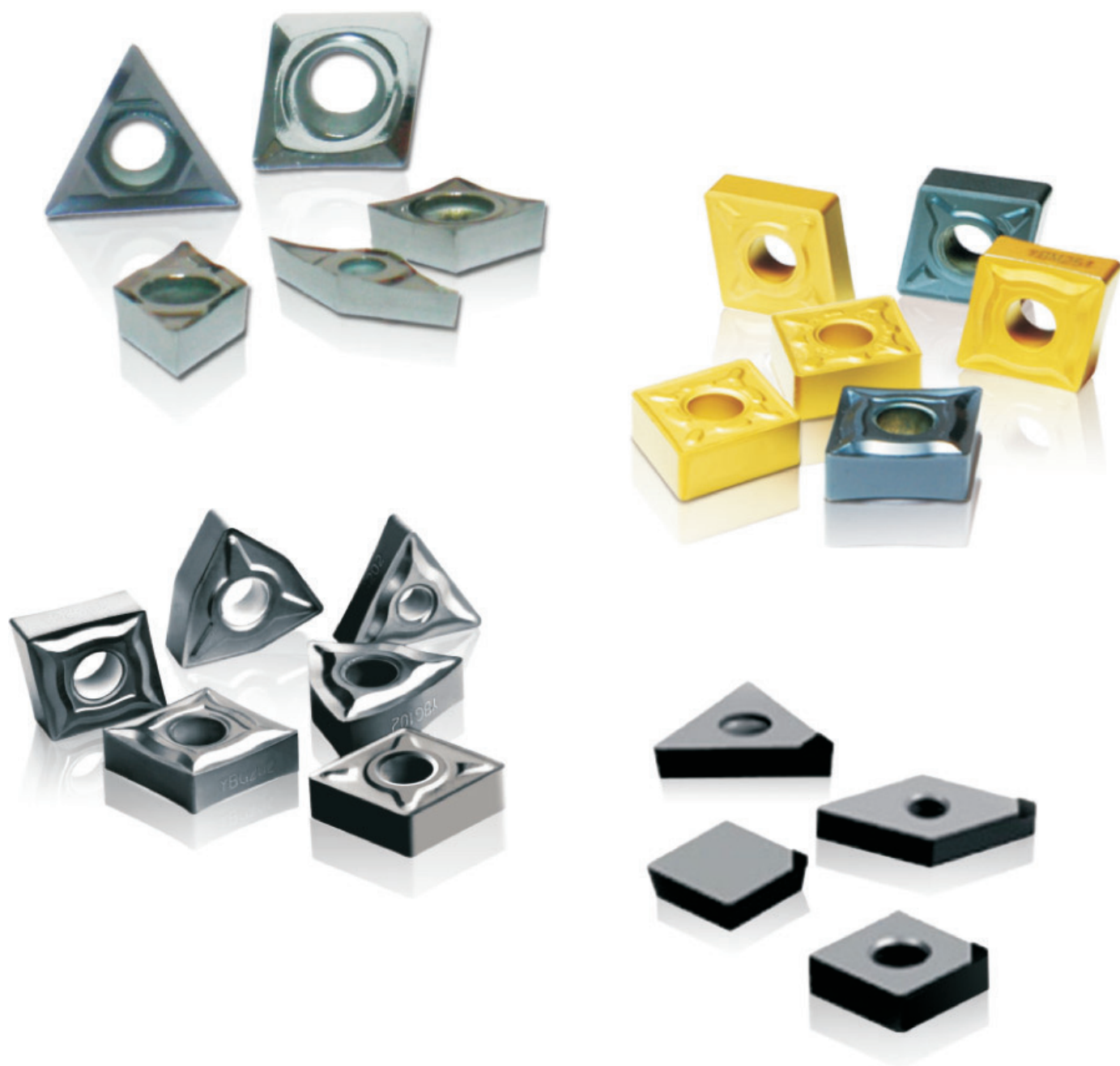




ISO standard

T N M G 22 04 08 (N) – DM

1 2 3 4 5 6 7 8 9

Insert shape		
A	B	C
D	E	H
K	L	M
O	P	R
S	T	T
V	W	Z Special

1

Clearance angle	
A	B
C	D
E	F
G	N
P	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

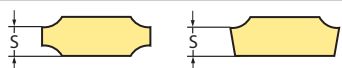
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Fastening features (metric)	
Insert shape	
A	B
C	F
G	H
J	M
N	Q
R	T
U	W
X Special	

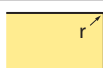
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Cutting edge length l [mm]							
I.C [mm]	Insert shape						
3,97	06						
5,0	05						
5,56	09						
6,0	06						
6,35	06	07			11	11	
8,0	08						
9,525	09	11	09	09	16	16	06
10,0	10						
12,0	12						
12,7	12	15	12	12	22	22	08
15,875	16		15	15	27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

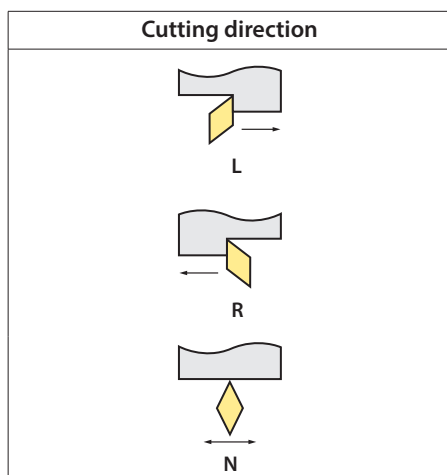
5

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		

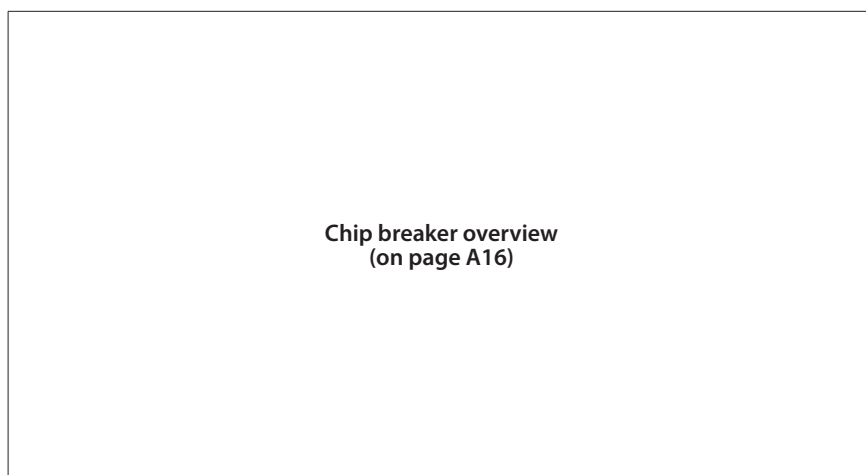
6

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



8



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

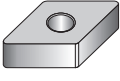
6

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

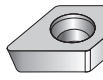
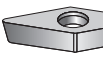
7

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
Insert shape V 	160404	331
	160408	332
	160412	333
Insert shape R 	0903MO	32
	1204MO	43

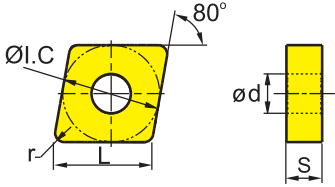
Positive angle/insert

	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
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
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
Inserts shape V 	110304	221
	110308	222
	16T302	30
	16T304	31
	16T308	32
	16T312	33
	160400	330
	220408	432
	220412	433
	220416	434
Insert shape S 	270408	532
	270412	533
	330612	643
	330616	644
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
Insert shape S 	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
Insert shape S 	190412	633
	190424	636
	190612	643
	190616	644
	250724	856
	250732	858
	250924	866
	250932	868

Turning inserts

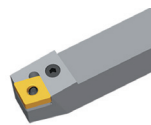
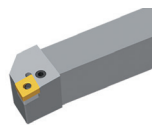
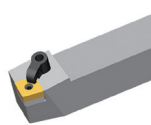
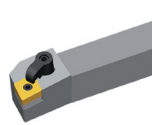
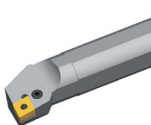
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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				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
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

A

Turning

B

Milling

C

Drilling

D

Technical Information

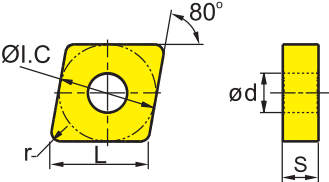
E

Index

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

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

Turning inserts

CN** 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	YBG320	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

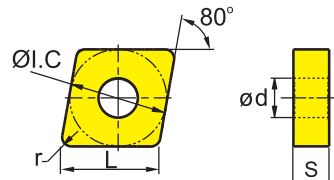
Technical info > A447

Cutting data > A324

Turning inserts

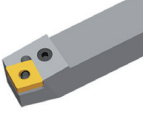
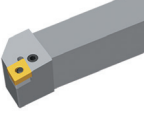
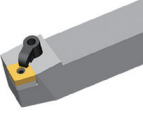
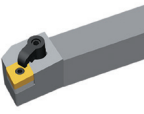
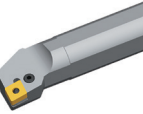
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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

CN** negative insert				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	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

A

Turning

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

B

Milling

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	CNMG120404-ZM				0.4	0.5-3.0	0.05-0.30	●																						
	CNMG120408-ZM				0.8	0.5-4.0	0.1-0.5	○																						
Medium Cut																														

● Ex stock ○ On demand

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

C

Drilling

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

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System code > A42

Grade selection > A40

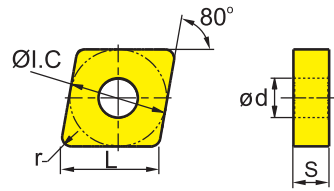
Technical info > A447

Cutting data > A324

Turning inserts

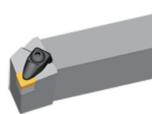
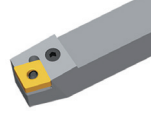
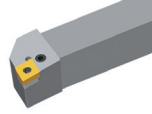
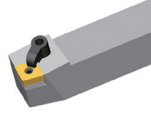
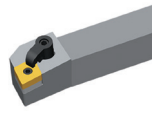
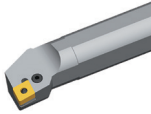
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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					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	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																								
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

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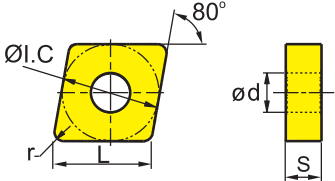
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Turning inserts

- 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										
				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

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

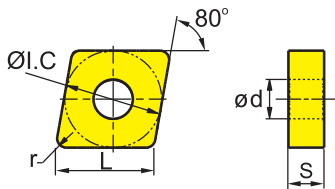
Technical info > A447

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
25 07	25.79	25.4	7.94	9.12
25 09	25.79	25.4	9.525	9.12

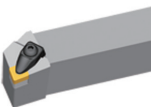
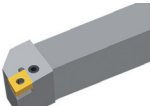
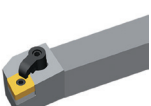
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

Turning inserts

CN** negative insert					HC ¹ (CVD)										HC ¹ (PVD)				HT		HC ²	HW							
					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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201	
 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		●	●	●	○	○																				
 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								●																	
 Roughing	CNMM250724-ER	2.4	2.0-12.5	0.3-1.4		●																							
	CNMM250732-ER	3.2	2.0-12.5	0.45-1.80		○						○																	
	CNMM250924-ER	2.4	2.0-12.5	0.3-1.4		●						●																	
	CNMM250932-ER	3.2	2.0-12.5	0.45-1.80		●						○																	

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

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

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

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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																					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			
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

