0.4	0.08-0.50	0.05-0.20	○
	CCGT120408**	0.8	0.08-0.50	0.05-0.25	○

● Ex stock ○ On demand DP Polycrystalline diamond

Tool holder

SCACR/L	**SCLCR/L**	**SCACR/L-SC**	**SCLCR/L-SC**	**SCLCR/L**	**SCFCR/L**	**SCLCR/L**
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A235	A236	A272	A273	A293	A310	A311

SCLCR/L
Kr: 95°

A313

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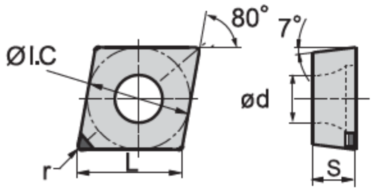
System code A40 Grade selection A146 Technical info A447 Cutting data A324

CCGW	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

◯ Ideal machining conditions
✪ Normal machining conditions
❁ Unfavourable machining conditions

Turning PKD inserts

CC** positive insert



	DP
P	
K	
N	◯
H	

	ISO	r	a_p	f	YCD421
	**CCGW060202****	0.2	0.08-0.50	0.05-0.15	○
	CCGW060204**	0.4	0.08-0.50	0.05-0.20	○
	CCGW09T304**	0.4	0.08-0.50	0.05-0.20	○
	CCGW09T308**	0.8	0.08-0.50	0.05-0.25	○
	CCGW120404**	0.4	0.08-0.50	0.05-0.20	○
	CCGW120408**	0.8	0.08-0.50	0.05-0.25	○

● Ex stock ○ On demand

DP Polycrystalline diamond

Tool holder

SCACR/L	**SCLCR/L**	**SCACR/L-SC**	**SCLCR/L-SC**	**SCLCR/L**	**SCFCR/L**	**SCLCR/L**
Kr: 90°	Kr: 95°	Kr: 90°	Kr: 95°	Kr: 95°	Kr: 90°	Kr: 95°
						
A235	A236	A272	A273	A293	A310	A311

SCLCR/L
Kr: 95°

A313

System code > A40
Grade selection > A146
Technical info > A447
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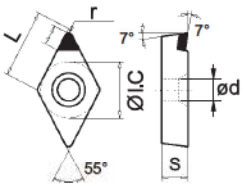
Turning PKD inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
❋ Unfavourable machining conditions

DCGT	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



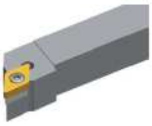
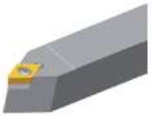
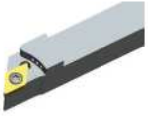
	DP
P	
K	
N	◯
H	

ISO		r	a_p	f	YCD421
	**DCGT070202****	0.2	0.08-0.50	0.05-0.15	○
	DCGT070204**	0.4	0.08-0.50	0.05-0.20	○
	DCGT11T304**	0.4	0.08-0.50	0.05-0.20	○
	DCGT11T308**	0.8	0.08-0.50	0.05-0.25	●

● Ex stock ○ On demand

DP Polycrystalline diamond

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'
						
A237	A238	A239	A274	A275	A276	A277

SDQCR/L	**SDUCR/L**	**SDZCR/L**	**SDQCR/L**
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

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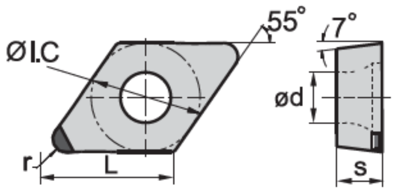
System code › A40 Grade selection › A146 Technical info › A447 Cutting data › A324

Turning PKD inserts

○ Ideal machining conditions
⊕ Normal machining conditions
✱ Unfavourable machining conditions

DCGW	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



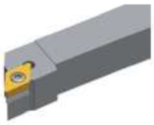
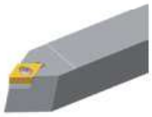
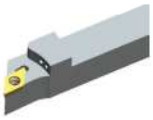
	DP
P	
K	
N	○
H	

	ISO	r	a_p	f	YCD421
	**DCGW070202****	0.2	0.08-0.50	0.05-0.15	○
	DCGW070204**	0.4	0.08-0.50	0.05-0.20	○
	DCGW070208**	0.8	0.08-0.50	0.05-0.25	○
	DCGW11T302**	0.2	0.08-0.50	0.05-0.15	○
	DCGW11T304**	0.4	0.08-0.50	0.05-0.20	○
	DCGW11T308**	0.8	0.08-0.50	0.05-0.25	○

● Ex stock ○ On demand

DP Polycrystalline diamond

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'
						
A237	A238	A239	A274	A275	A276	A277

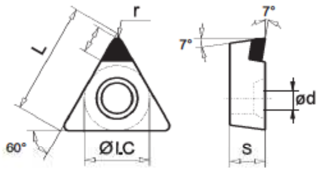
SDQCR/L	SDUCR/L	SDZCR/L	SDQCR/L
Kr: 107°30'	Kr: 93°	Kr: 85°	Kr: 107°30'
			
A295	A296	A297	A315

Turning PKD inserts

◯ Ideal machining conditions
⊕ Normal machining conditions
✲ Unfavourable machining conditions

TCGT	L	I.C	S	d
11 02	11	6.35	2.38	2.8
16 T3	16.5	9.525	3.97	4.4

TC** positive insert



	DP
P	
K	
N	◯
H	

	ISO	r	a_p	f	YCD421
	**TCGT110202****	0.2	0.08-0.50	0.05-0.15	○
	TCGT110204**	0.4	0.08-0.50	0.05-0.20	○
	TCGT110208**	0.8	0.08-0.50	0.05-0.25	○
	TCGT16T304**	0.4	0.08-0.50	0.05-0.20	○
	TCGT16T308**	0.8	0.08-0.50	0.05-0.25	○

● Ex stock ○ On demand DP Polycrystalline diamond

Tool holder

STACR/L	STFCR/L	STGCR/L	STTCR/L	STFCR/L	STFCR/L
Kr: 90°	Kr: 91°	Kr: 91°	Kr: 60°	Kr: 91°	Kr: 90°
					
A249	A250	A251	A252	A300	A319

A Turning
B Milling
C Drilling
D Technical Information
E Index

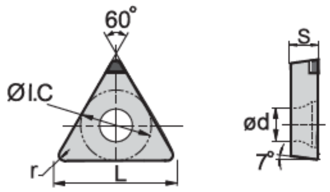
System code A40 Grade selection A146 Technical info A447 Cutting data A324

Turning PKD inserts

- ○ Ideal machining conditions
- ⊛ Normal machining conditions
- ❁ Unfavourable machining conditions

TCGW	L	I.C	S	d
11 02	11	6.35	2.38	2.8
16 T3	16.5	9.525	3.97	4.4

TC** positive insert



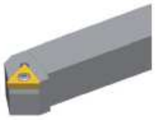
	DP
P	
K	
N	○
H	

	ISO	r	a_p	f	YCD421
	**TCGW110208****	0.8	0.08-0.50	0.05-0.25	○
	TCGW16T302**	0.2	0.08-0.50	0.05-0.15	○
	TCGW16T304**	0.4	0.08-0.50	0.05-0.20	○

● Ex stock ○ On demand

DP Polycrystalline diamond

Tool holder

STACR/L	STFCR/L	STGCR/L	STTCR/L	STFCR/L	STFCR/L
Kr: 90°	Kr: 91°	Kr: 91°	Kr: 60°	Kr: 91°	Kr: 90°
					
A249	A250	A251	A252	A300	A319

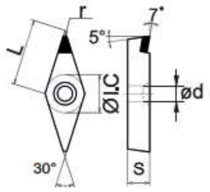
System code > A40
Grade selection > A146
Technical info > A447
Cutting data > A324

Turning PKD inserts

- ○ Ideal machining conditions
- ❂ Normal machining conditions
- ✺ Unfavourable machining conditions

VBGT	L	I.C	S	d
16 04	16.6	9.525	4.76	4.4

VB** positive insert



	DP
P	
K	
N	○
H	

ISO		r	a_p	f	YCD421
	**VBGT160402****	0.2	0.08-0.50	0.05-0.15	○
	VBGT160404**	0.4	0.08-0.50	0.05-0.20	○
	VBGT160408**	0.8	0.08-0.50	0.05-0.25	○

● Ex stock ○ On demand

DP Polycrystalline diamond

Tool holder

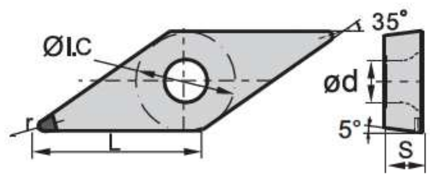
SVJBR/L	SVABR/L	SVVBN	SVQBR/L	SVUBR/L
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°
				
A240	A241	A242	A304	A305

System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

Turning PKD inserts

◯ Ideal machining conditions
◎ Normal machining conditions
✻ Unfavourable machining conditions

VBGW	L	I.C	S	d
16 04	16.6	9.525	4.76	4.4



VB** positive insert		DP
	P	
	K	
	N	◯
	H	

	ISO	r	a_p	f	YCD421
	**VBGW160404****	0.4	0.08-0.50	0.05-0.20	○
	VBGW160408**	0.8	0.08-0.50	0.05-0.25	○

● Ex stock ○ On demand

DP Polycrystalline diamond

Tool holder

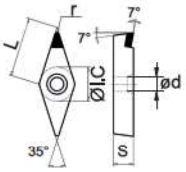
SVJBR/L	**SVABR/L**	**SVVBN**	**SVQBR/L**	**SVUBR/L**
Kr: 93°	Kr: 90°	Kr: 72°30'	Kr: 107°30'	Kr: 93°
				
A240	A241	A242	A304	A305

System code > A40 Grade selection > A146 Technical info > A447 Cutting data > A324

◯ Ideal machining conditions
❂ Normal machining conditions
✺ Unfavourable machining conditions

VCGT	L	I.C	S	d
16 04	16.6	9.525	4.76	4.4

Turning PKD inserts



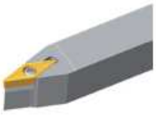
VC** positive insert	DP
P	
K	
N	◯
H	

	ISO	r	a_p	f	YCD421
	**VCGT160402****	0.2	0.08-0.50	0.05-0.15	○
	VCGT160404**	0.4	0.08-0.50	0.05-0.20	○
	VCGT160408**	0.8	0.08-0.50	0.05-0.25	○

● Ex stock ○ On demand

DP Polycrystalline diamond

Tool holder

SVVCN	**SVJCR/L**	**SVUCR/L**
Kr: 72°30'	Kr: 93°	Kr: 93°
		
A243	A244	A322

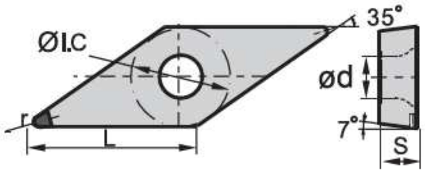
System code > A40
Grade selection > A146
Technical info > A447
Cutting data > A324

Turning PKD inserts

- ◯ Ideal machining conditions
- ⊕ Normal machining conditions
- ✻ Unfavourable machining conditions

VCGW	L	I.C	S	d
16 04	16.6	9.525	4.76	4.4

VC** positive insert



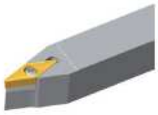
	DP
P	
K	
N	◯
H	

	ISO	r	a_p	f	YCD421
	**VCGW160404****	0.4	0.08-0.50	0.05-0.20	○
	VCGW160408**	0.8	0.08-0.50	0.05-0.25	○

● Ex stock ○ On demand

DP Polycrystalline diamond

Tool holder

SVVCN	**SVJCR/L**	**SVUCR/L**
Kr: 72°30'	Kr: 93°	Kr: 93°
		
A243	A244	A322

Trouble shooting – PCBN & PCD

Type of wear	Countermeasure	
	Geometry	Cutting condition
Flank wear	– Sharper cutting edge for reduced cutting force – Smaller negative chamfer – Use positive inserts	– Reduce cutting speed – Increase feed rate to reduce operation time
Notch wear	– Bigger radius	– Use "method of altering feed rate"
Crater wear/breakage due to crater wear	– Sharper cutting edge for reduced cutting force	– Reduce cutting speed – Increase feed rate to minimise operation time and to increase distance between cutting edge and crater
Chipping due to rough condition or vibration	– Bigger negative chamfer angle and/or honed chamfer	– Increase feed rate to reduce number of hits
Flaking	– Sharper cutting edge to reduce cutting force – Smaller negative chamfer – Use positive inserts	– Increase feed rate to reduce operation time
Thermal crack/breakage	– Sharper cutting edge for reduced cutting force – Smaller negative chamfer – Use positive inserts	– Reduce cutting speed, feed rate and depth of cut – Dry machining
Chipping	– Bigger negative chamfer	– Increase cutting speed to reduce cutting force

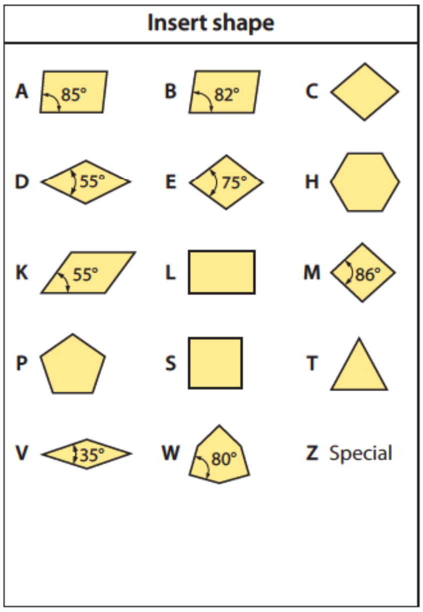
For investigation please send us the used inserts. If breakage is the problem please use inserts only 80–90 % of expected tool life because broken inserts almost have no information.

General turning

ISO code – ceramic inserts

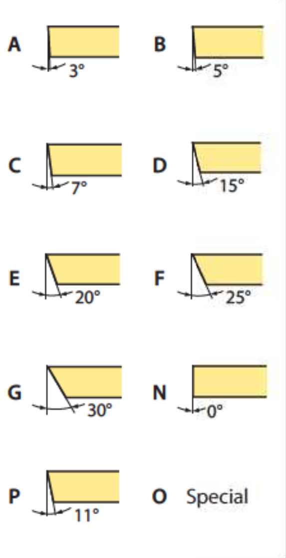
T	N	G	A	12	04	08	T	020	20
1	2	3	4	5	6	7	8	9	10

Insert shape



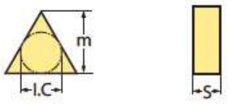
1

Clearance angle



2

Tolerance class

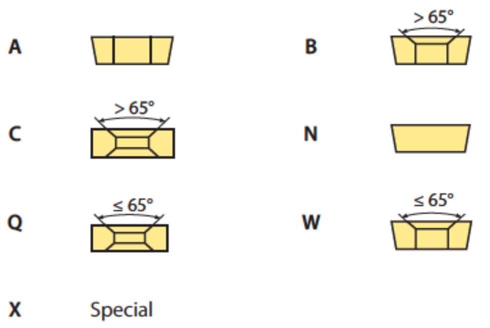


Code	I.C [mm]	m [mm]	S [mm]
A	±0,025	±0,005	±0,025
C	±0,025	±0,013	±0,025
E	±0,025	±0,025	±0,025
F	±0,013	±0,005	±0,025
G	±0,025	±0,025	±0,130
H	±0,013	±0,013	±0,025
J	±0,05–0,15	±0,005	±0,025
K	±0,05–0,15	±0,013	±0,025
L	±0,05–0,15	±0,025	±0,025
M	±0,05–0,15	±0,08–0,20	±0,130
N	±0,05–0,15	±0,08–0,20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

3

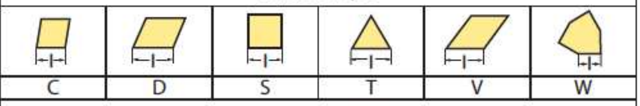
Fastening features (metric)

Insert shape



4

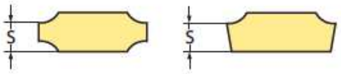
Cutting edge length l [mm]



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

5

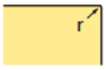
Insert thickness S [mm]



Code	S	Code	S
02	2,38	**06**	6,35
T2	2,58	**T6**	6,75
03	3,18	**07**	7,94
T3	3,97	**09**	9,52
04	4,76	**T9**	9,72
T4	4,96	**11**	11,11
05	5,56	**12**	12,70
T5	5,95		

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	Plaquettes rondes

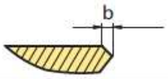
7

Cutting edge profile

Code	Cutting edge	Insert shape
E	Rounding	
F	Sharp edge	
T	Chamfer	
S	Chamfer + Rounding	

8

Chamfer width b [mm]



Code	b
010	0,10
015	0,15
020	0,20
025	0,25
030	0,30
035	0,35
040	0,40
045	0,45
050	0,50
100	1,00
200	2,00

9

Angle du chanfrein α

Code	α
05	5°
10	10°
15	15°
20	20°
25	25°
30	30°

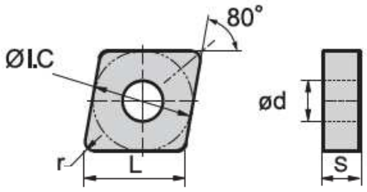
10

Turning ceramic inserts

○ Ideal machining conditions
◍ Normal machining conditions
❋ Unfavourable machining conditions

CNGA	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



	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	◍
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
	**CNGA120404T02020**	0.4	0.5-2.0	0.15-0.40		●	
	CNGA120408T02020	0.8	0.5-5.0	0.2-0.6	●	○	
	CNGA120412T02020	1.2	1-4	0.2-0.6		●	
	CNGA120412T03020	1.2	0.5-2.0	0.15-0.40		○	
	CNGA160612T02020	1.2	2-5	0.15-0.40		●	
	CNGA160616T02020	1.6	2-5	0.15-0.40		●	

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder	
MCBNR/L	**MCLNR/L**
Kr: 75°	Kr: 95°
	
A218	A219

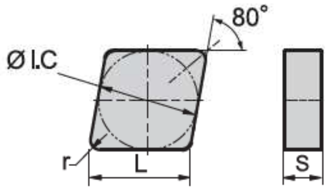
System code A40 Grade selection A174 Technical info A447 Cutting data A324

CNGN	L	I.C	S
12 04	12.9	12.7	4.76
12 07	12.9	12.7	7.94
16 04	16.1	15.875	4.76
16 06	16.1	15.875	6.35

Turning ceramic inserts

◯ Ideal machining conditions
❁ Normal machining conditions
❋ Unfavourable machining conditions

CN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	◯		
K	◯	◯	❁
N			
H			

ISO	r	a_p	f	CM CA1000	CN CN1000	CN CN2000
CNGN120404T02020	0.4	0.5-4.0	0.15-0.50	○		
CNGN120408T02020	0.8	1-5	0.2-0.6	●	●	●
CNGN120412T02020	1.2	1-4	0.2-0.6	○	●	●
CNGN120708T02020	0.8	0.5-2.0	0.2-0.5	○	●	●
CNGN120712T02020	1.2	1-4	0.2-0.6	●	○	○
CNGN120716T02020	1.6	0.5-2.0	0.2-0.6	○	○	○
CNGN160408T02020	0.8	0.5-2.0	0.2-0.5	○		
CNGN160612T02020	1.2	0.5-4.0	0.15-0.60	○	○	
CNGN160616T02020	1.6	2-5	0.2-0.6	○	○	

● Ex stock ○ On demand

CM	Mixed ceramic
CN	Si3N4 Ceramic

Tool holder
CCLNR/L
Kr: 95°

A258

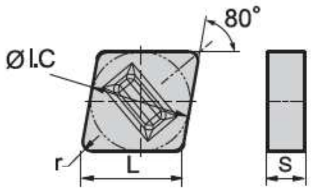
A Turning
B Milling
C Drilling
D Technical Information
E Index

Turning ceramic inserts

○ Ideal machining conditions
◍ Normal machining conditions
✲ Unfavourable machining conditions

CNGX	L	I.C	S
12 07	12.9	12.7	7.94

CN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	◍
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
 Medium Cut	**CNGX120712T02020**	1.2	1-4	0.2-0.6		●	
	CNGX120716T02020	1.6	0.5-2.0	0.2-0.6		○	

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder
JCLNR/L
Kr: 95°

A266

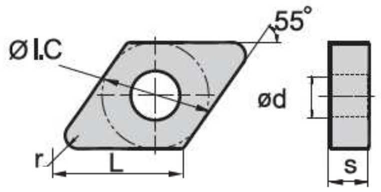
System code > A40 Grade selection > A174 Technical info > A447 Cutting data > A324

Turning ceramic inserts

◯ Ideal machining conditions
◍ Normal machining conditions
❃ Unfavourable machining conditions

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

DN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	◯		
K	◯	◯	◍
N			
H			

ISO	r	a_p	f	CA1000	CN1000	CN2000
DNGA150604T02020	0.4	0.5-2.0	0.15-0.40		○	
DNGA150608T02020	0.8	0.5-2.0	0.2-0.5		●	
DNGA150612T02020	1.2	1-4	0.2-0.6		○	
DNGA150616T02020	1.6	2-5	0.2-0.6		○	

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder

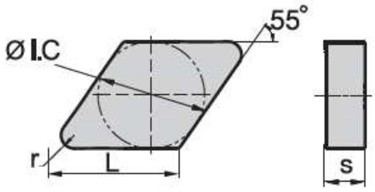
MDJNR/L	MDPNN
Kr: 93°	Kr: 62°30'
	
A220	A221

Turning ceramic inserts

- ○ Ideal machining conditions
- ⊛ Normal machining conditions
- ✺ Unfavourable machining conditions

DNGN	L	I.C	S
15 04	15.5	12.7	4.76
15 07	15.5	12.7	7.94

DN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	⊛
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
 Medium Cut	**DNGN150408T02020**	0.8	0.5-2.0	0.2-0.5	○		
	DNGN150412T02020	1.2	1-4	0.2-0.6	○		
	DNGN150704T02020	0.4	0.5-2.0	0.15-0.40	○	○	○
	DNGN150708T02020	0.8	0.5-2.0	0.2-0.5	●	○	○
	DNGN150712T02020	1.2	0.5-4.0	0.15-0.60	○	○	○
	DNGN150716T02020	1.6	2-5	0.2-0.6	○		

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder
CDJNR/L
Kr: 93°

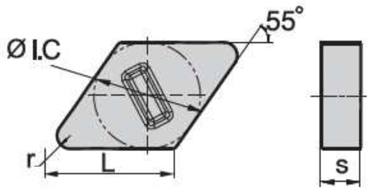
A260

Turning ceramic inserts

○ Ideal machining conditions
⊛ Normal machining conditions
✻ Unfavourable machining conditions

DNGX	L	I.C	S
15 07	15.5	12.7	7.94

DN** negative insert



	CM	CN	
P	○		
K	○	○	⊛
N			
H			

Medium Cut

ISO	r	a_p	f	CA1000	CN1000	CN2000
DNGX150712T02020	1.2	1-4	0.2-0.6		○	
DNGX150716T02020	1.6	2-5	0.2-0.6		○	

● Ex stock ○ On demand

CM	Mixed ceramic
CN	Si3N4 Ceramic

Tool holder
JDJNR/L
Kr: 93°

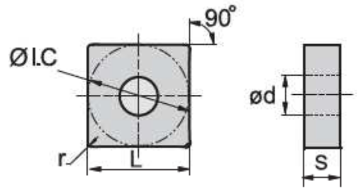
A267

Turning ceramic inserts

- ○ Ideal machining conditions
- ⊛ Normal machining conditions
- ✻ Unfavourable machining conditions

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

SN** negative insert



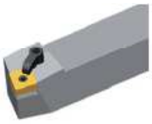
	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	⊛
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
	**SNGA120408T02020**	0.8	0.5-2.0	0.2-0.5		○	
	SNGA120412T02020	1.2	1-4	0.2-0.6		○	

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder

MSBNR/L	**MSRNR/L**	**MSKNR/L**	**MSDNN**
Kr: 75°	Kr: 75°	Kr: 75°	Kr: 45°
			
A222	A223	A224	A225

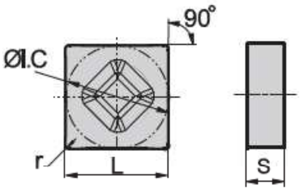
System code > A40 Grade selection > A174 Technical info > A447 Cutting data > A324

Turning ceramic inserts

- ○ Ideal machining conditions
- ❂ Normal machining conditions
- ✽ Unfavourable machining conditions

SNGX	L	I.C	S
12 07	12.7	12.7	7.94

SN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	❂
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
 Medium Cut	**SNGX120712T02020**	1.2	1-4	0.2-0.6		○	
	SNGX120716T02020	1.6	0.5-2.0	0.2-0.6		○	

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder
JSDNN
Kr: 45°

A268

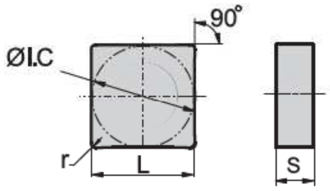
A
Turning
B
Milling
C
Drilling
D
Technical Information
E
Index

Turning ceramic inserts

○ Ideal machining conditions
⊛ Normal machining conditions
❋ Unfavourable machining conditions

SNGN	L	I.C	S
12 04	12.7	12.7	4.76
12 07	12.7	12.7	7.94
15 07	15.875	15.875	7.94
19 07	19.05	19.05	7.94

SN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	⊛
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
	**SNGN120404T02020**	0.4	0.5-2.0	0.15-0.40	○		
	SNGN120408T02020	0.8	0.5-2.0	0.2-0.5	○	●	
	SNGN120412T02020	1.2	1-4	0.2-0.6	○	○	○
	SNGN120416T02020	1.6	0.5-5.0	0.2-0.6	○	○	○
	SNGN120704T02020	0.4	0.5-2.0	0.15-0.40	●		
	SNGN120708T02020	0.8	0.5-4.0	0.2-0.6	○	○	
	SNGN120712T02020	1.2	1-5	0.2-0.6	○	●	
	SNGN120716T02020	1.6	1-5	0.2-0.6	○		○
	SNGN150708T02020	0.8	0.5-2.0	0.2-0.5	○		
	SNGN150712T02020	1.2	1-4	0.2-0.6	●	○	○
	SNGN150716T02020	1.6	0.5-2.0	0.2-0.6	●	○	○
	SNGN190716T03020	1.6	2-5	0.2-0.6	○		

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder

CSKNR/L	CSRNR/L	CSDNN
Kr: 75°	Kr: 75°	Kr: 45°
		
A262	A263	A265

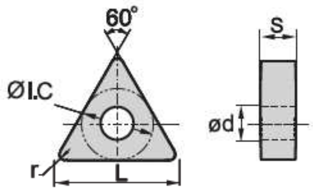
System code > A40 Grade selection > A174 Technical info > A447 Cutting data > A324

Turning ceramic inserts

○ Ideal machining conditions
⊕ Normal machining conditions
✳ Unfavourable machining conditions

TNGA	L	I.C	S	d
16 04	16.5	9.525	4.76	3.86
22 04	22	12.7	4.76	5.16

TN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	⊕
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
	**TNGA160404T01020**	0.4	2-5	0.15-0.40		●	
	TNGA160408T02020	0.8	2-5	0.2-0.5		●	
	TNGA160412T02020	1.2	1-4	0.2-0.6		●	
	TNGA220408T02020	0.8	2-5	0.2-0.5		○	
	TNGA220412T02020	1.2	2-5	0.2-0.6		○	
	TNGA220416T02020	1.6	2-5	0.2-0.6		○	

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder

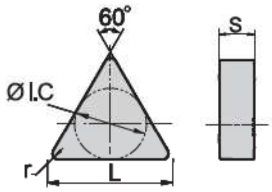
MTGNR/L	**MTJNR/L**	**MTJNR/L-Z**	**MTFNR/L**
Kr: 90°	Kr: 93°	Kr: 93°	Kr: 91°
			
A226	A227	A228	A229

Turning ceramic inserts

◯ Ideal machining conditions
⊛ Normal machining conditions
✺ Unfavourable machining conditions

TNGN	L	I.C	S
16 04	16.5	9.525	4.76
16 07	16.5	9.525	7.94
22 04	22	12.7	4.76

TN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	◯		
K	◯	◯	⊛
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
 Medium Cut	**TNGN160404T02020**	0.4	0.5-4.0	0.15-0.50	○		
	TNGN160408T02020	0.8	0.5-5.0	0.2-0.6	○	○	
	TNGN160412T02020	1.2	1-5	0.2-0.6	○	○	○
	TNGN160708T02020	0.8	0.5-2.0	0.2-0.5		○	○
	TNGN160712T02020	1.2	1-4	0.2-0.6	○		
	TNGN220408T02020	0.8	0.5-2.0	0.2-0.5	○	○	
	TNGN220412T02020	1.2	1-4	0.2-0.6	○	○	
	TNGN220416T02020	1.6	2-5	0.2-0.6	○	○	

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

Tool holder

CTJNR/L	CTUNR/L
Kr: 93°	Kr: 93°
	
A259	A261

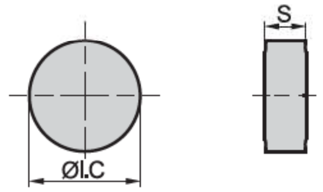
System code A40 Grade selection A174 Technical info A447 Cutting data A324

RNGN	I.C	S
09 04	9.53	4.76
12 04	12.7	4.76
12 07	12.7	7.94
15 07	15.875	7.94
19 07	19.05	7.94
25 10	25.4	10.05

Turning ceramic inserts

- ○ Ideal machining conditions
- ⊛ Normal machining conditions
- ❃ Unfavourable machining conditions

RN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	⊛
N			
H			

	ISO	a_p	f	CA1000	CN1000	CN2000
	**RNGN090400T02020**	0.5-2.0	0.2-0.5	○		
	RNGN120400T02020	0.5-2.0	0.2-0.5	○	○	●
	RNGN120700T02020	0.5-2.0	0.2-0.5	●	●	●
	RNGN150700T02020	0.5-2.0	0.2-0.5	○		
	RNGN190700T03020	0.5-2.0	0.2-0.5	○		●
	RNGN251000T05020	0.5-2.0	0.2-0.5	○		

● Ex stock ○ On demand

CM	Mixed ceramic
CN	Si3N4 Ceramic

Tool holder
CRDNN

A264

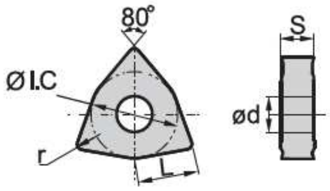
System code > A40 Grade selection > A174 Technical info > A447 Cutting data > A324

Turning ceramic inserts

○ Ideal machining conditions
⊛ Normal machining conditions
❋ Unfavourable machining conditions

WNGA	L	I.C	S	d
08 04	8.69	12.7	4.76	5.16

WN** negative insert



	CM	CN	
	CA1000	CN1000	CN2000
P	○		
K	○	○	⊛
N			
H			

	ISO	r	a_p	f	CA1000	CN1000	CN2000
	**WNGA080408T02020**	0.8	0.5-2.0	0.2-0.5		●	
	WNGA080412T02020	1.2	2-5	0.2-0.6		●	
	WNGA080416T02020	1.6	2-5	0.2-0.6		●	

