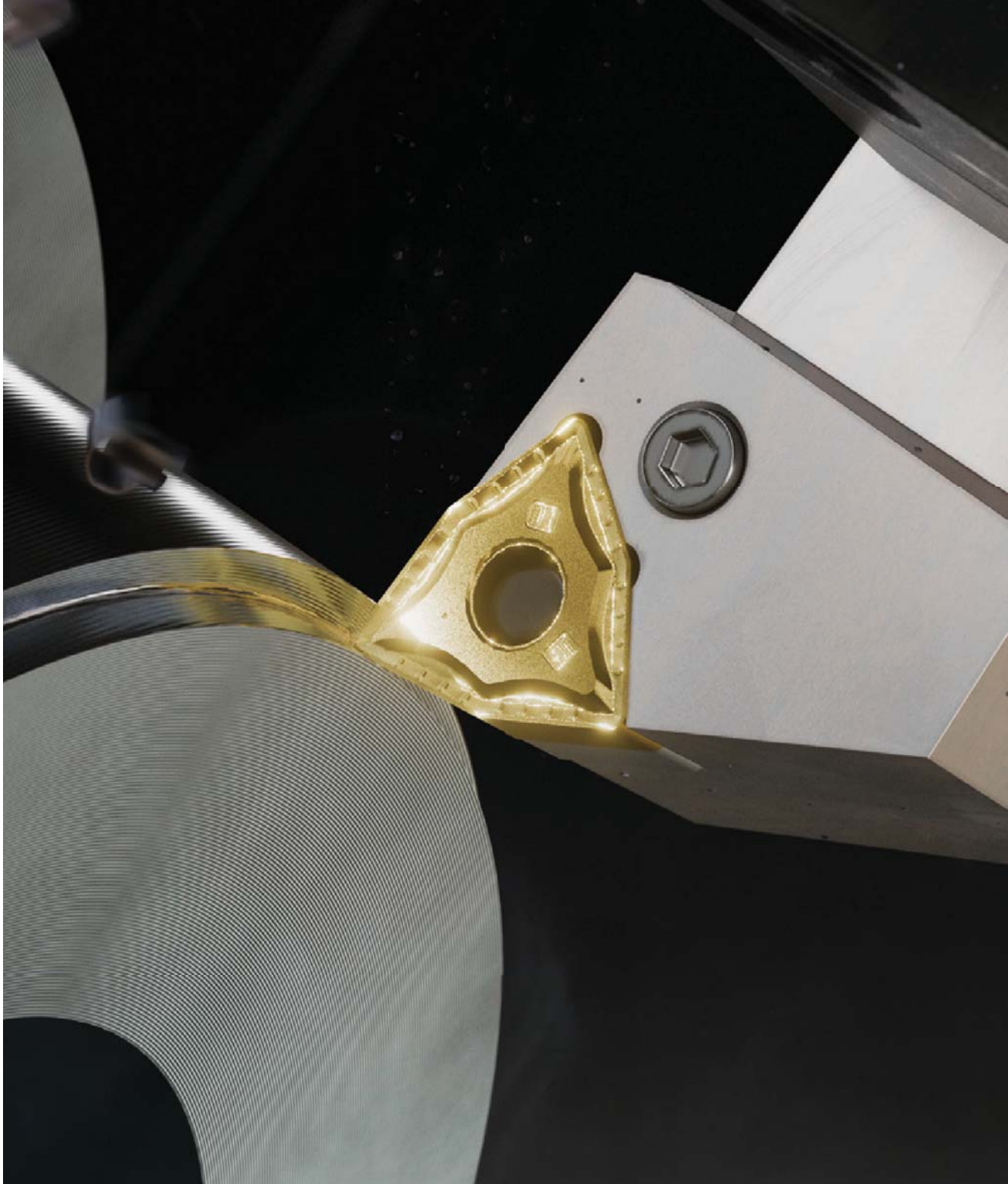




ISO TURNING

Product Overview

Application Guide

Turning Inserts Overview

Turning Inserts

Turning Holders Overview

Turning Holders

Turning - Name Code System

External Turning Holder Code

1	2	3	4	5	6	7	8	9	10
P	C	L	N	R	25	25	M	12	(C)
Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Shank Height (H)	Shank Width (B)	Length (LF)	Insert Size	(Optional Clamp)

1 - Clamping System

Symbol	System
C	Top Clamp (No Clamping Hole Insert)
M	Multi lock (Straight Clamping Hole Insert)
P	Lever Lock (Straight Clamping Hole Insert)
S	Screw Clamp (Screw Clamping Hole Insert)
T (D, A)	Double Clamp (Straight Clamping Hole Insert)

2, 4 - Insert Compatibility *



* Related to Insert Designation to check compatibility

* Refer to '1-shape' of page 18

3 - Tool Style

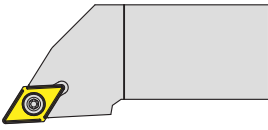
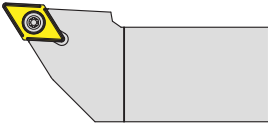
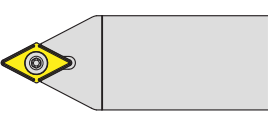
Approach Angle (KAPR)	Side Direction		End Direction
	Straight Shank	Offset Shank	
45°	D 	S 	
60°		T 	
62.5°	N 		
72.5°	V 		
75°	B 		K
90°/91°	A 	G 	F
93°		J 	U
95°		L (Both Direction) 	
107.5°		H 	

Turning - Name Code System

External Turning Holder Code

1	2	3	4	5	6	7	8	9
S	D	J	C	R	20	20	K	11
Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Shank Height (H)	Shank Width (B)	Length (LF)	Insert Size

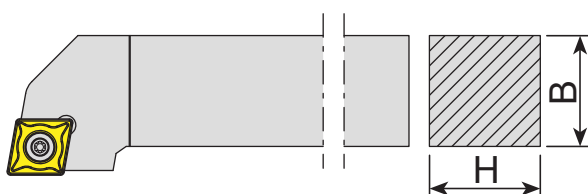
5 - Hand Direction

Symbol	Hand Direction
R	Right Hand 
L	Left Hand 
N	Neutral 

8 - Length (LF)

Symbol	Length (mm)	Symbol	Length (mm)
E	70	Q	180
F	80	R	200
H	100	S	250
K	125	T	300
M	150	U	350
P	170	V	400

6, 7 - Shank Height (H) Shank Width (B)



9 - Insert Size *

Examples	is Compatible with...
PCLNR 2525M 12	CNMG 1204**
SCLCR 2020K 09	CCMT 09T3**
TWLNr 2525M 08	WNMG 0804**

* Related to Insert Designation to check compatibility

(10 - Optional Clamp)

Symbol	Optional Clamp
C	Included

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning - Name Code System

Internal Turning Holder Code

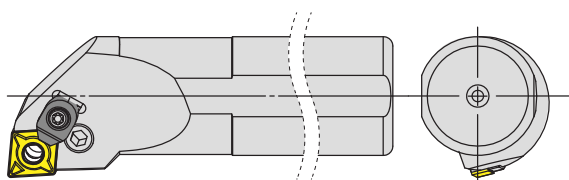
*Metric

1	2	3		4	5	6	7	8	9	10
A	32	S	-	P	W	L	N	R	12	(C)
Coolant & Material	Shank Diameter (DCON)	Legth (LF)		Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Insert Size	(Optional Clamp)

1 - Coolant and Tool Material

Symbol	Internal Coolant	Tool Material
A	O	Steel
S	X	
E	O	Carbide
C	X	

2 - Shank Diameter (DCON)



3 - Length (LF)

Symbol	Length (mm)	Symbol	Length (mm)
E	70	Q	180
F	80	R	200
H	100	S	250
K	125	T	300
M	150	U	350
P	170	V	400

4 - Clamping System

Symbol	System
C	Top Clamp (No Clamping Hole Insert)
M	Multi lock (Straight Clamping Hole Insert)
P	Lever Lock (Straight Clamping Hole Insert)
S	Screw Clamp (Screw Clamping Hole Insert)
T (D, A)	Double Clamp (Straight Clamping Hole Insert)

Turning - Name Code System

Internal Turning Holder Code

*Metric

1	2	3	-	4	5	6	7	8	9
A	25	R	-	S	C	L	C	R	09
Coolant & Material	Shank Diameter (DCON)	Legth (LF)		Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Insert Size

6 - Tool Style

Approach Angle (KAPR)	Side Direction	End Direction
	Offset Shank	
75°		K
91°		F
93°	J	U
95°	L (Both Direction)	
107.5°		Q

8 - Hand Direction

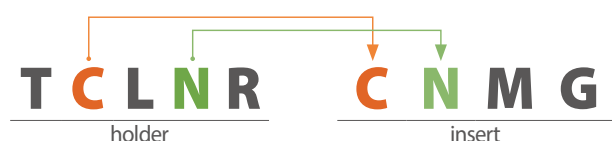
Symbol	Hand Direction
R	Right Hand
L	Left Hand

9 - Insert Size *

Examples	is Compatible with...
PCLNR 2525M 12	CNMG 1204**
SCLCR 2020K 09	CCMT 09T3**
TWLNR 2525M 08	WNMG 0804**

* Related to Insert Designation to check compatibility

5, 7 - Insert Compatibility *



* Related to Insert Designation to check compatibility

* Refer to '1-Shape' of page 18

(10 - Optional Clamp)

Symbol	Optional Clamp
C	Included

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Insert ISO Code System

*Metric : According to ISO 1832

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page 12

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

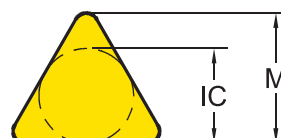
1	2	3	4	5	6	7	8	9
C	N	M	G	12	04	08	-UG	YG3115
Shape	Clearance	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

1 - Shape

Symbol	Shape	
H	Hexagonal	
O	Octagonal	
P	Pentagonal	
S	Square	
T	Triangular	
C	Rhombic 80°	
D	Rhombic 55°	
V	Rhombic 35°	
W	Trigon	
L	Rectangular	
K	Parallelogram 55°	
R	Round	

2 - Relief Angle (AN)

Symbol	Relief Angle (AN)	
N	No Relief Angle	
B	Relief 5°	
C	Relief 7°	
P	Relief 11°	
D	Relief 15°	
E	Relief 20°	
F	Relief 25°	
O	Special	