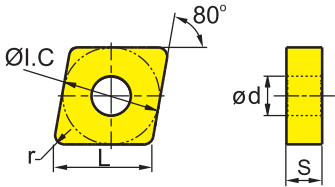
Technical info > A447

Cutting data > A324

Turning inserts

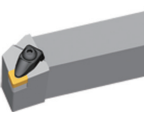
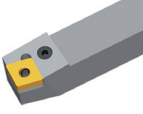
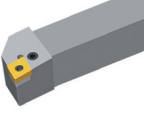
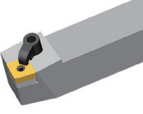
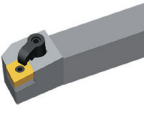
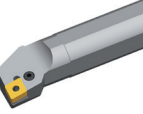
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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

CN** 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 	CNMM120404	0.4	0.5-7.0	0.1-0.5				○																				
	CNMM190612	1.2	0.5-10.5	0.1-0.8				●																				
	CNMM190616	1.6	0.5-10.5	0.1-1.0				○																				
Medium Cut																												
HDR 	CNMM120408-HDR	0.8	1-7	0.2-0.6	●	●	●	○																				
	CNMM120412-HDR	1.2	1-7	0.3-0.8	○	●	●	○																				
	CNMM120416-HDR	1.6	1-7	0.4-1.0	●	●			●																			
	CNMM160612-HDR	1.2	1.5-7.5	0.3-0.8	●	●	●	○																				
	CNMM160616-HDR	1.6	1.5-8.5	0.4-1.0	○	●	●	○																				
	CNMM160624-HDR	2.4	1.5-10.5	0.8-1.2	○	●																						
	CNMM190608-HDR	0.8	2.0-12.5	0.3-0.7	○																							
	CNMM190612-HDR	1.2	2.0-12.5	0.35-0.80	○	●	○		●																			
	CNMM190616-HDR	1.6	2.0-12.5	0.5-1.1	○	●	●	○									○	○										
	CNMM190624-HDR	2.4	2.0-12.5	0.8-1.2	●	●	○																					
	CNMM250924-HDR	2.4	2.0-12.5	0.8-1.4	○	●																						
HPR 	CNMM190616-HPR	1.6	2.0-10.5	0.5-1.0		○																						
	CNMM190624-HPR	2.4	2.0-10.5	0.7-1.4	●	●																						
	CNMM250924-HPR	2.4	2.0-12.5	0.7-1.4			●		●																			
Roughing																												

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

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

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

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

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B

Milling

C

Drilling

D

Technical Information

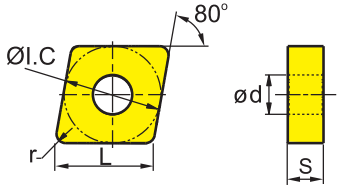
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Turning inserts

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

CN** negative insert					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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201							
	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																															
	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

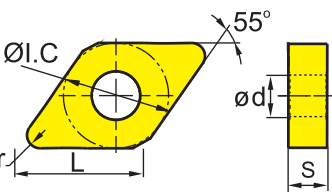
Technical info > A447

Cutting data > A324

Turning inserts

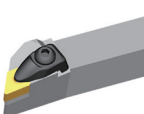
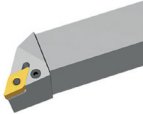
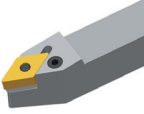
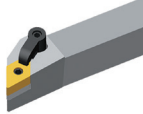
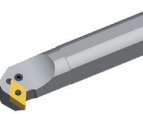
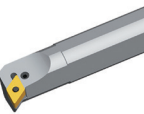
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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				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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
 WG	DNMX110404-WG	0.4	0.2-1.5	0.08-0.30			○																							
	DNMX110408-WG	0.8	0.5-3.5	0.15-0.50			●	●																						
	DNMX150608-WG	0.8	0.5-5.0	0.15-0.70			○	○																						
	DNMX150612-WG	1.2	0.8-6.0	0.20-0.75			○																							
Wiper																														
 ADF	DNMG150604-ADF	0.4	0.5-6.0	0.15-0.50	○																					○				
	DNMG150608-ADF	0.8	0.1-4.0	0.08-0.50	○																					○				
	DNMG150612-ADF	1.2	0.5-4.0	0.15-0.50	○																									
Finishing																														
 DF	DNMG110404-DF	0.4	0.15-2.00	0.08-0.25			●	●	○																					
	DNMG110408-DF	0.8	0.15-2.00	0.1-0.3			●	●																						
	DNMG110412-DF	1.2	0.35-1.50	0.15-0.50			○	○																						
	DNMG150404-DF	0.4	0.15-2.00	0.08-0.25			●	●	○																					
	DNMG150408-DF	0.8	0.15-2.00	0.1-0.3			●	●	○																					
	DNMG150412-DF	1.2	0.35-1.50	0.15-0.50				○																						
	DNMG150604-DF	0.4	0.8-6.0	0.18-0.60			●	●	○																					
	DNMG150608-DF	0.8	0.15-2.00	0.1-0.3			●	●	●																					
Finishing	DNMG150612-DF	1.2	0.2-2.5	0.10-0.35			●	○																						
 SF	DNMG110404-SF	0.4	0.05-0.50	0.05-0.25																							●			
	DNMG150404-SF	0.4	0.05-0.50	0.05-0.25																							●			
	DNMG150408-SF	0.8	0.05-0.50	0.10-0.35																							●			
	DNMG150604-SF	0.4	0.05-0.50	0.05-0.25																							●			
	DNMG150608-SF	0.8	0.05-0.50	0.10-0.35																							●			
Finishing																														

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

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

Tool holder						
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

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				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	DNMG110404-DM	0.4	0.4-5.0	0.1-0.3	●	●	●																							
	DNMG110408-DM	0.8	0.5-5.0	0.15-0.50	●	●	●																							
	DNMG110412-DM	1.2	0.8-5.0	0.18-0.50	●	●																								
	DNMG150404-DM	0.4	0.4-6.0	0.1-0.3	●	●	●																							
	DNMG150408-DM	0.8	0.5-6.0	0.15-0.50	●	●	○																							
	DNMG150412-DM	1.2	0.8-6.0	0.18-0.60	○	●																								
	DNMG150604-DM	0.4	1-6	0.23-0.65	●	●	●																							
	DNMG150608-DM	0.8	0.5-6.0	0.15-0.50	○	●	●	○			●																			
	DNMG150612-DM	1.2	0.8-6.0	0.18-0.60	●	●	●	○																						
	DNMG150616-DM	1.6	1-6	0.23-0.65	○	●	●	●	○																					
PM  Medium Cut	DNMG110404-PM	0.4	0.4-5.0	0.1-0.3		●	●						○																	
	DNMG110408-PM	0.8	0.5-5.0	0.15-0.50	○	○	●		○				●																	
	DNMG110412-PM	1.2	0.8-5.0	0.18-0.50		○							○	●																
	DNMG150404-PM	0.4	0.4-6.0	0.1-0.3	○	○																								
	DNMG150408-PM	0.8	0.5-6.0	0.15-0.50	●	●	●						○	●		●														
	DNMG150412-PM	1.2	0.8-6.0	0.18-0.60		●	○							○		○														
	DNMG150416-PM	1.6	1-6	0.23-0.65		○																								
	DNMG150604-PM	0.4	0.4-6.0	0.1-0.3	●	●	●						●	●		○														
	DNMG150608-PM	0.8	0.5-6.0	0.15-0.50	●	●	●	●	○				○	●		●														
	DNMG150612-PM	1.2	0.8-6.0	0.18-0.60	●	●	●						○	●		●														
	DNMG150616-PM	1.6	1-6	0.23-0.65		●	●						○																	

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

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

Tool holder

DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	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

E

Index

System code > A42

Grade selection > A40

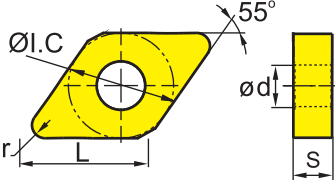
Technical info > A447

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				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			
ZM 	DNMG150612-ZM	1.2	1.0-5.5	0.15-0.60	○	●																											
	Medium Cut																																

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

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

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

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324



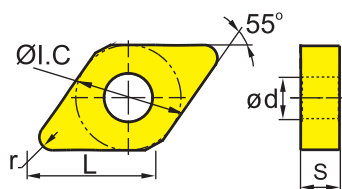
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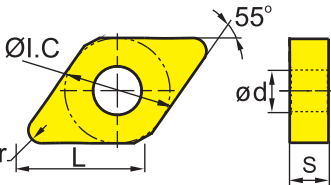
Turning

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					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	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

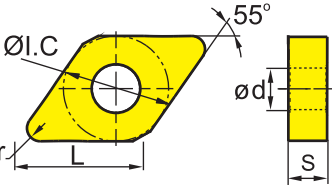
Technical info > A447

Cutting data > A324

Turning inserts

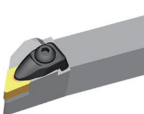
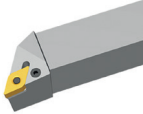
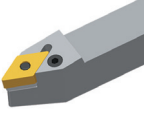
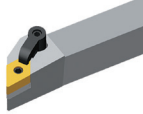
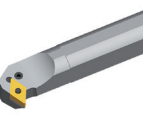
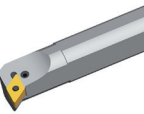
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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					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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201				
 EG	DNMG150604-EG	0.4	1-3	0.05-0.30							●										●											
	DNMG150608-EG	0.8	1-3	0.1-0.4							●	●									●	●										
	DNMG150612-EG	1.2	1-3	0.2-0.6							●	●									●	●										
Medium Cut																																
 EM	DNMG110404-EM	0.4	0.5-4.4	0.05-0.30							●											●	○									
	DNMG110408-EM	0.8	0.5-4.4	0.10-0.45							●											●										
	DNMG150404-EM	0.4	0.5-6.4	0.05-0.30							○											○										
	DNMG150408-EM	0.8	0.5-6.4	0.10-0.45							○											●										
	DNMG150412-EM	1.2	0.5-6.4	0.1-0.6							○																					
	DNMG150604-EM	0.4	0.2-6.4	0.05-0.30							●	●											●	○								
	DNMG150608-EM	0.8	0.5-6.4	0.10-0.45							●	●											●	○								
	DNMG150612-EM	1.2	0.5-6.4	0.1-0.6							●	●										●										
 NM	DNMG150412-NM	1.2	0.2-4.0	0.2-0.6																○												
	DNMG150608-NM	0.8	0.2-4.0	0.1-0.4																○	●											
	DNMG150612-NM	1.2	0.2-4.0	0.2-0.6																○	●											
	Medium Cut																															
 TC	DNMG150608-TC	0.8	0.5-5.0	0.15-0.40										●		●																
	DNMG150612-TC	1.2	0.5-5.0	0.2-0.6											●		○															
	Medium Cut																															

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

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

Tool holder						
DDJNR/L	PDJNR/L	PDNNR/L	MDJNR/L	MDPNN	S***-PDSNR/L	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

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

B

Milling

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

C

Drilling

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

D

Technical Information

E

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System code > A42

Grade selection > A40

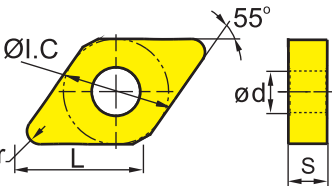
Technical info > A447

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				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 	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												●	○		○											
Medium Cut																														
ER 	DNMG150608-ER	0.8	2-6	0.15-0.55											●															
	DNMG150612-ER	1.2	2-6	0.25-0.80												●														
Roughing																														