● Ex stock ○ On demand

CM Mixed ceramic
CN Si3N4 Ceramic

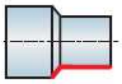
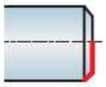
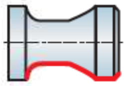
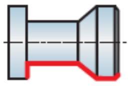
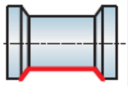
Tool holder
MWLNR/L
Kr: 95°

A232

System code > A40 Grade selection > A174 Technical info > A447 Cutting data > A324

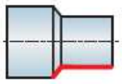
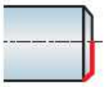
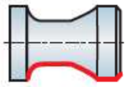
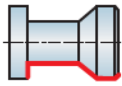
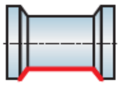
Notes

External turning tool holders

Tool holder			Application					Workpiece		Page
			External machining	Facing	Profiling	Profiling	Profiling	Stable	Unstable	
										
D	**DCLNR/L** **95°**		●	●				●		A197
	DDJNR/L **93°**				●	●	●	●	●	A198
	DSBNR/L **75°**		●					●		A199
	DTGNR/L **91°**		●					●		A200
	DVVNN **72.5°**						●	●		A201
	DVJNR/L **93°**				●	●		●	●	A202
	DWLNR/L **95°**		●	●				●		A203
P	**PCBNR/ L** **75°**		●					●		A204
	PCLNR/ L **95°**		●	●				●		A205
	PDJNR/ L **93°**				●	●	●	●	●	A206
	PDNNR/ L **63°**						●	●		A207
	PSBNR/ L **75°**		●					●		A208
	PSDNN **45°**		●				●	●		A210
	PSKNR/ L **75°**			●				●		A211
	PSSNR/ L **45°**		●	●				●		A212

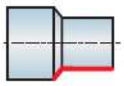
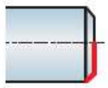
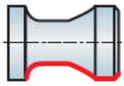
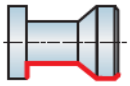
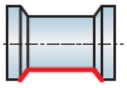
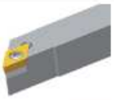
● Recommended

External turning tool holders

	Tool holder	Application					Workpiece		Page
		External machining	Facing	Profiling	Profiling	Profiling	Stable	Unstable	
									
P	**PTFNR/L** **91°** 		●				●		A213
	PTTNR/L **60°** 	●					●		A214
	PTGNR/L **90°** 	●					●		A215
	PWLNR/L **95°** 	●	●				●		A217
M	**MCBNR/L** **75°** 	●					●		A218
	MCLNR/L **95°** 	●	●				●		A219
	MDJNR/L **93°** 			●	●	●	●	●	A220
	MDPNN **62.5°** 					●	●		A221
	MSBNR/L **75°** 	●					●		A222
	MSRNR/L **75°** 	●					●		A223
	MSKNR/L **75°** 		●				●		A224
	MSDNN **45°** 					●	●		A225
	MTGNR/L **90°** 	●					●		A226
	MTJNR/L **93°** 	●					●		A227
	MTJNR/L-Z **93°** 		●		●		●		A228

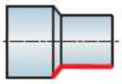
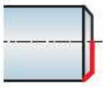
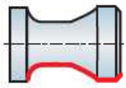
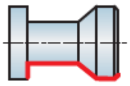
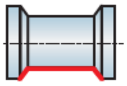
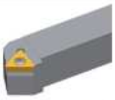
● Recommended

External turning tool holders

	Tool holder	Application					Workpiece		Page
		External machining	Facing	Profiling	Profiling	Profiling	Stable	Unstable	
									
M	**MTFNR/L** **91°** 		●				●		A229
	MVVNN **72,5°** 					●	●		A230
	MVJNR/L **93°** 			●	●		●	●	A231
	MWLNR/L **95°** 	●	●				●		A232
	MRGNR/L **-** 			●			●		A234
	MRDNN **-** 					●	●		A233
S	**SCACR/L** **90°** 	●					●	●	A235
	SCLCR/L **95°** 	●	●				●	●	A236
	SDACR/L **90°** 				●		●	●	A237
	SDJCR/L **93°** 	●			●		●	●	A238
	SDNCN **63°** 					●	●	●	A239
	SVJBR/L **93°** 	●			●		●	●	A240
	SVABR/L **90°** 	●			●		●	●	A241
	SVVBN **72,5°** 					●	●	●	A242
	SVVCN **72,5°** 					●	●	●	A243

● Recommended

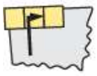
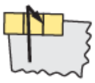
External turning tool holders

Tool holder		Application					Workpiece		Page
		External machining	Facing	Profiling	Profiling	Profiling	Stable	Unstable	
									
S	**SVJCR/L** **93°** 	●			●		●	●	A244
	SSBCR/L **75°** 	●					●		A245
	SSDCN **45°** 					●	●		A246
	SSKCR/L **75°** 		●				●		A247
	SSSCR/L **45°** 	●					●		A248
	STACR/L **90°** 	●					●	●	A249
	STFCR/L **91°** 		●				●		A250
	STGCR/L **91°** 	●					●	●	A251
	STTCR/L **60°** 	●					●		A252
	SWACR/L **90°** 	●					●	●	A253
	SRDCN **-** 					●	●		A254
	SRGCR/L **-** 			●			●		A255
C	**CKJNR/L** **93°** 	●			●		●		A256
	CKNNR/L **63°** 					●	●		A257

● Recommended

P	C	L	N	L	25	25	M	12
1	2	3	4	5	6	7	8	9

Clamping system

Code	Description	
P	Système de serrage à levier	
M	Serrage à bride et levier	
S	Système de serrage à vis	
C/J	Serrage par bride	
D	Serrage double	

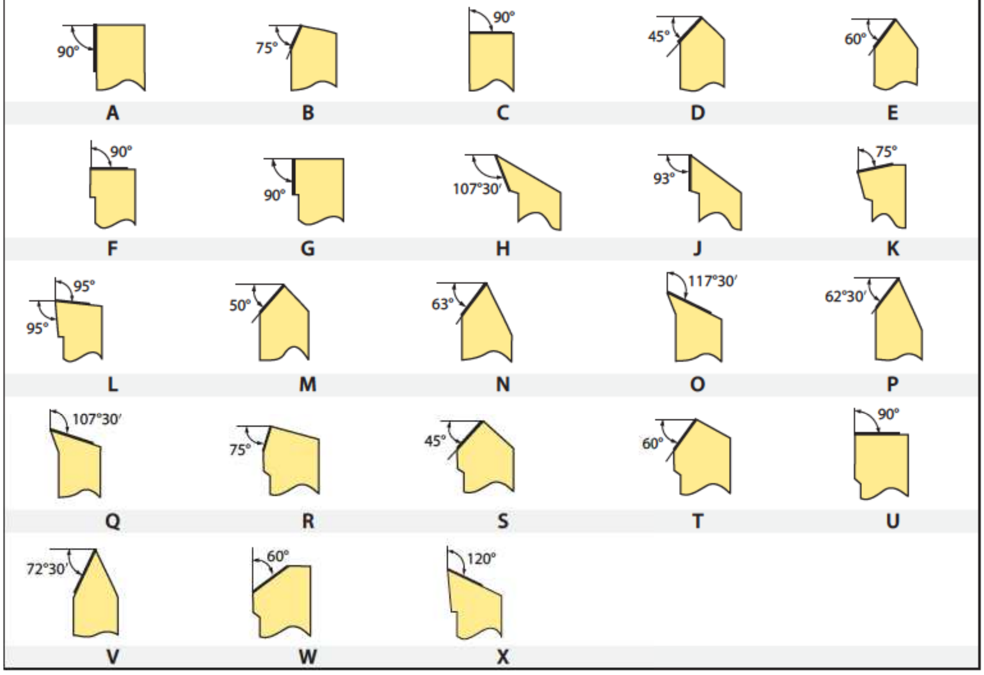
1

Insert shape

C	
D	
R	
S	
T	
V	
W	

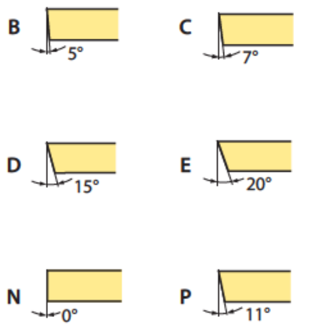
2

Tool holder type and entering angle



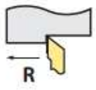
3

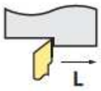
Clearance angle

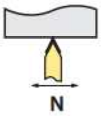


4

Cutting direction

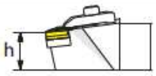






5

Shank height h [mm]



Code	h
12	12
16	16
20	20
25	25
32	32
40	40
50	50

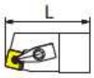
6

Shank width b [mm]

Code	b
12	12
16	16
20	20
25	25
32	32
40	40
50	50

7

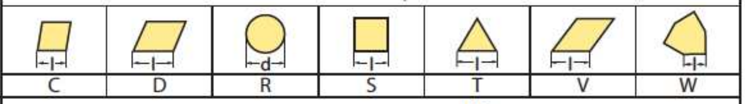
Holder length L [mm]



Code	L
H	100
K	125
M	150
P	170
Q	180
R	200
S	250
T	300

8

Cutting edge length l [mm]



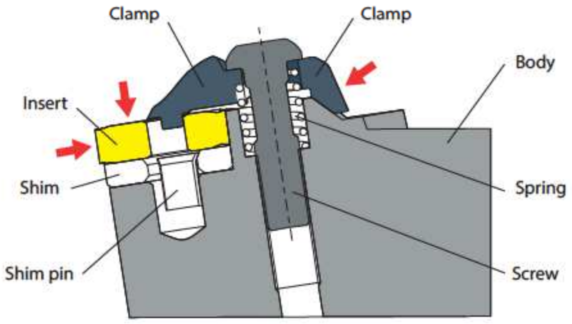
I.C [mm]	Insert shape						
	C	D	R	S	T	V	W
5,56					**09**		
6,35	**06**	**07**			**11**		
9,525	**09**	**11**	**09**	**09**	**16**	**16**	**06**
12,7	**12**	**15**	**12**	**12**	**22**	**22**	**08**
15,875	**16**	**19**	**15**	**15**	**27**		
19,05	**19**		**19**	**19**	**33**		
25,4	**25**		**25**	**25**	**44**		
32			**32**				

9

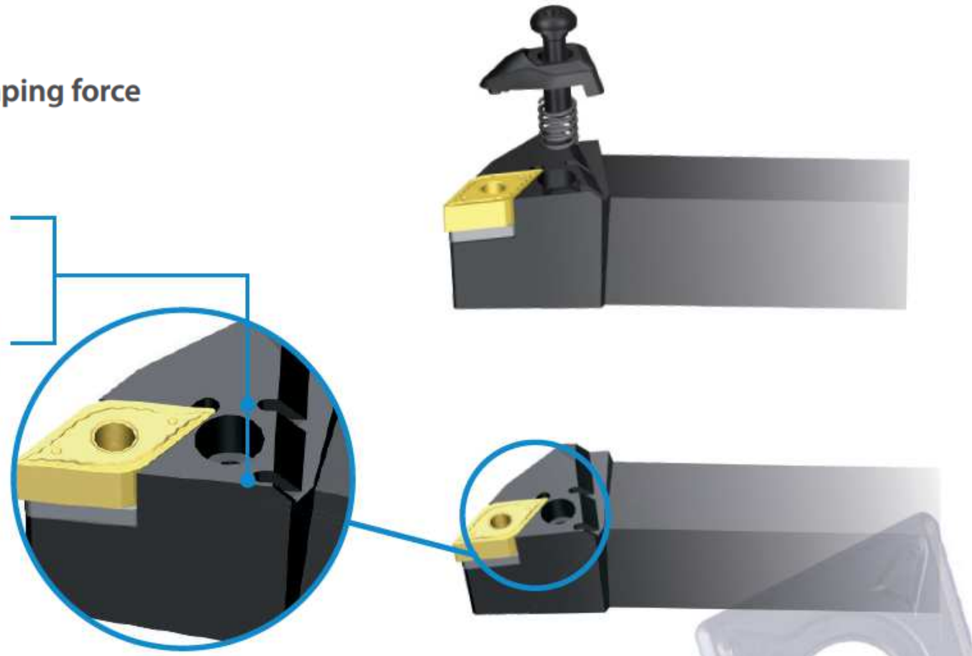
Double clamping tool holder

D-Type clamp tool holder

Double clamping system in one operation. The special designed clamping finger enables a stable holding of the inserts, with high accuracy and clamping force for better tool life and higher machining accuracy.



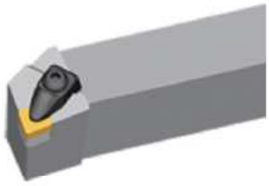
Best indexing accuracy, high clamping force

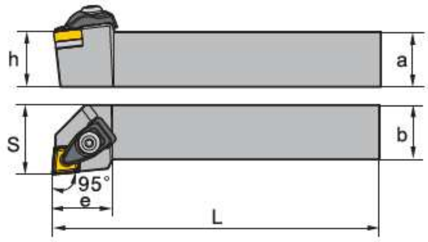


Special clamp nose design for more stability and high clamping accuracy

CN** holder (external) D-Clamping

DCLNR/L Kr: 95°





Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
DCLNR/L1616H09		●	○	16	16	100	16	20	24	CN**0903**
DCLNR/L2020K09		●	●	20	20	125	20	25	24	CN**0903**
DCLNR/L2525M09		●	●	25	25	150	25	32	24	CN**0903**
DCLNR/L2020K12		●	●	20	20	125	20	25	28	CN**1204**
DCLNR/L2525M12		●	●	25	25	150	25	32	28	CN**1204**
DCLNR/L3225P12		●	●	32	25	170	32	32	28	CN**1204**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**CN**0903****	**CN**1204****
	h	**16-25**	**20-32**
	Clamp	C1RA	C2RA
	Screw (clamp)	CM5x22C (4.0 Nm)	CM6x25C (7.0 Nm)
	Screw (shim)	SM5x8.65XA1	SM6×10XA1
	Shim	C09BM	C12BM
	Spring	SPR6	SPR4
	Wrench (shim)	WH30L	WH40L
	Wrench (clamp)	WH30L	WH40L

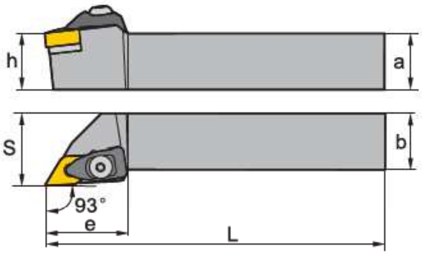
Insert

Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A45	A45	A46	A53	A53	A148

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

DN** holder (external) D-Clamping

DDJNR/L Kr: 93°



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
DDJNR/L1616H11		●	●	16	16	100	16	20	30	DN**1104**
DDJNR/L2020K11		●	●	20	20	125	20	25	30	DN**1104**
DDJNR/L2525M11		●	●	25	25	150	25	32	30	DN**1104**
DDJNR/L3225P11		○	○	32	25	170	32	32	30	DN**1104**
DDJNR/L2020K15		●	●	20	20	125	20	25	35	DN**1506**
DDJNR/L2525M15		●	●	25	25	150	25	32	35	DN**1506**
DDJNR/L3232P15		●	●	32	32	170	32	40	35	DN**1506**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DN**1104****	**DN**1506****
	h	**16-32**	**20-32**
	Clamp	C1RA	C2RA
	Screw (clamp)	CM5x22C (4.0 Nm)	CM6x25C (7.0 Nm)
	Screw (shim)	SM5x8.65XA1	SM6×10XA1
	Shim	D11BM	D15BM
	Spring	SPR6	SPR4
	Wrench (shim)	WH30L	WH40L
	Wrench (clamp)	WH30L	WH40L

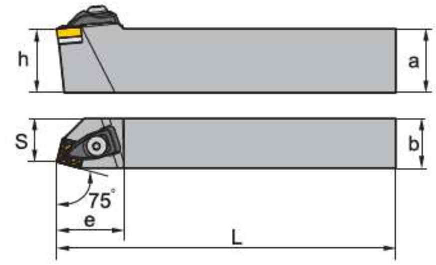
Insert

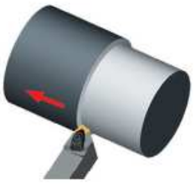
					
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A55	A55	A56	A60	A61	A149

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

SN** holder (external) D-Clamping

DSBNR/L Kr: 75°





Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
DSBNR/L1616H09		○	○	16	16	100	16	13	26	SN**0903**
DSBNR/L2020K12		●	●	20	20	125	20	17	34	SN**1204**
DSBNR/L2525M12		●	●	25	25	150	25	22	34	SN**1204**
DSBNR/L3225P12		●	●	32	25	170	32	22	34	SN**1204**
DSBNR/L3232P15		●	●	32	32	170	32	27	41	SN**1506**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SN**0903****	**SN**1204****	**SN**1506****
	h	**16**	**20-32**	**32**
	Clamp	C1RA	C2RA	C3RA
	Screw (clamp)	CM5x22C (4.0 Nm)	CM6x25C (7.0 Nm)	CM6x25C (7.0 Nm)
	Screw (shim)	SM5x8.65XA1	SM6×10XA1	SM6×10XA2
	Shim	S09BM	S12BM	S15BM
	Spring	SPR6	SPR4	SPR4
	Wrench (shim)	WH30L	WH40L	WH40L
	Wrench (clamp)	WH30L	WH40L	WH40L

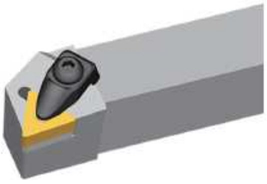
Insert

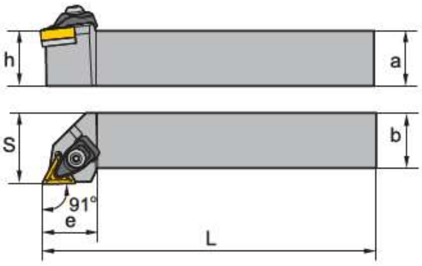
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A63	A65	A68	A74	A150

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

TN** holder (external) D-Clamping

DTGNR/L Kr: 91°





Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
DTGNR/L1616H16		●	●	16	16	100	16	20	25	TN**1604**
DTGNR/L2020K16		●	●	20	20	125	20	25	25	TN**1604**
DTGNR/L2525M16		●	●	25	25	150	25	32	25	TN**1604**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**TN**1604****
	h	**16-25**
	Clamp	C1RA
	Screw (clamp)	CM5x22C (4.0 Nm)
	Screw (shim)	SM5x8.65XA1
	Shim	T16BM
	Spring	SPR6
	Wrench (shim)	WH30L
	Wrench (clamp)	WH30L

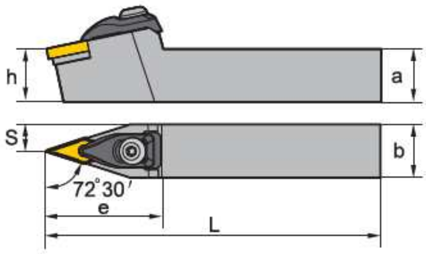
Insert

 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A78	A79	A81	A84	A88	A151

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

VN** holder (external) **D-Clamping**

DVVNN Kr: 72°30'



Article	✲	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
DVVNN2020K16		●	20	20	125	20	10	44	VN**1604**
DVVNN2525M16		●	25	25	150	25	12.5	44	VN**1604**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VN**1604****
	h	**20-25**
	Clamp	C6RA
	Screw (clamp)	CM5×22C (4.0 Nm)
	Screw (shim)	SM5x8.65XA1
	Shim	V16BM
	Spring	SPR6
	Wrench (shim)	WH30L
	Wrench (clamp)	WH30L

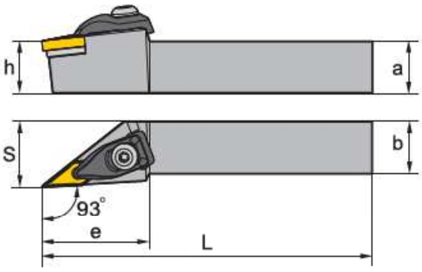
Insert

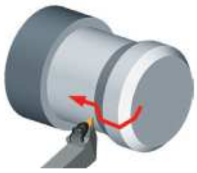
Finishing	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A91	A93	A93	A92	A152

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

VN** holder (external) D-Clamping

DVJNR/L Kr: 93°





Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
DVJNR/L2020K16		●	●	20	20	125	20	25	41	VN**1604**
DVJNR/L2525M16		●	●	25	25	150	25	32	41	VN**1604**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts		
	Insert	**VN**1604****
	h	**20-25**
	Clamp	C6RA
	Screw (clamp)	CM5x22C (4.0 Nm)
	Screw (shim)	SM5x8.65XA1
	Shim	V16BM
	Spring	SPR6
	Wrench (clamp)	WH30L
	Wrench (shim)	WH30L

Insert

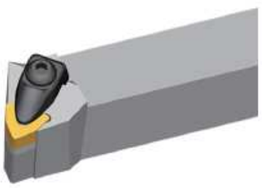
				
Finishing	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A91	A93	A93	A92	A152

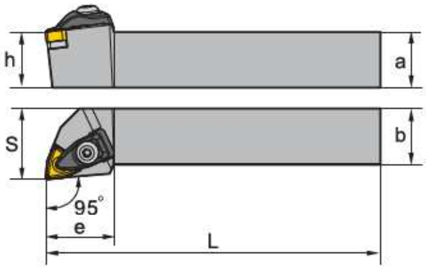
System code › A194 Grade selection › A40 Technical info › A447 Cutting data › A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

WN** holder (external) D-Clamping

DWLNR/L Kr: 95°





Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
DWLNR/L1616H06		●	●	16	16	100	16	25	24	WN**0604**
DWLNR/L2020K06		●	●	20	20	125	20	25	24	WN**0604**
DWLNR/L2525M06		●	●	25	25	150	25	32	24	WN**0604**
DWLNR/L2020K08		●	●	20	20	125	20	25	31	WN**0804**
DWLNR/L2525M08		●	●	25	25	150	25	32	31	WN**0804**
DWLNR/L3225P08		●	●	32	25	170	32	32	31	WN**0804**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**WN**0604****	**WN**0804****
	h	**16-25**	**20-32**
	Clamp	C1RA	C2RA
	Screw (clamp)	CM5×22C (4.0 Nm)	CM6×25C (7.0 Nm)
	Screw (shim)	SM5x8.65XA1	SM6×10XA1
	Shim	W06BM	W08BM
	Spring	SPR6	SPR4
	Wrench (shim)	WH30L	WH40L
	Wrench (clamp)	WH30L	WH40L

Insert

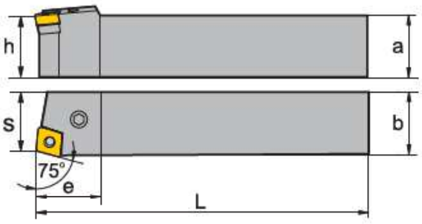
 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A95	A94	A97	A98	A98	A153

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

CN** holder (external) **P-Clamping**

PCBNR/L Kr: 75°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PCBNR/L2020K12		●	●	20	20	125	20	17	27	CN**1204**
PCBNR/L2525M12		●	●	25	25	150	25	22	27	CN**1204**
PCBNR/L3232P12		●	●	32	32	170	32	27	27	CN**1204**
PCBNR/L2525M16		●	●	25	25	150	25	22	33	CN**1606**
PCBNR/L3232P16		●	●	32	32	170	32	27	33	CN**1606**
PCBNR/L3232P19		●	●	32	32	170	32	27	38	CN**1906**
PCBNR/L4040S19		●	●	40	40	250	40	35	38	CN**1906**
PCBNR/L4040S2507		●	●	40	40	250	40	35	50	CN**2507**
PCBNR/L4040S2509		●	●	40	40	250	40	35	50	CN**2509**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CN**1204****	**CN**1606****	**CN**1906****	**CN**2507****	**CN**2509****
	h	**20-32**	**25-32**	**32-40**	**40**	**40**
	Knee lever	L4	L5	L6	L8	L8
	Screw	LEM8×21 (10.2 Nm)	LEM8×25 (10.2 Nm)	LEM10×27 (16.6 Nm)		
	Screw				LEM12x36A (25.2 Nm)	LEM12x36A (25.2 Nm)
	Shim	C12AP	C16AP	C19AP	C25AP-07	C25AP
	Shim pin (shim)	SP4	SP5	SP6	SP8	SP8
	Wrench	WH30L	WH30L	WH40L	WH50L	WH50L

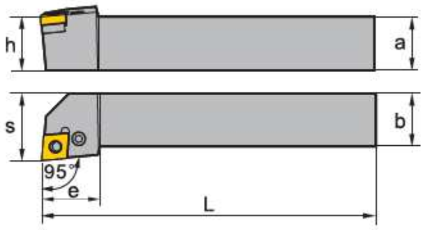
Insert

					
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A45	A45	A46	A51	A53	A148

CN** holder (external) P-Clamping

PCLNR/L Kr: 95°

Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PCLNR/L1616H09		●	●	16	16	100	16	20	20	CN**0903**
PCLNR/L2020K09		●	●	20	20	125	20	25	22	CN**0903**
PCLNR/L2525M09		○	●	25	25	150	25	32	22	CN**0903**
PCLNR/L2020K12		●	●	20	20	125	20	25	28	CN**1204**
PCLNR/L2525M12		●	●	25	25	150	25	32	28	CN**1204**
PCLNR/L3232P12		●	●	32	32	170	32	40	28	CN**1204**
PCLNR/L2525M16		●	●	25	25	150	25	32	33	CN**1606**
PCLNR/L3232P16		●	●	32	32	170	32	40	33	CN**1606**
PCLNR/L3232P19		●	●	32	32	170	32	40	38	CN**1906**
PCLNR/L4040S19		●	●	40	40	250	40	50	38	CN**1906**
PCLNR/L4040S2507		●	●	40	40	250	40	50	49	CN**2507**
PCLNR/L4040S2509		●	●	40	40	250	40	50	49	CN**2509**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**CN**0903****	**CN**1204****	**CN**1606****	**CN**1906****	**CN**2507****	**CN**2509****
	h	**16-25**	**20-32**	**25-32**	**32-40**	**40**	**40**
	Knee lever	L3	L4	L5	L6	L8	L8
	Screw		LEM8×21 (10.2 Nm)	LEM8×25 (10.2 Nm)	LEM10×27 (16.6 Nm)		
	Screw	LEM6×13.4A (7.0 Nm)				LEM12×36A (25.2 Nm)	LEM12×36A (25.2 Nm)
	Shim	C09AP	C12AP	C16AP	C19AP	C25AP-07	C25AP
	Shim pin (shim)	SP10	SP4	SP5	SP6	SP8	SP8
	Wrench	WH25L	WH30L	WH30L	WH40L	WH50L	WH50L

Insert

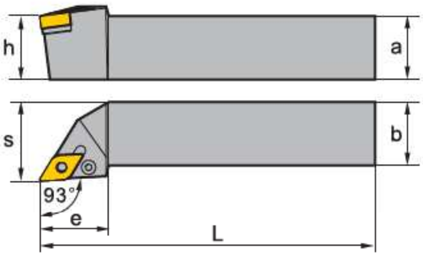
 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A45	A45	A46	A51	A53	A148

System code A194 Grade selection A40 Technical info A447 Cutting data A324

DN** holder (external) P-Clamping

PDJNR/L Kr: 93°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PDJNR/L1616H11		●	●	16	16	100	16	20	25	DN**1104**
PDJNR/L2020K11		●	●	20	20	125	20	25	25	DN**1104**
PDJNR/L2525M11		●	●	25	25	150	25	32	30	DN**1104**
PDJNR/L2020K15-3		●	○	20	20	125	20	25	35	DN**1504**
PDJNR/L2525M15-3		●	●	25	25	150	25	32	35	DN**1504**
PDJNR/L3232P15-3		●	●	32	32	170	32	40	35	DN**1504**
PDJNR/L2020K15		●	●	20	20	125	20	25	35	DN**1506**
PDJNR/L2525M15		●	●	25	25	150	25	32	35	DN**1506**
PDJNR/L3232P15		●	●	32	32	170	32	40	35	DN**1506**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DN**1104****	**DN**1504****	**DN**1506****
	h	**16-32**	**20-32**	**20-32**
	Knee lever	L3	L4	L4B
	Screw		LEM8×21 (10.2 Nm)	LEM8×21 (10.2 Nm)
	Screw	LEM6×13.4A (7.0 Nm)		
	Shim	D11AP	D15AP	D15AP
	Shim pin (shim)	SP3	SP4	SP4
	Wrench	WH25L	WH30L	WH30L

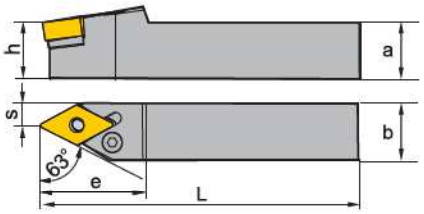
Insert

Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A55	A55	A56	A60	A61	A149

System code A194 Grade selection A40 Technical info A447 Cutting data A324

DN** holder (external) P-Clamping

PDNNR/L Kr: 63°



Left hand style

Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PDNNR/L2020K15-3		●	○	20	20	125	20	8	37	DN**1504**
PDNNR/L2525M15-3		●	○	25	25	150	25	12.5	37	DN**1504**
PDNNR/L3232P15-3		●	●	32	32	170	32	16	37	DN**1504**
PDNNR/L2020K15		●	●	20	20	125	20	8	37	DN**1506**
PDNNR/L2525M15		●	●	25	25	150	25	12.5	37	DN**1506**
PDNNR/L3232P15		●	●	32	32	170	32	16	37	DN**1506**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DN**1504****	**DN**1506****
	h	**20-32**	**20-32**
	Knee lever	L4	L4B
	Screw	LEM8×21 (10.2 Nm)	LEM8×21 (10.2 Nm)
	Shim	D15AP	D15AP
	Shim pin (shim)	SP4	SP4
	Wrench	WH30L	WH30L

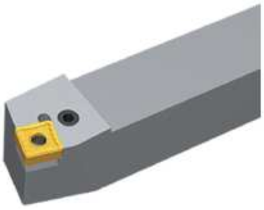
Insert

 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A55	A55	A56	A60	A61	A149

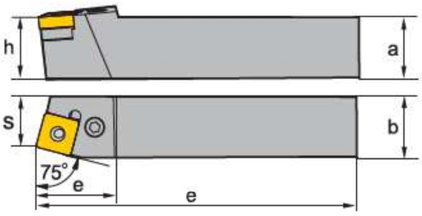
System code A194 Grade selection A40 Technical info A447 Cutting data A324