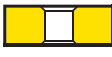


3 - Tolerance Class

Symbol	Inner Circle IC (mm)	Nose Height M (mm)	Thickness S (mm)
C	± 0.025	± 0.013	± 0.025
E	± 0.025	± 0.025	± 0.025
G	± 0.025	± 0.025	± 0.13
H	± 0.013	± 0.013	± 0.025
K*	± 0.05~0.15*	± 0.013	± 0.025
M*	± 0.05~0.15*	± 0.08~0.2*	± 0.13
U*	± 0.08~0.25*	± 0.13~0.38*	± 0.13

* Tolerance is different by insert IC size. Please see ISO 1832

4 - Clamping & Chipbreaker

Symbol	Clamping	Chipbreaker	Figure
N	No clamping hole	X	
R		One Face	
A	Cylindrical Clamping hole	X	
M		One Face	
G		Both Faces	
W	Screw Hole	X	
T		One Face	
U		Both Faces	
X	Special		

Insert ISO Code System

*Inch

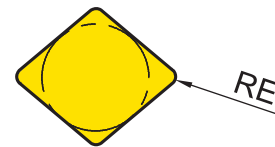
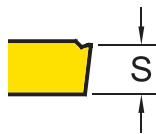
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1	2	3	4	5	6	7	8	9
C	N	M	G	4	3	2	-UG	YG3115
Shape	Clearance	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

5 - Insert Size

Metric							Inner Circle IC (mm)	Inch
06	11	06	07	11			6.35	2
07	13	08	09	13	15		7.94	2.5
09	16	09	11	16	06	09 (00)	9.525	3
12	22	12	15	22	08	12 (00)	12.7	4
15	27	16	19	27	10		15.875	5
19	33	19	23	33	13		19.05	6
25		25					25.4	8
						06 (M0)	6	
						08 (M0)	8	
						10 (M0)	10	
						12 (M0)	12	
						16 (M0)	16	



6 - Insert Thickness (S)

Metric	Thickness - S (mm)	Inch
T1	1.98	1.2
02	2.38	1.5
03	3.18	2
T3	3.97	2.5
04	4.76	3
05	5.56	3.5
06	6.35	4
07	7.94	5
09	9.525	6

7 - Corner Radius (RE)

Metric	Corner Radius - RE (mm)	Inch
01	0.1	03
02	0.2	05
04	0.4	1
08	0.8	2
12	1.2	3
16	1.6	4
20	2.0	5
24	2.4	6

Grade Naming System

TURNING

1	2	3	4	5	(6)
YG	3	1	1	5	(G)
YG Brand	Workpiece Material	Grade Version	Application Range (1st Digit)	Application Range (2nd Digit)	Minor Variation

PARTING & GROOVING

Carbide CVD (4 Digits)	●	●	●	●	YG3115
Carbide PVD (3 Digits)	●	●	●		YG211
Carbide Uncoated (2 Digits)	●	●			YG10

MILLING

1 - YG Brand

2 - Workpiece Material

Symbol	Workpiece Material	Turning	Milling	Drilling	Parting
1	K Cast Iron or N Non-Ferrous	●			
2	M Stainless Steel	●			
3	P Steel	●			
4	S Superalloys	●			
5	K Cast Iron or N Non-Ferrous		●	●	●
6	M Stainless Steel or Universal		●	●	●
7	P Steel		●	●	●
8	Universal	●			
9	Exotic Material		●		
0	Hardened Steel		●		

DRILLING

TECHNICAL INFORMATION

4 & 5 - Application Range

Symbol	
05	 Wear Resistant Grade Stable Application Continuous Cut Finishing
10	
15	
20	 Balanced Grade High Versatility General Application
25	
30	
35	 Tougher Grade Unstable Application Interrupted Cut Chipping Resistance Roughing
40	
45	

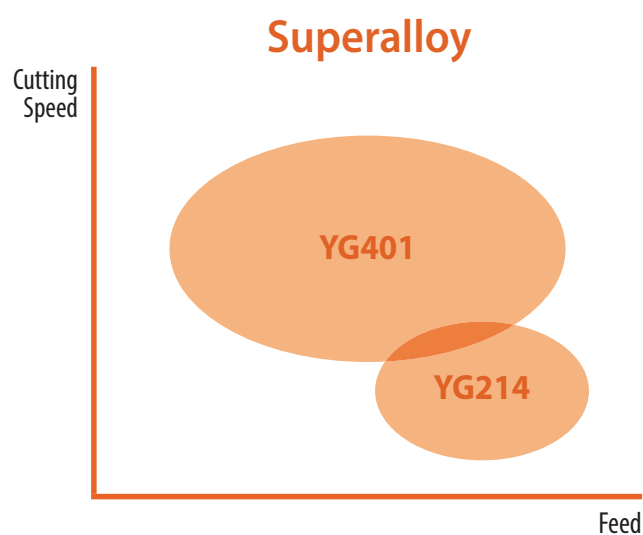
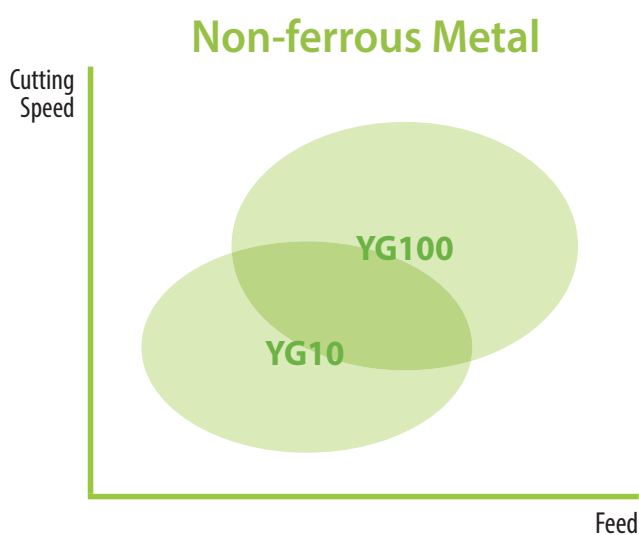
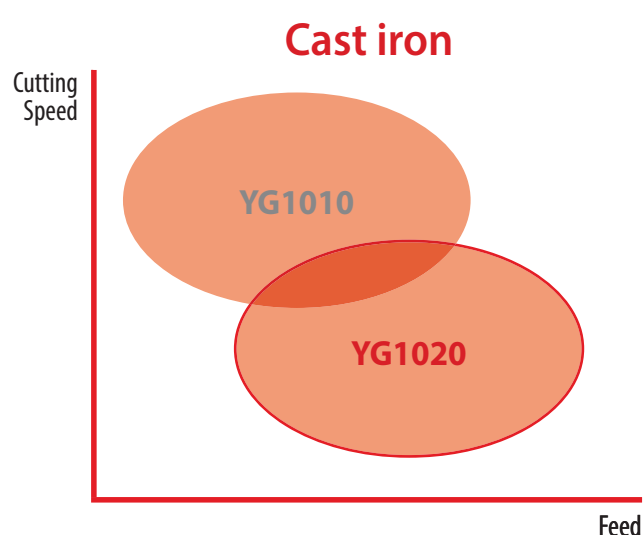
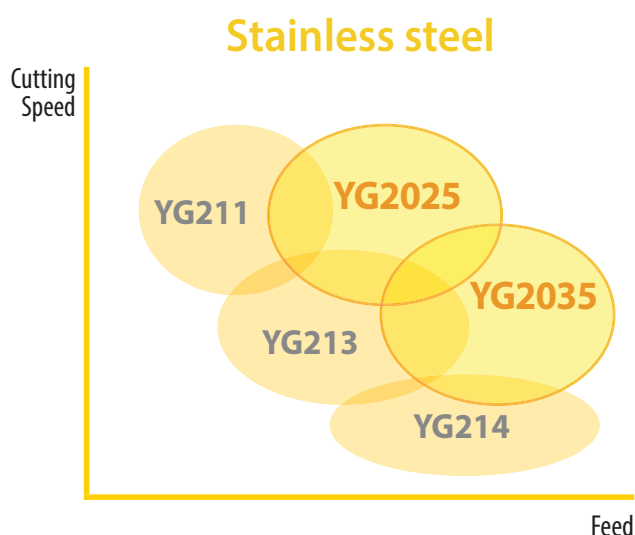
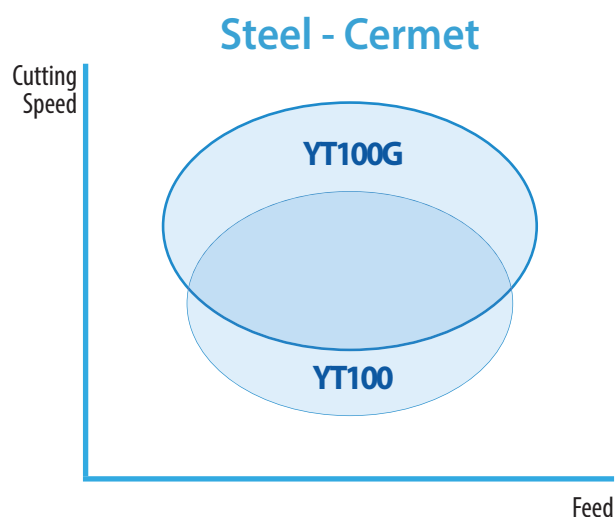
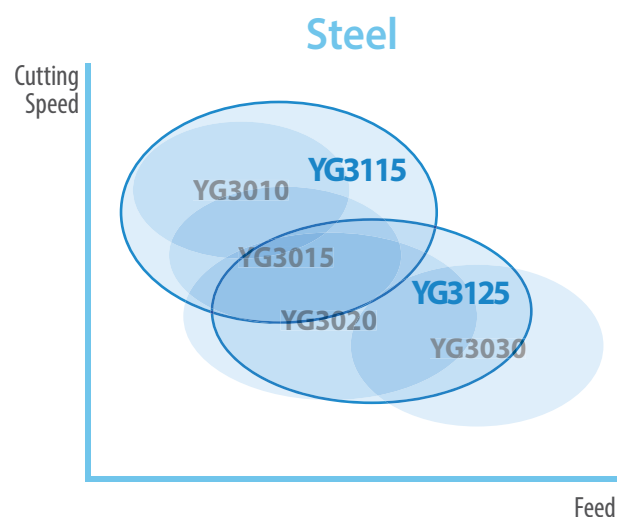
(6) - (Minor Variation)

G - Gold Coated Version

Product Overview

Turning Grades Map

Speed : Vc (m/min.)
Feed : Fn (mm/rev.)