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

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

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

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

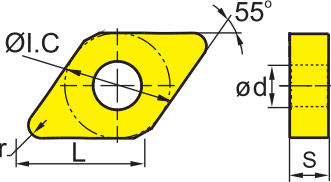
A

Turning

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					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			
 DR	DNMM150608-DR	0.8	0.7-6.0	0.20-0.55	●	●	○																								
	DNMM150612-DR	1.2	1-6	0.25-0.70	●	●		●																							
	DNMM150616-DR	1.6	1.5-6.0	0.32-0.90	●	●																									
Roughing																															
 ER	DNMM150608-ER	0.8	0.7-6.0	0.20-0.55							●																				
	DNMM150612-ER	1.2	1-6	0.25-0.70								●																			
Roughing																															
 HDR	DNMM150608-HDR	0.8	1-7	0.25-0.60	●	○	○		○																						
	DNMM150612-HDR	1.2	1-7	0.3-0.8	○					○																					
	DNMM150616-HDR	1.6	1.5-7.0	0.4-1.0	○		○		○																						
Roughing																															
 LR	DNMM150608-LR	0.8	2-6	0.1-0.6	●	●						●																			
	DNMM150612-LR	1.2	2-6	0.2-0.8	●	●						●																			
	DNMM150616-LR	1.6	2-6	0.25-1.00	●	●							○																		
Roughing																															

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

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

B

Milling

C

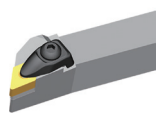
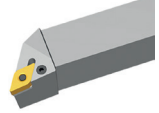
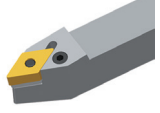
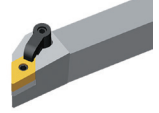
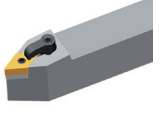
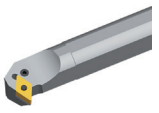
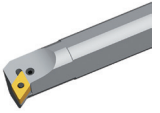
Drilling

D

Technical Information

E

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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

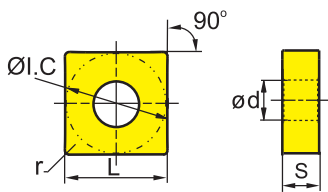
Technical info > A447

Cutting data > A324

Turning inserts

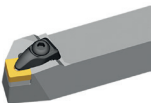
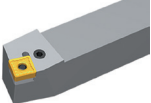
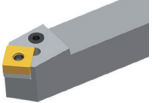
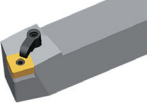
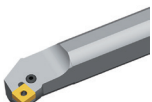
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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				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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201			
ADF 	SNMG120404-ADF	0.4	0.5-5.0	0.1-0.3	●																●										
	SNMG120408-ADF	0.8	0.5-5.0	0.12-0.50	●																●										
	SNMG120412-ADF	1.2	1-5	0.2-0.6	●																●										
Finishing																															
DF 	SNMG120408-DF	0.8	0.3-1.5	0.1-0.4	●	●	○																								
	SNMG120412-DF	1.2	0.35-1.50	0.15-0.50	●	●	○																								
Finishing																															
SF 	SNMG090304-SF	0.4	0.05-0.50	0.05-0.20																					●						
	SNMG090308-SF	0.8	0.05-0.50	0.10-0.35																					●						
	SNMG120404-SF	0.4	0.05-0.50	0.05-0.20																					○						
	SNMG120408-SF	0.8	0.05-0.50	0.10-0.35																					○						
Finishing																															

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

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

Tool holder						
DSBNN/L	PSBNN/L	PSDNN	PSKNR/L	PSSNR/L	MSBNN/L	MSRNN/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

A

Turning

B

Milling

C

Drilling

D

Technical Information

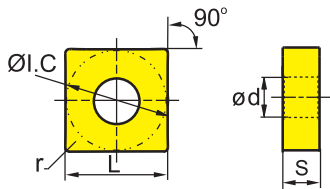
E

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

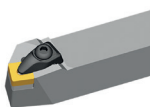
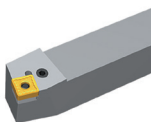
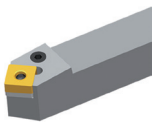
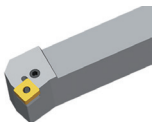
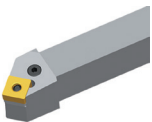
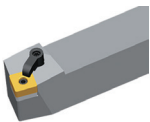
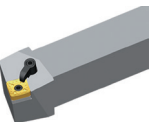
Turning inserts

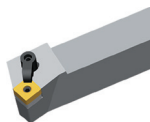
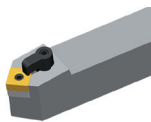
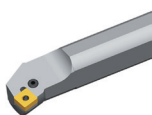
SNMG	L	I.C	S	d
09 03	9.525	9.525	3.18	3.81
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35

SN** negative insert					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	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: 45°	Kr: 75°
		
A224	A225	A289

System code > A42

Grade selection > A40

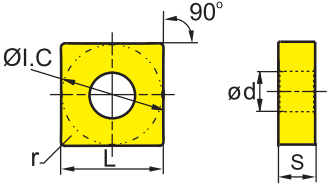
Technical info > A447

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
19 06	19.05	19.05	6.35	7.94

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
 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: 45°	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

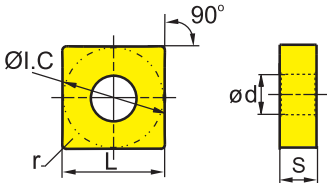
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SNMG	L	I.C	S	d
09 03	9.525	9.525	3.18	3.81
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94

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

Turning inserts

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

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

Tool holder						
DSBNR/L Kr: 75°	PSBNR/L Kr: 75°	PSDNN Kr: 45°	PSKNR/L Kr: 75°	PSSNR/L Kr: 45°	MSBNR/L Kr: 75°	MSRNR/L Kr: 75°
A199	A208	A210	A211	A212	A222	A223

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

System code > A42

Grade selection > A40

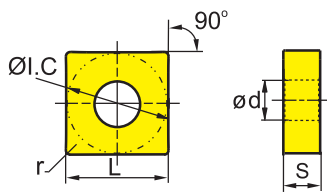
Technical info > A447

Cutting data > A324

Turning inserts

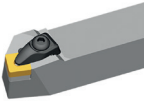
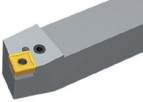
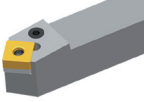
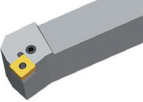
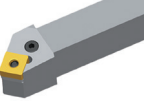
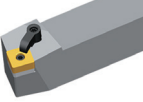
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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				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				
 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: 45°	Kr: 75°				
						
A224	A225	A289				

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Turning

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Milling

C

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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

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

Turning inserts

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							
NM 	SNMG120408-NM	0.8	0.5-5.0	0.1-0.4														●	●								○								
	SNMG120412-NM	1.2	0.5-5.0	0.15-0.50																○															
	Medium Cut																																		
DR 	SNMG120408-DR	0.8	0.7-7.0	0.2-0.5	○	●	●		○				●			●																			
	SNMG120412-DR	1.2	1-7	0.25-0.70	●	●	●	●	○				●			●																			
	SNMG120416-DR	1.6	1.5-7.0	0.32-0.75	○	●	●						●			●																			
	SNMG150612-DR	1.2	1-8	0.25-0.70	●	●	○		●				●			●																			
	SNMG150616-DR	1.6	1.5-8.0	0.3-0.8	○	●	●							○		○																			
	SNMG190612-DR	1.2	1-10	0.25-0.70	●	●	●	●	●								●																		
	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

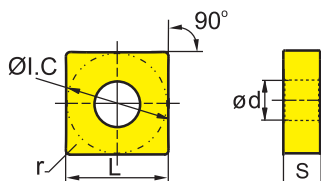
Technical info > A447

Cutting data > A324

Turning inserts

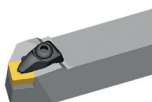
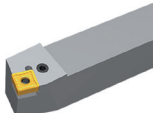
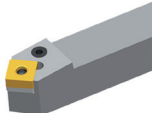
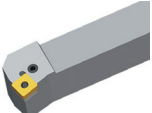
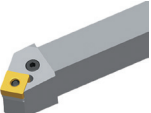
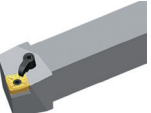
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

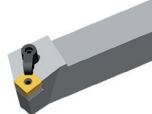
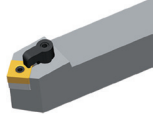
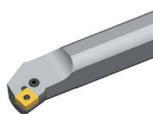
SNMG	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94

SN** negative insert					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	YBG320	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

A

Turning

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Milling

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Technical Information

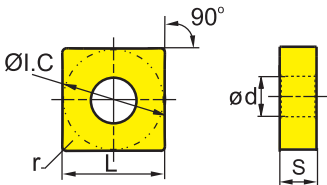
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SNMM	L	I.C	S	d
15 06	15.875	15.875	6.35	6.35
19 06	19.05	19.05	6.35	7.94
25 07	25.4	25.4	7.94	9.12
25 09	25.4	25.4	9.525	9.12

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

Turning inserts

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	YBG320	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

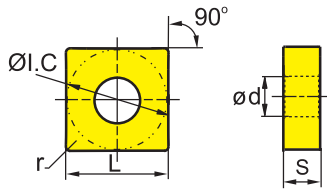
Technical info > A447

Cutting data > A324

Turning inserts

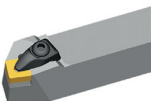
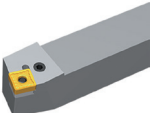
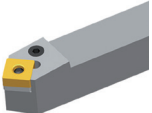
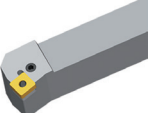
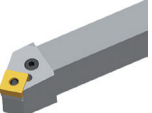
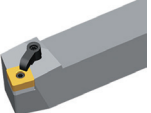
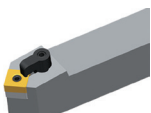
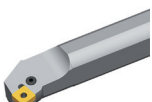
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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

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			
 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				

A

Turning

B

Milling

C

Drilling

D

Technical Information

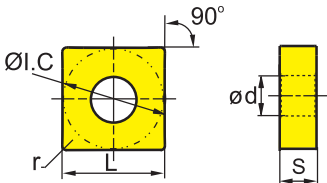
E

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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

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

Turning inserts

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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
 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

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

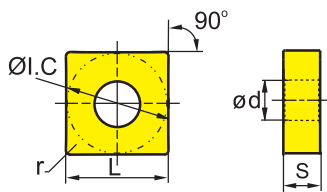
Technical info > A447

Cutting data > A324

Turning inserts

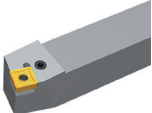
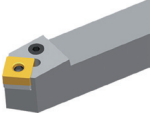
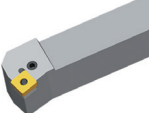
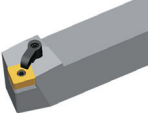
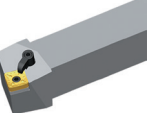
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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				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		
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

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

A

Turning

B

Milling

C

Drilling

D

Technical Information

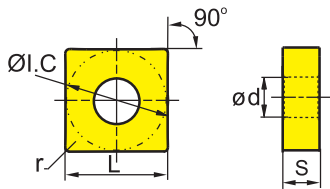
E

Index

Turning inserts

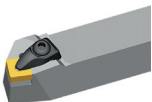
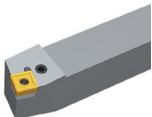
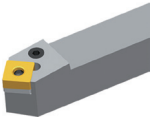
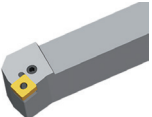
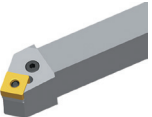
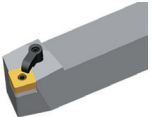
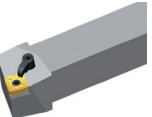
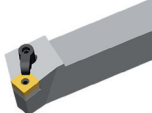
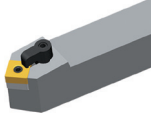
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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				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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
Basic	SNMG120408	0.8	0.5-6.0	0.1-0.6	●	●	●																							
	SNMG120412	1.2	0.5-6.0	0.1-0.7	○	○	○																							
Medium Cut	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