SN** holder (external) P-Clamping

PSBNR/L Kr: 75°



Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PSBNR/L1616H09		●	○	16	16	100	16	13	21	SN**0903**
PSBNR/L2020K09		●	○	20	20	125	20	17	23	SN**0903**
PSBNR/L2020K12		●	●	20	20	125	20	17	28	SN**1204**
PSBNR/L2525M12		●	●	25	25	125	25	22	28	SN**1204**
PSBNR/L3225P12		●	○	32	25	170	32	22	28	SN**1204**
PSBNR/L3232P12		●	○	32	32	170	32	27	28	SN**1204**
PSBNR/L2525M15		●	○	25	25	150	25	22	35	SN**1506**
PSBNR/L3232P15		●	●	32	32	170	32	27	35	SN**1506**
PSBNR/L3232P19		●	●	32	32	170	32	27	40	SN**1906**
PSBNR/L4040S19		●	●	40	40	250	40	35	40	SN**1906**
PSBNR/L4040S2507		○	○	40	40	250	40	35	48	SN**2507**
PSBNR/L4040S2509		○	○	40	40	250	40	35	48	SN**2509**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SN**0903****	**SN**1204****	**SN**1506****	**SN**1906****	**SN**2507****	**SN**2509****
	h	**16-20**	**20-32**	**25-32**	**32-40**	**40**	**40**
	Knee lever	L3	L4	L5	L6	L8	L8
	Screw		LEM8×21 (10.2 Nm)	LEM8×25 (10.2 Nm)	LEM10×27 (16.6 Nm)		
	Screw	LEM6×13.4A (7.0 Nm)				LEM12×36A (25.2 Nm)	LEM12×36A (25.2 Nm)
	Shim	S09AP	S12AP	S15AP	S19AP	S25AP	
	Shim						S25AP-09
	Shim pin (shim)	SP10	SP4	SP5	SP6	SP8	SP8
	Wrench	WH25L	WH30L	WH30L	WH40L	WH50L	WH50L

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

SN** holder (external)

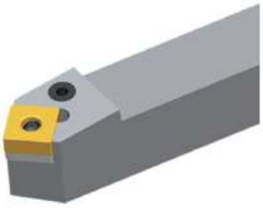
Insert

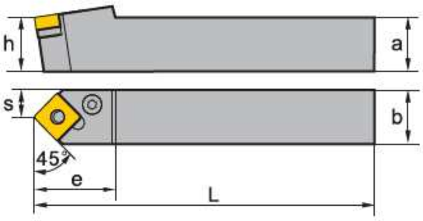
				
Finishing	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A63	A65	A68	A74	A150

System code > A194
Grade selection > A40
Technical info > A447
Cutting data > A324

SN** holder (external) **P-Clamping**

PSDNN Kr: 45°





Article	✻	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
PSDNN1212F09		○	12	12	80	12	6	21	SN**0903**
PSDNN1616H09		●	16	16	100	16	8	23	SN**0903**
PSDNN2020K12		●	20	20	125	20	10	30	SN**1204**
PSDNN2525M12		●	20	20	150	20	12.5	30	SN**1204**
PSDNN3232P12		●	32	32	170	32	16	40	SN**1204**
PSDNN2525M15		●	25	25	150	25	12.5	40	SN**1506**
PSDNN3232P15		●	32	32	170	32	16	40	SN**1506**
PSDNN3232P19		●	32	32	170	32	16	40	SN**1906**
PSDNN4040S19		●	40	40	250	40	20	40	SN**1906**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SN**0903****	**SN**0903****	**SN**1204****	**SN**1506****	**SN**1906****
	h	**12**	**16**	**20-32**	**25-32**	**32-40**
	Knee lever	L3B	L3	L3	L5	L6
	Screw	LEM5×12B (4.0 Nm)				
	Screw				LEM8×25 (10.2 Nm)	LEM10×27 (16.6 Nm)
	Screw		LEM6×13.4A (7.0 Nm)	LEM6×13.4A (7.0 Nm)		
	Shim		S09AP	S09AP	S15AP	S19AP
	Shim pin (shim)		SP10	SP10	SP5	SP6
	Wrench	WH20L	WH25L	WH25L	WH30L	WH40L

Insert

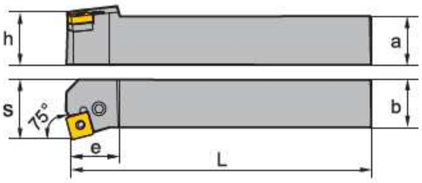
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A63	A65	A68	A74	A150

System code › A194 Grade selection › A40 Technical info › A447 Cutting data › A324

SN** holder (external) P-Clamping

PSKNR/L Kr: 75°

Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PSKNR/L1616H09		○	○	16	16	100	16	20	17	SN**0903**
PSKNR/L2020K09		●	○	20	20	125	20	25	20	SN**0903**
PSKNR/L2020K12		●	●	20	20	125	20	25	26	SN**1204**
PSKNR/L2525M12		●	●	25	25	150	25	32	26	SN**1204**
PSKNR/L3232P12		●	●	32	32	170	32	40	26	SN**1204**
PSKNR/L2525M15		●	○	25	25	150	25	32	32	SN**1506**
PSKNR/L3232P15		●	●	32	32	170	32	40	32	SN**1506**
PSKNR/L3232P19		●	●	32	32	170	32	40	36	SN**1906**
PSKNR/L4040S19		○	○	40	40	250	40	50	40	SN**1906**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SN**0903****	**SN**1204****	**SN**1506****	**SN**1906****
	h	**16-20**	**20-32**	**25-32**	**32-40**
	Knee lever	L3	L4	L5	L6
	Screw		LEM8×21 (10.2 Nm)	LEM8×25 (10.2 Nm)	LEM10×27 (16.6 Nm)
	Screw	LEM6×13.4A (7.0 Nm)			
	Shim	S09AP	S12AP	S15AP	S19AP
	Shim pin (shim)	SP10	SP4	SP5	SP6
	Wrench	WH25L	WH30L	WH30L	WH40L

Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A63	A65	A68	A74	A150

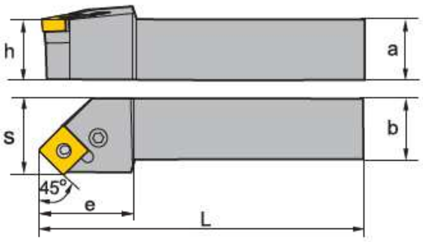
System code A194 Grade selection A40 Technical info A447 Cutting data A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

SN** holder (external) P-Clamping

PSSNR/L Kr: 45°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PSSNR/L1616H09		●	●	16	16	100	16	20	25	SN**0903**
PSSNR/L2020K12		●	●	20	20	125	20	25	30	SN**1204**
PSSNR/L2525M12		●	●	25	25	150	25	32	30	SN**1204**
PSSNR/L3232P12		●	●	32	32	170	32	40	40	SN**1204**
PSSNR/L2525M15		●	●	25	25	150	25	32	30	SN**1506**
PSSNR/L3232P15		●	●	32	32	170	32	40	40	SN**1506**
PSSNR/L3232P19		●	●	32	32	170	32	40	40	SN**1906**
PSSNR/L4040S19		●	●	40	40	250	40	50	50	SN**1906**
PSSNR/L4040S2507		●	●	40	40	250	40	50	50	SN**2507**
PSSNR/L4040S2509		●	●	40	40	250	40	50	50	SN**2509**

● Ex stock ○ On demand
✻ With internal cooling

Spare parts

	Insert	**SN**0903****	**SN**1204****	**SN**1506****	**SN**1906****	**SN**2507****	**SN**2509****
	h	**16**	**20-32**	**25-32**	**32-40**	**40**	**40**
	Knee lever	L3	L4	L5	L6	L8	L8
	Screw		LEM8×21 (10.2 Nm)	LEM8×25 (10.2 Nm)	LEM10×27 (16.6 Nm)		
	Screw	LEM6×13.4A (7.0 Nm)				LEM12×36A (25.2 Nm)	LEM12×36A (25.2 Nm)
	Shim	S09AP	S12AP	S15AP	S19AP	S25AP	
	Shim						S25AP-09
	Shim pin (shim)	SP10	SP4	SP5	SP6	SP8	SP8
	Wrench	WH25L	WH30L	WH30L	WH40L	WH50L	WH50L

Insert

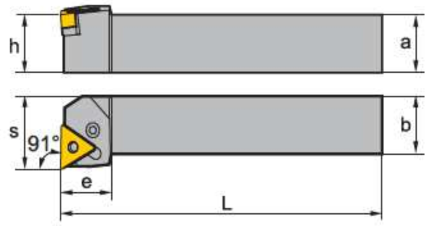
Finishing	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A63	A65	A68	A74	A150

System code A194 Grade selection A40 Technical info A447 Cutting data A324

TN** holder (external) P-Clamping

PTFNR/L Kr: 91°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PTFNR/L1616H16		●	●	16	16	100	16	20	20	TN**1604**
PTFNR/L2020K16		●	●	20	20	125	20	25	20	TN**1604**
PTFNR/L2525M16		●	●	25	25	150	25	32	20	TN**1604**
PTFNR/L2525M22		●	●	25	25	150	25	32	25	TN**2204**
PTFNR/L3232P22		●	●	32	32	170	32	40	25	TN**2204**
PTFNR/L3232P27		●	○	32	32	170	32	40	34	TN**2706**
PTFNR/L4040S27		○	○	40	40	250	40	50	34	TN**2706**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TN**1604****	**TN**2204****	**TN**2706****
	h	**16-25**	**25-32**	**32-40**
	Knee lever	L3	L4	L5
	Screw		LEM8×21 (10.2 Nm)	LEM8×25 (10.2 Nm)
	Screw	LEM6×13.4A (7.0 Nm)		
	Shim	T16AP	T22AP	T27AP
	Shim pin (shim)	SP3	SP4	SP5
	Wrench	WH25L	WH30L	WH30L

Insert

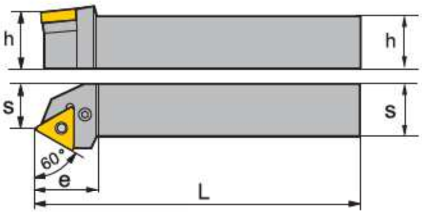
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Heavy Turning**	**Cast Iron**	**PCBN/PCD**
A78	A79	A81	A84	A87	A88	A151

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

TN** holder (external) **P-Clamping**

PTTNR/L Kr: 60°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PTTNR/L1616H16		●	●	16	16	100	16	13	25	TN**1604**
PTTNR/L2020K16		●	○	20	20	125	20	17	25	TN**1604**
PTTNR/L2525M22		●	●	25	25	150	20	22	32	TN**2204**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TN**1604****	**TN**2204****
	h	**16-25**	**20**
	Knee lever	L3	L4
	Screw		LEM8×21 (10.2 Nm)
	Screw	LEM6×13.4A (7.0 Nm)	
	Shim	T16AP	T22AP
	Shim pin (shim)	SP3	SP4
	Wrench	WH25L	WH30L

Insert

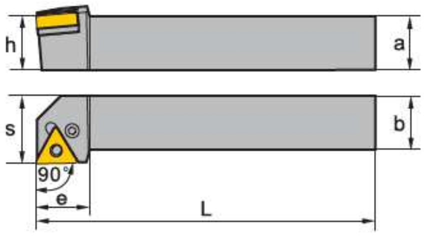
						
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Heavy Turning**	**Cast Iron**	**PCBN/PCD**
A78	A79	A81	A84	A87	A88	A151

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

TN** holder (external) P-Clamping

PTGNR/L Kr: 90°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PTGNR/L1010E11		●		10	10	70	10	14	16	TN**1103**
PTGNR/L1212F11		●	●	12	12	80	12	16	14	TN**1103**
PTGNR/L1616H11		●	●	16	16	100	16	20	18	TN**1103**
PTGNR/L2020K11		●	○	20	20	125	20	25	19	TN**1103**
PTGNR/L2525M11		○	○	25	25	150	25	32	20	TN**1103**
PTGNR/L1616H16		●	●	16	16	100	16	20	20	TN**1604**
PTGNR/L2020K16		●	●	20	20	125	20	25	20	TN**1604**
PTGNR/L2525M16		●	●	25	25	150	25	32	20	TN**1604**
PTGNR/L3232P16		●	○	32	32	170	32	40	20	TN**1604**
PTGNR/L2525M22		●	●	25	25	150	25	32	28	TN**2204**
PTGNR/L3232P22		●	●	32	32	170	32	40	28	TN**2204**
PTGNR/L3232P27		●	○	32	32	170	32	40	33	TN**2706**
PTGNR/L4040S27		○	○	40	40	250	40	50	33	TN**2706**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TN**1103****	**TN**1604****	**TN**2204****	**TN**2706****
	h	**10-25**	**16-32**	**25-32**	**32-40**
	Knee lever	L2	L3	L4	L5
	Screw	LEM5×9B (4.0 Nm)			
	Screw			LEM8×21 (10.2 Nm)	LEM8×25 (10.2 Nm)
	Screw		LEM6×13.4A (7.0 Nm)		
	Shim		T16AP	T22AP	T27AP
	Shim pin (shim)		SP3	SP4	SP5
	Wrench	WH20L	WH25L	WH30L	WH30L

System code › A194 Grade selection › A40 Technical info › A447 Cutting data › A324

TN** holder (external)

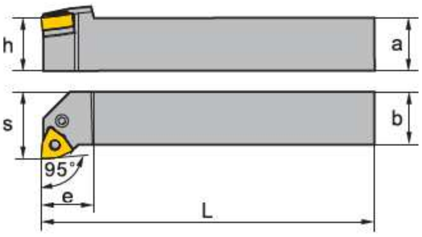
Insert						
						
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Heavy Turning**	**Cast Iron**	**PCBN/PCD**
A78	A79	A81	A84	A87	A88	A151

System code A194
Grade selection A40
Technical info A447
Cutting data A324

WN** holder (external) P-Clamping

PWLNR/L Kr: 95°

Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
PWLNR/L1616H06		●	●	16	16	100	16	20	20	WN**0604**
PWLNR/L2020K06		●	●	20	20	125	20	25	20	WN**0604**
PWLNR/L2525M06		●	●	25	25	150	25	32	20	WN**0604**
PWLNR/L2020K08		●	●	20	20	125	20	25	26	WN**0804**
PWLNR/L2525M08		●	●	25	25	150	25	32	26	WN**0804**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**WN**0604****	**WN**0804****
	h	**16-25**	**20-25**
	Knee lever	L3	L4
	Screw		LEM8×21 (10.2 Nm)
	Screw	LEM6×13.4A (7.0 Nm)	
	Shim	W06AP	W08AP
	Shim pin (shim)	SP3	SP4
	Wrench	WH25L	WH30L

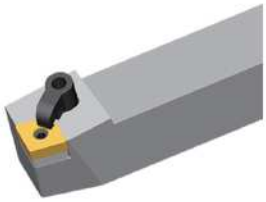
Insert

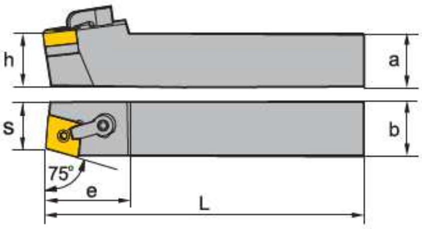
					
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A95	A94	A97	A98	A98	A153

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

CN** holder (external) M-Clamping

MCBNR/L Kr: 75°


Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MCBNR/L2020K12		●	○	20	20	125	20	17	32	CN**1204**
MCBNR/L2525M12		●	●	25	25	150	20	22	32	CN**1204**
MCBNR/L3225P12		●	●	32	25	170	32	22	32	CN**1204**
MCBNR/L2525M16		○	○	25	25	150	25	22	40	CN**1606**
MCBNR/L3232P16		●	●	32	32	170	32	27	40	CN**1606**
MCBNR/L3232P19		○	○	32	32	170	32	27	45	CN**1906**
MCBNR/L4040R19		○	●	40	40	200	40	35	45	CN**1906**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CN**1204****	**CN**1204****	**CN**1606****	**CN**1906****
	h	**20**	**25-32**	**25-32**	**32-40**
	Clamp	C1RD	C1RD	C2RD	C5RD
	Dowel pin	TM6×17	TM6×17	TM8×21	TM10×21
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)	
	Screw (clamp)				DM8×30X (10.2 Nm)
	Shim	C12BM	C12BM	C16BM	C19BM
	Wrench (dowel pin)	WH30L	WH30L	WH30L	WH40L
	Wrench (clamp)	WH30L	WH30L	WH30L	WH40L

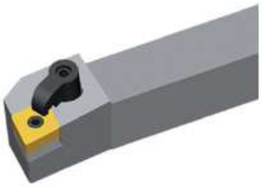
Insert

					
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A45	A45	A46	A53	A53	A148

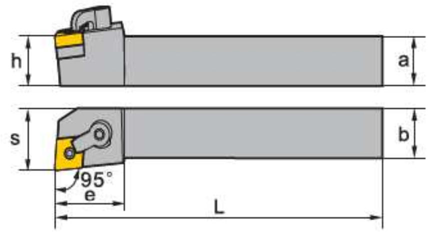
System code A194 Grade selection A40 Technical info A447 Cutting data A324

CN** holder (external) **M-Clamping**

MCLNR/L Kr: 95°



Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MCLNR/L2020K12		●	●	20	20	125	20	25	32	CN**1204**
MCLNR/L2525M12		●	●	25	25	150	25	32	32	CN**1204**
MCLNR/L3225P12		●	●	32	25	170	32	32	32	CN**1204**
MCLNR/L2525M16		●	●	25	25	150	25	32	38	CN**1606**
MCLNR/L3232P16		●	●	32	32	170	32	40	38	CN**1606**
MCLNR/L3232P19		●	●	32	32	170	32	40	45	CN**1906**
MCLNR/L4040R19		●	○	40	40	200	40	50	45	CN**1906**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CN**1204****	**CN**1204****	**CN**1606****	**CN**1906****
	h	**20**	**25-32**	**25-32**	**32-40**
	Clamp	C1RD	C1RD	C2RD	C5RD
	Dowel pin	TM6×17	TM6×17	TM8×21	TM10×21
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)	
	Screw (clamp)				DM8×30X (10.2 Nm)
	Shim	C12BM	C12BM	C16BM	C19BM
	Wrench (dowel pin)	WH30L	WH30L	WH30L	WH40L
	Wrench (clamp)	WH30L	WH30L	WH30L	WH40L

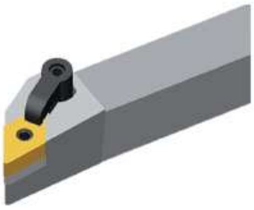
Insert

 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A45	A45	A46	A53	A53	A148

System code A194 Grade selection A40 Technical info A447 Cutting data A324

DN** holder (external) M-Clamping

MDJNR/L Kr: 93°



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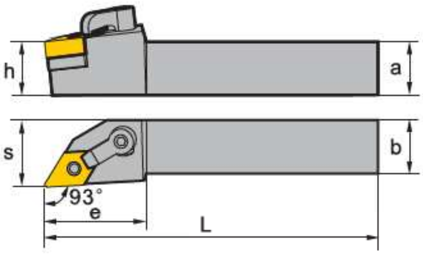


Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MDJNR/L2020K11		●	●	20	20	125	20	25	32	DN**1104**
MDJNR/L2525M11		●	●	25	25	150	25	32	32	DN**1104**
MDJNR/L3225P11		●	○	32	25	170	32	32	32	DN**1104**
MDJNR/L2020K15		●	●	20	20	125	20	25	38	DN**1506**
MDJNR/L2525M15		●	●	25	25	150	25	32	38	DN**1506**
MDJNR/L3225P15		●	●	32	25	170	32	32	38	DN**1506**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

Insert	**DN**1104****	**DN**1104****	**DN**1506****	**DN**1506****
h	**20**	**25-32**	**20**	**25-32**
Clamp	C1RD	C1RD	C2RD	C2RD
Dowel pin	TM5x13	TM5x13	TM6×19	TM6×19
Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)
Shim	D11BM	D11BM	D15BM	D15BM
Wrench (clamp)	WH30L	WH30L	WH30L	WH30L
Wrench (dowel pin)	WH20L	WH20L	WH30L	WH30L

Insert

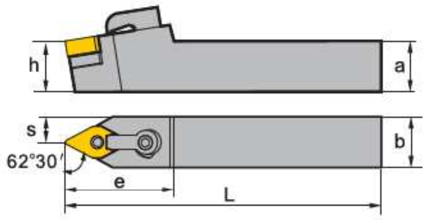
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A55	A55	A56	A60	A61	A149

System code A194 Grade selection A40 Technical info A447 Cutting data A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

DN** holder (external) **M-Clamping**

MDPNN Kr: 62°30'



Article	✻	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
MDPNN2020K11		●	20	20	125	20	10	35	DN**1104**
MDPNN2525M11		●	25	25	150	25	12.5	35	DN**1104**
MDPNN3225P11		●	32	25	170	32	12.5	35	DN**1104**
MDPNN2020K15		●	20	20	125	20	10	40	DN**1506**
MDPNN2525M15		●	25	25	150	25	12.5	40	DN**1506**
MDPNN3225P15		●	32	25	170	32	12.5	40	DN**1506**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DN**1104****	**DN**1104****	**DN**1506****	**DN**1506****
	h	**20**	**25-32**	**20**	**25-32**
	Clamp	C1RD	C1RD	C2RD	C2RD
	Dowel pin	TM5x13	TM5x13	TM6×19	TM6×19
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	D11BM	D11BM	D15BM	D15BM
	Wrench (clamp)	WH30L	WH30L	WH30L	WH30L
	Wrench (dowel pin)	WH20L	WH20L	WH30L	WH30L

Insert

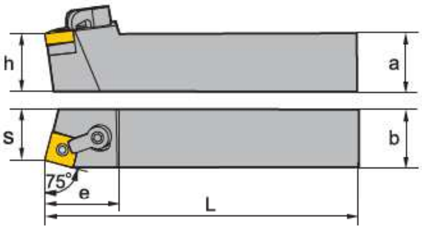
 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A55	A55	A56	A60	A61	A149

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

SN** holder (external) M-Clamping

MSBNR/L Kr: 75°

Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MSBNR/L2020K12		●	●	20	20	125	20	17	32	SN**1204**
MSBNR/L2525M12		●	○	25	25	150	25	22	32	SN**1204**
MSBNR/L3225P12		●	●	32	25	170	32	22	32	SN**1204**
MSBNR/L2525M15		●	○	25	25	150	25	22	38	SN**1506**
MSBNR/L3232P15		●	●	32	32	170	32	29	38	SN**1506**
MSBNR/L4032R15		○		40	32	200	40	27	38	SN**1506**
MSBNR/L3232P19		●	●	32	32	170	32	27	45	SN**1906**
MSBNR/L4040R19		○	●	40	40	200	40	35	45	SN**1906**
MSBNR/L4040R25		●	○	40	40	200	40	35	50	SN**2507**
MSBNR/L4040S2509		○	○	40	40	250	40	35	50	SN**2509**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SN**1204****	**SN**1204****	**SN**1506****	**SN**1906****	**SN**2507****	**SN**2509****
	h	**20**	**25-32**	**25-40**	**32-40**	**40**	**40**
	Clamp	C1RD	C1RD	C2RD	C5RD	C6RD	C6RD
	Dowel pin	TM6×17	TM6×17	TM8×21	TM10×21	TM12×29	TM12×29
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)			
	Screw (clamp)				DM8×30X (10.2 Nm)	DM10×35X (16.6 Nm)	DM10×35X (16.6 Nm)
	Shim	S12BM	S12BM	S15BM	S19BM	S25BM	S25BM
	Wrench (clamp)	WH30L	WH30L	WH30L	WH40L	WH40L	WH40L
	Wrench (dowel pin)	WH31L	WH31L	WH30L	WH40L	WH50L	WH50L

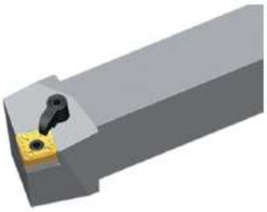
Insert

Finishing	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A63	A65	A68	A74	A150

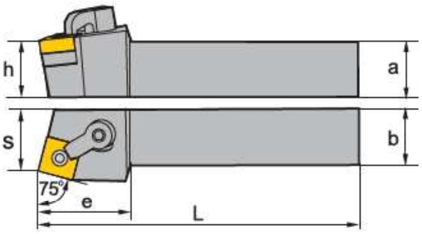
System code A194 Grade selection A40 Technical info A447 Cutting data A324

SN** holder (external) M-Clamping

MSRNR/L Kr: 75°



Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MSRNR/L2020K12		●	●	20	20	125	20	22	36	SN**1204**
MSRNR/L2525M12		●	●	25	25	150	25	27	36	SN**1204**
MSRNR/L3225P12		●	○	32	25	170	32	27	36	SN**1204**
MSRNR/L2525M15		●	○	25	25	150	25	27	40	SN**1506**
MSRNR/L3232P15		●	●	32	32	170	32	35	40	SN**1506**
MSRNR/L4032R15		○		40	32	200	40	35	40	SN**1506**
MSRNR/L3232P19		○	○	32	32	170	32	35	45	SN**1906**
MSRNR/L4040R19		○		40	40	200	40	43	45	SN**1906**
MSRNR/L4040R2509		○	○	40	40	200	40	43	50	SN**2509**
MSRNR/L4040S2509		○	○	40	40	250	40	43	50	SN**2509**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SN**1204****	**SN**1204****	**SN**1506****	**SN**1906****	**SN**2509****
	h	**20**	**25-32**	**25-40**	**32-40**	**40**
	Clamp	C1RD	C1RD	C2RD	C5RD	C6RD
	Dowel pin	TM6×17	TM6×17	TM8×21	TM10×21	TM12×29
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)		
	Screw (clamp)				DM8×30X (10.2 Nm)	DM10×35X (16.6 Nm)
	Shim	S12BM	S12BM	S15BM	S19BM	S25BM
	Wrench (clamp)	WH30L	WH30L	WH30L	WH40L	WH40L
	Wrench (dowel pin)	WH31L	WH31L	WH30L	WH40L	WH50L

Insert

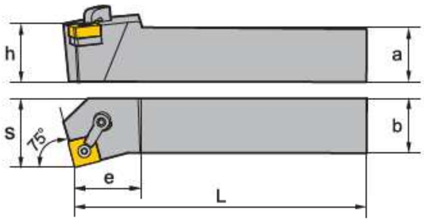
				
Finishing	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A63	A65	A68	A74	A150

System code A194 Grade selection A40 Technical info A447 Cutting data A324

SN** holder (external) **M-Clamping**

MSKNR/L Kr: 75°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MSKNR/L2020K12		●	●	20	20	125	20	25	32	SN**1204**
MSKNR/L2525M12		●	●	25	25	150	25	32	32	SN**1204**
MSKNR/L3225P12		●	○	32	25	170	32	32	32	SN**1204**
MSKNR/L2525M15		●	○	25	25	150	25	32	28	SN**1506**
MSKNR/L3232P15		●	○	32	32	170	32	40	38	SN**1506**
MSKNR/L4032R15			○	40	32	200	40	40	38	SN**1506**
MSKNR/L3232P19		●	●	32	32	170	32	40	45	SN**1906**
MSKNR/L4040R19		○	○	40	40	200	40	50	45	SN**1906**
MSKNR/L4040S2509		○	●	40	40	250	40	50	50	SN**2509**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SN**1204****	**SN**1204****	**SN**1506****	**SN**1906****	**SN**2509****
	h	**20**	**25-32**	**25-40**	**32-40**	**40**
	Clamp	C1RD	C1RD	C2RD	C5RD	C6RD
	Dowel pin	TM6×17	TM6×17	TM8×21	TM10×21	TM12×29
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)		
	Screw (clamp)				DM8×30X (10.2 Nm)	DM10×35X (16.6 Nm)
	Shim	S12BM	S12BM	S15BM	S19BM	S25BM
	Wrench (clamp)	WH30L	WH30L	WH30L	WH40L	WH40L
	Wrench (dowel pin)	WH30L	WH30L	WH30L	WH40L	WH50L

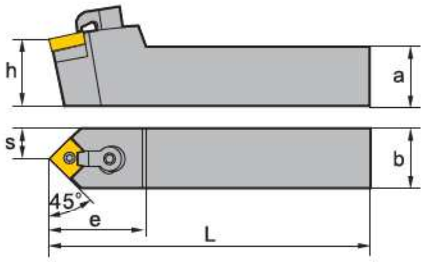
Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A63	A65	A68	A74	A150

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

SN** holder (external) M-Clamping

MSDNN Kr: 45°



Article	✻	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
MSDNN2020K12		●	20	20	125	20	10	35	SN**1204**
MSDNN2525M12		●	25	25	150	25	12.5	35	SN**1204**
MSDNN3225P12		●	32	25	170	32	12.5	35	SN**1204**
MSDNN2525M15		●	25	25	150	25	12.5	42	SN**1506**
MSDNN3232P15		○	32	32	170	32	16	42	SN**1506**
MSDNN4032R15		○	40	32	200	40	16	42	SN**1506**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SN**1204****	**SN**1204****	**SN**1506****
	h	**20**	**25-32**	**25-40**
	Clamp	C1RD	C1RD	C2RD
	Dowel pin	TM6×17	TM6×17	TM8×21
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	S12BM	S12BM	S15BM
	Wrench (clamp)	WH30L	WH30L	WH30L
	Wrench (dowel pin)	WH30L	WH30L	WH30L

Insert

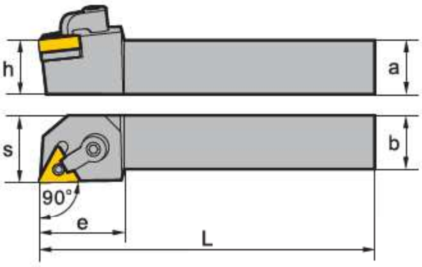
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A63	A65	A68	A74	A150

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

TN** holder (external) **M-Clamping**

MTGNR/L Kr: 90°

Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MTGNR/L2020K16		●	○	20	20	125	20	25	33	TN**1604**
MTGNR/L2525M16		●	●	25	25	150	25	32	33	TN**1604**
MTGNR/L3225P16		●	○	32	25	170	32	32	33	TN**1604**
MTGNR/L2525M22		●	○	25	25	150	25	32	35	TN**2204**
MTGNR/L3225P22		○	○	32	25	170	32	32	35	TN**2204**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

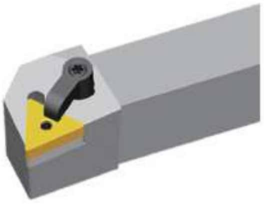
	Insert	**TN**1604****	**TN**1604****	**TN**2204****
	h	**20**	**25-32**	**25-32**
	Clamp	C1RD	C1RD	C2RD
	Dowel pin	TM5x13	TM5x13	TM6x17
	Screw (clamp)	DM6x25 (7.0 Nm)	DM6x30 (7.0 Nm)	DM6x30 (7.0 Nm)
	Shim	T16BM	T16BM	T22BM
	Wrench (clamp)	WH30L	WH30L	WH30L
	Wrench (dowel pin)	WH20L	WH20L	WH30L

Insert

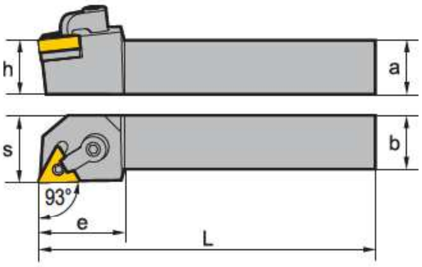
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Heavy Turning**	**Cast Iron**	**PCBN/PCD**
A78	A79	A81	A84	A87	A88	A151