TURNING

PARTING & GROOVING

MILLING

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TECHNICAL INFORMATION

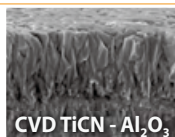
Product Overview

Turning Grades

	Turning Grades	P Steel				M Stainless steel			K Cast iron			N Non-ferrous		S Superalloys	
		P10	P20	P30	P40	M10	M20	M30	K10	K20	K30	N10	N20	S10	S20
TURNING	YG1010								1010						
	YG1001	1001							1001						
	YG1020								1020						
	YG3010	3010							3010						
	YG3015	3015													
	YG3115	3115													
	YG3125	3125													
	YG3020	3020													
	YG3030	3030													
	YG2025					2025									
	YG2035						2035								
PARTING & GROOVING	YG801	801													
	YG211					211									
	YG213					213									
	YG214					214									214
	YG401													401	
MILLING	YG100	YT100				YT100			YT100						
	YT100G	YT100G				YT100G			YT100G						
	YG100											100			
DRILLING	YG10											10			
	-														

YG1010

K05 - K15

CVD TiCN - Al₂O₃

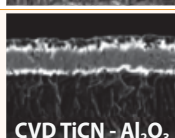
First Choice for Cast Iron

- Effective coating structure enables high speed machining
- Special post treatment for improved chipping resistance

YG1001

P01 - P10

K10 - K25

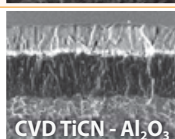
CVD TiCN - Al₂O₃

Stable Machining of Cast Iron

- Substrate especially designed for high wear resistance
- Thick Al₂O₃ layer ensures good wear resistance at high cutting speeds including dry machining

NEW YG1020

K15 - K25

CVD TiCN - Al₂O₃

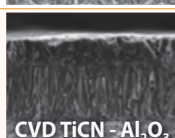
First choice for ductile cast iron

- Excellent wear and fracture resistance when machining ductile cast iron
- New coating ensures outstanding resistance to abrasion wear

YG3010

P05 - P20

K15 - K35

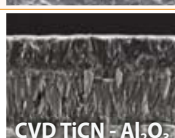
CVD TiCN - Al₂O₃

First choice for Finishing Steels, and Ductile Cast iron

- Finishing and light machining of steel under in stable condition
- New Al₂O₃ coating technology and excellent surface smoothness increase wear resistance and chipping resistance

YG3015

P10 - P25

CVD TiCN - Al₂O₃

Balanced Productivity for Continuous cut

- High wear resistance and improved toughness ensures high productivity with less trouble

YG3115

P15 - P25

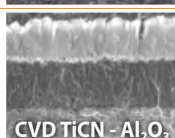
CVD MT-TiCN - Al₂O₃

First choice grade for high cutting speed in Steels

- Suitable for mass production due to stable and predictable tool life
- Minimizing built up edge due to new post surface treatment in mild steels, low carbon steel and low carbon alloy steel.
- Best choice for both continuous as well as interrupted cuts

NEW YG3125

P20 - P30

CVD TiCN - Al₂O₃

Recommended first grade for steel

- New substrates with a unique combination of good toughness and plastic deformation resistance
- General Machining on steel

Product Overview

Turning Grades

YG3020 P15 - P30	 CVD TiCN - Al ₂ O ₃	First Choice Grade for General Steel Application • Substrate especially designed for good toughness • Excellent surface smoothness increases wear resistance and reliability
YG3030 P20 - P35	 CVD TiCN - Al ₂ O ₃	Interrupted Cutting of Steel and Stainless steel • Substrate for heavy roughing in mild steel and low carbon alloy steel • New Al₂O₃ technology and optimized surface treatment achieves a good balance between wear resistance and chipping resistance
YG801 P10 - P30	 PVD - TiAlN	for Carbon Steel with Low Cutting Speed • Recommended for mild steel and boring application • Substrate and special PVD coating for excellent wear resistance
YG2025 M15 - M35	 CVD TiCN - Al ₂ O ₃	CVD grade for High Cutting Speed for Stainless steel • Utilizing a new carbide substrate and new coating • Excellent combination of wear resistance and chipping resistance • Minimized built up edge due to post surface treatment
NEW YG2035 M30 - M40	 CVD TiCN - Al ₂ O ₃	CVD Coated Grade for stainless steel at Low Cutting Speed • Substrate withstands heavy interruption, while the coating provides the wear resistance needed for a long tool life • Smooth surface resists build-up edge, even at low cutting speeds
YG211 M05 - M25	 PVD - TiAlN	High wear Resistance Grade for Stainless steel • Finishing Stainless steel
YG213 M20 - M35	 PVD - TiAlN	First Choice Grade on Low Cutting Speed of Stainless steel • First choice on Stainless steel for Low cutting speed • For Medium to low cutting speed
YG214 M30 - M40 S25 - S30	 PVD - TiAlN	Heavy Interrupted cut for Stainless steel • For Heavy Interrupted cut on Stainless steel • Minimize risk of Mechanical fracture or Chipping
YG401 S10 - S20	 PVD - TiAlSiN	PVD Turning Grade for HRSA • Highly heat-resistant TiAlSiN structure for excellent wear resistance • Greatly improved film coating realizes excellent boundary defect resistance • Top coating layer provides a smooth surface and lubricant effect
YT100 P10 - P20 M10 - M20 K10 - K20	 Cermet	New Generation Cermet Grade • Enhanced wear resistance & chipping resistance • Excellent fracture resistance • Superior surface finish with special edge preparation
NEW YT100G P5 - P20 M5 - M20 K5 - K20	 PVD TiN	PVD-coated Cermet grade for turning • Outstanding wear resistance and a low coefficient of friction enable high-speed turning of steels, stainless steels, and cast irons with extended tool life
YG100 N05 - N25	 DLC	First Choice Grade for Aluminum with DLC Coating • Submicron carbide for high wear resistance • DLC coating minimizes Built Up Edge tendency. • Improve tool life in sticky non-ferrous alloy
YG10 N05 - N25	 Uncoated	Uncoated Grade for General Aluminum • Substrate consisted of submicron carbide for high wear resistance • Shining surface to prevent built up edge

TURNING

PARTING & GROOVING

MILLING

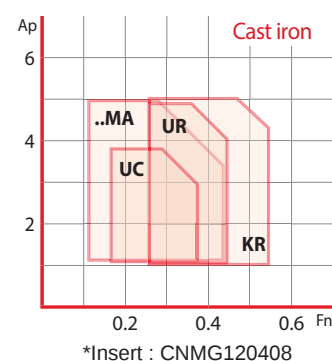
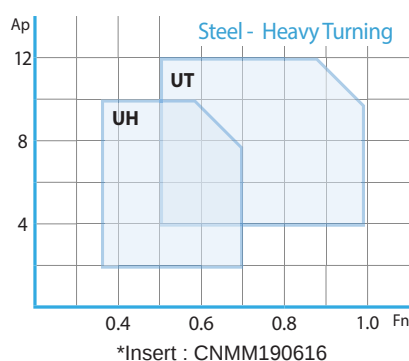
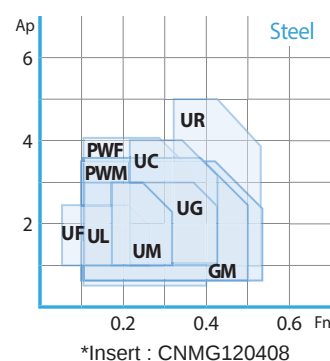
DRILLING

TECHNICAL INFORMATION

Product Overview

Turning Chipbreakers - Negative

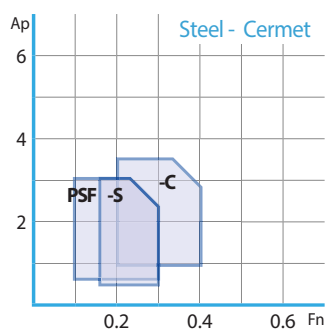
	P	M	K	N	S			Feed	Fn (mm/rev.)						
									0	0.1	0.2	0.3	0.4	0.5	0.6
TURNING	P					UF	Finishing				Fn 0.05~0.25 Ap 1.0~2.5				
	P					NEW PWF	Wiper-Finishing				Fn 0.10~0.40 Ap 0.5~4.0				
	P					UL	Semi Finishing and sticky materials				Fn 0.1~0.3 Ap 1.0~3.0				
PARTING & GROOVING	P					UM	Medium & Unstable conditions				Fn 0.15~0.3 Ap 1.0~3.0				
	P					NEW GM	Medium machining for steel & Stainless steel				Fn 0.17~0.50 Ap 0.8~5.0				
	P					UG	First Choice for Medium (Stable conditions)				Fn 0.2~0.4 Ap 1.0~3.0				
MILLING	P					PWM	Wiper-Medium				Fn 0.1~0.5 Ap 0.8~3.5				
	P					UH	Low cutting force				Fn 0.35~0.7 Ap 2.0~9.0				
	P					UT	Heavy roughing				Fn 0.5~1.0 Ap 4.0~12.0				
DRILLING	P					UC	Medium Roughing and First choice for Cast iron				Fn 0.2~0.4 Ap 1.0~4.0				
	P					UR	Roughing and Heavy interrupted cut				Fn 0.3~0.5 Ap 1.0~5.0				
						..MA	Cast iron Heavy Roughing				Fn 0.15~0.50 Ap 1.0~5.0				
TECHNICAL INFORMATION															



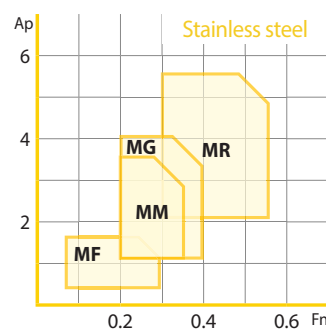
Product Overview

Turning Chipbreakers - Negative

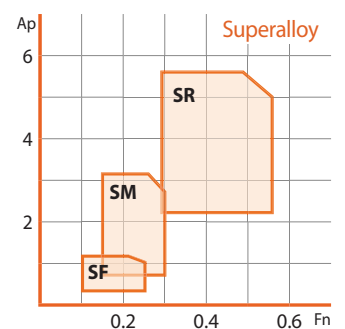
							Feed									
P	M	K	N	S			0	0.1	0.2	0.3	0.4	0.5	0.6	Fn (mm/rev.)		
		K			KR	Cast Iron Heavy Roughing								Fn 0.3~0.6		
	M			S	MF	Stainless steel Finishing				Fn 0.07~0.30						
P	M			S	MM	Stainless steel Medium and Low Carbon Steel				Fn 0.20~0.35						
	M			S	MG	Stainless steel General				Fn 0.20~0.40						
	M			S	MR	Stainless steel Roughing					Fn 0.30~0.55					
				S	SF	HRSA Finishing				Fn 0.1~0.25						
				S	SM	HRSA Medium				Fn 0.15~0.30						
				S	SR	Roughing for HRSA					Fn 0.30~0.55					
P	M	K			PSF	Cermet Finishing to Semi medium				Fn 0.10~0.30						
P	M	K			-S	Cermet Finishing				Fn 0.15~0.30						
P	M	K			-C	Cermet Medium					Fn 0.20~0.40					
								0	1	2	3	4	5	6	Depth of Cut	
															Ap (mm)	