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

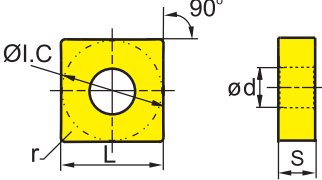
Technical info > A447

Cutting data > A324

Turning inserts

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

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

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					
	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																														
	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 Kr: 75°	PSBNR/L Kr: 75°	PSDNN Kr: 45°	PSKNR/L Kr: 75°	PSSNR/L Kr: 45°	MSBNR/L Kr: 75°	MSRNR/L Kr: 75°
A199	A208	A210	A211	A212	A222	A223
MSKNR/L Kr: 75°	MSDNN Kr: 45°	S***-PSKNR/L Kr: 75°				
A224	A225	A289				

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

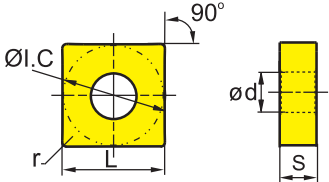
A

Turning

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				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	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

B

Milling



C

Drilling

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

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Technical Information

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System code > A42

Grade selection > A40

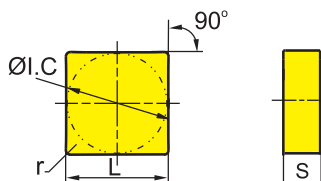
Technical info > A447

Cutting data > A324

Turning inserts

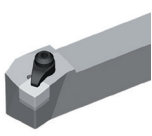
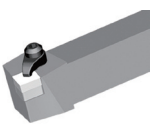
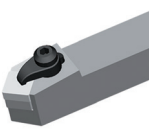
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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				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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201	
Flat 	SNUN120408	0.8	0.7-6.0	0.2-0.5																											
	SNUN120412	1.2	0.7-6.0	0.25-0.60																											
	SNUN190412	1.2	0.9-6.0	0.25-0.60																											
	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 Kr: 75°	CSRNR/L Kr: 75°	CSDNN Kr: 45°
		
A262	A263	A265

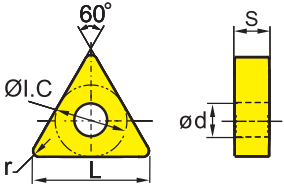
A

Turning

Turning inserts

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

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

TN** negative insert				HC ¹ (CVD)												HC ¹ (PVD)				HT	HC ²	HW							
				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

D

Technical Information

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					

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System code > A42

Grade selection > A40

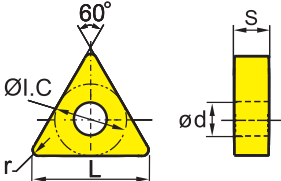
Technical info > A447

Cutting data > A324

Turning inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

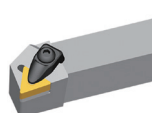
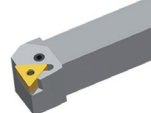
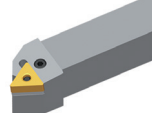
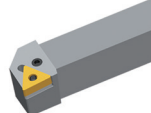
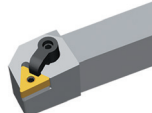
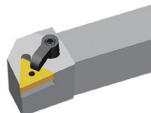
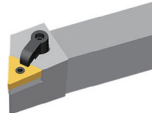
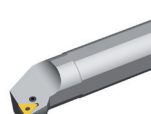
TNMG	L	I.C	S	d
11 03	11	6.35	3.18	2.26
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16

TN** negative insert				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	YBG320	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					

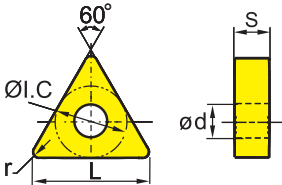
A

Turning

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																						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

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

D

Technical Information

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					

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System code > A42

Grade selection > A40

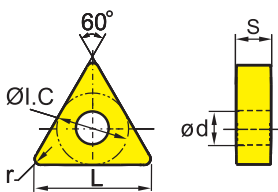
Technical info > A447

Cutting data > A324

Turning inserts

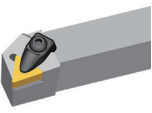
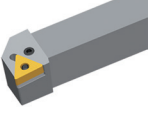
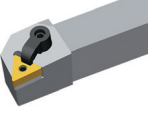
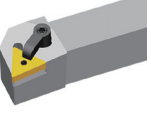
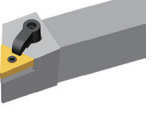
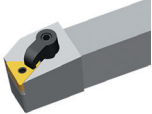
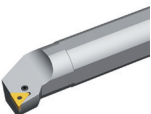
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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				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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
 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																								
 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						
DTG NR/L	PTF NR/L	PTT NR/L	PTG NR/L	MTG NR/L	MTJ NR/L	MTJ NR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A200	A213	A214	A215	A226	A227	A228
MTF NR/L	S***-PTF NR/L					
Kr: 91°	Kr: 90°					
						
A229	A290					

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

A

Turning

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

B

Milling

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 	TNMG160404-ZM	0.4	0.5-5.0	0.08-0.30	●																							
	TNMG160408-ZM	0.8	0.5-5.0	0.1-0.4	●																							
	TNMG160412-ZM	1.2	0.5-5.0	0.1-0.6	●																							
Medium Cut																												

● Ex stock ○ On demand

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

C

Drilling

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

D

Technical Information

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

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System code > A42

Grade selection > A40

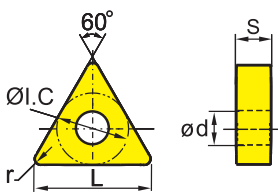
Technical info > A447

Cutting data > A324

Turning inserts

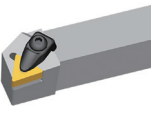
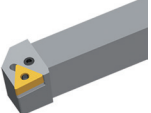
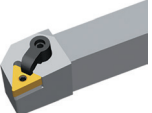
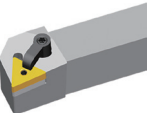
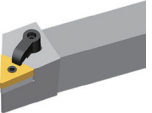
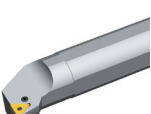
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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				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
 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							●	●									●	●						
 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								●									●							
 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

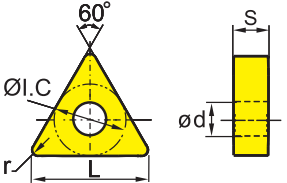
A

Turning

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																				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	YBG320	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

C

Drilling

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					

D

Technical Information

E

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System code > A42

Grade selection > A40

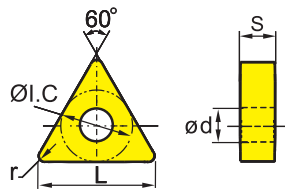
Technical info > A447

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
27 06	27.5	15.875	6.35	5.16

TN** negative insert				HC ¹ (CVD)												HC ¹ (PVD)				HT	HC ²	HW						
				P																								
				M																								
				K																								
				N																								
				S																								
				H																								
ISO		r	a _p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
 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			○																					
 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								○																
 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

A

Turning

B

Milling

C

Drilling

D

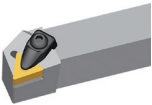
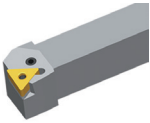
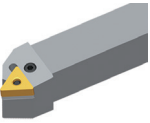
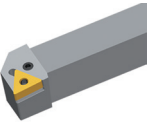
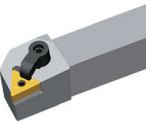
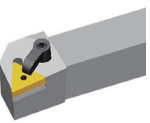
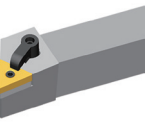
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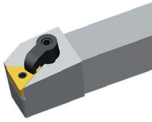
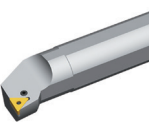
A

Turning

Tool holder						
DTG NR/L	PTF NR/L	PTT NR/L	PTG NR/L	MTG NR/L	MTJ NR/L	MTJ NR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A200	A213	A214	A215	A226	A227	A228

B

Milling

MTF NR/L	S***-PTF NR/L
Kr: 91°	Kr: 90°
	
A229	A290

C

Drilling

D

Technical Information

E

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System code > A42

Grade selection > A40

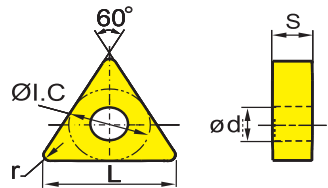
Technical info > A447

Cutting data > A324

Turning inserts

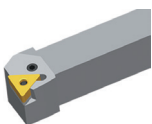
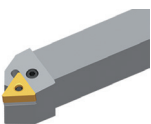
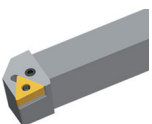
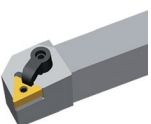
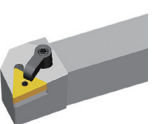
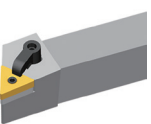
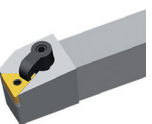
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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					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		
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

A

Turning

B

Milling

C

Drilling

D

Technical Information

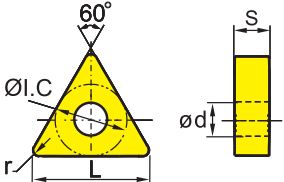
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TNMG	L	I.C	S	d
16 04	16.5	9.525	4.76	3.81
22 04	22	12.7	4.76	5.16
27 06	27.5	15.875	6.35	6.35
33 09	33	19.05	9.525	7.94

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

Turning inserts

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
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

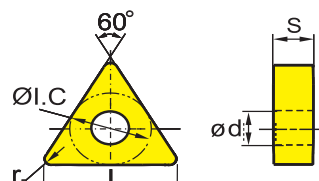
Technical info > A447

Cutting data > A324

Turning inserts

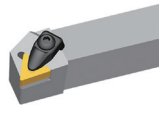
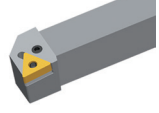
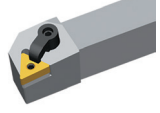
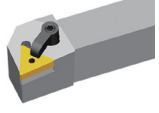
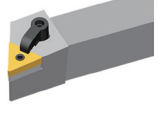
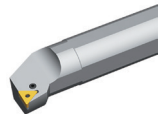
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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

TN** negative insert				HC ¹ (CVD)												HC ¹ (PVD)				HT		HC ²	HW							
				P																										
				M																										
				K																										
				N																										
				S																										
				H																										
ISO		r	a _p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
	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																											
	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						
DTG NR/L	PTF NR/L	PTT NR/L	PTG NR/L	MTG NR/L	MTJ NR/L	MTJ NR/L
Kr: 91°	Kr: 91°	Kr: 60°	Kr: 90°	Kr: 90°	Kr: 93°	Kr: 93°
						
A200	A213	A214	A215	A226	A227	A228
MTF NR/L	S***-PTF NR/L					
Kr: 91°	Kr: 90°					
						
A229	A290					

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

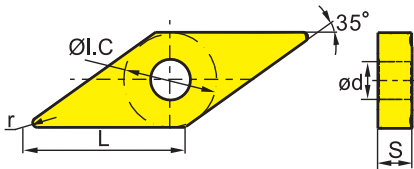
A

Turning

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
				P	●	●	●	●	●	●				●	●	●	
				M						●	●			●	●	●	
				K						●	●	●	●				
				N										●			●
				S										●			●
				H													