TN** holder (external) M-Clamping

MTJNR/L Kr: 93°



Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MTJNR/L2020K16		●		20	20	125	20	25	32	TN**1604**
MTJNR/L2525M16		○	○	25	25	150	25	32	32	TN**1604**
MTJNR/L3225P16		○		32	25	170	32	32	32	TN**1604**
MTJNR/L2525M22		○		25	25	150	25	32	36	TN**2204**
MTJNR/L3225P22		○	●	32	25	170	32	32	36	TN**2204**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TN**1604****	**TN**1604****	**TN**2204****
	h	**20**	**25-32**	**25-32**
	Clamp	C1RD	C1RD	C2RD
	Dowel pin	TM5x13	TM5x13	TM6×17
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	T16BM	T16BM	T22BM
	Wrench (clamp)	WH30L	WH30L	WH30L
	Wrench (dowel pin)	WH20L	WH20L	WH30L

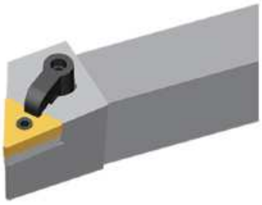
Insert

						
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Heavy Turning**	**Cast Iron**	**PCBN/PCD**
A78	A79	A81	A84	A87	A88	A151

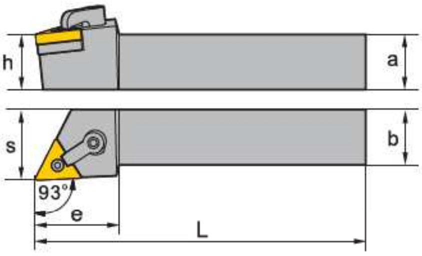
System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

TN** holder (external) M-Clamping

MTJNR/L-Z Kr: 93°



Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MTJNR/L2020K16-Z		●	●	20	20	125	20	25	32	TN**1604**
MTJNR/L2525M16-Z		●	●	25	25	150	25	32	32	TN**1604**
MTJNR/L3225P16-Z		●	○	32	25	170	32	32	32	TN**1604**
MTJNR/L2525M22-Z		●	●	25	25	150	25	32	36	TN**2204**
MTJNR/L3225P22-Z		●	○	32	25	170	32	32	36	TN**2204**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**TN**1604****	**TN**1604****	**TN**2204****
	h	**20**	**25-32**	**25-32**
	Clamp	C1RD	C1RD	C2RD
	Dowel pin	TM5x13	TM5x13	TM6×17
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	T16BM	T16BM	T22BM
	Wrench (clamp)	WH30L	WH30L	WH30L
	Wrench (dowel pin)	WH20L	WH20L	WH30L

Insert

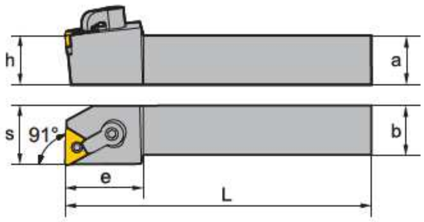
 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Heavy Turning**	 **Cast Iron**	 **PCBN/PCD**
A78	A79	A81	A84	A87	A88	A151

System code A194 Grade selection A40 Technical info A447 Cutting data A324

TN** holder (external) **M-Clamping**

MTFNR/L Kr: 91°

Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MTFNR/L2020K16		●	○	20	20	125	20	25	32	TN**1604**
MTFNR/L2525M16		●	●	25	25	150	25	32	32	TN**1604**
MTFNR/L3225P16		●		32	25	170	32	32	32	TN**1604**
MTFNR/L2525M22		●	○	25	25	150	25	32	36	TN**2204**
MTFNR/L3225P22		●	○	32	25	170	32	32	36	TN**2204**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**TN**1604****	**TN**1604****	**TN**2204****
	h	**20**	**25-32**	**25-32**
	Clamp	C1RD	C1RD	C2RD
	Dowel pin	TM5x13	TM5x13	TM6×17
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	T16BM	T16BM	T22BM
	Wrench (clamp)	WH30L	WH30L	WH30L
	Wrench (dowel pin)	WH20L	WH20L	WH30L

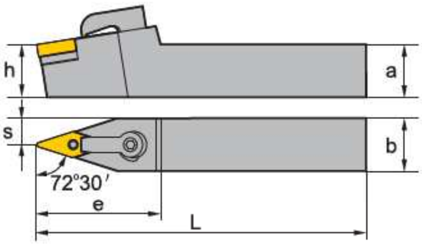
Insert

						
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Heavy Turning**	**Cast Iron**	**PCBN/PCD**
A78	A79	A81	A84	A87	A88	A151

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

VN** holder (external) M-Clamping

MVVNN Kr: 72°30'



Article	✲	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
MVVNN2020K16		●	20	20	125	20	10	45	VN**1604**
MVVNN2525M16		●	25	25	150	25	12.5	45	VN**1604**
MVVNN3225P16		○	32	25	170	32	12.5	45	VN**1604**
MVVNN3232P16		●	32	32	170	32	16	45	VN**1604**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VN**1604****	**VN**1604****
	h	**20**	**25-32**
	Clamp	C3RD	C3RD
	Dowel pin	TM5x13	TM5x13
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	V16BM	V16BM
	Wrench (clamp)	WH30L	WH30L
	Wrench (dowel pin)	WH20L	WH20L

Insert

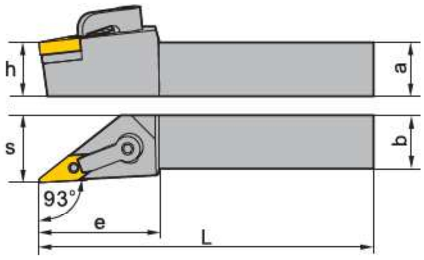
Finishing	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A91	A93	A93	A92	A152

System code A194 Grade selection A40 Technical info A447 Cutting data A324

VN** holder (external) **M-Clamping**

MVJNR/L Kr: 93°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MVJNR/L2020K16		●	●	20	20	125	20	25	45	VN**1604**
MVJNR/L2525M16		●	●	25	25	150	25	32	45	VN**1604**
MVJNR/L3225P16		●	●	32	25	170	32	32	45	VN**1604**
MVJNR/L3232P16		●	●	32	32	170	32	40	45	VN**1604**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**VN**1604****	**VN**1604****
	h	**20**	**25-32**
	Clamp	C3RD	C3RD
	Dowel pin	TM5x13	TM5x13
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	V16BM	V16BM
	Wrench (clamp)	WH30L	WH30L
	Wrench (dowel pin)	WH20L	WH20L

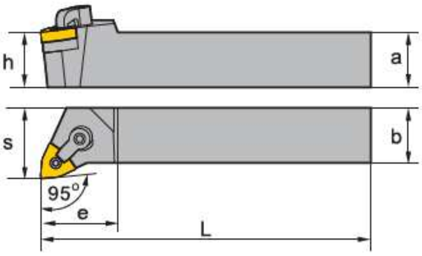
Insert

Finishing	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A91	A93	A93	A92	A152

WN** holder (external) M-Clamping

MWLNR/L Kr: 95°

Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MWLNR/L2020K06		●	●	20	20	125	20	25	30	WN**0604**
MWLNR/L2525M06		●	●	25	25	150	25	32	30	WN**0604**
MWLNR/L2020K08		●	●	20	20	125	20	25	30	WN**0804**
MWLNR/L2525M08		●	●	25	25	150	25	32	35	WN**0804**
MWLNR/L3232P08		●	●	32	32	170	32	40	35	WN**0804**

● Ex stock ○ On demand
✲ With internal cooling

Spare parts

	Insert	**WN**0604****	**WN**0604****	**WN**0804****	**WN**0804****
	h	**20**	**25**	**20**	**25-32**
	Clamp	C1RD	C1RD	C1RD	C1RD
	Dowel pin	TM5x13	TM5x13	TM6×17	TM6×17
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	W06BM	W06BM	W08BM	W08BM
	Wrench (clamp)	WH30L	WH30L	WH30L	WH30L
	Wrench (dowel pin)	WH20L	WH20L	WH30L	WH30L

Insert

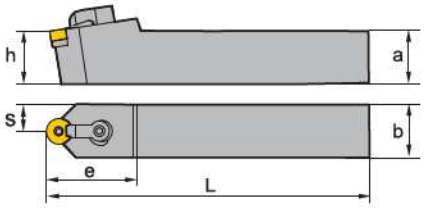
					
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A95	A94	A97	A98	A98	A153

System code A194 Grade selection A40 Technical info A447 Cutting data A324

RN** holder (external) M-Clamping

MRDNN

Right hand style



Article	✻	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
MRDNN2020K12		○	20	20	125	20	10	35	RN**1204**
MRDNN2525M12		○	25	25	150	25	12.5	35	RN**1204**
MRDNN3225P12		○	32	25	170	32	12.5	35	RN**1204**
MRDNN3232P12		○	32	32	170	32	16	35	RN**1204**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**RN**1204****	**RN**1204****
	h	**20**	**25-32**
	Clamp	C1RD	C1RD
	Dowel pin	TM6×17	TM6×17
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	R12BM	R12BM
	Wrench (clamp)	WH30L	WH30L
	Wrench (dowel pin)	WH30L	WH30L

Insert

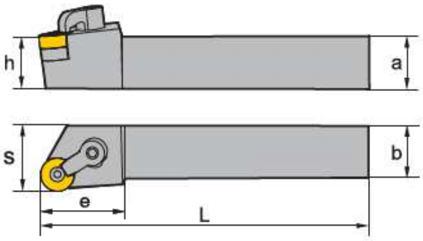
Cast Iron
A99

System code A194 Grade selection A40 Technical info A447 Cutting data A324

RN** holder (external) M-Clamping

MRGNR/L

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
MRGNR/L2020K12		○	○	20	20	125	20	25	32	RN**1204**
MRGNR/L2525M12		○	●	25	25	150	25	32	32	RN**1204**
MRGNR/L3225P12		○	○	32	25	170	32	32	32	RN**1204**
MRGNR/L3232P12		○	○	32	32	170	32	40	32	RN**1204**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**RN**1204****	**RN**1204****
	h	**20**	**25-32**
	Clamp	C1RD	C1RD
	Dowel pin	TM6×17	TM6×17
	Screw (clamp)	DM6×25 (7.0 Nm)	DM6×30 (7.0 Nm)
	Shim	R12BM	R12BM
	Wrench (clamp)	WH30L	WH30L
	Wrench (dowel pin)	WH30L	WH30L

Insert

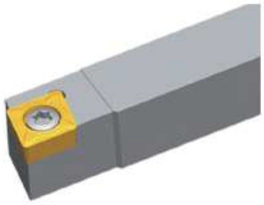
Cast Iron

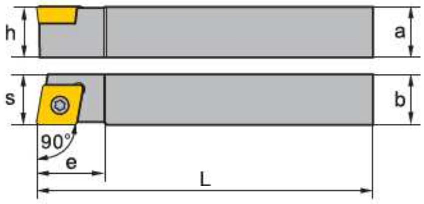
A99

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

CC** holder (external) **S-Clamping**

SCACR/L Kr: 90°





Right hand style

Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SCACR/L1010E06		●	●	10	10	70	10	10.5	10	CC**0602**
SCACR/L1212F09		●	●	12	12	80	12	12.7	16	CC**09T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**CC**0602****	**CC**09T3****
	h	**10**	**12**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)
	Wrench (screw)	WT07IP	WT15IP

Insert

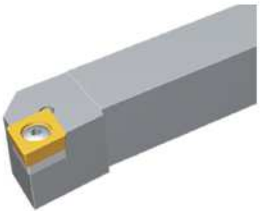
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A102	A106	A107	A108	A107	A154

A Turning
B Milling
C Drilling
D Technical Information
E Index

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

CC** holder (external) S-Clamping

SCLCR/L Kr: 95°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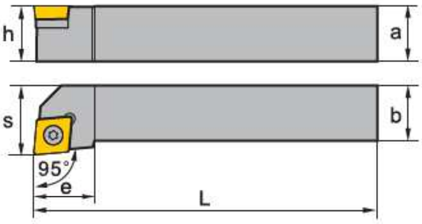
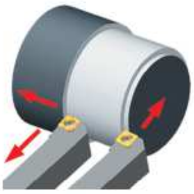




Article	✼	Stock		Dimensions [mm]							Inserts
		R	L	a	b	L	h	s	L_2	e	
SCLCR/L0808D06		●	●	8	8	60	8	10	10	10	CC**0602**
SCLCR/L1010E06		●	●	10	10	70	10	12	10	10	CC**0602**
SCLCR/L1212F09		●	●	12	12	80	12	16	16	16	CC**09T3**
SCLCR/L1616H09		●	●	16	16	100	16	20	16	16	CC**09T3**
SCLCR/L2020K09		●	●	20	20	125	20	25	25	25	CC**09T3**
SCLCR/L1616H12		●	●	16	16	100	16	20	18	18	CC**1204**
SCLCR/L2020K12		●	●	20	20	125	20	25	25	25	CC**1204**
SCLCR/L2525M12		●	●	25	25	150	25	32	26	26	CC**1204**
SCLCR/L3225P12		○	○	32	25	170	32	32	26	26	CC**1204**
SCLCR/L3232P12		●	●	32	32	170	32	40	28	28	CC**1204**

● Ex stock ○ On demand

✼ With internal cooling

Spare parts

	Insert	**CC**0602****	**CC**09T3****	**CC**1204****
	h	**8-10**	**12-20**	**16-32**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5x8 (2.7 Nm)	
	Screw			I60M4×11X (3.4 Nm)
	Screw (shim)			SM6×10XA
	Shim			C12BS
	Wrench (screw)	WT07IP	WT15IP	WT15IP
	Wrench (shim)			WH40L

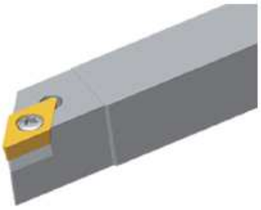
Insert

					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A102	A106	A107	A108	A107	A154

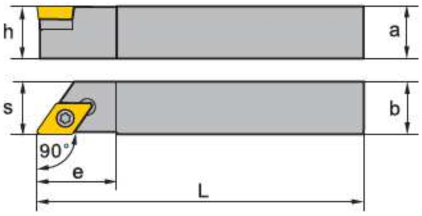
System code A194 Grade selection A40 Technical info A447 Cutting data A324

DC** holder (external) S-Clamping

SDACR/L Kr: 90°



Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SDACR/L1010E07		●	●	10	10	70	10	10.5	15	DC**0702**
SDACR/L1212F11		●	●	12	12	80	12	12.5	15	DC**11T3**
SDACR/L1616H11		●	●	16	16	100	16	16.7	24	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**11T3****	**DC**11T3****
	h	**10**	**12**	**16**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)			SM5×8.65XA
	Shim			D11BS
	Wrench (screw)	WT07IP	WT15IP	WT15IP
	Wrench (shim)			WH35L

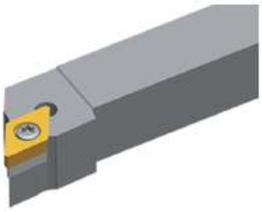
Insert

					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A112	A114	A115	A115	A115	A155

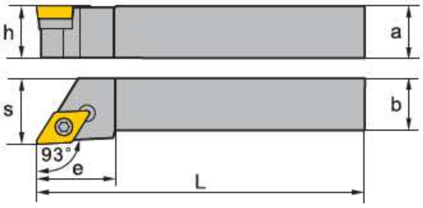
System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** holder (external) S-Clamping

SDJCR/L Kr: 93°



Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SDJCR/L1010E07		●	●	10	10	70	10	12	15	DC**0702**
SDJCR/L1212F07		●	●	12	12	80	12	16	15	DC**0702**
SDJCR/L1616H07		●	●	16	16	100	16	20	18	DC**0702**
SDJCR/L1616H11		●	●	16	16	100	16	20	24	DC**11T3**
SDJCR/L2020K11		●	●	20	20	125	20	25	24	DC**11T3**
SDJCR/L2525M11		●	●	25	25	150	25	32	29	DC**11T3**
SDJCR/L3225P11		●	●	32	25	170	32	32	29	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**11T3****
	h	**10-16**	**16-32**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		D11BS
	Wrench (screw)	WT07IP	WT15IP
	Wrench (shim)		WH35L

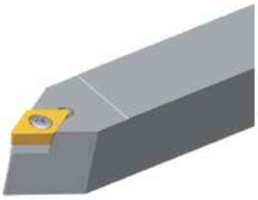
Insert

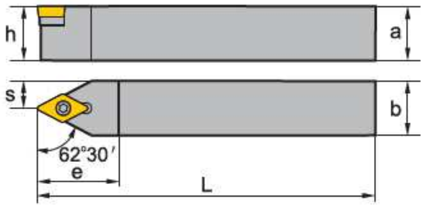
					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** holder (external) S-Clamping

SDNCN Kr: 62°30'





Article	✻	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
SDNCN1010E07		●	10	10	70	10	5	20	DC**0702**
SDNCN1212F07		●	12	12	80	12	6	20	DC**0702**
SDNCN1212H11		●	12	12	100	12	6	30	DC**11T3**
SDNCN1616H11		●	16	16	100	16	8	30	DC**11T3**
SDNCN2020K11		●	20	20	125	20	10	30	DC**11T3**
SDNCN2525M11		●	25	25	150	25	12.5	30	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**11T3****	**DC**11T3****
	h	**10-12**	**12**	**16-25**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)			SM5×8.65XA
	Shim			D11BS
	Wrench (screw)	WT07IP	WT15IP	WT15IP
	Wrench (shim)			WH35L

Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

A
Turning
B
Milling
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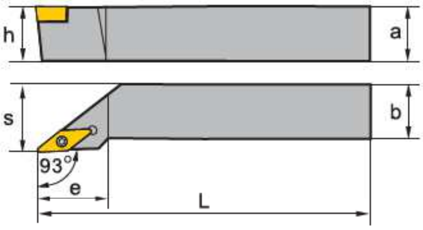
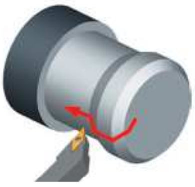
VB** holder (external) S-Clamping

SVJBR/L Kr: 93°

Right hand style





Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SVJBR/L1212F11		●	●	12	12	80	12	16	27	VB**1102**
SVJBR/L1616H11		●	●	16	16	100	16	20	27	VB**1102**
SVJBR/L2020K11		●	●	20	20	125	20	25	27	VB**1102**
SVJBR/L2525M11		●	●	25	25	150	25	32	27	VB**1102**
SVJBR/L1616H16		●	●	16	16	100	16	20	36	VB**1604**
SVJBR/L2020K16		●	●	20	20	125	20	25	41	VB**1604**
SVJBR/L2525M16		●	●	25	25	150	25	32	41	VB**1604**
SVJBR/L3225P16		●	●	32	25	170	32	32	41	VB**1604**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VB**1102****	**VB**1604****
	h	**12-25**	**16-32**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		V16BS
	Wrench (screw)	WT07IP	WT15IP
	Wrench (shim)		WH35L

Insert

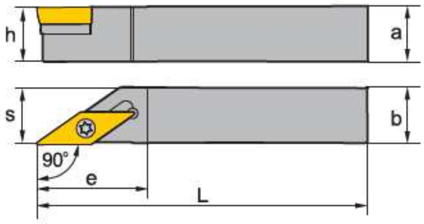
			
Finishing	**Medium Cut**	**Roughing**	**PCBN/PCD**
A140	A142	A143	A157

System code A194 Grade selection A40 Technical info A447 Cutting data A324

VB** holder (external) S-Clamping

SVABR/L Kr: 90°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SVABR/L1010F11		●	●	10	10	80	10			VB**1102**
SVABR/L1616H16		●	○	16	16	100	16	16.5	28	VB**1604**
SVABR/L2020K16		●	○	20	20	125	20	20.5	28	VB**1604**
SVABR/L2525M16		●	●	25	25	150	25	25.5	28	VB**1604**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	VB**1102**	VB**1604**
	h	10	16-32
	Screw	I60M2.5x6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		V16BS
	Wrench (screw)	WT07IP	WT15IP
	Wrench (shim)		WH35L

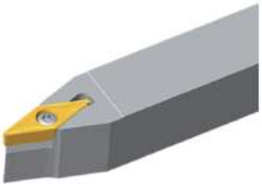
Insert

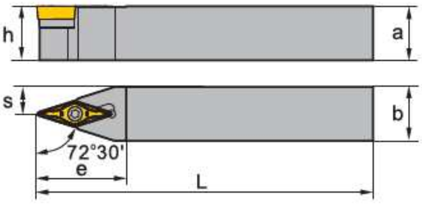
			
Finishing	**Medium Cut**	**Roughing**	**PCBN/PCD**
A140	A142	A143	A157

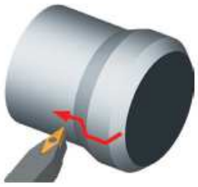
System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

VB** holder (external) **S-Clamping**

SVVBN Kr: 72°30'







Article	✲	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
SVVBN1212F11		●	12	12	80	12	6	27	VB**1102**
SVVBN1616H11		●	16	16	100	16	8	27	VB**1102**
SVVBN2020K11		●	20	20	125	20	10	30	VB**1102**
SVVBN1616H16		●	16	16	100	16	8	33	VB**1604**
SVVBN2020K16		●	20	20	125	20	10	33	VB**1604**
SVVBN2525M16		●	25	25	150	25	12.5	38	VB**1604**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VB**1102****	**VB**1604****
	h	**12-25**	**16-32**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		V16BS
	Wrench (screw)	WT07IP	WT15IP
	Wrench (shim)		WH35L

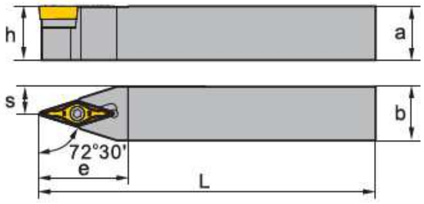
Insert

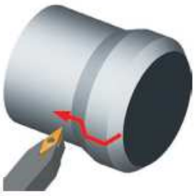
 **Finishing**	 **Medium Cut**	 **Roughing**	 **PCBN/PCD**
A140	A142	A143	A157

System code › A194 Grade selection › A40 Technical info › A447 Cutting data › A324

VC** holder (external) **S-Clamping**

SVVCN Kr: 72°30'





Article	✲	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
SVVCN1212F11		●	12	12	80	12	6	27	VC**1103**
SVVCN1616H11		●	16	16	100	16	8	27	VC**1103**
SVVCN2020K11		●	20	20	125	20	10	30	VC**1103**
SVVCN1212M11		●	12	12	150	12	6	27	VC**1103**
SVVCN2525M11		●	25	25	150	25	12.5	38	VC**1103**
SVVCN1616H16		●	16	16	100	16	8	33	VC**1604**
SVVCN2020K16		●	20	20	125	20	10	33	VC**1604**
SVVCN2525M16		●	25	25	150	25	12.5	38	VC**1604**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VC**1103****	**VC**1604****
	h	**12-25**	**16-32**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		V16BSC
	Wrench (screw)	WT07IP	WT15IP
	Wrench (shim)		WH35L

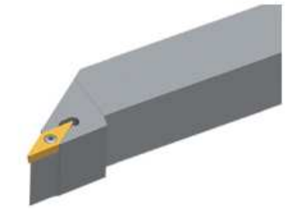
Insert

			
Finishing	**Medium Cut**	**Alum Machining**	**PCBN/PCD**
A135	A138	A136	A158

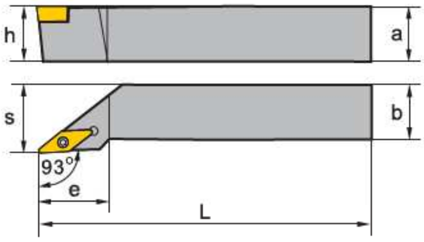
System code A194 Grade selection A40 Technical info A447 Cutting data A324

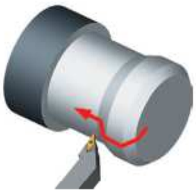
VC** holder (external) S-Clamping

SVJCR/L Kr: 93°



Right hand style





Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SVJCR/L1010E11		●		10	10	70	10	12	22	VC**1103**
SVJCR/L1212F11		●	●	12	12	80	12	16	27	VC**1103**
SVJCR/L1616H11		●	●	16	16	100	16	20	27	VC**1103**
SVJCR/L2020K11		●	●	20	20	125	20	25	27	VC**1103**
SVJCR/L2525M11		●	●	25	25	150	25	32	27	VC**1103**
SVJCR/L1616H16		●	●	16	16	100	16	20	36	VC**1604**
SVJCR/L2020K16		●	●	20	20	125	20	25	41	VC**1604**
SVJCR/L2020M16		●	●	20	20	150	20	25	41	VC**1604**
SVJCR/L2525M16		●	●	25	25	150	20	32	41	VC**1604**
SVJCR/L3225P16		○	○	32	25	170	32	32	41	VC**1604**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**VC**1103****	**VC**1604****
	h	**10-25**	**16-32**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		V16BSC
	Wrench (screw)	WT07IP	WT15IP
	Wrench (shim)		WH35L

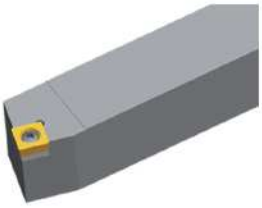
Insert

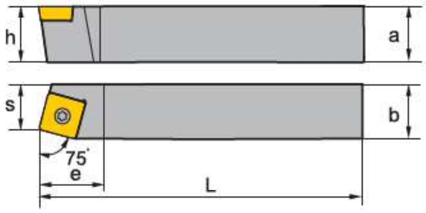
Finishing	**Medium Cut**	**Alum Machining**	**PCBN/PCD**
A135	A138	A136	A158

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

SC** steel boring bar **S-Clamping**

SSBCR/L Kr: 75°





Right hand style

Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SSBCR/L1212F09		●	●	12	12	80	12	11	16	SC**09T3**
SSBCR/L1616H09		●	●	16	16	100	16	13	16	SC**09T3**
SSBCR/L2020K12		●	●	20	20	125	20	17	25	SC**1204**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SC**09T3****	**SC**09T3****	**SC**1204****
	h	**12**	**16**	**20**
	Screw	I60M3.5×8 (2.7 Nm)	I60M3.5×8 (2.7 Nm)	
	Screw			I60M4×11X (3.4 Nm)
	Screw (shim)		SM5×8.65XA	SM6×10XA
	Shim		S09BS	S12BS
	Wrench (screw)	WT15IP	WT15IP	WT15IP
	Wrench (shim)		WH35L	WH40L

Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**
A120	A121	A122	A122

System code A194 | Grade selection A40 | Technical info A447 | Cutting data A324

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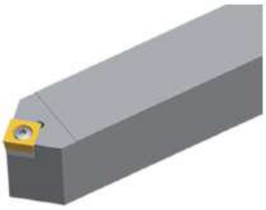
SC** steel boring bar S-Clamping

SSDCN Kr: 45°



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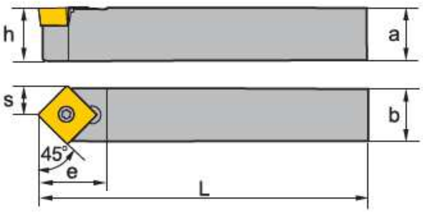


Article	✻	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
SSDCN1212F09		●	12	12	80	12	6	15.5	SC**09T3**
SSDCN1616H09		●	16	16	100	16	8	15.5	SC**09T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SC**09T3****	**SC**09T3****
	h	**12**	**16**
	Screw	I60M3.5×8 (2.7 Nm)	I60M3.5×8 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		S09BS
	Wrench (screw)	WT15IP	WT15IP
	Wrench (shim)		WH35L

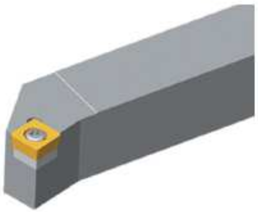
Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**
A120	A121	A122	A122

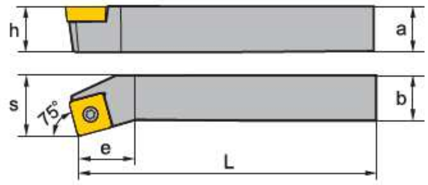
System code A194 Grade selection A40 Technical info A447 Cutting data A324

SC** steel boring bar **S-Clamping**

SSKCR/L Kr: 75°



Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SSKCR/L1616H09		●	●	16	16	100	16	20	13	SC**09T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SC**09T3****
	h	**16**
	Screw	I60M3.5×8 (2.7 Nm)
	Screw (shim)	SM5×8.65XA
	Shim	S09BS
	Wrench (screw)	WT15IP
	Wrench (shim)	WH35L

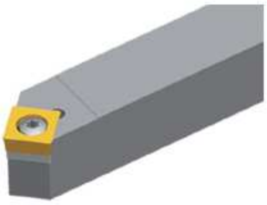
Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**
A120	A121	A122	A122

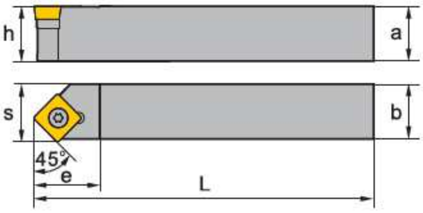
System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

SC** steel boring bar **S-Clamping**

SSSCR/L Kr: 45°



Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SSSCR/L1616H09		●	●	16	16	100	16	17	17	SC**09T3**
SSSCR/L2020K12		●	●	20	20	125	20	21	21	SC**1204**

● Ex stock ○ On demand
✻ With internal cooling

Spare parts

	Insert	**SC**09T3****	**SC**1204****
	h	**16**	**20**
	Screw	I60M3.5×12 (2.7 Nm)	
	Screw		I60M4×11X (3.4 Nm)
	Screw (shim)		SM6×10XA
	Shim		S12BS
	Wrench (screw)	WT15IP	WT15IP
	Wrench (shim)		WH40L

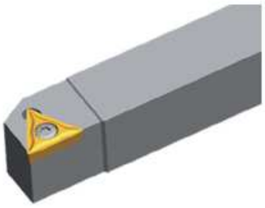
Insert

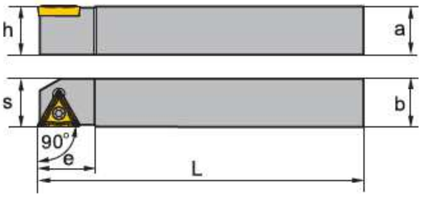
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**
A120	A121	A122	A122

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

TC** holder (external) **S-Clamping**

STACR/L Kr: 90°





Right hand style

Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
STACR/L1212F11		●	●	12	12	80	12	12.5	14	TC**1102**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**TC**1102****
	h	**12**
	Screw	I60M2.5×6.5 (1.0 Nm)
	Wrench (screw)	WT07IP

Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **PCBN/PCD**
A127	A128	A129	A131	A156

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

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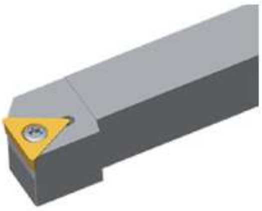
TC** holder (external) S-Clamping

STFCR/L Kr: 91°



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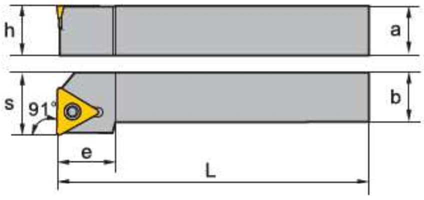


Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
STFCR/L1212F11		●	○	12	12	80	12	16	14	TC**1102**
STFCR/L1616H11		●	○	16	16	100	16	20	14	TC**1102**
STFCR/L1616H16		●	○	16	16	100	16	20	19	TC**16T3**
STFCR/L2020K16		●	●	20	20	125	20	25	19	TC**16T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TC**1102****	**TC**16T3****
	h	**12-16**	**16-20**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		T16BS
	Wrench (screw)	WT07IP	WT15IP
	Wrench (shim)		WH35L

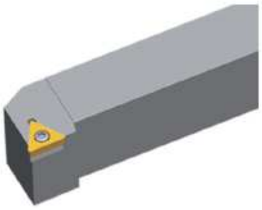
Insert

					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A127	A128	A129	A131	A129	A156

System code A194 Grade selection A40 Technical info A447 Cutting data A324

TC** holder (external) **S-Clamping**

STGCR/L Kr: 91°



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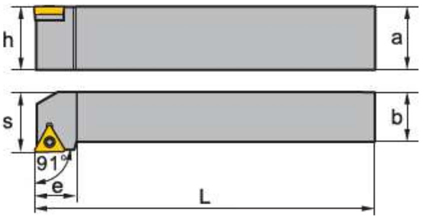


Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
STGCR/L0808D09		○	○	8	8	60	8	10	11	TC**0902**
STGCR/L1010E09		●	○	10	10	70	10	12	11	TC**0902**
STGCR/L1212F11		●	●	12	12	80	12	16	14	TC**1102**
STGCR/L1616H11		●	●	16	16	100	16	20	16	TC**1102**
STGCR/L2020K16		●	●	20	20	125	20	25	21	TC**16T3**
STGCR/L2525M16		●	●	25	25	150	25	25	21	TC**16T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**TC**0902****	**TC**1102****	**TC**16T3****
	h	**8-10**	**12-16**	**20-25**
	Screw	I60M2.2×5.5 (0.8 Nm)	I60M2.5×6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)			SM5×8.65XA
	Shim			T16BS
	Wrench (screw)	WT06IP	WT07IP	WT15IP
	Wrench (shim)			WH35L

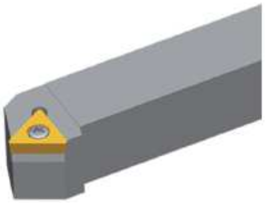
Insert

					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A126	A128	A129	A131	A129	A156

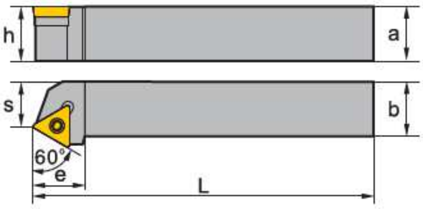
System code > A194
Grade selection > A40
Technical info > A447
Cutting data > A324

TC** holder (external) **S-Clamping**

STTCR/L Kr: 60°



Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	▲
STTCR/L1616H11		●	○	16	16	100	16	13	14	TC**1102**
STTCR/L1616H16		●	●	16	16	100	16	13	19	TC**16T3**
STTCR/L2020K16		●	●	20	20	125	20	17	19	TC**16T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**TC**1102****	**TC**16T3****
	h	**16**	**16-20**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		T16BS
	Wrench (screw)	WT07IP	WT15IP
	Wrench (shim)		WH35L

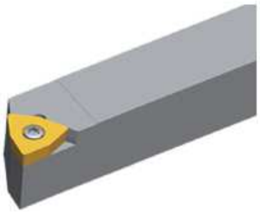
Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A127	A128	A129	A131	A129	A156

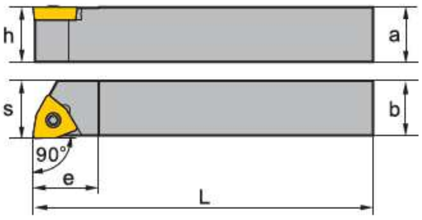
System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

WC** holder (external) S-Clamping

SWACR/L Kr: 90°



Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
SWACR/L1010E04		●	○	10	10	70	10	10.5	10	WC**0402**
SWACR/L1212F04		●	○	12	12	80	12	12	14	WC**0402**
SWACR/L1616H06		●	●	16	16	100	16	16.5	20	WC**06T3**
SWACR/L2020K08		●	●	20	20	125	20	20.5	24	WC**0804**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

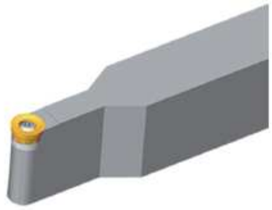
	Insert	**WC**0402****	**WC**06T3****	**WC**0804****
	h	**10-12**	**16**	**20**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3×7 (1.8 Nm)	I60M3.5×12 (2.7 Nm)
	Wrench (screw)	WT07IP	WT10IP	WT15IP

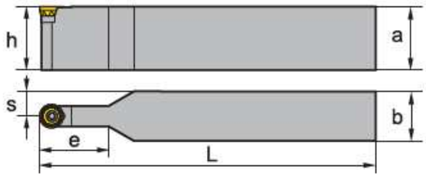
Insert
 **Medium Cut**
A144

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

RC** holder (external) S-Clamping

SRDCN





Article	✲	Stock	Dimensions [mm]						Inserts	
			a	b	L	h	s	e		
SRDCN1616H08		○	16	16	100	16	8	16	RCGX0803MO	RCMT0803MO
SRDCN2020K08		●	20	20	125	20	10	16	RCGX0803MO	RCMT0803MO
SRDCN2020K12		●	20	20	125	20	10	35	RCGX1204MO	RCMT1204MO
SRDCN2525M12		●	25	25	150	25	12.5	35	RCGX1204MO	RCMT1204MO
SRDCN3225P12		●	32	25	170	32	12.5	35	RCGX1204MO	RCMT1204MO
SRDCN2020K10		●	20	20	125	20	10	25	RCMT10T3MO	
SRDCN2525M10		●	25	25	150	25	12.5	25	RCMT10T3MO	
SRDCN3225P16		●	32	25	170	32	12.5	35	RCMT1606MO	
SRDCN3232P16		●	32	32	170	32	16	40	RCMT1606MO	
SRDCN4040S16		●	40	40	250	40	20	50	RCMT1606MO	
SRDCN4040S20		●	40	40	250	40	20	50	RCMT2006MO	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**RCGX0803MO**	**RCGX1204MO**	**RCMT10T3MO**	**RCMT1606MO**	**RCMT2006MO**
	h	**16-20**	**20-32**	**20-25**	**32-40**	**40**
	Screw	I60M3×7 (1.8 Nm)	I60M3.5×12 (2.7 Nm)	I60M3.5×10 (2.7 Nm)		I43M6*16 (9.1 Nm)
	Screw				I60M4×15X (3.4 Nm)	
	Screw (shim)		SM5×8.65XA		SM6×10XA	
	Shim		R12BS		R16BS	
	Wrench (screw)	WT10IP	WT15IP	WT15IP	WT15IP	
	Wrench (screw)					WT25IT
	Wrench (shim)		WH35L		WH40L	

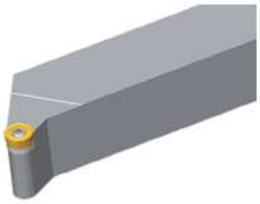
Insert

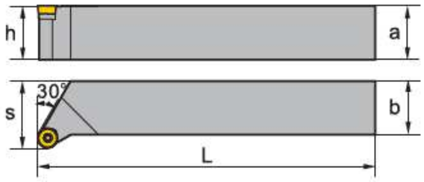
	
Alum Machining	**Cast Iron**
A118	A118

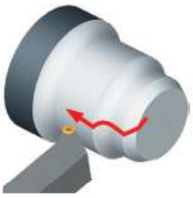
System code A194 Grade selection A40 Technical info A447 Cutting data A324

RC** holder (external) S-Clamping

SRGCR/L







Right hand style

Article	✻	Stock		Dimensions [mm]					Inserts	
		R	L	a	b	L	h	s		
SRGCR/L1616H08		●	●	16	16	100	16	20	RCGX0803MO-LH	RCMT0803MO
SRGCR/L2020K12		●	○	20	20	125	20	27	RCGX1204MO	RCMT1204MO
SRGCR/L2525M12		●	○	25	25	150	25	32	RCGX1204MO	RCMT1204MO
SRGCR/L2525M10		●	○	25	25	100	25	32	RCMT10T3MO	
SRGCR/L2020K10		●	○	20	20	125	20	25	RCMT10T3MO	

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**RCGX0803MO-LH**	**RCGX1204MO**	**RCMT10T3MO**
	h	**16**	**20-25**	**16-25**
	Screw	I60M3.5×10 (2.7 Nm)	I60M3.5×12 (2.7 Nm)	I60M3.5×10 (2.7 Nm)
	Screw (shim)		SM5×8.65XA	
	Shim		R12BS	
	Wrench (screw)	WT15IP	WT15IP	WT15IP
	Wrench (shim)		WH35L	

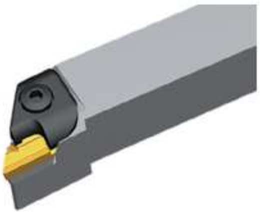
Insert

 **Alum Machining**	 **Cast Iron**
A118	A118

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

KNUX** holder C-Clamping

CKJNR/L Kr: 93°



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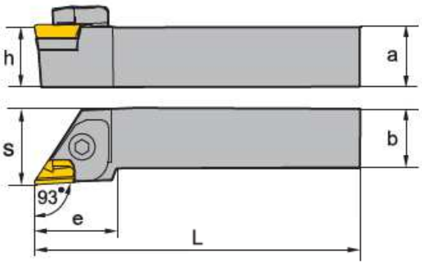


Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
CKJNL2525M16			●	25	25	150	25	32	32	KNUX1604**L
CKJNL3232P16			●	32	32	170	32	40	32	KNUX1604**L
CKJNL4040R16			●	40	40	200	40	50	32	KNUX1604**L
CKJNR2525M16		●		25	25	150	25	32	32	KNUX1604**R
CKJNR3232P16		●		32	32	170	32	40	32	KNUX1604**R
CKJNR4040R16		○		40	40	200	40	50	32	KNUX1604**R

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**KNUX1604**L**	**KNUX1604**R**
	h	**25-40**	**25-40**
	Clamp	C6L1T	C6R1T
	Dowel pin	P0515	P0515
	Screw (clamp)	CM6×25A (7.0 Nm)	CM6×25A (7.0 Nm)
	Screw (shim)	SM3×10B	SM3×10B
	Shim		K16CC
	Shim	K16CCL	
	Spring (clamp)	SPR1	SPR1
	Spring (dowel pin)	SPR2	SPR2
	Wrench (clamp)	WH40L	WH40L
	Wrench (shim)	WH20L	WH20L

Insert

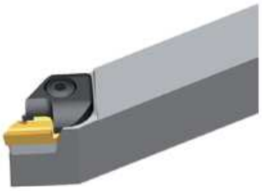
Finishing

A100

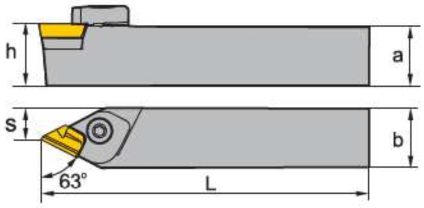
System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

KNUX** holder C-Clamping

CKNNR/L Kr: 63°



Right hand style



Article	✲	Stock		Dimensions [mm]					Inserts
		R	L	a	b	L	h	s	
CKNNL2525M16			●	25	25	150	25	14.3	KNUX1604**L
CKNNL3232P16			○	32	32	170	32	16.8	KNUX1604**L
CKNNR2525M16		●		25	25	150	25	14.3	KNUX1604**R

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**KNUX1604**L**	**KNUX1604**R**
	h	**25-32**	**25-32**
	Clamp	C6L1T	C6R1T
	Dowel pin	P0515	P0515
	Screw (clamp)	CM6×25A (7.0 Nm)	CM6×25A (7.0 Nm)
	Screw (shim)	SM3×10B	SM3×10B
	Shim		K16CC
	Shim	K16CCL	
	Spring (clamp)	SPR1	SPR1
	Spring (dowel pin)	SPR2	SPR2
	Wrench (clamp)	WH40L	WH40L
	Wrench (shim)	WH20L	WH20L

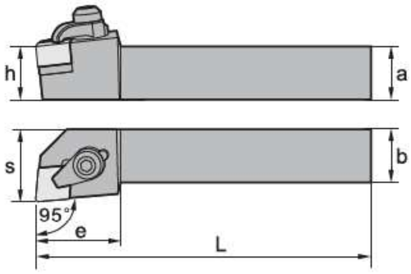
Insert

Finishing
A100

CN** holder (external) **C-Clamping**

CCLNR/L Kr: 95°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts	
		R	L	a	b	L	h	s	e		
CCLNR/L2020K12		○	○	20	20	125	20	27	32	CNGN1204**	CNGN1207**
CCLNR/L2525M12		○	●	25	20	100	25	27	36	CNGN1204**	CNGN1207**
CCLNR/L2525M16		○	○	25	25	150	25	32	36	CNGN1604**	CNGN1606**
CCLNR/L3225P16		○	○	32	25	170	32	32	36	CNGN1604**	CNGN1606**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CNGN1204****	**CNGN1207****	**CNGN1604****	**CNGN1606****
	h	**20-25**	**20-25**	**25-32**	**25-32**
	Clamp	C1RC	C1RC	C2RC	C2RC
	Screw (clamp)	CM6×30B (7.0 Nm)	CM6×30B (7.0 Nm)	CM8×30B (10.2 Nm)	CM8×30B (10.2 Nm)
	Screw (shim)	SM3×10B	SM3×10B	SM4×12B	SM4×12B
	Shim	C12CC-04	C12CC-07	C16CC-04	C16CC-06
	Spring	SPR1	SPR1	SPR3	SPR3
	Wrench (clamp)	WH40L	WH40L	WH50L	WH50L
	Wrench (shim)	WH20L	WH20L	WH30L	WH30L

Insert

PCBN/PCD

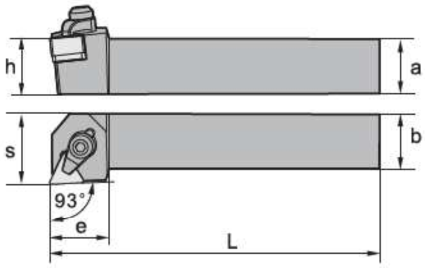
A159

System code A194 Grade selection A40 Technical info A447 Cutting data A324

TN** holder (external) C-Clamping

CTJNR/L Kr: 93°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts	
		R	L	a	b	L	h	s	e		
CTJNR/L2020K16		○	○	20	20	125	20	25	30	TNGN1604**	TNGN1607**
CTJNR/L2525M16		○	○	25	25	150	25	32	30	TNGN1604**	TNGN1607**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TNGN1604****	**TNGN1607****
	h	**20-25**	**20-25**
	Clamp	C1RC	C1RC
	Screw (clamp)	CM6×30B (7.0 Nm)	CM6×30B (7.0 Nm)
	Screw (shim)	SM3×10B	SM3×10B
	Shim	T16CC-04	T16CC-07
	Spring	SPR1	SPR1
	Wrench (clamp)	WH40L	WH40L
	Wrench (shim)	WH20L	WH20L

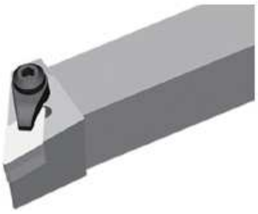
Insert
Medium Cut
A186

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

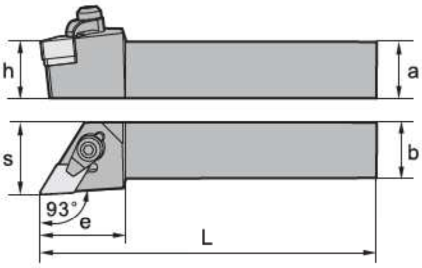
A Turning
B Milling
C Drilling
D Technical Information
E Index

DN** holder (external) C-Clamping

CDJNR/L Kr: 93°



Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts	
		R	L	a	b	L	h	s	e		
CDJNR/L2525M15		●	●	25	25	150	25	32	32	DNGN1504**	DNGN1507**
CDJNR/L3225P15		○	○	32	25	170	32	32	32	DNGN1504**	DNGN1507**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	DNGN1504**	DNGN1507**
	h	**25-32**	**25-32**
	Clamp	C1RC	C1RC
	Screw (clamp)	CM6×30B (7.0 Nm)	CM6×30B (7.0 Nm)
	Screw (shim)	SM3×10B	SM3×10B
	Shim	D15CC-04	D15CC-07
	Spring	SPR1	SPR1
	Wrench (clamp)	WH40L	WH40L
	Wrench (shim)	WH20L	WH20L

Insert

Medium Cut

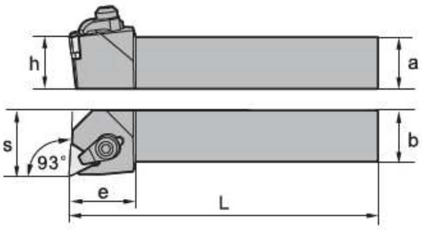
A180

System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

TN** holder (external) C-Clamping

CTUNR/L Kr: 93°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts	
		R	L	a	b	L	h	s	e		
CTUNR/L2525M16		○	○	25	25	150	25	32	27	TNGN1604**	TNGN1607**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TNGN1604****	**TNGN1607****
	h	**20-25**	**20-25**
	Clamp	C1RC	C1RC
	Screw (clamp)	CM6×30B (7.0 Nm)	CM6×30B (7.0 Nm)
	Screw (shim)	SM3×10B	SM3×10B
	Shim	T16CC-04	T16CC-07
	Spring	SPR1	SPR1
	Wrench (clamp)	WH40L	WH40L
	Wrench (shim)	WH20L	WH20L

Insert

Medium Cut
A186

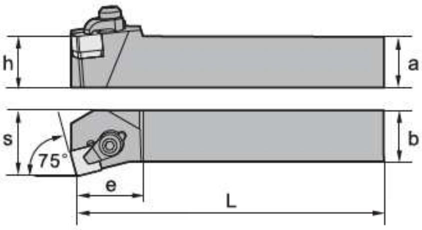
A Turning
B Milling
C Drilling
D Technical Information
E Index

System code A194 Grade selection A40 Technical info A447 Cutting data A324

SN** holder (external) C-Clamping

CSKNR/L Kr: 75°

Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts	
		R	L	a	b	L	h	s	e	🟨	🟨
CSKNR/L2020K12		○	○	20	20	125	20	25	25	SNGN1204**	SNGN1207**
CSKNR/L2525M12		○	○	25	25	170	25	32	25	SNGN1204**	SNGN1207**
CSKNR/L3225P12		○	○	32	25	170	32	32	25	SNGN1204**	SNGN1207**
CSKNR/L3225P15		○	○	32	25	170	32	32	30	SNGN1507**	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SNGN1204****	**SNGN1207****	**SNGN1507****
	h	**20-32**	**20-32**	**32**
	Clamp	C1RC	C1RC	C2RC
	Screw (clamp)	CM6×30B (7.0 Nm)	CM6×30B (7.0 Nm)	CM8×30B (10.2 Nm)
	Screw (shim)	SM3×10B	SM3×10B	SM4×12B
	Shim	S12CC-04	S12CC-07	S15CC-07
	Spring	SPR1	SPR1	SPR3
	Wrench (clamp)	WH40L	WH40L	WH50L
	Wrench (shim)	WH20L	WH20L	WH30L

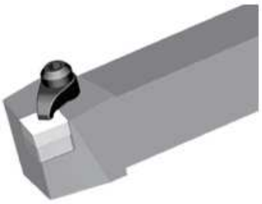
Insert

🟨	⬛
Cast Iron	**PCBN/PCD**
A77	A160

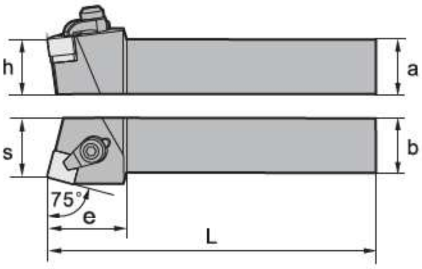
System code A194 Grade selection A40 Technical info A447 Cutting data A324

SN** holder (external) C-Clamping

CSRNR/L Kr: 75°



Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts	
		R	L	a	b	L	h	s	e	🟨	🟨
CSRNR/L2020K12		○	○	20	20	125	20	22	32	SNGN1204**	SNGN1207**
CSRNR/L2525M12		○	○	25	20	100	25	27	32	SNGN1204**	SNGN1207**
CSRNR/L3225P12		○	○	32	25	170	32	27	32	SNGN1204**	SNGN1207**
CSRNR/L3225P15		○	○	32	25	170	32	32	40	SNGN1507**	
CSRNR/L4040R15		○	○	40	40	200	40	43	40	SNGN1507**	

● Ex stock ○ On demand
✲ With internal cooling

Spare parts

	Insert	**SNGN1204****	**SNGN1207****	**SNGN1507****
	h	**20-32**	**20-32**	**32-40**
	Clamp	C1RC	C1RC	C2RC
	Screw (clamp)	CM6×30B (7.0 Nm)	CM6×30B (7.0 Nm)	CM8×30B (10.2 Nm)
	Screw (shim)	SM3×10B	SM3×10B	SM4×12B
	Shim	S12CC-04	S12CC-07	S15CC-07
	Spring	SPR1	SPR1	SPR3
	Wrench (clamp)	WH40L	WH40L	WH50L
	Wrench (shim)	WH20L	WH20L	WH30L

Insert

🟨	⬛
Cast Iron	**PCBN/PCD**
A77	A160

A
Turning
B
Milling
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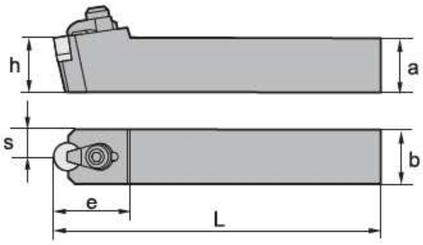
RN** holder (external) C-Clamping

CRDNN



Article	✲	Stock	Dimensions [mm]						Inserts	
			a	b	L	h	s	e		
CRDNN2020K12		○	20	20	125	20	10	32	RNGN1204**	RNGN1207**
CRDNN2525M12		○	25	25	150	25	12.5	32	RNGN1204**	RNGN1207**
CRDNN3225P12		○	32	25	170	32	12.5	32	RNGN1204**	RNGN1207**
CRDNN3232P15		○	32	32	170	32	17.5	40	RNGN1507**	
CRDNN4040R15		○	40	40	200	40	20	40	RNGN1507**	

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**RNGN1204****	**RNGN1207****	**RNGN1507****
	h	**20-32**	**20-32**	**32-40**
	Clamp	C1RC	C1RC	C2RC
	Screw (clamp)	CM6×30B (7.0 Nm)	CM6×30B (7.0 Nm)	CM8×30B (10.2 Nm)
	Screw (shim)	SM3×10B	SM3×10B	SM4×12B
	Shim	R12CC-04	R12CC-07	R15CC-07
	Spring	SPR1	SPR1	SPR3
	Wrench (clamp)	WH40L	WH40L	WH50L
	Wrench (shim)	WH20L	WH20L	WH30L

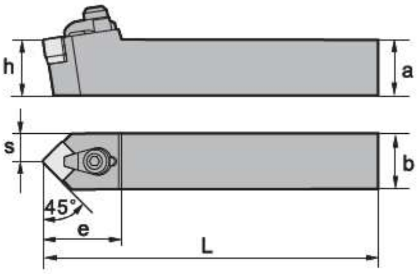
Insert

PCBN/PCD
A162

System code A194 Grade selection A40 Technical info A447 Cutting data A324

SN** holder (external) C-Clamping

CSDNN Kr: 45°



Article	✲	Stock	Dimensions [mm]						Inserts	
			a	b	L	h	s	e	🟨	🟨
CSDNN2020K12		○	20	20	125	20	10	35	SNGN1204**	SNGN1207**
CSDNN2525M12		●	25	25	150	25	12.5	30	SNGN1204**	SNGN1207**
CSDNN3225P12		○	32	25	170	32	12.5	35	SNGN1204**	SNGN1207**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SNGN1204****	**SNGN1207****
	h	**20-32**	**20-32**
	Clamp	C1RC	C1RC
	Screw (clamp)	CM6×30B (7.0 Nm)	CM6×30B (7.0 Nm)
	Screw (shim)	SM3×10B	SM3×10B
	Shim	S12CC-04	S12CC-07
	Spring	SPR1	SPR1
	Wrench (clamp)	WH40L	WH40L
	Wrench (shim)	WH20L	WH20L

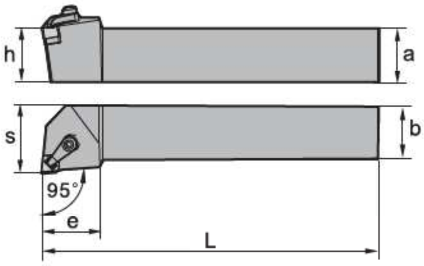
Insert

🟨	⬛
Cast Iron	**PCBN/PCD**
A77	A160

CN** holder (external) J-Clamping

JCLNR/L Kr: 95°

Right hand style



Article	✻	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
JCLNR/L2020K12		○	○	20	20	125	20	29	32	CNGX1207**
JCLNR/L2525M12		○	○	25	25	150	25	32	32	CNGX1207**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts		
	Insert	**CNGX1207****
	h	**20-25**
	Clamp	C1RJ
	Screw (clamp)	CM6×30B (7.0 Nm)
	Screw (shim)	SM3×10B
	Shim	C12CC-07
	Spring	SPR1
	Wrench (clamp)	WH40L
	Wrench (shim)	WH20L

Insert

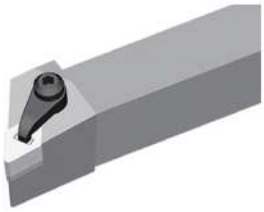
Medium Cut

A178

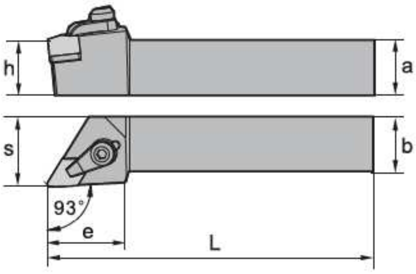
System code > A194 Grade selection > A40 Technical info > A447 Cutting data > A324

DN** holder (external) J-Clamping

JDJNR/L Kr: 93°



Right hand style



Article	✲	Stock		Dimensions [mm]						Inserts
		R	L	a	b	L	h	s	e	
JDJNR/L2525M15		●	○	25	25	150	25	32	38	DNGX1507**
JDJNR/L3225P15		○	○	32	25	170	32	32	38	DNGX1507**

● Ex stock ○ On demand

✲ With internal cooling

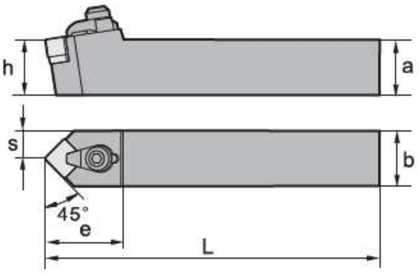
Spare parts		
	Insert	**DNGX1507****
	h	**25-32**
	Clamp	C1RJ
	Screw (clamp)	CM6×30B (7.0 Nm)
	Screw (shim)	SM3×10B
	Shim	D15CC-07
	Spring	SPR1
	Wrench (clamp)	WH40L
	Wrench (shim)	WH20L

Insert

Medium Cut
A181

SN** holder (external) J-Clamping

JSDNN Kr: 45°



Article	✻	Stock	Dimensions [mm]						Inserts
			a	b	L	h	s	e	
JSDNN2020K12		○	20	20	125	20	10	40	SNGX1207**
JSDNN2525M12		○	25	25	150	25	12.5	40	SNGX1207**
JSDNN3225P12		○	32	25	170	32	12.5	40	SNGX1207**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SNGX1207****
	h	**20-32**
	Clamp	C1RJ
	Screw (clamp)	CM6×30B (7.0 Nm)
	Screw (shim)	SM3×10B
	Shim	S12CC-07
	Spring	SPR1
	Wrench (clamp)	WH40L
	Wrench (shim)	WH20L

Insert

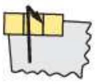
Medium Cut
A183

System code A194 Grade selection A40 Technical info A447 Cutting data A324

Notes

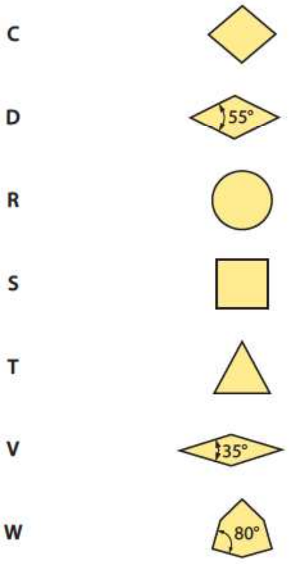
S	C	L	N	L	25	25	M	12	–	S	C
1	2	3	4	5	6	7	8	9		10	11

Clamping system

Code	Description
S	Knee lever clamping 

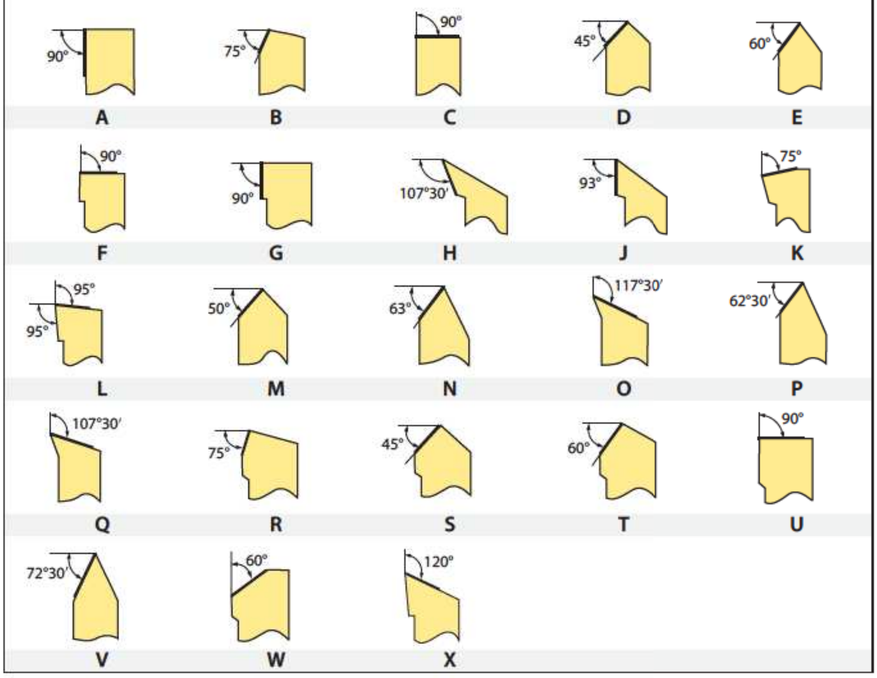
1

Insert shape



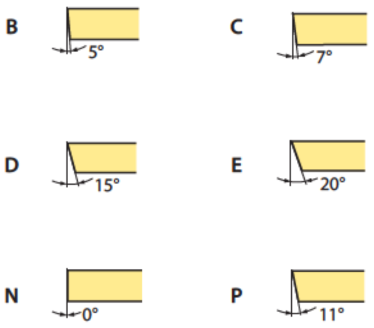
2

Tool holder type and entering angle



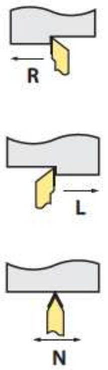
3

Clearance angle



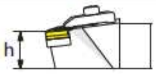
4

Cutting direction



5

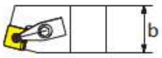
Shank height h [mm]