*Insert : CNMG120408 / TNGG160408



*Insert : CNMG120408



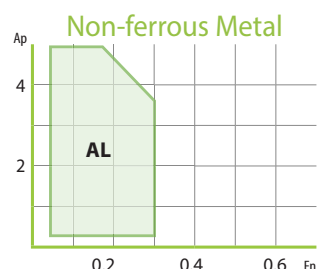
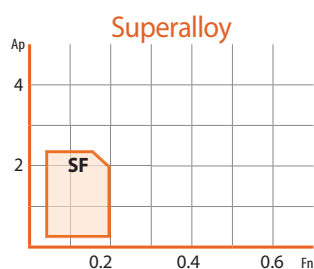
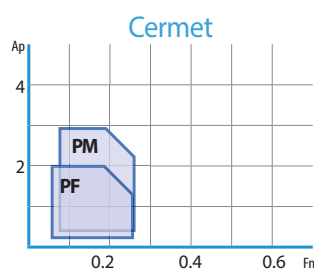
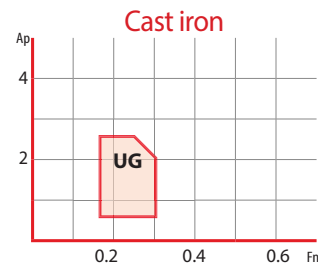
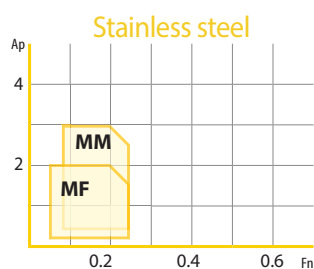
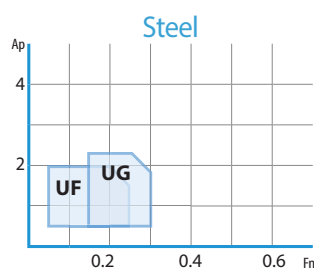
*Insert : CNMG120408

Product Overview

Turning Chipbreakers - Positive

	P M K N S					Feed												Fn (mm/rev.)				
						0 0.1 0.2 0.3 0.4 0.5 0.6																
TURNING				N		AL		Aluminum application		Fn 0.02~0.30		Ap 0.1~5.0										
	P	M				UF		Finishing application		Fn 0.05~0.25		Ap 0.5~2.0										
PARTING & GROOVING	P		K			UG		Medium application		Fn 0.15~0.30		Ap 0.5~2.5										
		M				MF		Stainless steel Finishing		Fn 0.04~0.30		Ap 0.1~2.0										
MILLING		M				MM		Stainless steel Medium		Fn 0.06~0.35		Ap 0.25~3.0										
				S		SF		HRSA Finishing		Fn 0.03~0.20		Ap 0.1~2.5										
DRILLING	P	M	K			PF		Finishing		Fn 0.06~0.25		Ap 0.1~2.0										
	P	M	K			PM		Medium		Fn 0.08~0.25		Ap 0.25~3.0										
									Depth of Cut												Ap (mm)	

TECHNICAL INFORMATION



*Insert : CCMT09T304

Turning Inserts Overview

Negative Inserts

Recommended Cutting Conditions : p.258

Shape	Series	Size & Thickness												Page
C		CNMA				1204				1606	1906			28
		CNMG	0903	0904		1204				1606	1906		2509	
		CNGG				1204								
		CNMM				1204				1606	1906		2509	
D		DNMA					1504	1506						33
		DNMG			1104		1504	1506						
		DNGG					1504	1506						
		DNMM						1506						
		DNUX					1504	1506						38
K		KNUX							1604					39
S		SNMA				1204		1506			1906			40
		SNMG	0903			1204					1906		2509	
		SNMM						1506			1906	2507	2509	
T		TNMA							1604					44
		TNMG							1604		2204			
		TNGG							1604					
		TNMM							1604		2204			
		TNUX							1604					50
V		VNMA							1604					51
		VNMG							1604					
		VNGG							1604					
W		WNMA				0804								53
		WNMG		0604		0804								
		WNGG				0804								

Positive Inserts

Shape	Series	Size & Thickness												Page
C		CCGT	0602			09T3				1204				57
		CCMT	0602			09T3				1204				
D		DCGT		0702						11T3				60
		DCMT		0702						11T3				
R		RCMT	0602		0803		10T3			1204		1606		62
		RCMX										1606	2006	63
S		SCGT				09T3								64
		SCMT				09T3				1204				
T		TCGT						1102				16T3		66
		TCMT						1102				16T3		
V		VBGT / VBMT							1103			1604		68
		VCGT / VCMT							1103			1604		69

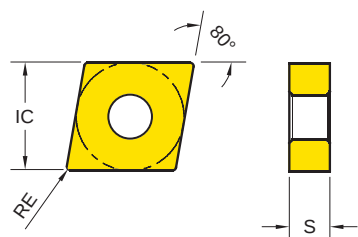
Turning Inserts - Negative

CNMA / CNMG (80° Rhombic)



Refer to

Turning holder



Series	IC	S	Series	IC	S
CN** 0903	9.525	3.18	CN** 1606	15.875	6.35
CN** 0904	9.525	4.76	CN** 1906	19.050	6.35
CN** 1204	12.700	4.76			

EDP 2200..

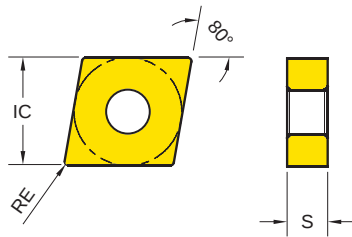
●: Stock item

○: Order made item

K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N25
YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
● 0894	○ 0089	● 3435	○ 0354																
● 1484	○ 0010	○ 3473	○ 0355																
● 0766	○ 0011	● 3426	○ 0356																
● 1207	○ 1188	● 3461	○ 1314																
● 0881	○ 0012	● 3433	○ 0357																
● 0937	○ 0446	○ 3452	○ 0447																
● 1617	○ 0989	● 3506	○ 0990																
● 1015	○ 0448	● 3456	○ 0449																
			○ 0178		● 2370	● 3200	● 0179	○ 0180	○ 0003			○ 2222							
			○ 0189	○ 1027	● 2204	● 3203	● 0190	● 0191											
			○ 1349		● 2598	● 3362	● 1360	● 1350											
● 3848					● 3855	● 3859		● 3866											
● 3849					● 3856	● 3860		● 3867											
			○ 1211		● 2589	● 3358	● 1328	● 1212											
			○ 1274		● 2590	● 3355	● 1270	● 1704											
			○ 1338		● 2591	● 3359	● 1335	● 1705											
			○ 1339		● 2592	● 3360	● 1336	● 1706											
			○ 0358		● 2381	● 3250	● 0359	● 0524											
			○ 0192		● 2315	● 3204	● 0193	● 0194											
			○ 0201		● 2396	● 3207	● 0202	● 0203											
● 1074	○ 0184				● 2174	● 3202	● 0185	● 0186											
● 0897	○ 0338	○ 0843			● 2218	● 3175	● 0100	● 0140											
● 1075	○ 0525				● 2387	● 3280	● 0486	● 0526											
					● 3630	● 3651				● 3690									
					● 3631	● 3652				● 3695									
					● 3632	● 3653				● 3700									

Turning Inserts - Negative CNMG (80° Rhombic)

Refer to
Turning holder
p. 92, 97, 113, 118, 124



Series	IC	S	Series	IC	S
CN** 0903	9.525	3.18	CN** 1606	15.875	6.35
CN** 0904	9.525	4.76	CN** 1906	19.050	6.35
CN** 1204	12.700	4.76	CN** 2509	25.400	9.52

EDP 2200.. ●: Stock item ○: Order made item

CNMG	Designation	RE	F _n (mm/rev.)	A _p (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-UG 	CNMG 120404 - UG	0.4	0.20-0.40	0.5-3.0	●	○	●	○		●	●	●	●											
	CNMG 120408 - UG	0.8	0.20-0.40	1.0-3.0	●	○	●	○	○	●	●	●	●	○										
	CNMG 120412 - UG	1.2	0.20-0.40	1.5-3.0	●	○	●	○		●	●	●	●											
	CNMG 160608 - UG	0.8	0.20-0.40	1.0-5.0	●	○		○		●	●	●	●											
	CNMG 160612 - UG	1.2	0.20-0.40	1.5-5.0	●	○		○		●	●	●	●		○	●								
	CNMG 160616 - UG	1.6	0.30-0.50	2.0-5.0	●	○		○		●	●	●	●											
	CNMG 190608 - UG	0.8	0.20-0.60	1.0-6.0	●			○		●	●	●	●											
-PWM 	CNMG 120404 - PWM	0.4	0.10-0.50	0.5-3.5	●	○				●	●	●	●	○										
	CNMG 120408 - PWM	0.8	0.10-0.50	0.8-3.5	●					●	●	●	●		○	●					●			
	CNMG 120412 - PWM	1.2	0.10-0.50	1.0-3.5	●					●	●	●	●											
-UC 	CNMG 120404 - UC	0.4	0.20-0.40	0.5-4.0	●	○	●	○		●	●	●	●											
	CNMG 120408 - UC	0.8	0.20-0.40	1.0-4.0	●	○	●	○		●	●	●	●											
	CNMG 120412 - UC	1.2	0.20-0.40	1.5-4.0	●	○	●	○		●	●	●	●											
-UR 	CNMG 120408 - UR	0.8	0.30-0.50	1.0-5.0	●	○	●	○		●	●	●	●											
	CNMG 120412 - UR	1.2	0.30-0.50	1.5-5.0	●	○	●	○		●	●	●	●	○					○					
	CNMG 120416 - UR	1.6	0.30-0.50	2.0-5.0	●	○	●	○		●	●	●	●											
	CNMG 160608 - UR	0.8	0.30-0.50	1.0-5.0	●	○		○		●	●	●	●											
	CNMG 160612 - UR	1.2	0.30-0.50	1.5-5.0	●	○	●	○		●	●	●	●											
	CNMG 160616 - UR	1.6	0.30-0.50	2.0-5.0	●	○		○		●	●	●	●											
	CNMG 190608 - UR	0.8	0.30-0.80	3.0-9.0	●		○	○		●	●	●	●											
	CNMG 190612 - UR	1.2	0.30-0.80	3.0-9.0	●	○	●	○		●	●	●	●											
	CNMG 190616 - UR	1.6	0.30-0.80	3.0-9.0	●	○	●	○		●	●	●	●											
	CNMG 250924 - UR	2.4	0.40-1.00	5.0-12.0	●					●	●	●	●											
-KR 	CNMG 120408 - KR	0.8	0.30-0.60	1.0-5.0	●	○	●	○		●														
	CNMG 120412 - KR	1.2	0.30-0.60	1.5-5.0	●	○	●	○		●														
	CNMG 160612 - KR	1.2	0.30-0.60	1.5-6.0	●	○	○	○		●														
	CNMG 160616 - KR	1.6	0.30-0.60	2.0-6.0	●	○	○	○		●														
	CNMG 190612 - KR	1.2	0.30-1.00	3.0-9.0	●					●														