B

Milling

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	VNMG160404-ADF	0.4	0.5-2.5	0.1-0.3	●																●							
	VNMG160408-ADF	0.8	0.5-2.5	0.1-0.5	●																●							
																												
Finishing																												
DF	VNMG160404-DF	0.4	0.25-1.50	0.07-0.30	○	●	●																					
	VNMG160408-DF	0.8	0.3-1.5	0.1-0.4	●	●	●																					
																												
Finishing																												
EF	VNMG160404-EF	0.4	0.1-1.5	0.05-0.25							●											●						
	VNMG160408-EF	0.8	0.2-2.5	0.08-0.35							●											●	○					
EF	VNMG160412-EF	1.2	0.2-2.5	0.10-0.45							○																	
Finishing																												
NF	VNEG160404-NF	0.4	0.2-4.0	0.05-0.30																○	●						○	
	VNEG160408-NF	0.8	0.2-4.0	0.05-0.50																○	●						○	
																												
Finishing																												

D

Technical Information

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

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

E

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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

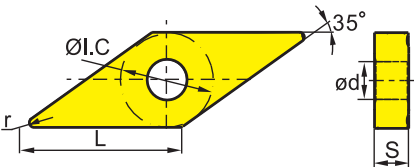
Technical info > A447

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					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				
NGF	VNEG160408-NGF	0.8	0.2-3.0	0.1-0.3																			●												
	VNEG160412-NGF	1.2	0.2-3.0	0.1-0.5																			○												
Finishing																																			
SF	VNMG160404-SF	0.4	0.05-3.00	0.05-0.20																									●						
	VNMG160408-SF	0.8	0.05-3.00	0.05-0.35																									○						
Finishing																																			

● Ex stock ○ On demand

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

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

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

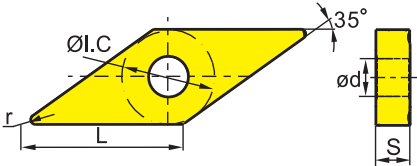
A

Turning

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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201					
Basic	VNMG160404	0.4	0.2-6.0	0.05-0.60	○																												
	VNMG160408	0.8	0.2-6.0	0.08-0.60	○																												
Medium Cut																																	
DM	VNMG160408-DM	0.8	0.5-4.0	0.15-0.50	●	●	●																										
	VNMG160412-DM	1.2	0.8-4.0	0.18-0.60	●	●	●																										
Medium Cut																																	
EM	VNMG160404-EM	0.4	0.2-3.0	0.05-0.30							●										●	○											
	VNMG160408-EM	0.8	0.5-4.0	0.10-0.45							●										●	○											
Medium Cut																																	
NM	VNMG160412-NM	1.2	0.2-4.0	0.05-0.40																●													
Medium Cut																																	

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

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

B

Milling

C

Drilling

D

Technical Information

E

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Tool holder			
DVNN	DVJNR/L	MVNN	MVJNR/L
Kr: 72°30'	Kr: 93°	Kr: 72°30'	Kr: 93°
A201	A202	A230	A231

System code > A42

Grade selection > A40

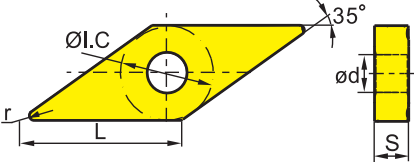
Technical info > A447

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	VNMG160404-PM	0.4	0.4-4.0	0.13-0.40	●	●	●									●		○															
	VNMG160408-PM	0.8	0.5-4.0	0.15-0.50	●	●	●		○						●	●		●															
	VNMG160412-PM	1.2	0.8-4.0	0.18-0.60	●	●	●									○	●																
Medium Cut																																	
 TC	VNMG160404-TC	0.4	0.5-2.0	0.05-0.20													●		●														
	VNMG160408-TC	0.8	0.5-2.0	0.08-0.25													●		●														
	VNMG160412-TC	1.2	0.5-3.0	0.08-0.30													●		●														
Medium Cut																																	
 ZM	VNMG160404-ZM	0.4	0.5-3.0	0.08-0.30	●																												
	VNMG160408-ZM	0.8	0.5-3.0	0.1-0.4	●																												
Medium Cut																																	
 SNR	VNMG160408-SNR	0.8	0.2-2.0	0.1-0.4																	●												
	VNMG160412-SNR	1.2	0.2-2.0	0.1-0.5																		●											
Roughing																																	

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

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

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

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

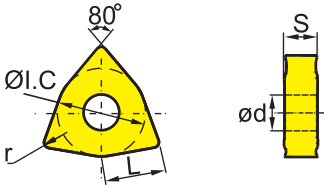
A

Turning

Turning inserts

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

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

WN** negative insert				HC ¹ (CVD)													HC ¹ (PVD)			HT	HC ²	HW										
				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

D

Technical Information

Tool holder			
DWLNr/L	PWLNr/L	MWLNr/L	S***-PWLNr/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
A203	A217	A232	A291

E

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System code > A42

Grade selection > A40

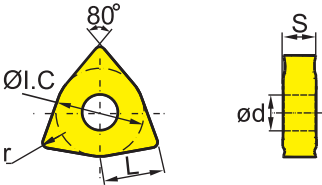
Technical info > A447

Cutting data > A324

Turning inserts

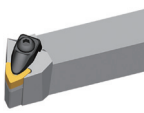
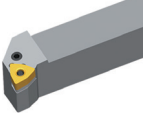
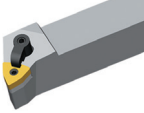
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
 WG Wiper	WNUMG080408-WG	0.8	0.5-5.0	0.15-0.70	●	●																						
	WNUMG080412-WG	1.2	0.8-6.0	0.20-0.75	●	○																						
 EF Finishing	WNUMG060404-EF	0.4	0.1-1.5	0.05-0.30						○											●	○						
	WNUMG060408-EF	0.8	0.1-1.5	0.1-0.4						○											●	○						
	WNUMG06T308-EF	0.8	0.1-1.5	0.1-0.4																	●							
	WNUMG080404-EF	0.4	0.1-1.5	0.05-0.30				○		●											●	●						
	WNUMG080408-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	WNUMG060408-NF	0.8	0.2-2.5	0.05-0.30														○	●									

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

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

Tool holder			
DWLNLR/L	PWLNLR/L	MWLNLR/L	S***-PWLNLR/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A203	A217	A232	A291

A

Turning

B

Milling

C

Drilling

D

Technical Information

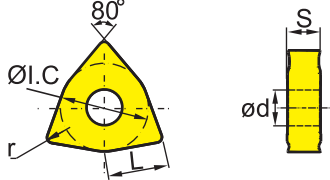
E

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Turning inserts

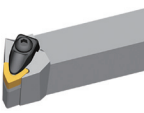
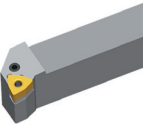
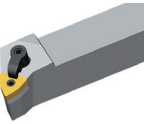
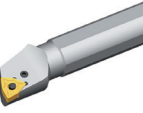
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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

WN** negative insert					HC ¹ (CVD)										HC ¹ (PVD)	HT	HC ²	HW														
					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				
 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		●	●																									
 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							●	●									●	●										
 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			
DWLNRL/L	PWLNRL/L	MWLNRL/L	S***-PWLNRL/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
			
A203	A217	A232	A291

System code > A42

Grade selection > A40

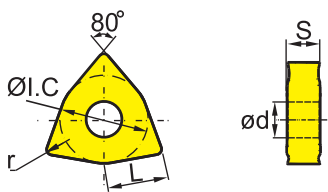
Technical info > A447

Cutting data > A324

Turning inserts

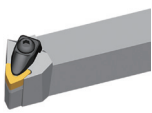
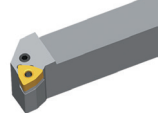
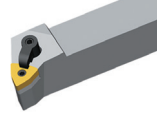
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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								
				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
 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		●									○	●		●										
 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

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

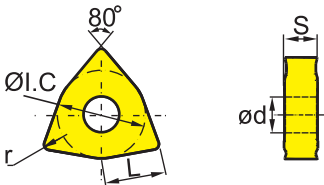
A

Turning

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

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

E

Index

Tool holder			
DWLNRL/L	PWLNRL/L	MWLNRL/L	S***-PWLNRL/L
Kr: 95°	Kr: 95°	Kr: 95°	Kr: 95°
A203	A217	A232	A291

System code > A42

Grade selection > A40

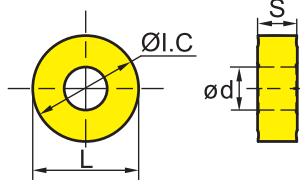
Technical info > A447

Cutting data > A324

Turning inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

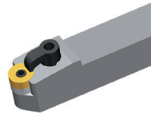
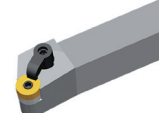
RNMG	L	I.C	S	d
12 04	12.7	12.7	4.76	5.16

RN** negative insert			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	RNMG120400	0.5-7.0	0.1-1.8			●								○	○													
 Medium Cut																												

● Ex stock

○ On demand

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

Tool holder	
MRDNN	MRGNN/L
	
A233	A234

A

Turning

B

Milling

C

Drilling

D

Technical
Information

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Index

A

Turning

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

B

Milling

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	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				●																				
Finishing	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

C

Drilling

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

D

Technical Information

E

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System code > A42

Grade selection > A40

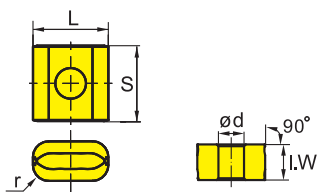
Technical info > A447

Cutting data > A324

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			HC ¹ (CVD)										HC ¹ (PVD)				HT	HC ²	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

A

Turning

B

Milling

C

Drilling

D

Technical
Information

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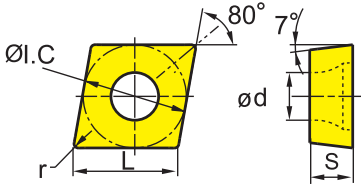
A

Turning

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

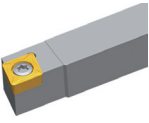
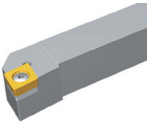
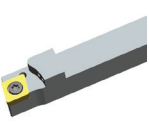
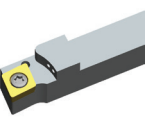
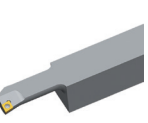
CC** positive insert				HC ¹ (CVD)												HC ¹ (PVD)			HT	HC ²	HW								
				P	●	●	●	●	●							●	●	●	●	●									
				M						●	●						●	●	●	●	●	●	●						
				K									●	●	●	●	●												
				N														●	●							●	●		
				S															●	●	●	●	●				●	●	
				H																									
ISO		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 	CCGT060202-SF	0.2	0.05-2.00	0.05-0.18																				●	●				
	CCGT060204-SF	0.4	0.05-2.00	0.05-0.35																				●	●	●			
	CCGT09T304-SF	0.4	0.05-2.00	0.05-0.35																				●	●	●			
	Finishing																												
USF 	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																		○	○						
	Finishing																												
USF 	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																		○							
	Finishing																												

● Ex stock ○ On demand

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

D

Technical Information

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

E

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System code > A42

Grade selection > A40

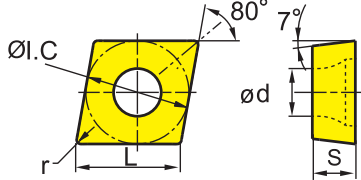
Technical info > A447

Cutting data > A324

Turning inserts

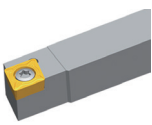
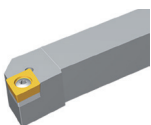
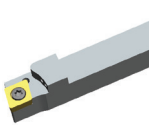
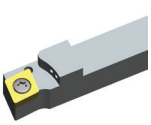
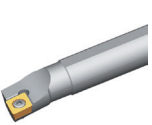
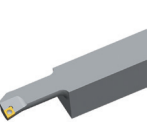
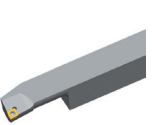
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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				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	YBG320	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°