Code	h
12	12
16	16
20	20
25	25
32	32
40	40
50	50

6

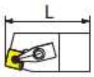
Shank width b [mm]



Code	b
12	12
16	16
20	20
25	25
32	32
40	40
50	50

7

Holder length L [mm]



Code	L
H	100
K	125
M	150
P	170
Q	180
R	200
S	250
T	300

8

Cutting edge length l [mm]

I.C [mm]	Insert shape						
	C	D	R	S	T	V	W
5,56					**09**		
6,35	**06**	**07**			**11**		
9,525	**09**	**11**	**09**	**09**	**16**	**16**	**06**
12,7	**12**	**15**	**12**	**12**	**22**	**22**	**08**
15,875	**16**	**19**	**15**	**15**	**27**		
19,05	**19**		**19**	**19**	**33**		
25,4	**25**		**25**	**25**	**44**		
32			**32**				

9

Swissturning

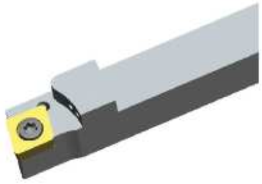
10

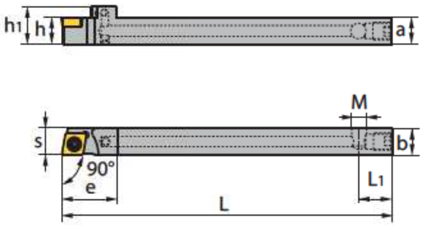
With inner cooling

11

CC** holder **S-Clamping**

SCACR/L-SC Kr: 90°





Article	✻	Stock		Dimensions [mm]									kg	Inserts
		R	L	a	b	L	h	h_1	s	L_1	e	M		
SCACR/L1212M09-SC	✻	●	●	12	12	150	12	17	12	15	25	M8X1	0.14	CC**09T3**
SCACR/L1616H09-SC	✻	●	●	16	16	100	16	21	16	15	28	M8X1	0.21	CC**09T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CC**09T3****
	h	**12-16**
	Screw	I60M3.5×8 (2.7 Nm)
	Wrench	WT15IP

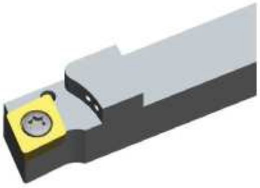
Insert

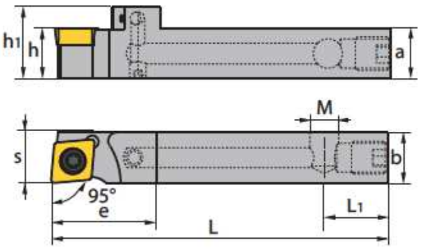
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A102	A106	A107	A108	A107	A154

System code A270 Grade selection A40 Technical info A447 Cutting data A324

CC** holder **S-Clamping**

SCLCR/L-SC Kr: 95°





Article	✲	Stock		Dimensions [mm]									kg	Inserts
		R	L	a	b	L	h	h_1	s	L_1	e	M		
SCLCR/L1010F06-S		●	●	10	10	80	10		10		10		0.06	CC**0602**
SCLCR/L1212F09-SC	✲	●	●	12	12	80	12	17	12	15	25	M8X1	0.07	CC**09T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**CC**0602****	**CC**09T3****
	h	**10**	**12**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)
	Wrench	WT07IP	WT15IP

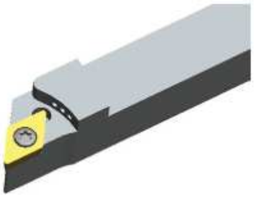
Insert

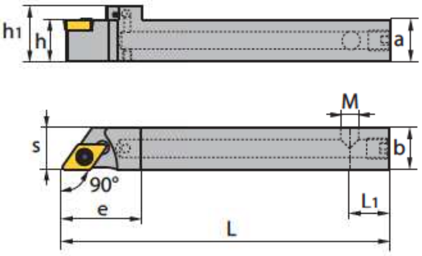
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A102	A106	A107	A108	A107	A154

System code > A270 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** holder **S-Clamping**

SDACR/L-SC Kr: 90°





Article	✻	Stock		Dimensions [mm]									kg	Inserts
		R	L	a	b	L	h	h_1	s	L_1	e	M		
SDACR/L1212M07-SC	✻	●	●	12	12	150	12	17	12	15	25	M8X1	0.15	DC**0702**
SDACR/L1616K11-SC	✻	●	●	16	16	125	16	21	16	15	30	M8X1	0.21	DC**11T3**
SDACR/L1212M11-SC	✻	●	●	12	12	150	12	17	12	15	30	M8X1	0.14	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**11T3****
	h	**12**	**12-16**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)
	Wrench	WT07IP	WT15IP

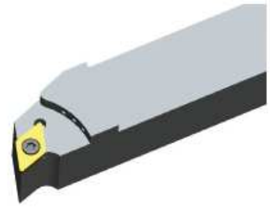
Insert

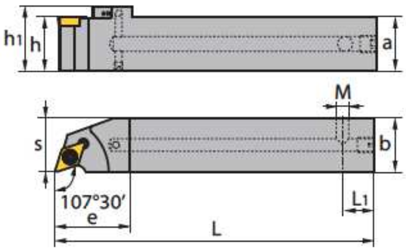
					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A270 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** holder S-Clamping

SDHCR/L-SC Kr: 107°30'





Article	✲	Stock	Dimensions [mm]									kg	Inserts
			a	b	L	h	h_1	s	L_1	e	M		
SDHCR/L2020K11-SC	✲	○	20	20	125	20	25	20	15	30	M8X1	0.35	DC**11T3**
SDHCR/L2525M11-SC	✲	●	25	25	150	25	30	25	15	35	M8X1	0.66	DC**11T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**DC**11T3****
	h	**20-25**
	Screw	I60M3.5×8 (2.7 Nm)
	Wrench	WT15IP

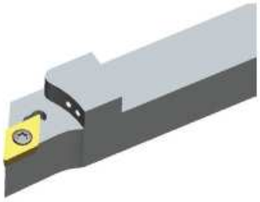
Insert

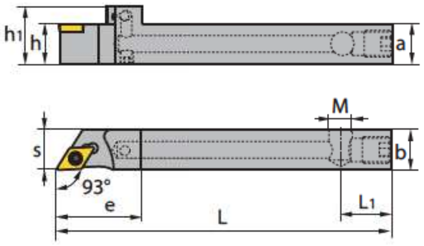
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A270 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** holder **S-Clamping**

SDJCR/L-SC Kr: 93°





Article	✻	Stock		Dimensions [mm]									kg	Inserts
		R	L	a	b	L	h	hh_1	s	L_1	e	M		
SDJCR/L1212H07-SC	✻	●	●	12	12	100	12	17	12	15	25	M8X1	0.1	DC**0702**
SDJCR/L1212H11-SC	✻	●	●	12	12	100	12	17	12	15	30	M8X1	0.1	DC**11T3**
SDJCR/L1616K11-SC	✻	●	●	16	16	125	16	21	16	15	30	M8X1	0.21	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**11T3****
	h	**12**	**12-16**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)
	Wrench	WT07IP	WT15IP

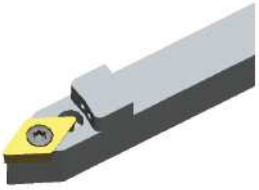
Insert

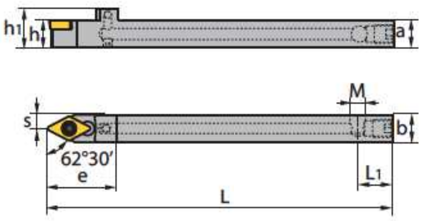
					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A270 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** holder **S-Clamping**

SDNCN-SC Kr: 62°30'





Article	✻	Stock	Dimensions [mm]									kg	Inserts
			a	b	L	h	h_1	s	L_1	e	M		
SDNCN1212M11-SC	✻	●	12	12	150	12	17	6	15	30	M8X1	0.14	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**11T3****
	h	**12**
	Screw	I60M3,5x8 (2.7 Nm)
	Wrench	WT15IP

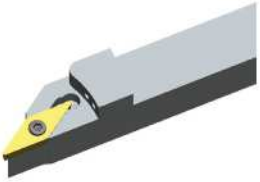
Insert

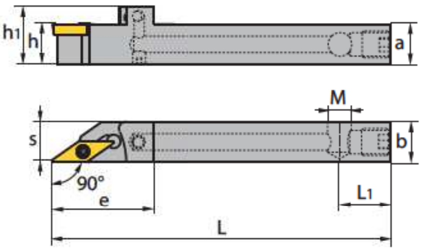
					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code › A270 Grade selection › A40 Technical info › A447 Cutting data › A324

VC** holder **S-Clamping**

SVACR/L-SC Kr: 90°





Article	✲	Stock		Dimensions [mm]									kg	Inserts
		R	L	a	b	L	h	h_1	s	L_1	e	M		
SVACR/L1212H11-SC	✲	●	●	12	12	100	12	17	12	15	30	M8X1	0.1	VC**1103**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VC**1103****
	h	**12**
	Screw	I60M2.5×6.5 (1.0 Nm)
	Wrench	WT07IP

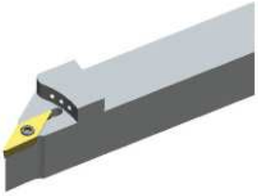
Insert

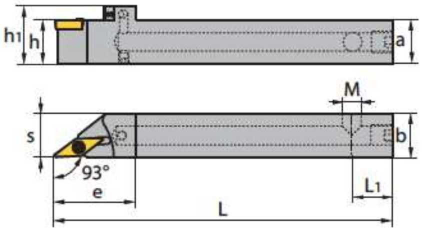
 **Finishing**	 **Alum Machining**
A135	A136

System code A270 Grade selection A40 Technical info A447 Cutting data A324

VC** holder **S-Clamping**

SVJCR/L-SC Kr: 93°





Article	✻	Stock		Dimensions [mm]									kg	Inserts
		R	L	a	b	L	h	h_1	s	L_1	e	M		
SVJCR/L0808H11-S		●	●	8	8	100	8		8		22		0.044	VC**1103**
SVJCR/L1212H11-SC	✻	●	●	12	12	100	12	17	12	15	30	M8X1	0.095	VC**1103**
SVJCR/L1616K11-SC	✻	●	●	16	16	125	16	21	16	15	30	M8X1	0.2	VC**1103**

● Ex stock ○ On demand

✻ With internal cooling

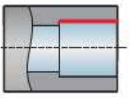
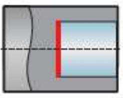
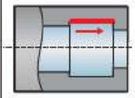
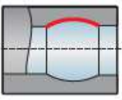
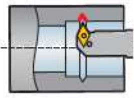
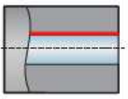
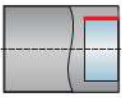
Spare parts

	Insert	**VC**1103****
	h	**8-16**
	Screw	I60M2.5×6.5 (1.0 Nm)
	Wrench	WT07IP

Insert

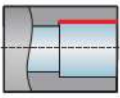
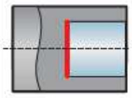
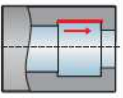
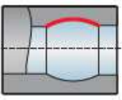
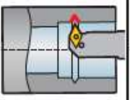
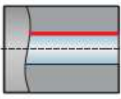
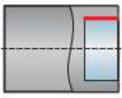
	
Finishing	**Alum Machining**
A135	A136

Boring bars

Boring bar		Application					Workpiece		Page
		Longitudinal turning	Facing	Undercut	Contouring	Profiling	Stable	Unstable	
									
P	**PDSNR/L** **62°30'** 	●		●	●	●	●		A286
	PCLNR/L **95°** 	●	●				●	●	A284
	PDUNR/L **93°** 	●			●	●	●	●	A287
	PSKNR/L **75°** 	●					●		A289
	PTFNR/L **91°** 	●					●		A290
	PWLNR/L **95°** 	●	●				●		A291
S	**SCFCR/L** **90°** 	●					●	●	A310
	SCLCR/L **95°** 	●	●				●		A293
	SCLPR/L **95°** 	●	●				●	●	A306
	SDQCR/L **107°30'** 	●			●	●	●	●	A295
	SDQPR/L **107°30'** 	●			●	●	●	●	A307
	SDUCR/L **93°** 	●			●	●	●	●	A296
	SDUPR/L **93°** 	●			●		●	●	A308
	SDZCR/L **95°** 			●			●		A297
	SSKCR/L **75°** 	●					●		A298

● Recommended

Boring bars

	Boring bar	Application					Workpiece		Page
		Longitudinal turning	Facing	Undercut	Contouring	Profiling	Stable	Unstable	
									
S	**STFCR/L** **91°** 	●							A300
	STUPR/L **93°** 	●							A309
	SVQBR/L **107°30'** 	●			●	●			A304
	SVQCR/L **107°30'** 	●							A302
	SVUBR/L **93°** 	●			●	●			A305
	SVUCR/L **93°** 	●			●	●			A303
Anti-vibratoire	**SCLPR/L** **95°** 	●	●						A312
	SDQPR/L **107°30'** 	●			●	●			A314
	SDUPR/L **93°** 	●							A316
	STUPR/L **93°** 	●							A318
	SVQCR/L **107°30'** 	●			●	●			A321
	SVUCR/L **93°** 	●			●	●			A322

● Recommended

General turning ISO-Code – boring bars

S	16	R	–	S	D	U	C	R	07
1	2	3		4	5	6	7	8	9

Shank type

Code	Description
A	Steel shank (IC)
C	Solid carbide shank
E	Solid carbide shank (IC)
S	Steel shank
X	Special application

1

Shank diameter d [mm]

Code	d
16	16
20	20
25	25
32	32
40	40
50	50

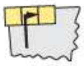
2

Clamping system

Code	L
H	100
K	125
M	150
N	160
Q	180
R	200
S	250
T	300
U	350
V	400

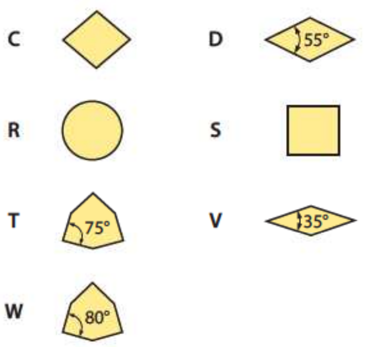
3

Clamping system

Code	Description	
P	Knee lever clamping	
S	Screw clamping	

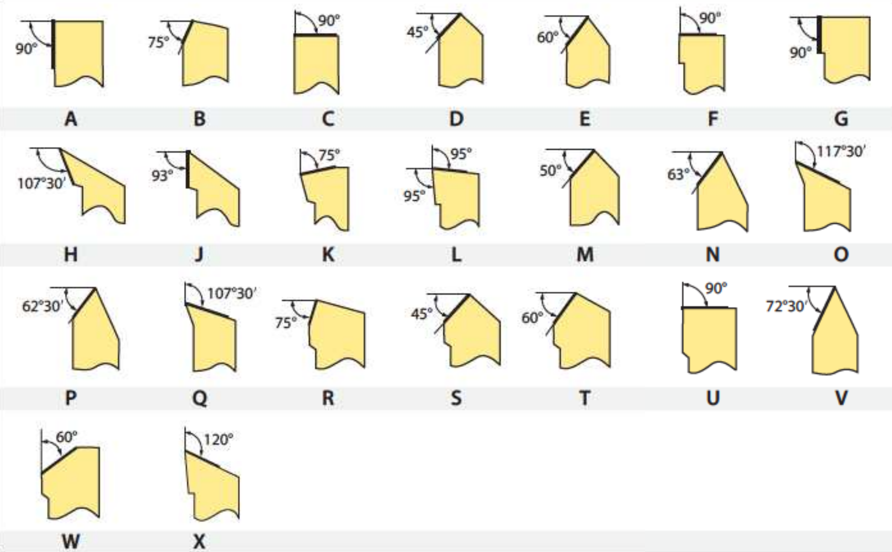
4

Insert shape



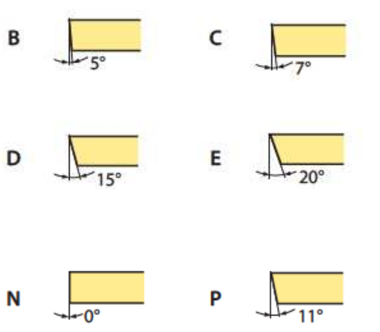
5

Tool holder type and entering angle



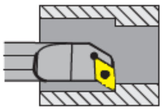
6

Clearance angle

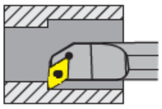


7

Cutting direction



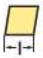
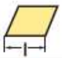
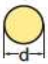
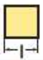
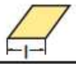
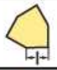
L



R

8

Cutting edge length l [mm]

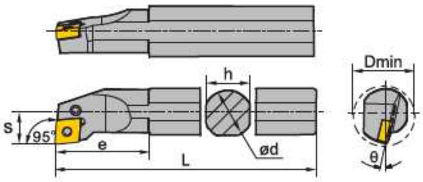
I.C [mm]	Insert shape						
	 C	 D	 R	 S	 T	 V	 W
5,56					**09**		
6,35	**06**	**07**			**11**		
9,525	**09**	**11**	**09**	**09**	**16**	**16**	**06**
12,7	**12**	**15**	**12**	**12**	**22**	**22**	**08**
15,875	**16**	**19**	**15**	**15**	**27**		
19,05	**19**		**19**	**19**	**33**		
25,4	**25**		**25**	**25**	**44**		
32			**32**				

9

CN** steel boring bar **P-Clamping**

PCLNR/L Kr: 95°

Right hand style



Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	S	e	D_{min}	θ	
S16M-PCLNR/L09		●	●	16	150	15	11	28	20	-12	CN**0903**
S16R-PCLNR/L09		●	●	16	200	15	11	28	20	-12	CN**0903**
S20Q-PCLNR/L09		●	●	20	180	18	13	31	25	-11	CN**0903**
S20S-PCLNR/L09		●	●	20	250	18	13	31	25	-11	CN**0903**
S25Q-PCLNR/L09		○	○	25	180	23	17	35	32	-10	CN**0903**
S25T-PCLNR/L09		●	○	25	300	23	17	35	32	-10	CN**0903**
S25Q-PCLNR/L12		○	○	25	180	23	17	40	32	-12	CN**1204**
S25T-PCLNR/L12		●	●	25	300	23	17	40	32	-12	CN**1204**
S32R-PCLNR/L12		●	●	32	200	30	22	50	44	-10	CN**1204**
S32U-PCLNR/L12		●	●	32	350	30	22	50	44	-10	CN**1204**
S40S-PCLNR/L12		○	●	40	250	37	27	55	54	-10	CN**1204**
S40V-PCLNR/L12		●	●	40	400	37	27	55	54	-10	CN**1204**
S50S-PCLNR/L12		○	○	50	250	47	35	56	63	-10	CN**1204**
S50W-PCLNR/L12		●	●	50	450	47	35	56	63	-10	CN**1204**
A25R-PCLNR/L12	✻	●	●	25	200	24	17	40	32	-12	CN**1204**
A32S-PCLNR/L12	✻	●	●	32	250	31	22	50	44	-10	CN**1204**
S50S-PCLNR/L19		○	○	50	250	47	35	63	63	-10	CN**1906**
S50W-PCLNR/L19		●	○	50	450	47	35	63	63	-10	CN**1906**

● Ex stock ○ On demand

✻ With internal cooling

System code A282 Grade selection A40 Technical info A447 Cutting data A324

CN** steel boring bar

Spare parts

	Insert	CN**0903**	CN**1204**	CN**1204**	CN**1906**
	ød	**16-25**	**25**	**32-50**	**50**
	Knee lever	L3C	L4A	L4	L6
	Screw	LEM5×12B (4.0 Nm)			
	Screw		LEM8×21 (10.2 Nm)	LEM8×21 (10.2 Nm)	LEM10×27 (16.6 Nm)
	Shim pin (shim)			SP4	SP6
	Shim				C19AP
	Shim			C12APB	
	Wrench	WH20L	WH25L	WH30L	WH40L

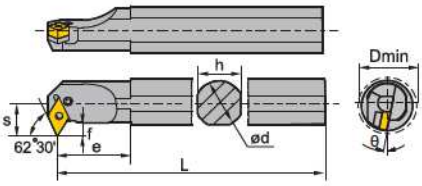
Insert

 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A45	A45	A46	A53	A53	A148

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

DN** steel boring bar P-Clamping

PDSNR/L Kr: 62°30'



Right hand style

Article	✻	Stock		Dimensions [mm]								Inserts
		R	L	ød	L	h	s	e	f	D_{min}	θ	
S32R-PDSNR/L15-3		○	○	32	200	30	22	45	8.5	40	-11	DN**1504**
S40V-PDSNR/L15-3		●		40	400	37	27	43	9.4	50	-11	DN**1504**
A32S-PDSNR/L15-3	✻	○	○	32	250	31	22	45	8.5	40	-11	DN**1504**
S32R-PDSNR/L15		●	●	32	200	30	22	45	8.5	40	-11	DN**1506**
S32U-PDSNR/L15		●	●	32	350	30	22	45	8.5	40	-11	DN**1506**
S40S-PDSNR/L15		○	○	40	250	37	27	43	9.4	50	-11	DN**1506**
S40V-PDSNR/L15		○	○	40	400	37	27	43	9.4	50	-11	DN**1506**
A32S-PDSNR/L15	✻	●	●	32	250	31	22	45	8.5	40	-11	DN**1506**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DN**1504****	**DN**1506****
	ød	**32-40**	**32-40**
	Knee lever	L4	L4B
	Screw	LEM8×21 (10.2 Nm)	LEM8×21 (10.2 Nm)
	Shim pin (shim)	SP4	SP4
	Shim	D15AP	D15AP
	Wrench	WH30L	WH30L

Insert

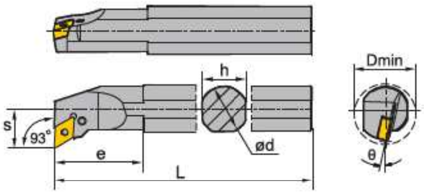
 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A55	A55	A56	A60	A61	A149

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

DN** steel boring bar **P-Clamping**

PDUNR/L Kr: 93°

Right hand style



Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S20Q-PDUNR/L11		●	○	20	180	18	13	30	25	-16	DN**1104**
S20S-PDUNR/L11		●	●	20	250	18	13	30	25	-16	DN**1104**
S25Q-PDUNR/L11		●	●	25	180	23	17	35	32	-13	DN**1104**
S25T-PDUNR/L11		●	●	25	300	23	17	35	32	-13	DN**1104**
S32R-PDUNR/L11		○	○	32	200	30	22	40	40	-16	DN**1104**
S32U-PDUNR/L11		●	●	32	350	30	22	40	40	-16	DN**1104**
S32R-PDUNR/L15-3		○	○	32	200	30	22	50	40	-16	DN**1504**
S32U-PDUNR/L15-3		●	●	32	350	30	22	50	40	-16	DN**1504**
S40S-PDUNR/L15-3		○	○	40	250	37	27	50	50	-11	DN**1504**
S40V-PDUNR/L15-3		●	●	40	400	37	27	50	50	-11	DN**1504**
A32S-PDUNR/L15-3	✲	●	●	32	250	31	22	50	40	-16	DN**1504**
S32R-PDUNR/L15		○	○	32	200	30	22	50	40	-16	DN**1506**
S32U-PDUNR/L15		●	●	32	350	30	22	50	40	-16	DN**1506**
S40S-PDUNR/L15		○	○	40	250	37	27	50	50	-11	DN**1506**
S40V-PDUNR/L15		●	●	40	400	37	27	50	50	-11	DN**1506**
A32S-PDUNR/L15	✲	●	●	32	250	31	22	50	40	-16	DN**1506**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**DN**1104****	**DN**1104****	**DN**1504****	**DN**1506****
	ød	**20-25**	**32**	**32-40**	**32-40**
	Knee lever	L3D	L3	L4	L4B
	Screw	LEM5×12B (4.0 Nm)	LEM6×17 (7.0 Nm)		
	Screw			LEM8×21 (10.2 Nm)	LEM8×21 (10.2 Nm)
	Shim pin (shim)		SP3	SP4	SP4
	Shim		D11AP	D15AP	D15AP
	Wrench	WH20L	WH25L	WH30L	WH30L

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

DN** steel boring bar

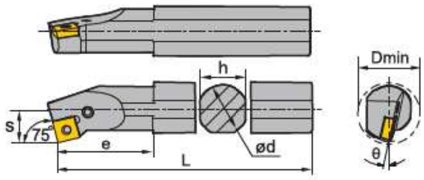
Insert					
 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A55	A55	A56	A60	A61	A149

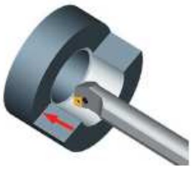
System code A282
Grade selection A40
Technical info A447
Cutting data A324

SN** steel boring bar **P-Clamping**

PSKNR/L Kr: 75°

Right hand style





Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S25Q-PSKNR/L12		○	●	25	180	23	17	42	32	-12	SN**1204**
S25T-PSKNR/L12		●	○	25	300	23	17	42	32	-12	SN**1204**
S32R-PSKNR/L12		○	○	32	200	30	22	45	44	-10	SN**1204**
S32U-PSKNR/L12		●	●	32	350	30	22	45	44	-10	SN**1204**
S40S-PSKNR/L12		○	○	40	250	37	27	50	54	-10	SN**1204**
S40V-PSKNR/L12		●	○	40	400	37	27	50	54	-10	SN**1204**
A25R-PSKNR/L12	✻	●	●	25	200	24	17	42	32	-12	SN**1204**
A32S-PSKNR/L12	✻	●	●	32	250	31	22	50	44	-12	SN**1204**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**SN**1204****	**SN**1204****
	ød	**25**	**32-40**
	Knee lever	L4A	L4
	Screw		LEM8×21 (10.2 Nm)
	Screw	LEM6×13.4A (7.0 Nm)	
	Shim pin (shim)		SP4
	Shim		S12APB
	Wrench	WH25L	WH30L

Insert

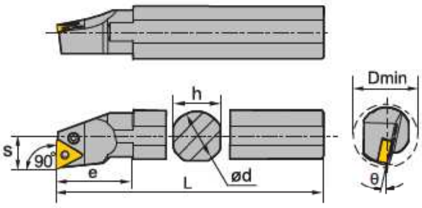
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A63	A65	A68	A74	A150

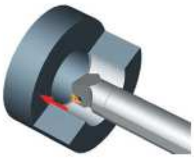
System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

TN** steel boring bar **P-Clamping**

PTFNR/L Kr: 90°

Right hand style





Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D$_{min}$	θ	
S16M-PTFNR/L11		○	○	16	150	15	11	28	20	-14	TN**1103**
S16R-PTFNR/L11		●	●	16	200	15	11	28	20	-14	TN**1103**
S20Q-PTFNR/L11		●	●	20	180	18	13	31	25	-12	TN**1103**
S20S-PTFNR/L11		●	●	20	250	18	13	31	25	-12	TN**1103**
S25Q-PTFNR/L11		○	○	25	180	23	17	35	32	-10	TN**1103**
S25T-PTFNR/L11		○	○	25	300	23	17	35	32	-10	TN**1103**
S25Q-PTFNR/L16		○	○	25	180	23	17	42	32	-12	TN**1604**
S25T-PTFNR/L16		●	●	25	300	23	17	42	32	-12	TN**1604**
S32R-PTFNR/L16		○	○	32	200	30	22	50	44	-10	TN**1604**
S32U-PTFNR/L16		●	●	32	350	30	22	50	44	-10	TN**1604**
S40S-PTFNR/L16		○	○	40	250	37	27	55	54	-10	TN**1604**
S40V-PTFNR/L16		●	●	40	400	37	27	55	54	-10	TN**1604**
A25R-PTFNR/L16	✻	●	○	25	200	24	17	40	32	-12	TN**1604**
A32S-PTFNR/L16	✻	●	●	32	250	31	22	50	44	-10	TN**1604**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	TN**1103**	TN**1604**	TN**1604**
	ød	16-25	25	32-40
	Knee lever	L2	L3B	L3
	Screw	LEM5×9B (4.0 Nm)	LEM5×12B (4.0 Nm)	LEM6×17 (7.0 Nm)
	Shim pin (shim)			SP3
	Shim			T16APB
	Wrench	WH20L	WH20L	WH25L

Insert

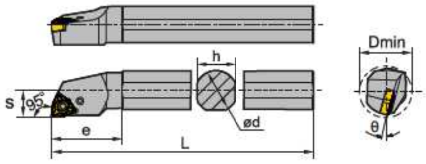
 **Wiper**	 **Finishing**	 **Medium Cut**	 **Roughing**	 **Cast Iron**	 **PCBN/PCD**
A78	A79	A81	A84	A88	A151

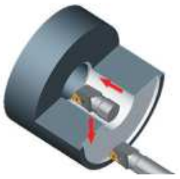
System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

WN** steel boring bar **P-Clamping**

PWLNR/L Kr: 95°

Right hand style





Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S16M-PWLNR/L06		●	●	16	150	15	11	25	20	-13	WN**0604**
S16R-PWLNR/L06		○		16	200	15	11	25	20	-13	WN**0604**
S20Q-PWLNR/L06		●	●	20	180	18	13	35	25	-13	WN**0604**
S20S-PWLNR/L06		●	○	20	250	18	13	35	25	-13	WN**0604**
S25Q-PWLNR/L06		○	○	25	180	23	17	35	32	-13	WN**0604**
S25T-PWLNR/L06		○		25	300	23	17	35	32	-13	WN**0604**
S20Q-PWLNR/L08		●	●	20	180	18	13	32	25	-13	WN**0804**
S20S-PWLNR/L08		●		20	250	18	13	32	25	-13	WN**0804**
S25Q-PWLNR/L08		●	○	25	180	23	17	45	32	-13	WN**0804**
S25T-PWLNR/L08		●	●	25	300	23	17	45	32	-13	WN**0804**
S32R-PWLNR/L08		●	●	32	200	30	22	50	40	-15	WN**0804**
S32U-PWLNR/L08		●	●	32	350	30	22	50	40	-15	WN**0804**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**WN**0604****	**WN**0804****	**WN**0804****
	ød	**16-25**	**20-25**	**32**
	Knee lever	L3B	L4A	L4
	Screw	LEM5×12B (4.0 Nm)		
	Screw			LEM8×21 (10.2 Nm)
	Screw		LEM6×13.4A (7.0 Nm)	
	Shim pin (shim)			SP4
	Shim			W08AP
	Wrench	WH20L	WH25L	WH30L

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

WN** steel boring bar

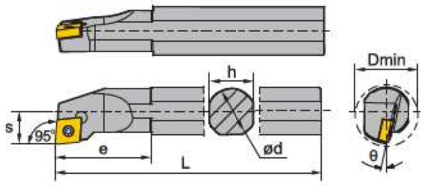
Insert					
					
Wiper	**Finishing**	**Medium Cut**	**Roughing**	**Cast Iron**	**PCBN/PCD**
A95	A94	A97	A98	A98	A153