Turning Inserts - Negative CNMG (80° Rhombic)

Refer to
Turning holder
p. 92, 97, 113, 118, 124

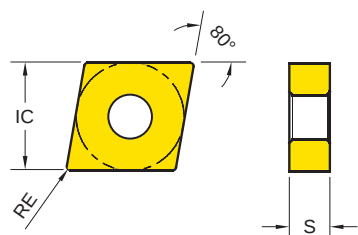
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



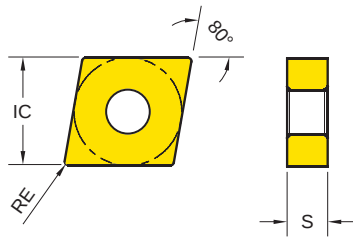
Series	IC	S	Series	IC	S
CN** 0903	9.525	3.18	CN** 1606	15.875	6.35
CN** 0904	9.525	4.76	CN** 1906	19.050	6.35
CN** 1204	12.700	4.76			

EDP 2200.. ● : Stock item ○ : Order made item

CNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	P05 K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
-MF Stainless steel Finishing	CNMG 120404 - MF	0.4	0.07 - 0.3	0.2 - 1.5																			
	CNMG 120408 - MF	0.8	0.07 - 0.3	0.2 - 1.5																			
	CNMG 120412 - MF	1.2	0.07 - 0.3	0.2 - 1.5																			
-MM Stainless steel Medium	CNMG 120404 - MM	0.4	0.20 - 0.35	0.5 - 3.5																			
	CNMG 120408 - MM	0.8	0.20 - 0.35	1.0 - 3.5																			
	CNMG 120412 - MM	1.2	0.20 - 0.35	1.5 - 3.5																			
	CNMG 190608 - MM	0.8	0.20 - 0.50	2.0 - 5.5																			
	CNMG 190612 - MM	1.2	0.20 - 0.55	2.0 - 5.5																			
-MG Stainless steel General	CNMG120404 - MG	0.4	0.20 - 0.40	0.5 - 4.0																			
	CNMG 120408 - MG	0.8	0.20 - 0.40	1.0 - 4.0																			
	CNMG 120412 - MG	1.2	0.20 - 0.40	1.5 - 4.0																			
	CNMG 160608 - MG	0.8	0.20 - 0.45	1.0 - 4.0																			
	CNMG 160612 - MG	1.2	0.20 - 0.50	2.0 - 4.0																			
	CNMG 160616 - MG	1.6	0.20 - 0.50	2.0 - 4.0																			
	CNMG 190616 - MG	1.6	0.20 - 0.50	2.0 - 5.0																			
-MR Stainless steel Roughing	CNMG 120408 - MR	0.8	0.30 - 0.55	2.0 - 5.5																			
	CNMG 120412 - MR	1.2	0.30 - 0.55	2.0 - 5.5																			
	CNMG 120416 - MR	1.6	0.30 - 0.55	2.0 - 5.5																			
	CNMG 160616 - MR	1.6	0.30 - 0.55	2.0 - 6.0																			

Turning Inserts - Negative

CNGG / CNMG (80° Rhombic)

Refer to
Turning holder
p. 92, 97, 113, 118, 124


Series	IC	S	Series	IC	S
CN** 0903	9.525	3.18	CN** 1606	15.875	6.35
CN** 0904	9.525	4.76	CN** 1906	19.050	6.35
CN** 1204	12.700	4.76			

EDP 2200..

● : Stock item ○ : Order made item

CNGG CNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10		
- SF	 HRSA Finishing	CNGG 120401 - SF	0.1	0.10~0.25	0.1~1.0																●	1882					
		CNGG 120402 - SF	0.2	0.10~0.25	0.1~1.0																	●	2097				
		CNGG 120404 - SF	0.4	0.10~0.25	0.2~1.0																	●	1291				
		CNGG 120408 - SF	0.8	0.10~0.25	0.2~1.0																	●	0943				
- SM	 HRSA Medium	CNMG 120404 - SM	0.4	0.15~0.30	0.5~3.0																●	3565					
		CNMG 120408 - SM	0.8	0.15~0.30	0.5~3.0														○	1088	○	1089	○	1395	●	1189	
		CNMG 120412 - SM	1.2	0.15~0.30	0.5~3.0															○	1373	○	1394	○	2305	●	1292
- SR	 HRSA Roughing	CNMG 120408 - SR	0.8	0.30~0.55	2.0~5.5																●	0945					
		CNMG 120412 - SR	1.2	0.30~0.55	2.0~5.5																	●	1279				
		CNMG 120416 - SR	1.6	0.30~0.55	2.0~5.5																	●	1912				
- PSF	 Cermet Finishing	CNMG 120404 - PSF	0.4	0.07~0.30	0.4~3.0																●	2531	○	3576			
		CNMG 120408 - PSF	0.8	0.10~0.30	0.6~3.0																	●	2532	○	3577		

TURNING

PARTING & GROOVING

MILLING

DRILLING

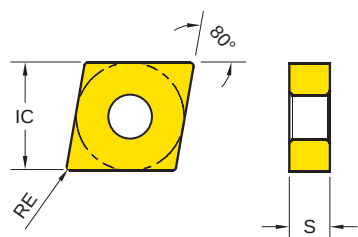
TECHNICAL INFORMATION

Turning Inserts - Negative

CNMM - Heavy Turning (80° Rhombic)

Refer to
Turning holder
p. 92, 97, 113, 118, 124

TURNING



Series	IC	S	Series	IC	S
CN** 1204	12.700	4.76	CN** 1906	19.050	6.35
CN** 1606	15.875	6.35	CN** 2507	25.400	7.94
			CN** 2509	25.400	9.52

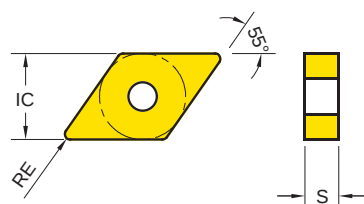
EDP 2200.. ● : Stock item ○ : Order made item

CNMM																								
Designation	RE	Fn (mm/rev.)	Ap (mm)		YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
- UH  Low cutting force	CNMM 120408 - UH	0.8	0.30-0.50	1.5-5.0						●	●	●	●		●									
	CNMM 120412 - UH	1.2	0.30-0.55	1.6-5.0						●					●									
	CNMM 120416 - UH	1.6	0.30-0.60	2.0-5.0						●					●									
	CNMM 160612 - UH	1.2	0.35-0.60	2.0-5.5						●	●	●	●		●									
	CNMM 160616 - UH	1.6	0.35-0.60	2.5-5.5						●	●	●	●		●									
	CNMM 190612 - UH	1.2	0.35-0.70	1.5-9.0	●			●			●	●	●	●		●								
	CNMM 190616 - UH	1.6	0.35-0.70	2.0-9.0	●			●			●	●	●	●		●								
	CNMM 190624 - UH	2.4	0.35-0.70	3.0-9.0	●			●			●	●	●	●		●								
	CNMM 250724 - UH	2.4	0.40-0.80	3.0-10.0						●						●								
	CNMM 250924 - UH	2.4	0.40-0.80	3.0-10.0	●			●			●	●	●	●		●								
- UT  Heavy Roughing	CNMM 120408 - UT	0.8	0.40-0.70	1.5-6.0						●	●	●	●											
	CNMM 160612 - UT	1.2	0.45-0.70	2.0-6.0						●	●	●	●											
	CNMM 160616 - UT	1.6	0.45-0.70	2.5-6.0						●	●	●	●											
	CNMM 190612 - UT	1.2	0.50-1.00	3.0-12.0	●		○	●			●	●	●	●										
	CNMM 190616 - UT	1.6	0.50-1.00	4.0-12.0	●		○	●			●	●	●	●										
	CNMM 190624 - UT	2.4	0.50-1.00	6.0-12.0	●		○	●			●	●	●	●										
	CNMM 250724 - UT	2.4	0.40-0.80	3.0-10.0						●														
	CNMM 250924 - UT	2.4	0.55-1.20	6.0-13.0	●		○	●			●	●	●	●										

Turning Inserts - Negative

DNMA / DNMG (55° Rhombic)