System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

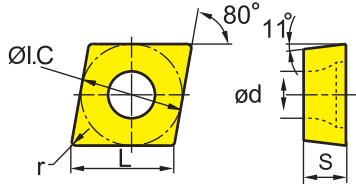
A

Turning

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																				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					
CPGT050204		0.4	0.5-2.0	0.08-0.40				○																									

● Ex stock ○ On demand

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

B

Milling

C

Drilling

D

Technical Information

E

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System code > A42

Grade selection > A40

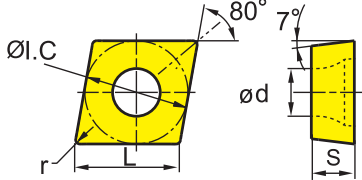
Technical info > A447

Cutting data > A324

Turning inserts

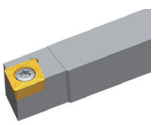
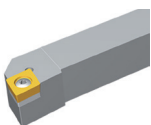
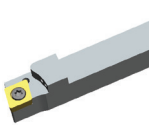
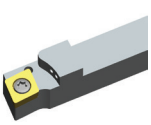
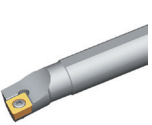
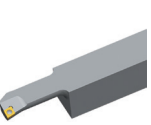
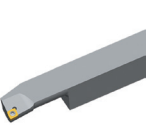
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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				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	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							●											●	○					
 EM Medium Cut	CCMT120408-EF	0.8	0.2-3.0	0.1-0.3						●											●	○						
	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°



A

Turning

B

Milling

C

Drilling

D

Technical Information

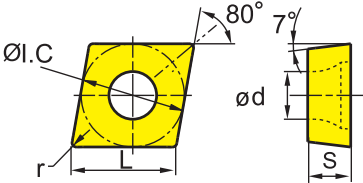
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Turning inserts

- 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				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																					
 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

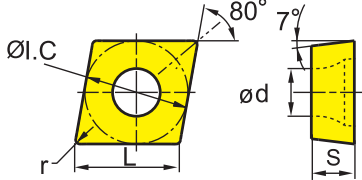
Technical info > A447

Cutting data > A324

Turning inserts

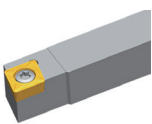
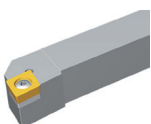
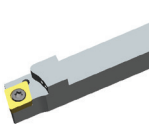
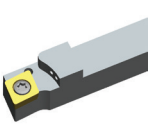
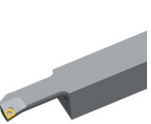
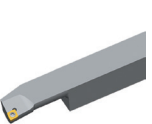
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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

CC** positive insert				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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
 Basic	CCMW09T304	0.4	0.1-5.0	0.05-0.50																										○		
	CCMW120404	0.4	0.2-5.0	0.05-0.50																									○	○		
	CCMW120408	0.8	0.5-5.0	0.08-0.50															○													
Medium Cut																																
 TC	CCMT060204-TC	0.4	0.5-3.0	0.1-0.3														○	●													
	CCMT09T304-TC	0.4	0.5-3.0	0.1-0.3														○	●													
	CCMT09T308-TC	0.8	0.5-3.0	0.1-0.4														●	●													
	CCMT120404-TC	0.4	1-4	0.1-0.3														●	●													
	CCMT120408-TC	0.8	1-4	0.1-0.4														●	●													
Medium Cut																		●	●													
 HR	CCMT060204-HR	0.4	0.5-3.0	0.05-0.24	●	●	●	○																								
	CCMT060208-HR	0.8	0.8-3.2	0.09-0.26	●	○	●												●													
	CCMT09T304-HR	0.4	0.2-4.0	0.05-0.30	●	●	●	○											●													
	CCMT09T308-HR	0.8	1-4	0.12-0.35	●	●	●	●			●	●	●					●														
	CCMT120408-HR	0.8	1.2-4.8	0.14-0.42	●	●	●	○			○	●	●					●														
	CCMT120412-HR	1.2	1.44-4.80	0.17-0.50	●	●	●									○	○															
Roughing																																

● 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

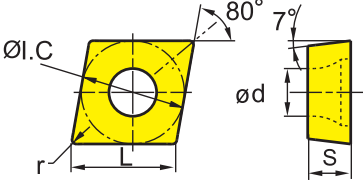
E

Index

Turning inserts

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

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					
				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	
 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														●									●		
 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

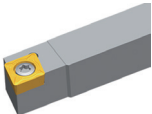
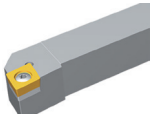
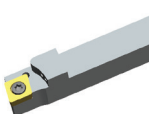
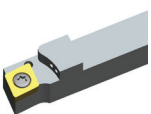
HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

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

A

Turning

B

Milling

C

Drilling

D

Technical
Information

E

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System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

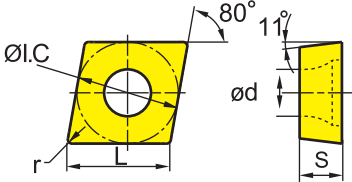
A

Turning

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

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

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

D

Technical Information

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

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System code > A42

Grade selection > A40

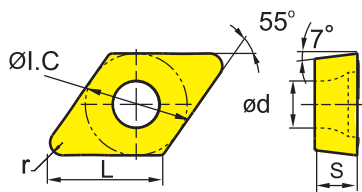
Technical info > A447

Cutting data > A324

Turning inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

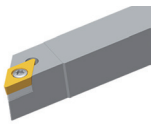
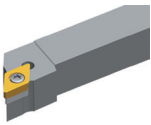
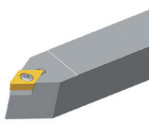
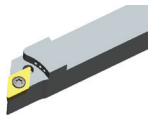
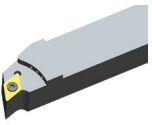
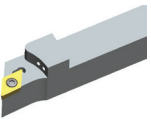
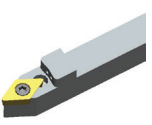
DC**	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

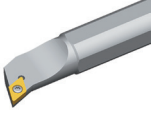
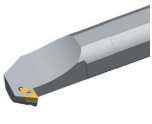
DC** positive insert				HC ¹ (CVD)												HC ¹ (PVD)				HT	HC ²	HW							
				P																									
				M																									
				K																									
				N																									
				S																									
				H																									
ISO		r	a _p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201	
 AHF	DCMT070204-AHF	0.4	0.2-2.5	0.05-0.20	○																●	○		●					
	DCMT11T302-AHF	0.2	0.5-3.0	0.05-0.15	○																●	●		●					
	DCMT11T304-AHF	0.4	0.5-3.0	0.05-0.30	●																●	●		●					
	DCMT11T308-AHF	0.8	0.5-3.0	0.05-0.40	●																●								
Finishing																													
 SF	DCGT070202-SF	0.2	0.05-1.50	0.05-0.15																				●	●	○			
	DCGT070204-SF	0.4	0.05-1.50	0.05-0.20																					○	●			
	DCGT070208-SF	0.8	0.05-1.50	0.05-0.30																						●			
	DCGT11T302-SF	0.2	0.05-2.00	0.05-0.15																○				○	●	●			
	DCGT11T304-SF	0.4	0.05-2.00	0.05-0.20																				●	●	●			
	DCGT11T308-SF	0.8	0.05-2.00	0.05-0.30																				●	●				
Finishing																								●	●				

● Ex stock ○ On demand

YBC152F, YBC252F, YBM153F, YBM253F available

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

Tool holder						
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

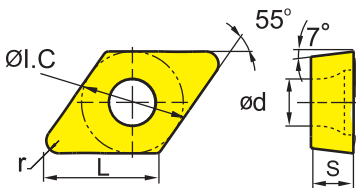
A

Turning

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					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			
USF	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																							○							
Finishing																																		
USF	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																							●							
Finishing																																		

● Ex stock ○ On demand

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

B

Milling

C

Drilling

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			

D

Technical Information

E

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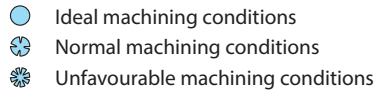
System code > A42

Grade selection > A40

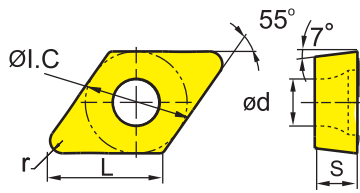
Technical info > A447

Cutting data > A324

Turning inserts



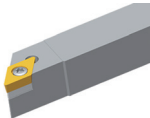
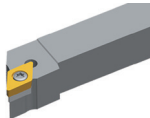
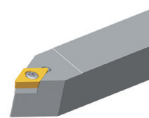
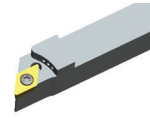
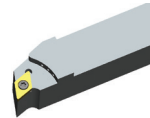
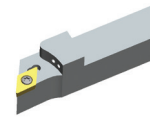
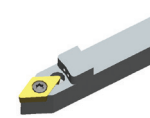
DCMT	L	I.C	S	d
07 02	7.8	6.35	2.38	2.8
11 T3	11.6	9.525	3.97	4.4

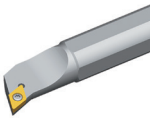
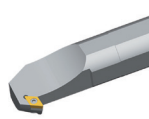


DC** positive insert				HC ¹ (CVD)										HC ¹ (PVD)				HT		HC ²		HW								
				P																										
				M																										
				K																										
				N																										
				S																										
				H																										
ISO				r	a _p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
 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

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

Tool holder						
SDACR/L Kr: 90°	SDJCR/L Kr: 93°	SDNCN Kr: 62°30'	SDACR/L-SC Kr: 90°	SDHCR/L-SC Kr: 107°30'	SDJCR/L-SC Kr: 93°	SDNCN-SC Kr: 62°30'
						
A237	A238	A239	A274	A275	A276	A277

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

A

Turning

Turning inserts

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

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

DC** positive insert				HC ¹ (CVD)					HC ¹ (PVD)	HT	HC ²	HW
				P	●	●	●	●	●	●	●	
				M					●	●	●	
				K					●	●	●	
				N					●	●	●	
				S					●	●	●	
				H								

B

Milling

ISO		r	a _p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
HM	DCMT070204-HM	0.4	0.19-2.25	0.06-0.17	●	●	●	○					●	●							●	●					
	DCMT070208-HM	0.8	0.38-2.25	0.08-0.23	●	●	●	○					●	●							●	●					
	DCMT11T304-HM	0.4	0.25-3.00	0.08-0.23	●	●	●	○					●	●							●	●					
	DCMT11T308-HM	0.8	0.5-3.0	0.1-0.3	●	●	●	○					●	●							●	●					
Medium Cut	DCMT11T312-HM	1.2	0.6-3.0	0.12-0.36	○	○	●	○					○	○													