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

CC** steel boring bar **S-Clamping**

SCLCR/L Kr: 95°

Right hand style



Article	✻	Stock		Dimensions [mm]								Inserts
		R	L	ød	L	h	s	L_2	e	D_{min}	θ	
S08K-SCLCR/L06		●	●	8	125	7	5	14	14	10	-15	CC**0602**
S10K-SCLCR/L06		●	●	10	125	7	5	14	14	10	-15	CC**0602**
S10M-SCLCR/L06		●	●	10	150	9	6	14	14	12	-13	CC**0602**
S12M-SCLCR/L06		●	●	12	150	11	9	25	25	16	-10	CC**0602**
A08F-SCLCR/L06	✻	●	●	8	80	7.5	5	14	14	10	-15	CC**0602**
A10H-SCLCR/L06	✻	●	●	10	100	9.5	6	14	14	12	-13	CC**0602**
A12K-SCLCR/L06	✻	●	●	12	125	11.5	9	25	25	16	-10	CC**0602**
S12M-SCLCR/L09		●	●	12	150	11	9	25	25	16	-10	CC**09T3**
S16M-SCLCR/L09		●	○	16	150	15	11	32.5	32.5	20	-12	CC**09T3**
S16R-SCLCR/L09		●	●	16	200	15	11	32.5	32.5	20	-12	CC**09T3**
S20Q-SCLCR/L09		●	●	20	180	18	13	38	38	25	-8	CC**09T3**
S20S-SCLCR/L09		●	●	20	250	18	13	38	38	25	-8	CC**09T3**
S25Q-SCLCR/L09		●	○	25	180	23	17	45	45	32	-6	CC**09T3**
S25T-SCLCR/L09		●	●	25	300	23	17	45	45	32	-6	CC**09T3**
A12K-SCLCR/L09	✻	●	●	12	125	11.5	9	25	25	16	-10	CC**09T3**
A16M-SCLCR/L09	✻	●	●	16	150	15.5	11	32.5	32.5	20	-12	CC**09T3**
A20Q-SCLCR/L09	✻	●	●	20	180	19	13	38	38	25	-8	CC**09T3**
A25R-SCLCR/L09	✻	●	●	25	200	24	17	45	45	32	-6	CC**09T3**
S25Q-SCLCR/L12		●	○	25	180	23	17	45	45	32	-6	CC**1204**
S25T-SCLCR/L12		●	●	25	300	23	17	45	45	32	-6	CC**1204**
S32R-SCLCR/L12		●	●	32	200	30	22	50	50	40	-10	CC**1204**
S32U-SCLCR/L12		●	●	32	350	30	22	50	50	40	-10	CC**1204**
S40S-SCLCR/L12		○		40	250	37	27	60	60	50	-8	CC**1204**
S40V-SCLCR/L12		●	●	40	400	37	27	60	60	50	-8	CC**1204**
A25R-SCLCR/L12	✻	●	●	25	200	24	17	45	45	32	-6	CC**1204**
A32S-SCLCR/L12	✻	●	●	32	250	31	22	50	50	40	-10	CC**1204**

● Ex stock ○ On demand

✻ With internal cooling

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

CC** steel boring bar

Spare parts

	Insert	**CC**0602****	**CC**09T3****	**CC**09T3****	**CC**1204****	**CC**1204****
	ød	**8-12**	**12-20**	**25**	**25**	**32-40**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)	I60M3.5×10 (2.7 Nm)		
	Screw				I60M4×11X (3.4 Nm)	I60M4×11X (3.4 Nm)
	Screw (shim)					SM6×10XA
	Shim					C12BS
	Wrench (screw)	WT07IP	WT15IP	WT15IP	WT15IP	WT15IP
	Wrench (shim)					WH40L

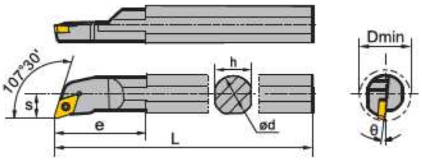
Insert

					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A102	A106	A107	A108	A107	A154

System code > A282
Grade selection > A40
Technical info > A447
Cutting data > A324

DC** steel boring bar **S-Clamping**

SDQCR/L Kr: 107°30'



Right hand style

Article	✲	Stock		Dimensions [mm]								Inserts
		R	L	ød	L	h	s	L_2	e	D_{min}	θ	
S10M-SDQCR/L07		●	●	10	150	9	7	20	20	13	-8	DC**0702**
S12M-SDQCR/L07		●	●	12	150	11	9	22	22	16	-8	DC**0702**
S16M-SDQCR/L07		○	●	16	150	15	11	27	27	20	-6	DC**0702**
S16Q-SDQCR/L07		●	●	16	180	15	11	27	27	20	-6	DC**0702**
S16R-SDQCR/L07		●	●	16	200	15	11	27	27	20	-6	DC**0702**
A10H-SDQCR/L07	✲	●	●	10	100	9.5	7	20	20	13	-8	DC**0702**
A12K-SDQCR/L07	✲	●	●	12	125	11.5	9	22	22	16	-8	DC**0702**
S20Q-SDQCR/L11		●	○	20	180	18	13	32	32	25	-6	DC**11T3**
S20S-SDQCR/L11		●	●	20	250	18	13	32	32	25	-6	DC**11T3**
S25Q-SDQCR/L11		●	○	25	180	23	17	32	32	32	-6	DC**11T3**
S25T-SDQCR/L11		●	●	25	300	23	17	32	32	32	-6	DC**11T3**
A16M-SDQCR/L11	✲	●	●	16	150	15.5	11	27	27	20	-6	DC**11T3**
A20Q-SDQCR/L11	✲	●	●	20	180	19	13	32	32	25	-6	DC**11T3**
A25R-SDQCR/L11	✲	●	●	25	200	24	17	32	32	32	-6	DC**11T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**0702****	**DC**11T3****	**DC**11T3****	**DC**11T3****
	ød	**10**	**12-16**	**16-20**	**20**	**25**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M2.5×6.5 (1.0 Nm)	I60M3.5x8 (2.7 Nm)	I60M3.5×8 (2.7 Nm)	I60M3.5×10 (2.7 Nm)
	Wrench (screw)	WT07IP	WT07IP	WT15IP	WT15IP	WT15IP

Insert

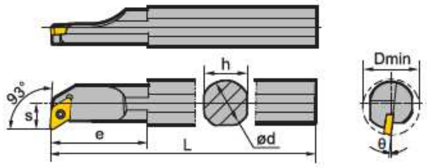
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** steel boring bar **S-Clamping**

SDUCR/L Kr: 93°

Right hand style



Article	✻	Stock		Dimensions [mm]								Inserts
		R	L	ød	L	h	s	L_2	e	D_{min}	θ	
S10M-SDUCR/L07		●	●	10	150	9	7	-	0	13	-8	DC**0702**
S12M-SDUCR/L07		●	●	12	150	11	9	22	22	16	-8	DC**0702**
S16M-SDUCR/L07		●	●	16	150	15	11	27	27	20	-6	DC**0702**
S16R-SDUCR/L07		●	●	16	200	15	11	27	27	20	-6	DC**0702**
A10H-SDUCR/L07	✻	●	●	10	100	9.5	7	-	0	13	-8	DC**0702**
A12K-SDUCR/L07	✻	●	●	12	125	11.5	9	22	22	16	-8	DC**0702**
A16M-SDUCR/L07	✻	●	●	16	150	15.5	11	27	27	20	-6	DC**0702**
S20Q-SDUCR/L11		●	●	20	180	18	13	40	40	25	-6	DC**11T3**
S20S-SDUCR/L11		●	●	20	250	18	13	40	40	25	-6	DC**11T3**
S25Q-SDUCR/L11		●	○	25	180	23	17	46	46	32	-6	DC**11T3**
S25T-SDUCR/L11		●	●	25	300	23	17	46	46	32	-6	DC**11T3**
A20Q-SDUCR/L11	✻	●	●	20	180	19	13	40	40	25	-6	DC**11T3**
A25R-SDUCR/L11	✻	●	●	25	200	24	17	46	46	32	-6	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**11T3****
	ød	**10-16**	**20-25**
	Screw	I60M2.5x5.5 (1.0 Nm)	I60M3.5x8 (2.7 Nm)
	Wrench	WT07IP	WT15IP

Insert

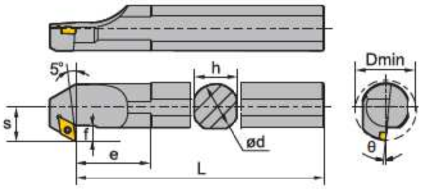
					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** steel boring bar **S-Clamping**

SDZCR/L Kr: 85°

Right hand style



Article	✻	Stock		Dimensions [mm]								Inserts
		R	L	ød	L	h	s	e	f	D_{min}	θ	
S25Q-SDZCR/L11		●	●	25	180	23	17	30	6.9	32	-6	DC**11T3**
S25T-SDZCR/L11		●	●	25	300	23	17	30	6.9	32	-6	DC**11T3**
S32R-SDZCR/L11		○		32	200	30	22	39	8.4	40	-6	DC**11T3**
S32U-SDZCR/L11		●	●	32	350	30	22	39	8.4	40	-6	DC**11T3**
S40S-SDZCR/L11		○	●	40	250	37	27	47	9.4	50	-4	DC**11T3**
S40V-SDZCR/L11		●	●	40	400	37	27	47	9.4	50	-4	DC**11T3**
A25R-SDZCR/L11	✻	●	●	25	200	24	17	30	4.5	32	-6	DC**11T3**
A32S-SDZCR/L11	✻	●	●	32	250	31	22	39	6	40	-6	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**11T3****	**DC**11T3****
	ød	**25**	**32-40**
	Screw	I60M3.5×10 (2.7 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)		SM5×8.65XA
	Shim		D11BS
	Wrench (screw)	WT15IP	WT15IP
	Wrench (shim)		WH35L

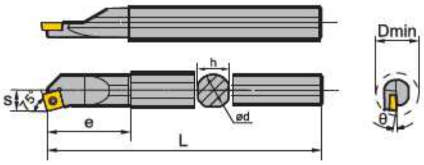
Insert

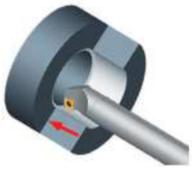
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

SC** steel boring bar S-Clamping

SSKCR/L Kr: 75°





Right hand style

Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S12M-SSKCR/L09		●	●	12	150	11	9	26	16	-10	SC**09T3**
S16M-SSKCR/L09		○	○	16	150	15	11	32.5	20	-11	SC**09T3**
S16R-SSKCR/L09		○	○	16	200	15	11	32.5	20	-11	SC**09T3**
S20Q-SSKCR/L09		○	○	20	180	18	13	34.5	25	-6	SC**09T3**
S20S-SSKCR/L09		●	○	20	250	18	13	34.5	25	-6	SC**09T3**
A12K-SSKCR/L09	✲	●	○	12	125	11	9	26	16	-10	SC**09T3**
A16M-SSKCR/L09	✲	●	○	16	150	15	11	32.5	20	-11	SC**09T3**
A20Q-SSKCR/L09	✲	●	○	20	180	19	13	34.5	25	-6	SC**09T3**
S25Q-SSKCR/L12		○	○	25	180	23	17	36.3	32	-8	SC**1204**
S25T-SSKCR/L12		●	○	25	300	23	17	36.3	32	-8	SC**1204**
S32R-SSKCR/L12		○	○	32	200	30	22	43.5	40	-10	SC**1204**
S32U-SSKCR/L12		●		32	350	30	22	43.5	40	-10	SC**1204**
A25R-SSKCR/L12	✲	●	○	25	200	24	17	41.3	32	-8	SC**1204**
A32S-SSKCR/L12	✲	●		32	250	31	22	42.8	40	-10	SC**1204**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**SC**09T3****	**SC**1204****	**SC**1204****
	ød	**12-20**	**25**	**32**
	Screw	I60M3.5×8 (2.7 Nm)		
	Screw		I60M4×11X (3.4 Nm)	I60M4×11X (3.4 Nm)
	Screw (shim)			SM6×10XA
	Shim			S12BS
	Wrench (screw)	WT15IP	WT15IP	WT15IP
	Wrench (shim)			WH40L

System code A282 Grade selection A40 Technical info A447 Cutting data A324

SC** steel boring bar

Insert

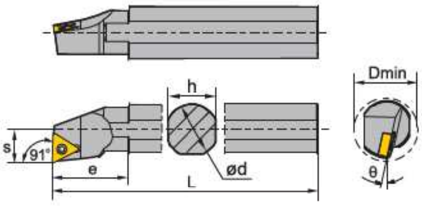
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**
A120	A121	A122	A122

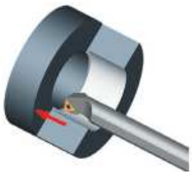
System code A282
Grade selection A40
Technical info A447
Cutting data A324

TC** steel boring bar **S-Clamping**

STFCR/L Kr: 91°

Right hand style





Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S12M-STFCR/L11		●	●	12	150	11	9	30	16	-10	TC**1102**
S16M-STFCR/L11		○	●	16	150	15	11	35	20	-6	TC**1102**
S16R-STFCR/L11		●	●	16	200	15	11	35	20	-6	TC**1102**
S20Q-STFCR/L11		○	○	20	180	18	13	36	25	-3	TC**1102**
S20S-STFCR/L11		●	●	20	250	18	13	36	25	-3	TC**1102**
A12K-STFCR/L11	✲	●	●	12	125	11.5	9	26	16	-10	TC**1102**
A16M-STFCR/L11	✲	●	●	16	150	15.5	11	30	20	-6	TC**1102**
A20Q-STFCR/L11	✲	●	●	20	180	19	13	36	25	-3	TC**1102**
S25Q-STFCR/L16		●	○	25	180	23	17	49	32	-6	TC**16T3**
S25T-STFCR/L16		●	●	25	300	23	17	49	32	-6	TC**16T3**
S32R-STFCR/L16		●	●	32	200	30	22	50	40	-10	TC**16T3**
S32U-STFCR/L16		●	●	32	350	30	22	50	40	-10	TC**16T3**
S40S-STFCR/L16		○	○	40	250	37	27	60	50	-8	TC**16T3**
S40V-STFCR/L16		●	●	40	400	37	27	60	50	-8	TC**16T3**
A25R-STFCR/L16	✲	●	●	25	200	24	17	45	32	-6	TC**16T3**
A32S-STFCR/L16	✲	●	○	32	250	31	22	49	40	-10	TC**16T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**TC**1102****	**TC**16T3****	**TC**16T3****
	ød	**12-20**	**25**	**32-40**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×10 (2.7 Nm)	I60M3.5×12 (2.7 Nm)
	Screw (shim)			SM5×8.65XA
	Shim			T16BS
	Wrench (screw)	WT07IP	WT15IP	WT15IP
	Wrench (shim)			WH35L

System code A282 Grade selection A40 Technical info A447 Cutting data A324

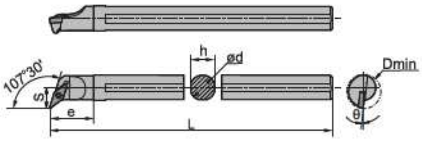
TC** steel boring bar

Insert					
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A127	A128	A129	A131	A129	A156

System code > A282
Grade selection > A40
Technical info > A447
Cutting data > A324

VC** steel boring bar S-Clamping

SVQCR/L Kr: 107°30'



Right hand style

Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S16Q-SVQCR/L11		●	●	16	180	15	13	28	22	-6	VC**1103**
S20R-SVQCR/L11		●	○	20	200	18	15	32	26	-4	VC**1103**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VC**1103****
	ød	**16-20**
	Screw	I60M2.5×6.5 (1.0 Nm)
	Wrench (screw)	WT07IP

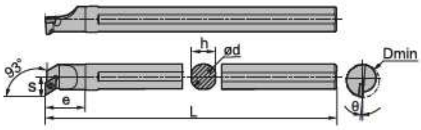
Insert

	
Finishing	**Alum Machining**
A135	A136

System code A282 Grade selection A40 Technical info A447 Cutting data A324

VC** steel boring bar **S-Clamping**

SVUCR/L Kr: 93°



Right hand style

Article	✻	Stock		Dimensions [mm]								Inserts
		R	L	ød	L	h	s	L_2	e	D_{min}	θ	
S16Q-SVUCR/L11		●	○	16	180	15	15	25	25	24	-6	VC**1103**
S20R-SVUCR/L11		●	●	20	200	18	17	30	30	28	-4	VC**1103**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**VC**1103****
	ød	**16-20**
	Screw	I60M2.5×6.5 (1.0 Nm)
	Wrench (screw)	WT07IP

Insert

 **Finishing**	 **Alum Machining**
A135	A136

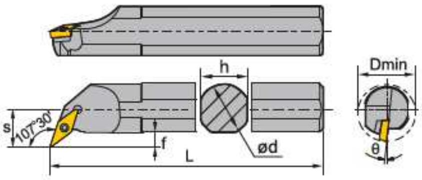
System code A282 Grade selection A40 Technical info A447 Cutting data A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

VB** steel boring bar S-Clamping

SVQBR/L Kr: 107°30'

Right hand style



Article	✲	Stock		Dimensions [mm]								Inserts
		R	L	ød	L	h	s	e	f	D_{min}	θ	
S32R-SVQBR/L16		●	●	32	200	30	22	56	8.4	40	-8	VB**1604**
S32U-SVQBR/L16		●	●	32	350	30	22	56	8.4	40	-8	VB**1604**
S40V-SVQBR/L16		●	●	40	400	37	27	64	9.4	50	-8	VB**1604**
A32S-SVQBR/L16	✲	○	○	32	250	31	22	56	8.4	40	-8	VB**1604**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VB**1604****
	ød	**32-40**
	Screw	I60M3.5×12 (2.7 Nm)
	Screw (shim)	SM5×8.65XA
	Shim	V16BS
	Wrench (screw)	WT15IP
	Wrench (shim)	WH35L

Insert

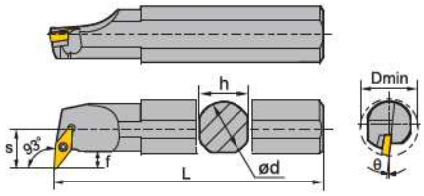
			
Finishing	**Medium Cut**	**Roughing**	**PCBN/PCD**
A140	A142	A143	A157

System code A282 Grade selection A40 Technical info A447 Cutting data A324

VB** steel boring bar **S-Clamping**

SVUBR/L Kr: 93°

Right hand style



Article	✲	Stock		Dimensions [mm]								Inserts
		R	L	ød	L	h	s	e	f	D_{min}	θ	
S32R-SVUBR/L16		●	○	32	200	30	22	49	8.4	40	-8	VB**1604**
S32U-SVUBR/L16		●	●	32	350	30	22	49	8.4	40	-8	VB**1604**
S40S-SVUBR/L16		●	○	40	250	37	27	56.5	9.4	50	-8	VB**1604**
S40V-SVUBR/L16		●	●	40	400	37	27	56.5	9.4	50	-8	VB**1604**
A32S-SVUBR/L16	✲	●	●	32	250	31	22	49	8.4	40	-8	VB**1604**

● Ex stock ○ On demand
✲ With internal cooling

Spare parts

	Insert	**VB**1604****
	ød	**32-40**
	Screw	I60M3.5×12 (2.7 Nm)
	Screw (shim)	SM5×8.65XA
	Shim	V16BS
	Wrench (screw)	WT15IP
	Wrench (shim)	WH35L

Insert

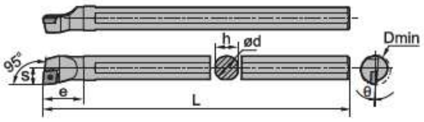
 **Finishing**	 **Medium Cut**	 **Roughing**	 **PCBN/PCD**
A140	A142	A143	A157

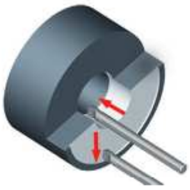
System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

CP** steel boring bar **S-Clamping**

SCLPR/L Kr: 95°

Right hand style





Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S10K-SCLPR/L06		●	●	10	125	9	6	17	12	-7	CP**0602**
S12M-SCLPR/L06		●	●	12	150	11	8	20	16	-4	CP**0602**
S16Q-SCLPR/L09		●	●	16	180	15	10	29	20	-4	CP**09T3**
S20R-SCLPR/L09		○	○	20	200	18	13	35	25	-4	CP**09T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CP**0602****	**CP**09T3****
	ød	**10-12**	**20-25**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)
	Wrench (screw)	WT07IP	WT15IP

Insert

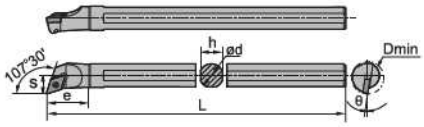
		
Finishing	**Medium Cut**	**Cast Iron**
A110	A110	A110

System code A282 Grade selection A40 Technical info A447 Cutting data A324

DP** steel boring bar **S-Clamping**

SDQPR/L Kr: 107°30'

Right hand style



Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S10K-SDQPR/L07		●	●	10	125	9	7	20	13	-8	DP**0702**
S12M-SDQPR/L07		●	●	12	150	11	9	22	16	-8	DP**0702**
S16Q-SDQPR/L07		●	●	16	180	15	11	27	20	-6	DP**0702**
S16Q-SDQPR/L11		●	●	16	180	15	11	32	20	-6	DP**11T3**
S20R-SDQPR/L11		○	○	20	200	18	13	33	25	-6	DP**11T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

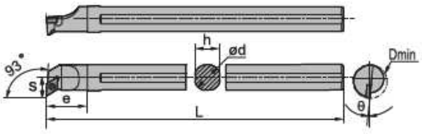
	Insert	**DP**0702****	**DP**0702****	**DP**11T3****
	ød	**10-12**	**16**	**16-20**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M2.5×6.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)
	Wrench (screw)	WT07IP	WT07IP	WT15IP

Insert

Finishing
A117

DP** steel boring bar S-Clamping

SDUPR/L Kr: 93°



Right hand style

Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S10K-SDUPR/L07		●	●	10	125	9	9	18	15	-8	DP**0702**
S12M-SDUPR/L07		●	●	12	150	11	9	19	16	-8	DP**0702**
S16Q-SDUPR/L07		●	●	16	180	15	11	25	20	-6	DP**0702**

● Ex stock ○ On demand
✲ With internal cooling

Spare parts

	Insert	**DP**0702****	**DP**0702****
	ød	**10-12**	**16**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M2.5×6.5 (1.0 Nm)
	Wrench (screw)	WT07IP	WT07IP

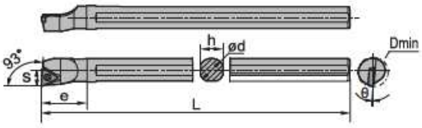
Insert

Finishing
A117

System code A282 Grade selection A40 Technical info A447 Cutting data A324

TP** steel boring bar **S-Clamping**

STUPR/L Kr: 93°



Right hand style

Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ød	L	h	s	e	D_{min}	θ	
S10K-STUPR/L09		●	●	10	125	9	6	20	12	-6	TP**0902**
S12M-STUPR/L09		●	●	12	150	11	8	22	16	-4	TP**0902**
S12M-STUPR/L11		●	●	12	150	11	8	25	16	-4	TP**1103**
S16Q-STUPR/L11		●	●	16	180	15	10	27	20	-3	TP**1103**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TP**0902****	**TP**1103****
	ød	**10-12**	**12-16**
	Screw	I60M2.2x5.5 (0.8 Nm)	I60M2.5x6.5 (1.0 Nm)
	Wrench	WT07IP	WT07IP

Insert

Finishing

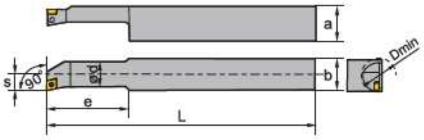
A133

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

CC** steel boring bar S-Clamping

SCFCR/L Kr: 90°



Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ød	a	b	L	s	e	D_{min}	
S10M-SCFCR/L06S25		●	○	10	27	25	150	7	30	13	CC**0602**
S12P-SCFCR/L06S25		●		12	27	25	170	9	35	16	CC**0602**
S16Q-SCFCR/L09S25		●	○	16	27	25	180	11	40	20	CC**09T3**
S20R-SCFCR/L09S25		●		20	27	25	200	13	45	25	CC**09T3**
S25R-SCFCR/L12S25		●	●	25	27	25	200	17	50	32	CC**1204**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CC**0602****	**CC**09T3****	**CC**1204****
	ød	**10-12**	**16-20**	**25**
	Screw	I60M2.5x5.5 (1.0 Nm)	I60M3.5x8 (2.7 Nm)	I60M5x13 (6.7 Nm)
	Wrench	WT07IP	WT15IP	WT20IP

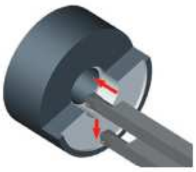
Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A102	A106	A107	A108	A107	A154

System code A282 Grade selection A40 Technical info A447 Cutting data A324

CC** steel boring bar **S-Clamping**

SCLCR/L Kr: 95°



Article	✻	Stock	Dimensions [mm]							Inserts
			ød	a	b	L	s	e	D_{min}	
S10M-SCLCR06S20		○	10	22	20	150	7	30	13	CC**0602**
S12P-SCLCR06S20		○	12	22	20	170	9	35	16	CC**0602**
S16Q-SCLCR09S20		●	16	22	20	180	11	40	20	CC**09T3**
S20R-SCLCR09S20		●	20	22	20	200	13	60	25	CC**09T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CC**0602****	**CC**09T3****
	ød	**10-12**	**16-20**
	Screw	I60M2.5x5.5 (1.0 Nm)	I60M3.5x8 (2.7 Nm)
	Wrench	WT07IP	WT15IP

Insert

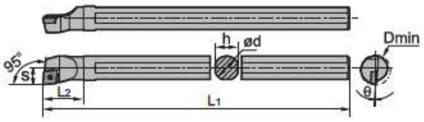
					
Finishing	**Medium Cut**	**Roughing**	**Alum Machining**	**Cast Iron**	**PCBN/PCD**
A102	A106	A107	A108	A107	A154

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

A Turning
B Milling
C Drilling
D Technical Information
E Index

CP** solid carbide boring bar S-Clamping

SCLPR/L Kr: 95°



Right hand style

Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
C10M-SCLPR/L06		●	●	12	10	9	6	150	17	7	CP**0602**
C12Q-SCLPR/L06		●	○	16	12	11	8	180	20	4	CP**0602**
C16R-SCLPR/L09		●	●	20	16	15	10	200	29	4	CP**09T3**
E16R-SCLPR/L09	✻	○	○	19	16	15.5	10	200	-	-2	CP**09T3**
C20S-SCLPR/L09		●	○	25	20	18	13	250	35	4	CP**09T3**
E20S-SCLPR/L09	✻	○	●	24	20	19.5	13	250	-	-2	CP**09T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**CP**0602****	**CP**09T3****
	ød	**10-12**	**16-20**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M3.5×10 (2.7 Nm)
	Wrench (screw)	WT07IP	WT15IP

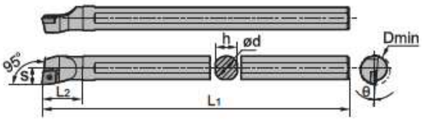
Insert

 **Finishing**	 **Medium Cut**	 **Cast Iron**
A110	A110	A110

System code A282 Grade selection A40 Technical info A447 Cutting data A324

CC** solid carbide boring bar **S-Clamping**

SCLCR/L Kr: 95°



Right hand style

Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
E08K-SCLCR/L06-09	✲	●	●	9	8	7.5	5	125	-	-12	CC**0602**
E08K-SCLCR/L06-10	✲	●	●	10	8	7.5	6	125	-	-12	CC**0602**
E10M-SCLCR/L06	✲	●	●	12	10	9.5	7	150	-	-10	CC**0602**
E12Q-SCLCR/L06	✲	●	●	15	12	11.5	9	180	-	-10	CC**0602**
E16R-SCLCR/L06	✲	●	●	18	16	15.5	10	200	-	-8	CC**0602**
E12Q-SCLCR/L09	✲	●	●	15	12	11.5	9	180	-	-9	CC**09T3**
E16R-SCLCR/L09	✲	●	●	18	16	15.5	10	200	-	-10	CC**09T3**
E20S-SCLCR/L09	✲	●	●	24	20	19.5	13	250	-	-8	CC**09T3**
E25T-SCLCR/L09	✲	●	●	31	25	24	17	300	-	-6	CC**09T3**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**CC**0602****	**CC**09T3****	**CC**09T3****
	ød	**8-16**	**12**	**16-25**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)	I60M3.5×10 (2.7 Nm)
	Wrench (screw)	WT07IP	WT15IP	WT15IP

Insert

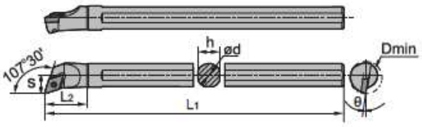
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A102	A106	A107	A108	A107	A154

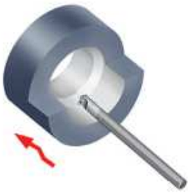
System code A282 Grade selection A40 Technical info A447 Cutting data A324

DP** solid carbide boring bar **S-Clamping**

SDQPR/L Kr: 107°30'

Right hand style





Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
C10M-SDQPR/L07		●	●	13	10	9	7	150	20	8	DP**0702
C12Q-SDQPR/L07		○	●	16	12	11	9	180	22	8	DP**0702
C16R-SDQPR/L07		○	○	20	16	15	11	200	27	6	DP**0702
C16R-SDQPR/L11		○	○	20	16	15	11	200	32	6	DP**11T3**
C20S-SDQPR/L11		●	○	25	20	18	13	250	33	6	DP**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DP**0702**	**DP**0702**	**DP**11T3****
	ød	**10-12**	**16**	**16-20**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M2.5×6.5 (1.0 Nm)	I60M3.5×8 (2.7 Nm)
	Wrench (screw)	WT07IP	WT07IP	WT15IP

Insert

Finishing

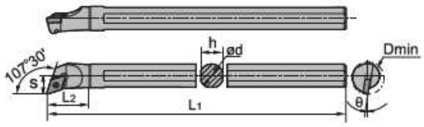
A117

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** solid carbide boring bar S-Clamping

SDQCR/L Kr: 107°30'


Right hand style



Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L₁	L₂	θ	
E08K-SDQCR/L07	✻	●	●	11	8	7.5	6.5	140	-	-12	DC**0702**
E10M-SDQCR/L07	✻	●	●	12	10	9.5	7	150	-	-10	DC**0702**
E12Q-SDQCR/L07	✻	●	●	15	12	11.5	9	180	-	-10	DC**0702**
E16R-SDQCR/L07	✻	●	○	18	16	15.5	10	200	-	-6	DC**0702**
E20S-SDQCR/L07	✻	●	○	24	20	19.5	13	250	-	-4	DC**0702**
E16R-SDQCR/L11	✻	●	●	18	16	15.5	10	200	-	-8	DC**11T3**
E20S-SDQCR/L11	✻	●	○	24	20	19.5	13	250	-	-8	DC**11T3**
E25T-SDQCR/L11	✻	●	○	31	25	24	17	300	-	-6	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**11T3****
	ød	**8-20**	**16-25**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M3.5×10 (2.7 Nm)
	Wrench (screw)	WT07IP	WT15IP