Refer to
Turning holder
p. 93, 98, 114, 119, 124



Series	IC	S
DN** 1104	9.525	4.76
DN** 1504	12.700	4.76
DN** 1506	12.700	6.35

EDP 2200.. ● : Stock item ○ : Order made item

					K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N25
DNMA DNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
..MA  Cast iron	DNMA 150404	0.4	0.10-0.50	0.5-5.0	●	○	○	○																
	DNMA 150408	0.8	0.15-0.50	1.0-5.0	●	○	○	○																
	DNMA 150412	1.2	0.15-0.50	1.5-5.0	●	○	●	○																
	DNMA 150604	0.4	0.10-0.50	1.0-5.0	●	○	○	○																
	DNMA 150608	0.8	0.15-0.50	1.0-5.0	●	○	●	○																
	DNMA 150612	1.2	0.15-0.50	1.5-5.0	●	○	●	○																
-UF  Finishing	DNMG 150404 - UF	0.4	0.05-0.25	0.5-2.5				○		●	●	●	●	○				○						
	DNMG 150408 - UF	0.8	0.05-0.25	1.0-2.5				○	○		●	●	●											
	DNMG 150412 - UF	1.2	0.05-0.25	1.5-2.5				○			●	●	●											
	DNMG 150604 - UF	0.4	0.05-0.25	1.0-2.0				○			●	●	●		○				○					
	DNMG 150608 - UF	0.8	0.05-0.25	1.5-3.5				○			●	●	●											
	DNMG 150612 - UF	1.2	0.05-0.25	1.5-2.5				○			●	●	●											
NEW -PWF  Wiper-Finishing	DNMG110404 - PWF	0.4	0.08-0.30	0.3-2.5	●					●	●		●											
	DNMG110408 - PWF	0.8	0.10-0.40	0.5-2.5	●					●	●		●											
	DNMG150408 - PWF	0.8	0.10-0.40	0.5-3.5	●					●	●		●											
	DNMG 150608 - PWF	0.8	0.10-0.40	0.5-3.5	●					●	●		●											
-UL  Light Machining and Sticky Material	DNMG 110404 - UL	0.4	0.10-0.3	0.5-2.5				○		●	●	●	●											
	DNMG 110408 - UL	0.8	0.10-0.3	1.0-2.5				○		●	●	●	●											
	DNMG 150404 - UL	0.4	0.10-0.3	0.5-3.0				○		●	●	●	●											
	DNMG 150408 - UL	0.8	0.10-0.3	1.0-3.0				○	○	●	●	●	●											
	DNMG 150412 - UL	1.2	0.10-0.3	1.5-3.0				○	○	●	●	●	●											
	DNMG 150604 - UL	0.4	0.10-0.3	0.5-3.0				○		●	●	●	●											
	DNMG 150608 - UL	0.8	0.10-0.3	1.0-3.0				○		●	●	●	●											
	DNMG 150612 - UL	1.2	0.10-0.3	1.5-3.0				○		●	●	●	●											

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Negative
DNMG (55° Rhombic)Refer to
Turning holder
p. 93, 98, 114, 119, 124

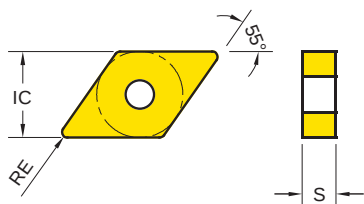
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series	IC	S
DN** 1104	9.525	4.76
DN** 1504	12.700	4.76
DN** 1506	12.700	6.35

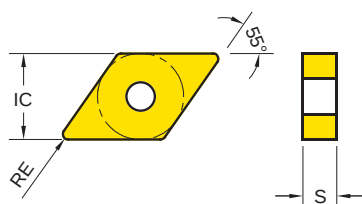
EDP 2200.. ● : Stock item ○ : Order made item

						K10	P05	K20	P10	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40	S10	P15	P10	N20	N20	
						K20	K30	K30	K30											S30	K15	K10				
DNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)		YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
-UM  Medium Machining Unstable condition	DNMG 150404 - UM	0.4	0.15 - 0.30	0.5 - 3.0	○ 1672	○ 1472		○ 1702		● 2608	● 3383	● 1703	● 1707													
	DNMG 150408 - UM	0.8	0.15 - 0.30	1.0 - 3.0		○ 1106		○ 0688		● 2360	● 3303	● 0689	● 0701													
	DNMG 150412 - UM	1.2	0.15 - 0.30	1.5 - 3.0		○ 0604		○ 0512		● 2203	● 3282	● 0488	● 0705													
	DNMG 150604 - UM	0.4	0.15 - 0.30	0.5 - 3.0		○ 1408		○ 1436		● 2609	● 3368	● 1409	● 1425													
	DNMG 150608 - UM	0.8	0.15 - 0.30	1.0 - 3.0		○ 1128		○ 0240		● 2201	● 3220	● 0241	● 0242													
	DNMG 150612 - UM	1.2	0.15 - 0.30	1.5 - 3.0		○ 1149		○ 1132		● 2612	● 3305	● 0695	● 0706													
NEW -GM  Medium machining for steel & Stainless steel	DNMG 150404 - GM	0.4	0.15 - 0.40	0.5 - 4.0						● 3633	● 3654							● 3717								
	DNMG 150408 - GM	0.8	0.17 - 0.50	0.8 - 4.0						● 3634	● 3655							● 3721								
	DNMG 150412 - GM	1.2	0.20 - 0.55	1.0 - 4.0						● 3636	● 3657							● 3724								
	DNMG 150608 - GM	0.8	0.17 - 0.50	0.8 - 4.0						● 3635	● 3656							● 3730								
	DNMG 150612 - GM	1.2	0.20 - 0.55	1.0 - 4.0						● 3637	● 3658							● 3733								
	-UG  Medium Machining at stable condition	DNMG 110408 - UG	0.8	0.20 - 0.40	1.0 - 2.5						● 2780															
DNMG 110412 - UG		1.2	0.20 - 0.40	1.5 - 2.5						● 2781																
DNMG 150404 - UG		0.4	0.20 - 0.40	0.5 - 3.0	● 1618	○ 1544	● 3507	○ 1131		● 2443	● 3316	● 0772	● 1137													
DNMG 150408 - UG		0.8	0.20 - 0.40	1.0 - 3.0	● 1608	○ 0452	● 3499	○ 0366		● 2368	● 3253	● 0367	● 0368	○ 0017				○ 2227								
DNMG 150412 - UG		1.2	0.20 - 0.40	1.5 - 3.0	● 1514	○ 0703	● 3484	○ 1107		● 2442	● 3281	● 0487	● 0704													
DNMG 150604 - UG		0.4	0.20 - 0.40	0.5 - 3.0	● 1619	○ 1545	● 3508	○ 0228		● 2375	● 3216	● 0229	● 0230													
DNMG 150608 - UG		0.8	0.20 - 0.40	1.0 - 3.0	● 1609	○ 0453	● 3500	○ 0234		● 2212	● 3218	● 0235	● 0236	○ 0019				○ 2229								
DNMG 150612 - UG		1.2	0.20 - 0.40	1.5 - 3.0	● 1511	○ 0454	● 3481	○ 0243		● 2356	● 3221	● 0244	● 0245													
DNMG 150616 - UG		1.6	0.20 - 0.40	1.8 - 3.0						● 2720																
-UC  Cast iron and Medium roughing		DNMG 150404 - UC	0.4	0.20 - 0.40	0.5 - 4.0	● 3827		● 3625			● 3829	● 3830		● 3828												
	DNMG 150408 - UC	0.8	0.20 - 0.40	1.0 - 4.0	● 1611	○ 0577	● 3502	○ 0578	○ 1273	● 2388	● 3348	● 1193	● 0700													
	DNMG 150412 - UC	1.2	0.20 - 0.40	1.5 - 4.0	● 1512	○ 0579	● 3482	○ 0580		● 2373	● 3345	● 1168	● 0702													
	DNMG 150604 - UC	0.4	0.20 - 0.40	0.5 - 4.0	● 3570		● 3831			● 3571	● 3572		● 3832													
	DNMG 150608 - UC	0.8	0.20 - 0.40	1.0 - 4.0	● 0898	○ 0090	● 3438	○ 0121	○ 1272	● 2376	● 3179	● 0104	● 0122													
	DNMG 150612 - UC	1.2	0.20 - 0.40	1.5 - 4.0	● 1509	○ 0098	● 3479	○ 0123		● 2410	● 3180	● 0105	● 0124													
-UR  Roughing	DNMG 150408 - UR	0.8	0.30 - 0.50	1.0 - 5.0	● 1621	○ 1095	● 3510	○ 0585		● 2446	● 3341	● 1096	● 1097													
	DNMG 150412 - UR	1.2	0.30 - 0.50	1.5 - 5.0	● 1513	○ 1127	● 3483	○ 0581		● 2400	● 3343	● 1134	● 1101													
	DNMG 150608 - UR	0.8	0.30 - 0.50	1.0 - 5.0	● 1622	○ 0691	● 3511	○ 0692		● 2447	● 3304	● 0693	● 0854													
	DNMG 150612 - UR	1.2	0.30 - 0.50	1.5 - 5.0	● 1510	○ 1258	● 3480	○ 0371		● 2416	● 3255	● 0372	● 0373	○ 0020				○ 2230								
	DNMG 150616 - UR	1.6	0.30 ~ 0.50	1.8 ~ 5.0	● 3833		● 3834			● 3626	● 3836		● 3835													

Turning Inserts - Negative

DNMG (55° Rhombic)

Refer to
Turning holder
p. 93, 98, 114, 119, 124



Series	IC	S
DN** 1104	9.525	4.76
DN** 1504	12.700	4.76
DN** 1506	12.700	6.35

EDP 2200.. ● : Stock item ○ : Order made item

DNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)																				
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-MF  Stainless steel Finishing	DNMG 150404 - MF	0.4	0.07 - 0.30	0.2 - 1.5						●						●	●	●	●	○		○		
	DNMG 150408 - MF	0.8	0.07 - 0.30	0.2 - 1.5						●				○		●	●	●	●	○				
	DNMG 150604 - MF	0.4	0.07 - 0.30	0.2 - 1.5						○						●	●	●	●	○		○		
	DNMG 150608 - MF	0.8	0.07 - 0.30	0.2 - 1.5						○	○	○	○			●	●	●	●	○				
-MM  Stainless steel Medium	DNMG 150404 - MM	0.4	0.20 - 0.35	0.5 - 3.5									○				●	●	●	○				
	DNMG 150408 - MM	0.8	0.20 - 0.35	1.0 - 3.5									○				●	●	●	○				
	DNMG 150412 - MM	1.2	0.20 - 0.35	1.5 - 3.5									○				●	●	●	○				
	DNMG 150604 - MM	0.4	0.20 - 0.35	0.5 - 3.5									○				●	●	●	○				
	DNMG 150608 - MM	0.8	0.20 - 0.35	1.0 - 3.5									○				●	●	●	○				
	DNMG 150612 - MM	1.2	0.20 - 0.35	1.5 - 3.5									○				●	●	●	○				
-MG  Stainless steel General	DNMG 110404 - MG	0.4	0.20 - 0.40	0.5 - 3.0											●	●								
	DNMG 110408 - MG	0.8	0.20 - 0.40	0.8 - 3.0											●	●								
	DNMG 150404 - MG	0.4	0.20 - 0.40	0.5 - 4.0											●	●								
	DNMG 150408 - MG	0.8	0.20 - 0.40	1.0 - 4.0						○					●	●	●	●	●	○				
	DNMG 150412 - MG	1.2	0.20 - 0.40	1.5 - 4.0											●	●								
	DNMG 150604 - MG	0.4	0.20 - 0.40	0.5 - 4.0											●	●								
	DNMG 150608 - MG	0.8	0.20 - 0.40	1.0 - 4.0						●					●	●	●	●	●	○				
	DNMG 150612 - MG	1.2	0.20 - 0.40	1.5 - 4.0											●	●								
-MR  Stainless steel Roughing	DNMG 150408 - MR	0.8	0.30 - 0.55	2.0 - 5.5									○		●	●	●	●	●					
	DNMG 150412 - MR	1.2	0.30 - 0.55	2.0 - 5.5											●	●	●	●	●					
	DNMG 150608 - MR	0.8	0.30 - 0.55	2.0 - 5.5									○		●	●	●	●	●					
	DNMG 150612 - MR	1.2	0.30 - 0.55	2.0 - 5.5											●	●	●	●	●					