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

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

C

Drilling

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

D

Technical Information

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

E

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System code > A42

Grade selection > A40

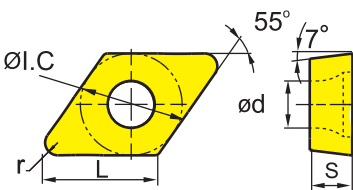
Technical info > A447

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					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 	DCMW11T304	0.4	0.5-5.0	0.05-0.20													○														
	DCMW11T308	0.8	0.4-5.0	0.1-0.4													○														
Medium Cut																															
HR 	DCMT11T304-HR	0.4	1-4	0.1-0.3	○	●	○		○								●		●												
	DCMT11T308-HR	0.8	1-4	0.12-0.35	●	●	●		●					○	●		●		●												
	DCMT11T312-HR	1.2	1.2-4.0	0.14-0.42	○	●	○										○														
Roughing																															
LC 	DCGX070201-LC	0.1	0.3-4.0	0.05-0.10																											●
	DCGX070202-LC	0.2	0.3-4.0	0.05-0.15																		●									●
	DCGX070204-LC	0.4	0.5-4.0	0.1-0.3																		●									●
	DCGX11T302-LC	0.2	0.3-5.5	0.05-0.15																		●									●
	DCGX11T304-LC	0.4	0.5-5.5	0.1-0.3																		●									●
	DCGX11T308-LC	0.8	0.5-5.5	0.15-0.60																		●									●
Aluminium Machining																															

● 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

A

Turning

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

B

Milling

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	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

C

Drilling

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

D

Technical Information

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

E

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System code > A42

Grade selection > A40

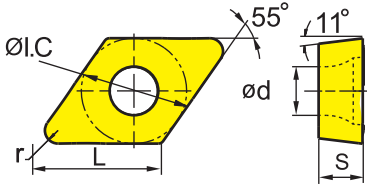
Technical info > A447

Cutting data > A324

Turning inserts

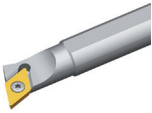
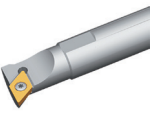
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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				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	DPGT070202-SF	0.2	0.05-2.00	0.05-0.15																				○	●			
	DPGT070204-SF	0.4	0.05-2.00	0.05-0.30																				●	●			
	DPGT11T304-SF	0.4	0.05-2.00	0.1-0.3																				●	●			
	DPGT11T308-SF	0.8	0.05-2.00	0.1-0.4																				○	○			
Finishing																												

● Ex stock ○ On demand

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

A

Turning

B

Milling

C

Drilling

D

Technical Information

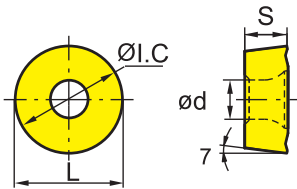
E

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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	4.4
16 06	16	16	6.35	5.5
20 06	20	20	6.35	6.5
25 07	25	25	7.94	7.7

- 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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201	
 Basic	RCGT1204MO	0.5-5.0	0.1-0.4				○																					
 Medium Cut																												
 Basic	RCMT0803MO	0.5-3.0	0.1-0.4			●							●															
	RCMT10T3MO	0.5-4.0	0.1-0.5			○	●						●								○							
	RCMT1204MO	0.8-5.0	0.1-0.6		●	●	●						●	●							○							
	RCMT1606MO	1-6	0.1-0.8		●	●	●		●		○	○	●															
	RCMT2006MO	1.2-8.0	0.1-1.0		●	●	●																					
	RCMT2507MO	1.4-10.0	0.1-1.2		○	●	●																					
 LH	RCGX0803MO-LH	1-4	0.2-0.5																							●		
	RCGX1204MO-LH	1.2-5.0	0.2-0.6																							●		
 Aluminium Machining																												

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

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

Tool holder	
SRDCN	SRGCR/L
A254	A255

System code > A42

Grade selection > A40

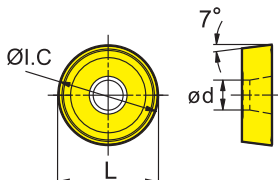
Technical info > A447

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						
			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
 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	RCMX2507MO-1	2-9	0.1-0.4	○	○																						
 Light Roughing																											
Basic	RCMX3209MO-PV	3-12	0.1-0.4	○	●	●																					
 Light Roughing																											

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

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

A

Turning

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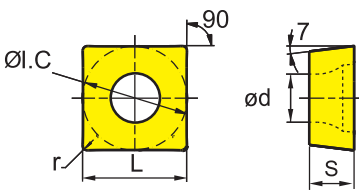
A

Turning

Turning inserts

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

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

SC** positive insert				HC ¹ (CVD)												HC ¹ (PVD)			HT	HC ²	HW									
				P																										
				M																										
				K																										
				N																										
				S																										
				H																										
ISO		r	a _p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
 AHF	SCMT09T304-AHF	0.4	0.5-3.0	0.05-0.30	●																●									
	SCMT09T308-AHF	0.8	0.5-3.0	0.05-0.40	●																●				●					
Finishing																														
 EF	SCMT09T302-EF	0.2	0.07-2.00	0.05-0.15																	●	○								
	SCMT09T304-EF	0.4	0.11-2.00	0.06-0.23																	●									
	SCMT09T308-EF	0.8	0.15-2.00	0.08-0.30																		●								
Finishing																														
 EM	SCMT09T304-EM	0.4	0.25-3.00	0.08-0.23							○	○									●									
	SCMT09T308-EM	0.8	0.5-3.0	0.1-0.3							●	●									●									
	SCMT120404-EM	0.4	0.3-3.6	0.09-0.27							○	○									●									
	SCMT120408-EM	0.8	0.6-3.6	0.12-0.36							○	○									●									
	SCMT120412-EM	1.2	0.72-3.60	0.14-0.43								○									●									
Finishing																														

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

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

D

Technical Information

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

E

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System code > A42

Grade selection > A40

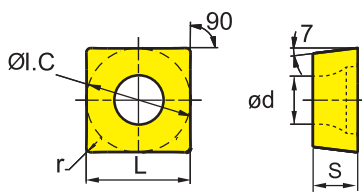
Technical info > A447

Cutting data > A324

Turning inserts

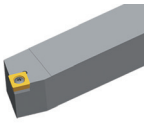
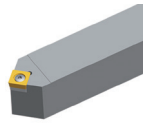
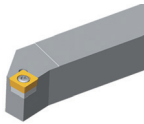
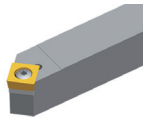
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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									
				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

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

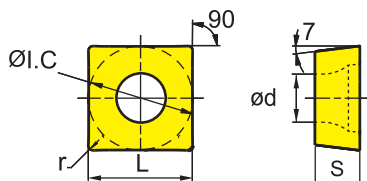
A

Turning

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
				P	●	●	●	●	●	●	●	
				M				●	●	●	●	
				K				●	●	●	●	
				N				●	●			●
				S				●	●	●	●	●
				H								

B

Milling

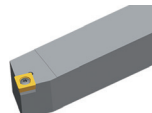
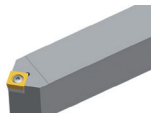
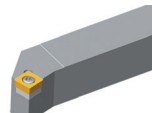
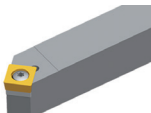
ISO		r	a _p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
HR  Roughing	SCMT09T304-HR	0.4	0.2-4.0	0.05-0.40	○	●	●		○							○						○								
	SCMT09T308-HR	0.8	1-4	0.12-0.35	●	●	●		●					●		●														
	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

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

C

Drilling

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

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System code > A42

Grade selection > A40

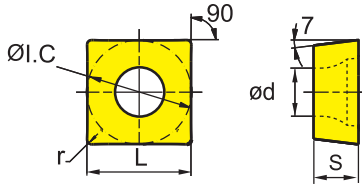
Technical info > A447

Cutting data > A324

Turning inserts

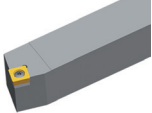
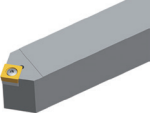
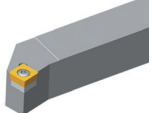
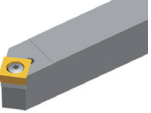
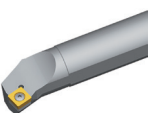
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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

SC** positive insert																					HC ¹ (CVD)					HC ¹ (PVD)				HT		HC ²		HW	
					P																														
					M																														
					K																														
					N																														
					S																														
					H																														
ISO					r	a _p	f	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

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Turning

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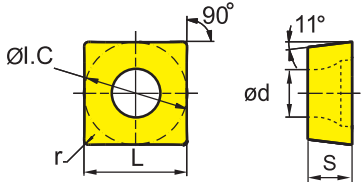
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- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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

Turning inserts

SP** 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
	SPMW09T304	0.4	0.5-4.0	0.1-0.4						○									○											
	SPMW09T308	0.8	0.5-4.0	0.2-0.4						○									○											
	SPMW120408	0.8	1-6	0.3-0.6															○											

● Ex stock ○ On demand

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

System code > A42

Grade selection > A40

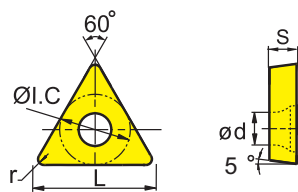
Technical info > A447

Cutting data > A324

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				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	
	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

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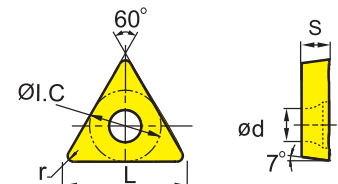
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Turning inserts

- 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

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

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

System code > A42

Grade selection > A40

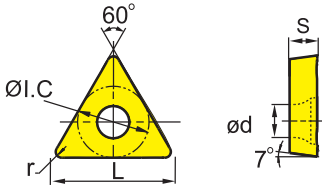
Technical info > A447

Cutting data > A324

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				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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
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	●		●																							

● 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



A

Turning

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				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	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

D

Technical Information

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

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System code > A42

Grade selection > A40

Technical info > A447

Cutting data > A324

Turning inserts

- Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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

TC** positive insert				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 	TCMW16T308	0.8	0.5-5.0	0.05-0.60													○											
Medium Cut																												
HM 	TCMT090204-HM	0.4	0.19-2.25	0.06-0.17	●	●	●							●		●												
	TCMT090208-HM	0.8	0.38-2.25	0.08-0.23	○	○	●										○											
	TCMT110204-HM	0.4	0.2-2.7	0.07-0.20	●	●	●		○					●		●							○					
	TCMT110208-HM	0.8	0.5-2.7	0.1-0.3	●	○	●										●											
	TCMT16T304-HM	0.4	0.25-3.00	0.08-0.23	●	●	●		●					●		●							●					
	TCMT16T308-HM	0.8	0.5-3.0	0.1-0.3	●	●	●		●					●		●							●					
	TCMT16T312-HM	1.2	0.6-3.0	0.12-0.36	○	●	●		○																			
HR 	TCMT090204-HR	0.4	0.5-3.0	0.1-0.3			○	●																				
	TCMT090208-HR	0.8	0.5-3.5	0.08-0.50			○	○									○											
	TCMT110204-HR	0.4	0.5-3.0	0.1-0.4			●	●																				
	TCMT110208-HR	0.8	1-4	0.1-0.5			●	●																				
	TCMT16T304-HR	0.4	0.5-4.0	0.1-0.4			●	●						●														
	TCMT16T308-HR	0.8	1-4	0.12-0.35			●	●	●	●				●		●												
	TCMT16T312-HR	1.2	1.2-4.0	0.14-0.42		○		●					○	○		●												
	TCMT220408-HR	0.8	1.2-4.8	0.14-0.42		●	●	●		●						●												

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

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

Tool holder					
STACR/L	STFCR/L	STGCR/L	STTCR/L	S***-STFCR/L	E***-STFCR/L
Kr: 90°	Kr: 91°	Kr: 91°	Kr: 60°	Kr: 91°	Kr: 90°
A249	A250	A251	A252	A300	A319

A

Turning

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																								HT	HC ²	HW		
60° ØI.C r L s ød 7°				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