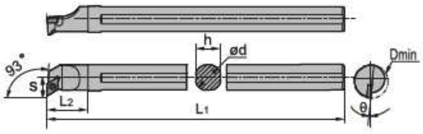
Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

DP** solid carbide boring bar **S-Clamping**

SDUPR/L Kr: 93°



Right hand style

Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
C10M-SDUPR/L07		●	●	15	10	9	9	150	18	8	DP**0702**
C12Q-SDUPR/L07		●	○	16	12	11	9	180	19	8	DP**0702**
C16R-SDUPR/L07		○	○	20	16	15	11	200	25	6	DP**0702**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**DP**0702****
	ød	**15-20**
	Screw	I60M2.5x5.5 (1.0 Nm)
	Wrench	WT07IP

Insert

Finishing

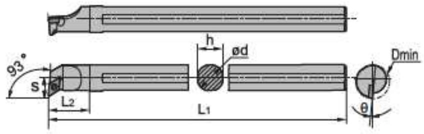
A117

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

DC** solid carbide boring bar S-Clamping

SDUCR/L Kr: 93°

Right hand style



Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
E10M-SDUCR/L07	✻	●	○	12	10	9.5	7	150	-	-10	DC**0702**
E12Q-SDUCR/L07	✻	●	●	15	12	11.5	9	180	-	-10	DC**0702**
E16R-SDUCR/L07	✻	●	○	18	16	15.5	10	200	-	-6	DC**0702**
E20S-SDUCR/L07	✻	○	○	24	20	19.5	13	250	-	-4	DC**0702**
E16R-SDUCR/L11	✻	●	○	18	16	15.5	10	200	-	-8	DC**11T3**
E20S-SDUCR/L11	✻	●	●	24	20	19.5	13	250	-	-8	DC**11T3**
E25T-SDUCR/L11	✻	○	○	31	25	24	17	300	-	-6	DC**11T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**DC**0702****	**DC**11T3****
	ød	**10-20**	**16-25**
	Screw	I60M2.5×5.5 (1.0 Nm)	I60M3.5×10 (2.7 Nm)
	Wrench (screw)	WT07IP	WT15IP

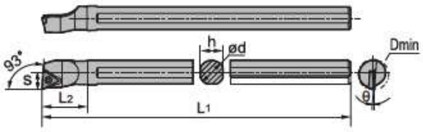
Insert

 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A112	A114	A115	A115	A115	A155

System code A282 Grade selection A40 Technical info A447 Cutting data A324

TP** solid carbide boring bar S-Clamping

STUPR/L Kr: 93°



Right hand style

Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
C10M-STUPR/L09		○	○	12	10	9	6	150	20	6	TP**0902**
C12Q-STUPR/L09		●	●	16	12	11	8	180	22	4	TP**0902**
C12Q-STUPR/L11		●		16	12	11	8	180	25	4	TP**1103
C16R-STUPR/L11		○	○	20	16	15	10	200	27	3	TP**1103

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TP**0902****	**TP**1103**
	ød	**10-12**	**12-16**
	Screw	I60M2.2×5.5 (0.8 Nm)	I60M2.5×6.5 (1.0 Nm)
	Wrench (screw)	WT07IP	WT07IP

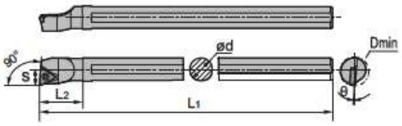
Insert

Finishing
A133

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

TC** solid carbide boring bar **S-Clamping**

STFCR/L Kr: 90°



Right hand style

Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
E08K-STFCR/L09	✻	○	●	11	8	7.5	6	125	-	-12	TC**0902**
E10M-STFCR/L09	✻	○	○	12	10	9.5	7	150	-	-10	TC**0902**
E12Q-STFCR/L11	✻	○	○	15	12	11.5	9	180	-	-10	TC**1102**
E16R-STFCR/L11	✻	○	○	18	16	15.5	10	200	-	-8	TC**1102**
E20S-STFCR/L11	✻	○	○	24	20	19.5	13	250	-	-8	TC**1102**
E20S-STFCR/L16	✻	○	○	24	20	19.5	13	250	-	-8	TC**16T3**
E25T-STFCR/L16	✻	○	○	31	25	24	17	300	-	-6	TC**16T3**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TC**0902****	**TC**1102****	**TC**16T3****
	ød	**8-10**	**12-20**	**20-25**
	Screw	I60M2.2×5.5 (0.8 Nm)	I60M2.5×5.5 (1.0 Nm)	I60M3.5×10 (2.7 Nm)
	Wrench (screw)	WT07IP	WT07IP	WT15IP

Insert

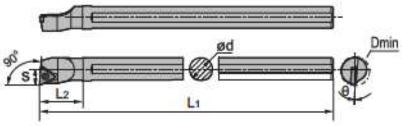
 **Finishing**	 **Medium Cut**	 **Roughing**	 **Alum Machining**	 **Cast Iron**	 **PCBN/PCD**
A126	A128	A129	A131	A129	A156

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

TC** solid carbide boring bar S-Clamping

STFPR/L Kr: 90°

Right hand style



Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
E10M-STFPR/L11	✻	○	○	12	10	9.5	6	150	-	-5	TP**1103**
E12Q-STFPR/L11	✻	○	○	15	12	11.5	8	180	-	-4	TP**1103**
E16R-STFPR/L11	✻	○	○	19	16	15.5	10	200	-	-2	TP**1103**
E20S-STFPR/L11	✻	○	○	24	20	19	13	250	-	-2	TP**1103**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**TP**1103****
	ød	**10-20**
	Screw	I60M3.0×7.0 (1.8 Nm)
	Wrench (screw)	WT08IP

Insert

Finishing

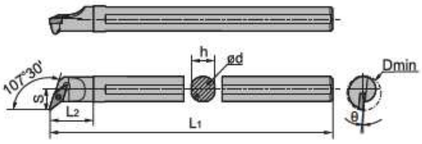
A133

System code A282 Grade selection A40 Technical info A447 Cutting data A324

VC** solid carbide boring bar S-Clamping

SVQCR/L Kr: 107°30'

Right hand style



Article	✲	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
C16R-SVQCR/L11		○	○	22	16	15	13	200	28	-6	VC**1103**
C20S-SVQCR/L11		○	○	26	20	18	15	250	32	-4	VC**1103**

● Ex stock ○ On demand

✲ With internal cooling

Spare parts

	Insert	**VC**1103****
	ød	**16-20**
	Screw	I60M2.5×6.5 (1.0 Nm)
	Wrench (screw)	WT07IP

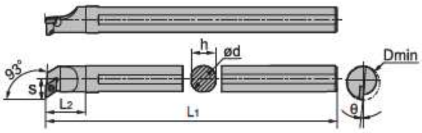
Insert

 **Finishing**	 **Alum Machining**
A135	A136

System code > A282 Grade selection > A40 Technical info > A447 Cutting data > A324

VC** solid carbide boring bar S-Clamping

SVUCR/L Kr: 93°



Right hand style

Article	✻	Stock		Dimensions [mm]							Inserts
		R	L	ØD	ød	h	s	L_1	L_2	θ	
C16R-SVUCR/L11		○	○	24	16	15	15	200	25	6	VC**1103**
E16R-SVUCR/L11	✻	○	○	22	16	15	13	200	-	-6.5	VC**1103**
C20S-SVUCR/L11		●	●	28	20	18	17	250	30	4	VC**1103**
E20S-SVUCR/L11	✻	○	○	27	20	18	13	250	-	-6.5	VC**1103**
E25T-SVUCR/L16	✻	○	○	35	25	23	20.5	300	-	-6.5	VC**1604**

● Ex stock ○ On demand

✻ With internal cooling

Spare parts

	Insert	**VC**1103****	**VC**1604****
	ød	**16-20**	**25**
	Screw	I60M2.5×6.5 (1.0 Nm)	I60M3.5×10 (2.7 Nm)
	Wrench (screw)	WT07IP	WT15IP

Insert

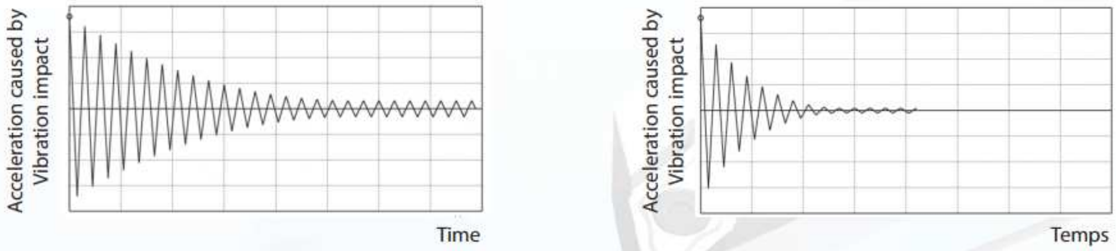
			
Finishing	**Medium Cut**	**Alum Machining**	**PCBN/PCD**
A135	A138	A136	A158

System code A282 Grade selection A40 Technical info A447 Cutting data A324

Anti Vibration Boring Bar

By increasing the rigidity of the tool materials the vibration will be reduced. The carbide tool holder performs much better than steel tool holders (steel tool holder approx. L≤3xD, carbide tool holder is approx. L≤6xD). The cutting data can be increased and the shank overhang extended. Therefore you achieve better surface and higher workpiece precision.

Vibration amplitude (under same machining conditions)



Steel tool holder

Cemented carbide tool holder

Turning insert, negative

	Material group	Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
						HC (CVD)								
						YB6315			YBC152			YBC252		
						Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
						0,1	0,2	0,6	0,1	0,2	0,6	0,1	0,4	0,8
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1	500	400	270	500	400	270	480	370	230
		approx. 0,45 % C	annealed	190	2	420	340	230	420	340	230	400	310	190
		approx. 0,45 % C	tempered	250	3	330	280	200	330	280	200	310	250	160
		approx. 0,75 % C	annealed	270	4	320	270	190	320	270	190	300	240	150
		approx. 0,75 % C	tempered	300	5	280	240	170	280	240	170	260	210	130
	Low-alloyed steel		annealed	180	6	400	300	180	400	300	180	380	290	170
			tempered	275	7	280	230	150	280	230	150	260	210	140
			tempered	300	8	260	220	150	260	220	150	240	200	140
			tempered	350	9	230	190	120	230	190	120	220	180	110
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	360	290	190	360	290	190	310	250	170
			hardened and tempered	325	11	190	160	130	190	160	130	150	130	100
M	Stainless steel	ferritic/martensitic	annealed	200	12									
		martensitic	tempered	240	13									
		austenitic	quench hardened	180	14									
		austenitic-ferritic		230	15									
K	Grey cast iron	perlitic/ferritic		180	16									
		perlitic (martensitic)		260	17									
	Cast iron with spheroidal graphite	ferritic		160	18									
		perlitic		250	19									
	Malleable cast iron	ferritic		130	20									
		perlitic		230	21									
N	Aluminium wrought alloys	cannot be hardened		60	22									
		hardenable	hardened	100	23									
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24									
		≤ 12% Si, hardenable	hardened	90	25									
		> 12% Si, cannot be hardened		130	26									
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27									
		CuZn, CuSnZn		90	28									
		CuSn, Pb-free copper, electrolytic copper		100	29									
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30									
			hardened	280	31									
		Ni or Co bass	annealed	250	32									
			hardened	350	33									
			cast	320	34									
	Titanium alloys	pure titanium		R_m 400	35									
		α and β alloys	hardened	R_m 1050	36									
H	Hardened steel		hardened and tempered	55 HRC	37									
			hardened and tempered	60 HRC	38									
	Hard cast iron		cast	400	39									
	Hardened cast iron		hardened and tempered	55 HRC	40									
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
For examples of material for cutting tool groups view page D22.

Starting values for cutting speed v_c [m/min]																							
HC (CVD)																							
YBC251			YBC352			YBM153			YBM253			YBD052			YBD102			YB7315			YBD152		
Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
0,1	0,4	0,8	0,2	0,5	1	0,2	0,4	0,6	0,2	0,4	0,6	0,1	0,3	0,4	0,1	0,3	0,4	0,1	0,3	0,5	0,1	0,3	0,5
430	320	180	430	330	220																		
350	260	140	350	270	180																		
260	190	110	260	210	150																		
250	180	100	250	200	140																		
210	160	80	210	170	120																		
330	230	120	320	240	150																		
210	170	110	200	170	120																		
190	150	100	180	160	120																		
170	140	90	150	130	90																		
260	190	120	220	180	130																		
100	75	50	-	-	-																		
						380	295	210	350	265	180												
						190	155	120	150	110	65												
						250	200	150	200	140	80												
						200	160	130	160	115	70												
												620	420	230	530	380	220	600	410	220	540	375	210
												300	220	150	240	200	150	330	240	150	280	210	140
												310	220	150	300	210	145	340	250	160	290	215	140
												230	160	110	220	150	105	260	190	120	210	155	100
												350	275	230	330	265	220	370	300	230	320	265	210
												250	160	105	230	155	100	280	200	120	230	165	100

Turning insert, negative

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
						HC (CVD)			HC (PVD)					
						YBD152C			YBG101			YBG105		
						Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
						0,1	0,3	0,5	0,1	0,3	0,6	0,1	0,3	0,6
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1									
		approx. 0,45 % C	annealed	190	2									
		approx. 0,45 % C	tempered	250	3									
		approx. 0,75 % C	annealed	270	4									
		approx. 0,75 % C	tempered	300	5									
	Low-alloyed steel		annealed	180	6									
			tempered	275	7									
			tempered	300	8									
			tempered	350	9									
	High-alloyed steel and high-alloyed tool steel		annealed	200	10									
			hardened and tempered	325	11									
M	Stainless steel	ferritic/martensitic	annealed	200	12							360	290	200
		martensitic	tempered	240	13							180	150	110
		austenitic	quench hardened	180	14							240	190	140
		austenitic-ferritic		230	15							190	150	110
K	Grey cast iron	perlitic/ferritic		180	16	570	395	220						
		perlitic (martensitic)		260	17	310	230	150						
	Cast iron with spheroidal graphite	ferritic		160	18	310	230	150						
		perlitic		250	19	230	170	110						
	Malleable cast iron	ferritic		130	20	340	280	220						
		perlitic		230	21	250	180	110						
N	Aluminium wrought alloys	cannot be hardened		60	22				2000	1200	-			
		hardenable	hardened	100	23				610	420	-			
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24				550	300	-			
		≤ 12% Si, hardenable	hardened	90	25				360	190	-			
		> 12% Si, cannot be hardened		130	26				320	170	-			
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27				730	350	-			
		CuZn, CuSnZn		90	28				370	330	-			
		CuSn, Pb-free copper, electrolytic copper		100	29				270	200	-			
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30							65	45	-
			hardened	280	31							60	40	-
		Ni or Co bass	annealed	250	32							60	40	-
			hardened	350	33							55	35	-
			cast	320	34							55	35	-
	Titanium alloys	pure titanium		R_m 400	35							100	60	-
		α and β alloys	hardened	R_m 1050	36							80	40	-
H	Hardened steel		hardened and tempered	55 HRC	37									
			hardened and tempered	60 HRC	38									
	Hard cast iron		cast	400	39									
	Hardened cast iron		hardened and tempered	55 HRC	40									
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
For examples of material for cutting tool groups view page D22.

Starting values for cutting speed v_c [m/min]																							
HC (PVD)						HC$_1$			HT						HW						BL		
YB9320			YBG205			YNG151C			YNG151			YNT251			YD101			YD201			YCB111		
Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
0,1	0,3	0,6	0,1	0,3	0,6	0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4	0,05	0,2	0,35	0,1	0,2	0,3	0,1	0,2	0,3
						510	350	-	510	350	-	510	350	-									
						430	270	-	430	270	-	430	270	-									
						330	220	-	330	220	-	330	220	-									
						320	200	-	320	200	-	320	200	-									
						280	170	-	280	170	-	280	170	-									
						400	240	-	400	240	-	400	240	-									
						290	180	-	290	180	-	290	180	-									
						240	170	-	240	170	-	240	170	-									
						220	150	-	220	150	-	220	150	-									
						340	220	-	340	220	-	340	220	-									
						180	110	-	180	110	-	180	110	-									
360	290	200	320	250	160																		
190	155	110	170	150	110																		
250	210	150	230	190	140																		
200	165	120	180	150	110																		
						430	365	280	430	365	280	430	365	280									
						390	340	270	390	340	270	390	340	270									
						360	300	220	360	300	220	360	300	220									
						340	295	230	340	295	230	340	295	230									
						310	260	190	310	260	190	310	260	190									
						250	210	150	250	210	150	250	210	150									
															1750	1200	800	1750	1200	800			
															510	380	250	510	380	250			
															460	320	175	460	320	175			
															300	205	110	300	205	110			
															270	185	100	270	185	100			
															610	410	205	610	410	205			
															310	250	195	310	250	195			
															225	170	115	225	170	115			
55	35	-	55	-	-	65	45	-	65	45	-	65	45	-									
50	30	-	50	-	-	60	40	-	60	40	-	60	40	-									
50	30	-	50	-	-	60	40	-	60	40	-	60	40	-									
45	25	-	45	-	-	55	35	-	55	35	-	55	35	-									
45	25	-	45	-	-	55	35	-	55	35	-	55	35	-									
80	60	-	70	-	-	90	60	-	90	60	-	90	60	-									
60	40	-	50	-	-	80	40	-	80	40	-	80	40	-									
																					240	180	140
																					220	180	140
																					250	150	100
																					200	150	100

A Turning
B Milling
C Drilling
D Technical Information
E Index

Turning insert, negative

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
						BL						BH		
						YCB121			YCB131			YCB211		
						Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
						0,1	0,2	0,3	0,1	0,3	0,5	0,1	0,3	0,5
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1									
		approx. 0,45 % C	annealed	190	2									
		approx. 0,45 % C	tempered	250	3									
		approx. 0,75 % C	annealed	270	4									
		approx. 0,75 % C	tempered	300	5									
	Low-alloyed steel		annealed	180	6									
			tempered	275	7									
			tempered	300	8									
			tempered	350	9									
	High-alloyed steel and high-alloyed tool steel		annealed	200	10									
			hardened and tempered	325	11									
M	Stainless steel	ferritic/martensitic	annealed	200	12									
		martensitic	tempered	240	13									
		austenitic	quench hardened	180	14									
		austenitic-ferritic		230	15									
K	Grey cast iron	perlitic/ferritic		180	16							1500	980	400
		perlitic (martensitic)		260	17							1250	800	320
	Cast iron with spheroidal graphite	ferritic		160	18							-	-	-
		perlitic		250	19							300	200	100
	Malleable cast iron	ferritic		130	20							-	-	-
		perlitic		230	21							300	200	100
N	Aluminium wrought alloys	cannot be hardened		60	22									
		hardenable	hardened	100	23									
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24									
		≤ 12% Si, hardenable	hardened	90	25									
		> 12% Si, cannot be hardened		130	26									
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27									
		CuZn, CuSnZn		90	28									
		CuSn, Pb-free copper, electrolytic copper		100	29									
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30									
			hardened	280	31									
		Ni or Co bass	annealed	250	32									
			hardened	350	33									
			cast	320	34									
	Titanium alloys	pure titanium		R_m 400	35									
		α and β alloys	hardened	R_m 1050	36									
H	Hardened steel		hardened and tempered	55 HRC	37	220	170	130	160	120	100			
			hardened and tempered	60 HRC	38	200	160	120	150	120	100			
	Hard cast iron		cast	400	39	200	150	100	180	120	100			
	Hardened cast iron		hardened and tempered	55 HRC	40	200	150	100	150	120	100			
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.
For examples of material for cutting tool groups view page D22.

Starting values for cutting speed v_c [m/min]															
BL			BH						CM			CN			
YZB121			YZB221			YZB231			CA1000			CN1000			CN2000			
Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			
0,3	0,9	1,5	0,3	0,9	1,5	0,1	0,6	1,5	0,1	0,6	1,5	0,1	0,6	1,5	0,1	0,6	1,5	
			1500	950	400	1200	800	400	1200	800	200	800	700	600	700	600	500	
			1250	780	320	980	650	320	1000	650	200	750	625	500	800	700	600	
			-	-	-	-	-	-	800	550	200	600	530	450	600	530	450	
			500	300	100	400	250	100	700	500	200	500	420	350	500	420	350	
			-	-	-	-	-	-	1200	750	200	800	700	600	800	700	600	
			500	300	100	400	250	100	1000	650	200	700	600	500	700	600	500	
200	160	120																
200	160	120																
200	155	100																
200	155	100																

Turning insert, positive

	Material group	Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
						HC (CVD)								
						YB6315			YBC152			YBC252		
						Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
						0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,3	0,6
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1	450	390	270	450	390	270	430	350	230
		approx. 0,45 % C	annealed	190	2	380	330	230	380	330	230	360	295	190
		approx. 0,45 % C	tempered	250	3	300	265	200	300	265	200	280	235	160
		approx. 0,75 % C	annealed	270	4	290	255	190	290	255	190	270	225	150
		approx. 0,75 % C	tempered	300	5	250	225	170	250	225	170	235	195	130
	Low-alloyed steel		annealed	180	6	360	300	180	360	300	180	340	270	170
			tempered	275	7	250	210	150	250	210	150	235	195	140
			tempered	300	8	230	200	150	230	200	150	220	180	140
			tempered	350	9	200	170	120	200	170	120	190	155	110
	High-alloyed steel and high-alloyed tool steel		annealed	200	10	320	275	190	320	275	190	280	230	170
			hardened and tempered	325	11	160	150	130	160	150	130	130	115	100
M	Stainless steel	ferritic/martensitic	annealed	200	12									
		martensitic	tempered	240	13									
		austenitic	quench hardened	180	14									
		austenitic-ferritic		230	15									
K	Grey cast iron	perlitic/ferritic		180	16									
		perlitic (martensitic)		260	17									
	Cast iron with spheroidal graphite	ferritic		160	18									
		perlitic		250	19									
	Malleable cast iron	ferritic		130	20									
		perlitic		230	21									
N	Aluminium wrought alloys	cannot be hardened		60	22									
		hardenable	hardened	100	23									
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24									
		≤ 12% Si, hardenable	hardened	90	25									
		> 12% Si, cannot be hardened		130	26									
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27									
		CuZn, CuSnZn		90	28									
		CuSn, Pb-free copper, electrolytic copper		100	29									
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30									
			hardened	280	31									
		Ni or Co bass	annealed	250	32									
			hardened	350	33									
			cast	320	34									
	Titanium alloys	pure titanium		R_m 400	35									
		α and β alloys	hardened	R_m 1050	36									
H	Hardened steel		hardened and tempered	55 HRC	37									
			hardened and tempered	60 HRC	38									
	Hard cast iron		cast	400	39									
	Hardened cast iron		hardened and tempered	55 HRC	40									
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
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For examples of material for cutting tool groups view page D22.

Starting values for cutting speed v_c [m/min]																							
HC (CVD)																							
YBC251			YBC352			YBM153			YBM253			YBD052			YBD102			YB7315			YBD152		
Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
0,1	0,3	0,6	0,2	0,4	0,6	0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4
390	310	180	390	310	230																		
315	245	140	315	250	190																		
235	185	110	230	195	160																		
225	175	100	220	185	150																		
190	150	80	185	155	120																		
300	230	120	290	225	150																		
190	160	110	170	150	130																		
170	140	100	150	140	130																		
145	120	90	130	110	90																		
230	185	120	180	160	140																		
90	75	50	-	-	-																		
						360	340	260	330	300	230												
						180	170	140	150	130	95												
						240	220	170	195	170	115												
						190	175	140	160	140	100												
												560	380	210	480	345	200	540	370	200	490	340	190
												270	200	140	220	180	135	300	220	135	250	190	130
												280	220	135	270	210	130	300	230	145	260	200	125
												210	160	100	200	150	95	230	180	110	190	140	90
												290	250	190	275	240	180	310	260	190	265	230	170
												210	160	90	190	145	85	230	170	100	190	140	90

Turning insert, positive

	Material group	Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
						HC (CVD)			HC (PVD)					
						YBD152C			YBG101			YBG105		
						Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
						0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1									
		approx. 0,45 % C	annealed	190	2									
		approx. 0,45 % C	tempered	250	3									
		approx. 0,75 % C	annealed	270	4									
		approx. 0,75 % C	tempered	300	5									
	Low-alloyed steel		annealed	180	6									
			tempered	275	7									
			tempered	300	8									
			tempered	350	9									
	High-alloyed steel and high-alloyed tool steel		annealed	200	10									
			hardened and tempered	325	11									
M	Stainless steel	ferritic/martensitic	annealed	200	12							305	245	205
		martensitic	tempered	240	13							150	125	100
		austenitic	quench hardened	180	14							200	165	145
		austenitic-ferritic		230	15							160	130	115
K	Grey cast iron	perlitic/ferritic		180	16	520	360	200						
		perlitic (martensitic)		260	17	280	210	135						
	Cast iron with spheroidal graphite	ferritic		160	18	280	220	135						
		perlitic		250	19	210	160	100						
	Malleable cast iron	ferritic		130	20	280	245	180						
		perlitic		230	21	210	160	100						
N	Aluminium wrought alloys	cannot be hardened		60	22				1800	880	-			
		hardenable	hardened	100	23				540	380	-			
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24				500	270	-			
		≤ 12% Si, hardenable	hardened	90	25				320	170	-			
		> 12% Si, cannot be hardened		130	26				290	150	-			
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27				660	320	-			
		CuZn, CuSnZn		90	28				330	300	-			
		CuSn, Pb-free copper, electrolytic copper		100	29				220	175	-			
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30				50	35	-	60	45	-
			hardened	280	31				45	30	-	55	40	-
		Ni or Co bass	annealed	250	32				45	30	-	55	40	-
			hardened	350	33				40	-	-	50	35	-
			cast	320	34				40	-	-	50	35	-
	Titanium alloys	pure titanium		R_m 400	35				85	60	-	95	60	-
		α and β alloys	hardened	R_m 1050	36				65	40	-	75	40	-
H	Hardened steel		hardened and tempered	55 HRC	37									
			hardened and tempered	60 HRC	38									
	Hard cast iron		cast	400	39									
	Hardened cast iron		hardened and tempered	55 HRC	40									
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

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For examples of material for cutting tool groups view page D22.

Starting values for cutting speed v_c [m/min]																							
HC (PVD)						HC_1			HT						HW						BL		
YB9320			YBG205			YNG151C			YNG151			YNT251			YD101			YD201			YCB111		
Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4	0,1	0,2	0,4	0,05	0,2	0,35	0,1	0,3	0,6	0,1	0,2	0,3
						470	320	-	470	320	-	470	320	-									
						400	250	-	400	250	-	400	250	-									
						300	200	-	300	200	-	300	200	-									
						290	180	-	290	180	-	290	180	-									
						245	150	-	245	150	-	245	150	-									
						370	220	-	370	220	-	370	220	-									
						255	160	-	255	160	-	255	160	-									
						200	140	-	200	140	-	200	140	-									
						185	130	-	185	130	-	185	130	-									
						285	180	-	285	180	-	285	180	-									
						150	90	-	150	90	-	150	90	-									
305	245	206	270	205	165																		
160	130	110	145	125	100																		
210	180	155	195	165	145																		
170	140	120	155	130	115																		
						390	330	255	390	330	255	390	330	255									
						355	310	245	355	310	245	355	310	245									
						330	270	200	330	270	200	330	270	200									
						310	270	210	310	270	210	310	270	210									
						260	220	160	260	220	160	260	220	160									
						210	170	120	210	170	120	210	170	120									
															1550	1050	700	1550	1050	700			
															450	320	200	450	320	200			
															400	270	150	400	270	150			
															250	170	95	250	170	95			
															230	150	85	230	150	85			
															550	370	170	550	370	170			
															260	210	160	260	210	160			
															190	145	95	190	145	95			
50	35	-	50	-	-	60	40	-	60	40	-	60	40	-	55	30	-	55	30	-			
45	30	-	45	-	-	55	35	-	55	35	-	55	35	-	55	25	-	55	25	-			
45	30	-	45	-	-	55	35	-	55	35	-	55	35	-	45	25	-	45	25	-			
40	-	-	40	-	-	50	30	-	50	30	-	50	30	-	35	20	-	35	20	-			
40	-	-	40	-	-	50	30	-	50	30	-	50	30	-	40	20	-	40	20	-			
75	60	-	70	-	-	85	55	-	85	55	-	85	55	-	60	40	-	60	40	-			
55	40	-	45	-	-	75	35	-	75	35	-	75	35	-	30	-	-	30	-	-			
																					240	180	140
																					220	180	140
																					250	150	100
																					200	150	100

Turning insert, positive

	Material group	Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]								
						BL						BH		
						YCB121			YCB131			YCB211		
						Feed rate [mm]			Feed rate [mm]			Feed rate [mm]		
						0,1	0,2	0,3	0,1	0,2	0,3	0,1	0,2	0,4
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1									
		approx. 0,45 % C	annealed	190	2									
		approx. 0,45 % C	tempered	250	3									
		approx. 0,75 % C	annealed	270	4									
		approx. 0,75 % C	tempered	300	5									
	Low-alloyed steel		annealed	180	6									
			tempered	275	7									
			tempered	300	8									
			tempered	350	9									
	High-alloyed steel and high-alloyed tool steel		annealed	200	10									
			hardened and tempered	325	11									
M	Stainless steel	ferritic/martensitic	annealed	200	12									
		martensitic	tempered	240	13									
		austenitic	quench hardened	180	14									
		austenitic-ferritic		230	15									
K	Grey cast iron	perlitic/ferritic		180	16							1330	905	410
		perlitic (martensitic)		260	17							1100	740	330
	Cast iron with spheroidal graphite	ferritic		160	18							-	-	-
		perlitic		250	19							240	180	100
	Malleable cast iron	ferritic		130	20							-	-	-
		perlitic		230	21							240	180	100
N	Aluminium wrought alloys	cannot be hardened		60	22									
		hardenable	hardened	100	23									
	Cast aluminium alloys	≤ 12% Si, cannot be hardened		75	24									
		≤ 12% Si, hardenable	hardened	90	25									
		> 12% Si, cannot be hardened		130	26									
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27									
		CuZn, CuSnZn		90	28									
		CuSn, Pb-free copper, electrolytic copper		100	29									
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30									
			hardened	280	31									
		Ni or Co bass	annealed	250	32									
			hardened	350	33									
			cast	320	34									
	Titanium alloys	pure titanium		R_m 400	35									
		α and β alloys	hardened	R_m 1050	36									
H	Hardened steel		hardened and tempered	55 HRC	37	220	170	130	160	120	100			
			hardened and tempered	60 HRC	38	200	160	120	150	120	100			
	Hard cast iron		cast	400	39	200	150	100	180	120	100			
	Hardened cast iron		hardened and tempered	55 HRC	40	200	150	100	150	120	100			
X	Non-metallic materials	Thermoplasts			41									
		Thermosetting plastics			42									
		Plastic, glass-fibre reinforced GFRP			43									
		Plastic, carbon fibre reinforced CFRP			44									
		Graphite			45									
		Wood			46									

Note: The given cutting values are guide values, which were determined under ideal conditions.
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For examples of material for cutting tool groups view page D22.

Notes