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Negative
DNGG / DNMG (55° Rhombic)

Refer to
Turning holder
p. 93, 98, 114, 119, 124

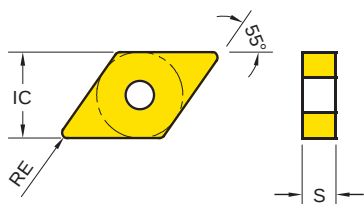
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series	IC	S
DN** 1104	9.525	4.76
DN** 1504	12.700	4.76
DN** 1506	12.700	6.35

EDP 2200.. ● : Stock item ○ : Order made item

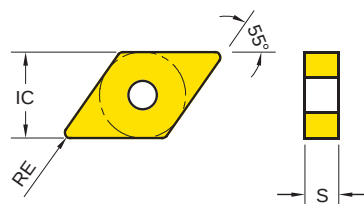
DNGG DNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-SF HRSA Finishing	DNGG 150404 - SF	0.4	0.10 - 0.25	0.2 - 1.0																●				
	DNGG 150408 - SF	0.8	0.10 - 0.25	0.2 - 1.0																●				
	DNGG 150604 - SF	0.4	0.10 - 0.25	0.2 - 1.0																●				
	DNGG 150608 - SF	0.8	0.10 - 0.25	0.2 - 1.0																●				
-SM HRSA Medium	DNMG 150408 - SM	0.8	0.15 - 0.30	0.5 - 3.0						○								○	○	○	●			
	DNMG 150412 - SM	1.2	0.15 - 0.30	0.5 - 3.0						3148								○	○	○	●			
	DNMG 150608 - SM	0.8	0.15 - 0.30	0.5 - 3.0						●								○	○	○	●			
	DNMG 150612 - SM	1.2	0.15 - 0.30	0.5 - 3.0						2716								○	○	○	●			
-SR HRSA Roughing	DNMG 150408 - SR	0.8	0.30 - 0.55	2.0 - 5.5																●				
	DNMG 150412 - SR	1.2	0.30 - 0.55	2.0 - 5.5																●				
	DNMG 150608 - SR	0.8	0.30 - 0.55	2.0 - 5.5																●				
	DNMG 150612 - SR	1.2	0.30 - 0.55	2.0 - 5.5																●				
-PSF Cermet Finishing	DNMG 150404 - PSF	0.4	0.07 - 0.30	0.4 - 3.0																●	○			
	DNMG 150408 - PSF	0.8	0.10 - 0.30	0.6 - 3.0																●	○			
	DNMG 150604 - PSF	0.4	0.07 - 0.30	0.4 - 3.0																●	○			
	DNMG 150608 - PSF	0.8	0.10 - 0.35	0.6 - 3.0																●	○			

Turning Inserts - Negative

DNMM - Heavy Turning (55° Rhombic)



Refer to
Turning holder
p. 93, 98, 114, 119, 124



Series	IC	S
DN** 1104	9.525	4.76
DN** 1504	12.700	4.76
DN** 1506	12.700	6.35

EDP 2200..

●: Stock item ○: Order made item

					CUTTING DATA																				
DNMM	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N2	
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
-UH  Low cutting force	DNMM 150612 - UH	1.2	0.30-0.50	2.0-7.0						●	●	●	●		●										
										2731	3414	2327	2328		2769										
-UT  Heavy Roughing	DNMM 150612 - UT	1.2	0.40-0.70	2.0-8.0						●	●	●	●												
										2732	3415	2329	2330												

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Negative

DNUX (4 Corners 55° Rhombic)

Refer to
Turning holder
p. 93, 98, 114, 119, 124

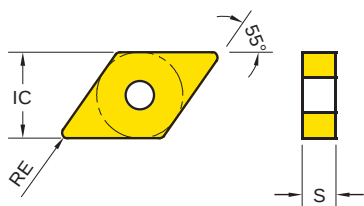
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series	IC	S
DNUX 1504	12.7	4.76
DNUX 1506	12.7	6.35

EDP 2200.. ● : Stock item ○ : Order made item

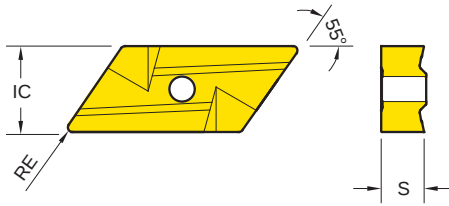
DNUX	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
..UX  Left Hand Shown	DNUX 150404 L	0.4	0.10 - 0.35	0.7 - 4.0				○ 1874		● 2613	● 3388	● 1872	● 1875											
	DNUX 150408 L	0.8	0.10 - 0.35	1.0 - 4.0				○ 1876		● 2615	● 3389	● 1877	● 1878											
	DNUX 150604 L	0.4	0.10 - 0.35	0.7 - 4.0				○ 1873		● 2617	● 3386	● 1869	● 1870					● 2735						
	DNUX 150608 L	0.8	0.10 - 0.35	1.0 - 4.0				○ 1879		● 2619	● 3387	● 1871	● 1880					● 2736						
..UX  Right Hand Shown	DNUX 150404 R	0.4	0.10 - 0.35	0.7 - 4.0				○ 1628		● 2614	● 3377	● 1555	● 1629								● 2734	○ 3612		
	DNUX 150408 R	0.8	0.10 - 0.35	1.0 - 4.0				○ 1630		● 2616	● 3381	● 1631	● 1632											
	DNUX 150604 R	0.4	0.10 - 0.35	0.7 - 4.0				○ 1625		● 2618	● 3357	● 1322	● 1323					● 1327	● 1321	● 2052				
	DNUX 150608 R	0.8	0.10 - 0.35	1.0 - 4.0				○ 1633		● 2620	● 3376	● 1546	● 1634					● 1948	● 1547	● 1574				

Turning Inserts - Negative

KNUX (2 Corners 55° Parallelogram)



Refer to
Turning holder
p. 99, 127



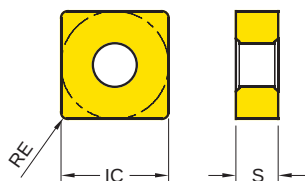
Series	IC	S
KN** 1604	9.525	4.76

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Turning Inserts - Negative
SNMA / SNMG (90° Square)

Refer to
Turning holder
p. 94, 100, 115, 120

TURNING



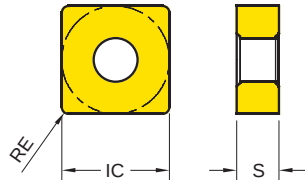
Series	IC	S	Series	IC	S
SN** 0903	9.525	3.18	SN** 1506	15.875	6.35
SN** 1204	12.700	4.76	SN** 1906	19.050	6.35

EDP 2200.. ● : Stock item ○ : Order made item

SNMA SNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
..MA  Cast iron	SNMA 120408	0.8	0.15 - 0.50	1.0 - 5.0	● 0767	○ 0027	● 3427	○ 1166																	
	SNMA 120412	1.2	0.15 - 0.50	1.5 - 5.0	● 0768	○ 0028	● 3428	○ 1133																	
	SNMA 120416	1.6	0.15 - 0.50	1.8 - 5.0	● 2023																				
	SNMA 150612	1.2	0.15 - 0.50	1.5 - 5.0	● 1423	○ 0729	● 3469	○ 1150																	
	SNMA 190616	1.6	0.15 - 0.50	2.0 - 9.0	● 1344	○ 1184	● 3465	○ 1261																	
-UF  Finishing	SNMG 090308 - UF	0.8	0.05 - 0.20	1.0 - 2.0							● 2630	● 3337	● 0999												
	SNMG 120404 - UF	0.4	0.05 - 0.25	0.5 - 1.5				○ 1458			● 2631	● 3373	● 1459	● 1454	○ 0029				○ 2237						
	SNMG 120408 - UF	0.8	0.05 - 0.25	1.0 - 2.5				○ 1430			● 2633	● 3370	● 1433	● 1437											
-UL  Light Machining and Sticky Material	SNMG 120404 - UL	0.4	0.10 - 0.30	0.5 - 3.0				○ 1167			● 2632	● 3313	● 0747	● 1194											
	SNMG 120408 - UL	0.8	0.10 - 0.30	1.0 - 3.0				○ 0389			● 2634	● 3261	● 0390	● 0391											
-UM  Medium Machining Unstable condition	SNMG 120408 - UM	0.8	0.15 - 0.30	1.0 - 3.0		○ 0983		○ 0739			● 2635	● 3318	● 0784	● 0740											

Turning Inserts - Negative SNMG (90° Square)

Refer to
Turning holder
p. 94, 100, 115, 120



Series	IC	S	Series	IC	S
SN** 0903	9.525	3.18	SN** 1906	19.050	6.35
SN** 1204	12.700	4.76	SN** 2509	25.400	9.52
SN** 1506	15.875	6.35			