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

C

Drilling

D

Technical Information

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System code > A42

Grade selection > A40

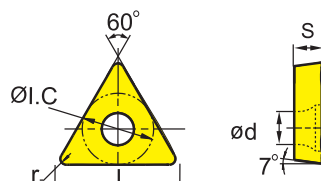
Technical info > A447

Cutting data > A324

Turning inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

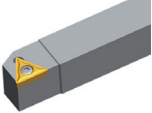
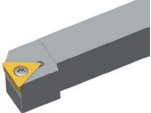
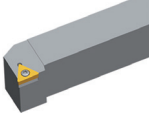
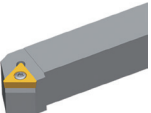
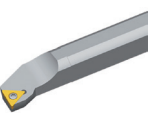
TCGX	L	I.C	S	d
09 02	9.63	5.56	2.38	2.5
11 02	11	6.35	2.38	2.8
16 T3	16.5	9.525	3.97	4.4

TC** positive insert				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	YBG320	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

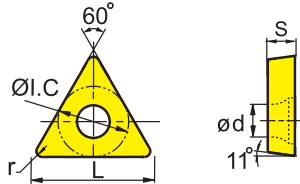
A

Turning

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	
				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

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

C

Drilling

D

Technical Information

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System code > A42

Grade selection > A40

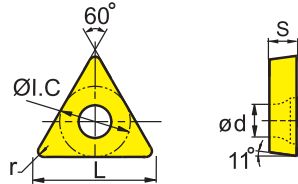
Technical info > A447

Cutting data > A324

Turning inserts

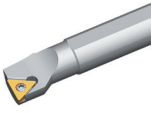
- Ideal machining conditions
- ⊗ Normal machining conditions
- ⊗ Unfavourable machining conditions

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				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	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

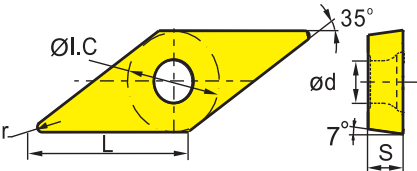
A

Turning

Turning inserts

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

VC GT	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				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		
HF	VC GT110304-HF	0.4	0.2-2.0	0.05-0.30				●														○								
																														
Finishing																														
NF	VC GT160408-NF	0.8	0.2-2.0	0.1-0.4															○	●										
																														
Finishing																														
SF	VC GT110302-SF	0.2	0.05-1.00	0.05-0.15																					●	●	●			
	VC GT110304-SF	0.4	0.05-1.00	0.05-0.25															○		●		●		○	●				
	VC GT160404-SF	0.4	0.05-1.50	0.05-0.25																						●				
Finishing																														

● Ex stock ○ On demand

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

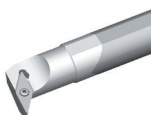
D

Technical Information

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

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System code > A42

Grade selection > A40

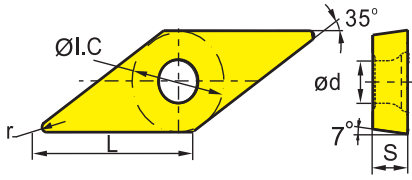
Technical info > A447

Cutting data > A324

Turning inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

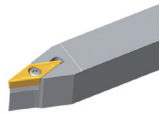
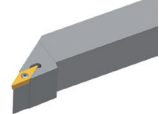
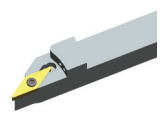
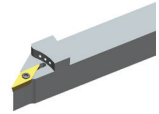
VC GT	L	I.C	S	d
11 03	11	6.35	3.18	2.8
13 03	13.8	7.94	3.175	3.4

VC** positive insert				HC ¹ (CVD)												HC ¹ (PVD)				HT		HC ²		HW				
				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	VC GT110301L-USF	0.1	0.05-2.00	0.03-0.08																			●					
	VC GT110302L-USF	0.2	0.05-2.00	0.05-0.18																			●					
																												
Finishing																												
USF	VC GT110301R-USF	0.1	0.05-2.00	0.03-0.08																			●					
	VC GT110302R-USF	0.2	0.05-2.00	0.05-0.18																			●					
																												
Finishing																												
	VC GT130304	0.4	1-5	0.1-0.3						●																		

● 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

A

Turning

B

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Technical Information

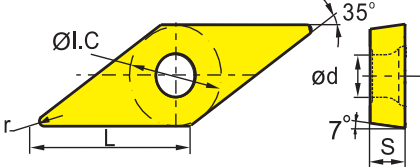
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Turning/Milling inserts

- 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				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
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

System code > A42

Grade selection > A40

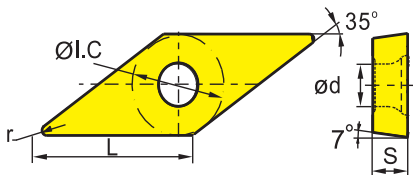
Technical info > A447

Cutting data > A324

Turning/Milling inserts

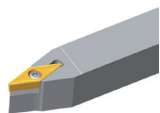
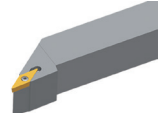
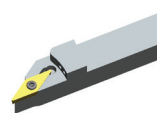
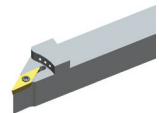
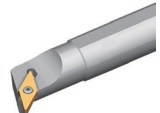
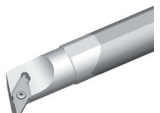
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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

VC** turning/milling 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
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						

A

Turning

B

Milling

C

Drilling

D

Technical Information

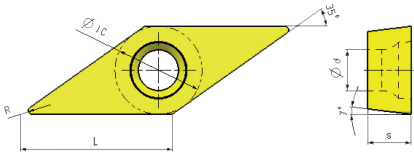
E

Index

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

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

Turning inserts

VC** 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	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201						
EF	VCMT160404-EF	0.4	0.5-2.5	0.05-0.20																		●												
																																		
Medium Cut																																		
EM	VCMT160404-EM	0.4	0.5-2.5	0.05-0.35							○											●												
	VCMT160408-EM	0.8	0.5-2.5	0.10-0.45							○											●												
Medium Cut																																		

● 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

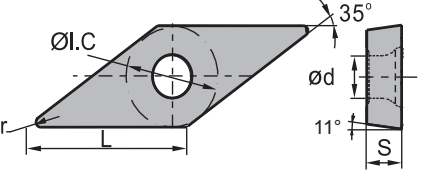
Technical info > A447

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								
				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	VPGT110301R-USF	0.1	0.2-2.5	0.03-0.08																					●					
 Finishing																														

● Ex stock ○ On demand

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

A

Turning

B

Milling

C

Drilling

D

Technical Information

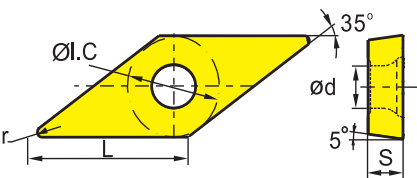
E

Index

Turning inserts

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

VB**	L	I.C	S	d
11 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					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				
AHF	VBMT160404-AHF	0.4	0.2-3.0	0.05-0.30	●																●											
	VBMT160408-AHF	0.8	0.8-3.5	0.08-0.40	●																●											
																																
Finishing																																
EF	VBMT110302-EF	0.2	0.06-1.70	0.03-0.13																	●	○										
	VBMT110304-EF	0.4	0.1-1.7	0.05-0.19							●										●	○										
	VBMT110308-EF	0.8	0.13-1.70	0.07-0.26							●										○	●										
	VBMT160404-EF	0.4	0.1-1.8	0.05-0.20							●										●											
	VBMT160408-EF	0.8	0.14-1.80	0.07-0.27							●										●											
Finishing											●										●											
HF	VBMT110202-HF	0.2	0.2-2.0	0.05-0.15			●															●										
	VBMT110204-HF	0.4	0.2-2.0	0.05-0.35			●															●			○							
	VBMT110208-HF	0.8	0.2-2.0	0.05-0.40			●															●										
Finishing																																
NF	VBET160404-NF	0.4	0.2-3.0	0.05-0.30															○	●												
	VBET160408-NF	0.8	0.2-3.0	0.08-0.40															○	●												
																																
Finishing																																

● Ex stock ○ On demand
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

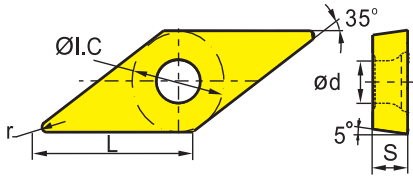
Technical info > A447

Cutting data > A324

Turning inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

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

VB** 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	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

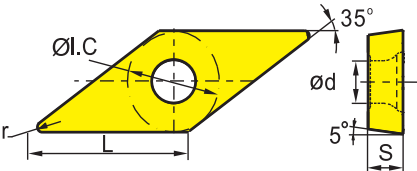
A

Turning

Turning inserts

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

VB**	L	I.C	S	d
11 03	11	6.35	3.18	2.8
16 04	16.5	9.525	4.76	4.4

VB** positive insert					HC ¹ (CVD)												HC ¹ (PVD)	HT	HC ²	HW											
					P	●	●	●	●	●							●	●	●	●	●										
					M							●	●						●	●	●	●	●	●	●						
					K											●	●	●	●	●											
					N																●	●							●	●	
					S																	●	●	●	●	●				●	●
					H																										
ISO		r	a _p	f	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YBG320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201			
NGF	VBET160408-NGF	0.8	0.2-3.0	0.08-0.30																●											
	VBET160412-NGF	1.2	0.2-3.0	0.1-0.4																●											
 Finishing																															
EM	VBMT110304-EM	0.4	0.15-2.00	0.07-0.20							●											●									
	VBMT110308-EM	0.8	0.2-2.0	0.09-0.27	○						●											●									
	VBMT160404-EM	0.4	0.23-2.70	0.07-0.20							●											●									
	VBMT160408-EM	0.8	0.45-2.70	0.09-0.27							●											●									
Medium Cut																															
HM	VBMT160404-HM	0.4	0.23-2.70	0.07-0.20	●	●	●		●	●			●									●									
	VBMT160408-HM	0.8	0.45-2.70	0.09-0.27	●	●	●		●	●			●	●								●					○				
	VBMT160412-HM	1.2	0.54-2.70	0.11-0.32	●	●	●		○																						
Medium Cut																															

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

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

D

Technical Information

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

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System code > A42

Grade selection > A40

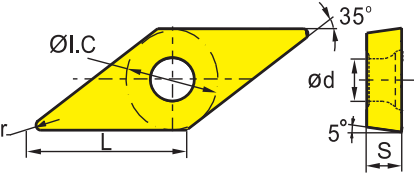
Technical info > A447

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					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			
HR	VBMT160404-HR	0.4	0.5-3.0	0.1-0.3	●	●																									
	VBMT160408-HR	0.8	0.9-3.6	0.11-0.32	○	●	●			○																					
	VBMT160412-HR	1.2	1.08-3.60	0.13-0.38	○	●	○						○																		
Roughing																															
SNR	VBMT160408-SNR	0.8	0.5-4.0	0.1-0.3																○											
	VBMT160412-SNR	1.2	0.5-4.0	0.3-0.6																●											
Roughing																															

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

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

Tool holder				
SVJBR/L	SVABR/L	SVVBN	S***-SVQBR/L	S***-SVUBR/L
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

A

Turning

B

Milling

C

Drilling

D

Technical Information

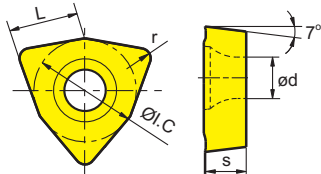
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Turning inserts

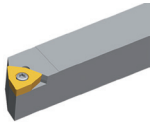
- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

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					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	YBG320	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