EDP 2200.. ● : Stock item ○ : Order made item

SNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-UG		SNMG 120408 - UG	0.8	0.20-0.40	1.0-3.0	●	○	●	○		●	●	●	●	○			○			○				
		SNMG 120412 - UG	1.2	0.20-0.40	1.5-3.0	●	○	●	○		●	●	●	●								○			
		SNMG 120416 - UG	1.6	0.20-0.40	2.0-3.0	●	○		○	○	●	●	●	●											
Medium Machining at stable condition						1610	1190	3501	0141		2361	3188	0142	0143	0030			0223			3150				
						1640	1164	3517	0258		2411	3226	0259	0260											
						1646	1165		0744	0789	2638	3346	1169	1195											
-UC		SNMG 120404 - UC	0.4	0.20-0.40	0.5-4.0	●					●														
		SNMG 120408 - UC	0.8	0.20-0.40	1.0-4.0	●	○	●	○		●	●	●	●											
		SNMG 120412 - UC	1.2	0.20-0.40	1.5-4.0	●	○	●	○		●	●	●	●											
Cast iron and Medium roughing						3567					3568														
						1488	0073	3476	0125		2405	3181	0106	0126											
						0900	0074	3439	0127		2429	3182	0107	0128											
-UR		SNMG 120408 - UR	0.8	0.30-0.50	1.0-5.0	●	○	●	○		●	●	●	●											
		SNMG 120412 - UR	1.2	0.30-0.50	1.5-5.0	●	○	●	○		●	●	●	●	○			○							
		SNMG 120416 - UR	1.6	0.30-0.50	2.0-5.0	●	○		○	○	●	●	●	●	○										
		SNMG 150616 - UR	1.6	0.30-0.60	2.0-7.0						●						●	●							
		SNMG 190612 - UR	1.2	0.30-0.80	3.0-9.0							●	○	●	●										
		SNMG 190616 - UR	1.6	0.30-0.80	3.0-9.0	●	○	●			●	●	●	●			○	●							
		SNMG 250924 - UR	2.4	0.40-1.00	5.0-12.0							●	●	●											
-KR		SNMG 120412 - KR	1.2	0.30-0.60	1.5-5.0	●	○	●	○		●														
		SNMG 120416 - KR	1.6	0.30-0.60	2.0-5.0	●	○	●	○	○	●														
Cast Iron Heavy Roughing						1064	1063	3457	1065		2636														
						1208	0730	3462	0950	0965	2637														

TURNING

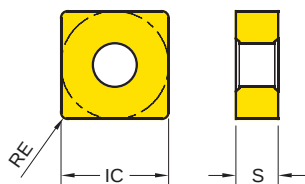
PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Negative SNMG (90° Square)

Refer to
Turning holder
p. 94, 100, 115, 120


Series	IC	S	Series	IC	S
SN** 0903	9.525	3.18	SN** 1506	15.875	6.35
SN** 1204	12.700	4.76	SN** 1906	19.050	6.35

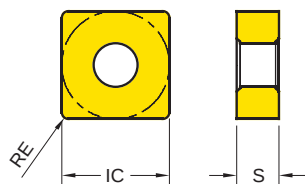
EDP 2200.. ● : Stock item ○ : Order made item

	SNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 K15	P10 K10	N20	N20
						YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
TURNING	 Stainless steel Finishing	SNMG 120404 - MF	0.4	0.07 - 0.30	0.2 - 1.5													●	●	●	○				
		SNMG 120408 - MF	0.8	0.07 - 0.30	0.2 - 1.5					●	2872			○	0818	●	●	●	●	●	○				
		SNMG 120412 - MF	1.2	0.07 - 0.30	0.2 - 1.5					●	2873			○	0821	●	●	●	●	●	○				
PARTING & GROOVING	 Stainless steel Medium	SNMG 120408 - MM	0.8	0.20 - 0.35	1.0 - 3.5													●	●	●	○				
		SNMG 120412 - MM	1.2	0.20 - 0.35	1.5 - 3.5													●	●	●	○				
																		●	●	●	○				
MILLING	 Stainless steel General	SNMG 120404 - MG	0.4	0.20 - 0.40	0.5 - 4.0											●	●								
		SNMG 120408 - MG	0.8	0.20 - 0.40	1.0 - 4.0											●	●	●	●	●	●				
		SNMG 120412 - MG	1.2	0.20 - 0.40	1.5 - 4.0											●	●								
DRILLING	 Stainless steel Roughing	SNMG 120408 - MR	0.8	0.30 - 0.55	2.0 - 5.5									○	1059	●	●	●	●	●					
		SNMG 120412 - MR	1.2	0.30 - 0.55	2.0 - 5.5									○	0823	●	●	●	●	●					
		SNMG 120416 - MR	1.6	0.30 - 0.55	2.0 - 5.5											●	●								
TECHNICAL INFORMATION	 HRSA Medium	SNMG 090304 - SM	0.4	0.15 - 0.30	0.5 - 3.0													○			●				
		SNMG 120408 - SM	0.8	0.15 - 0.30	0.5 - 3.0													○	○	○	●				
	 HRSA Roughing	SNMG 120408 - SR	0.8	0.30 - 0.55	2.0 - 5.5																●				
		SNMG 120412 - SR	1.2	0.30 - 0.55	2.0 - 5.5																●				

Turning Inserts - Negative

SNMM - Heavy Turning (90° Square)

Refer to
Turning holder
p. 94, 100, 115, 120



Series	IC	S	Series	IC	S
SN** 1506	15.875	6.35	SN** 2507	25.400	7.94
SN** 1906	19.050	6.35	SN** 2509	25.400	9.52

EDP 2200.. ● : Stock item ○ : Order made item

					IC S																				
					K10	P05	K20	P10	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40	S10	P15	P10	N20	N25	
					K20		K30											S30		K15					
SNMM	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
Low cutting force	SNMM 150612 - UH	1.2	0.35-0.60	2.0-5.5						●	●	●	●		●										
	SNMM 190612 - UH	1.2	0.35-0.70	1.5-9.0	● 2123			● 2124		●	●	●	●		●										
	SNMM 190616 - UH	1.6	0.35-0.70	2.0-9.0	● 2127			● 2128		●	●	●	●		●										
	SNMM 190624 - UH	2.4	0.35-0.70	3.0-9.0	● 2131			● 2132		●	●	●	●		●										
	SNMM 250724 - UH	2.4	0.40-0.80	3.0-10.0						●	●				●										
	SNMM 250924 - UH	2.4	0.40-0.80	3.0-10.0	● 2135			● 2136		●	●	●	●	●	●	●									
Heavy Roughing	SNMM 150612 - UT	1.2	0.45-0.70	2.0-6.0						●	●	●	●												
	SNMM 190612 - UT	1.2	0.50-1.00	3.0-12.0	● 2153		○ 3556	● 2154		●	●	●	●												
	SNMM 190616 - UT	1.6	0.50-1.00	4.0-12.0	● 2157		○ 3557	● 2158		●	●	●	●												
	SNMM 190624 - UT	2.4	0.50-1.00	6.0-12.0	● 2161		○ 3558	● 2018		●	●	●	●												
	SNMM 250724 - UT	2.4	0.55-1.20	6.0-13.0	● 2850	● 1330		● 1255		●	●	●	●	●											
	SNMM 250924 - UT	2.4	0.55-1.20	6.0-13.0	● 2164	● 1334	○ 3559	● 1626		●	●	●	●	●											

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

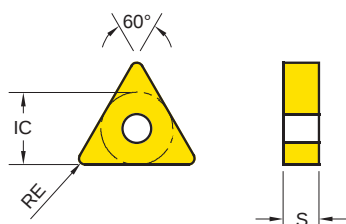
Turning Inserts - Negative

TNMA / TNMG (60° Triangle)



Refer to
Turning holder

Series	IC	S
TN** 1604	9.525	4.76
TN** 2204	12.700	4.76



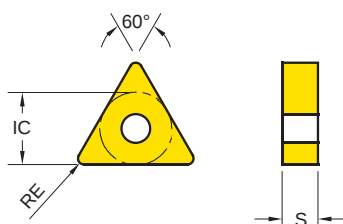
EDP 2200..

●: Stock item ○: Order made item

					In Stock Item										Order Made Item									
					K10	P05	K20	P10	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40	S10	P15	P10	N20	N25
					K20	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30	K30
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
					●	○	●	○																
					1582	1446	3496	1448																
					●	○	●	○																
					1486	0035	3475	1191																
					●	○	●	○																
					1485	0036	3474	1192																
..MA  Cast iron	TNMA 160404	0.4	0.15 - 0.50	0.5 - 5.0																				
	TNMA 160408	0.8	0.15 - 0.50	1.0 - 5.0																				
	TNMA 160412	1.2	0.15 - 0.50	1.5 - 5.0																				
-UF  Finishing	TNMG 160404 - UF	0.4	0.05 - 0.25	0.5 - 2.5				○		●	●	●	●	○										
	TNMG 160408 - UF	0.8	0.05 - 0.25	1.0 - 2.5				○		●	●	●	●											
	TNMG 160412 - UF	1.2	0.05 - 0.25	1.5 - 2.5				○		●	●	●	●											
	TNMG 220404 - UF	0.4	0.10 - 0.35	0.5 - 4.0				○		●	●	●	●	○										
								0407		2409	3350	1203	1205	0042										
NEW -PWF  Wiper-Finishing	TNMG160404 - PWF	0.4	0.08 - 0.25	0.3 - 2.5	●					●	●	●									○			
						3854				3858	3865		3872									3873		
-UL  Light Machining and Sticky Material	TNMG 160404 - UL	0.4	0.10 - 0.30	0.5 - 3.0				○		●	●	●	●											
	TNMG 160408 - UL	0.8	0.10 - 0.30	1.0 - 3.0				○	○	●	●	●	●											
	TNMG 160412 - UL	1.2	0.10 - 0.30	1.5 - 3.0				○		●	●	●	●											
								0884	0868	2586	3297	0621	1198											
-UM  Medium Machining Unstable condition	TNMG 160404 - UM	0.4	0.15 - 0.30	0.5 - 3.0	○	○		○	○	●	●	●	●											
	TNMG 160408 - UM	0.8	0.15 - 0.30	1.0 - 3.0	○	○		○	○	●	●	●	●											
	TNMG 160412 - UM	1.2	0.15 - 0.30	1.5 - 3.0	○	○		○	○	●	●	●	●											
						1143	0596		0597	0760	2587	3292	0586	0710										
NEW -GM  Medium machining for steel & Stainless steel	TNMG 160404 - GM	0.4	0.15 - 0.40	0.5 - 4.5						●	●					●								
	TNMG 160408 - GM	0.8	0.17 - 0.50	0.8 - 4.5						●	●						●							
	TNMG 160412 - GM	1.2	0.20 - 0.55	1.0 - 4.5						●	●						●							
										3640	3661						3774							

Turning Inserts - Negative TNMG (60° Triangle)

 **Refer to**
Turning holder
p. 95, 101, 116, 121, 125



Series	IC	S
TN** 1604	9.525	4.76
TN** 2204	12.700	4.76

EDP 2200.. ●: Stock item ○: Order made item

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Turning Inserts - Negative TNMG (60° Triangle)

Refer to
Turning holder
p.95, 101, 116, 121, 125

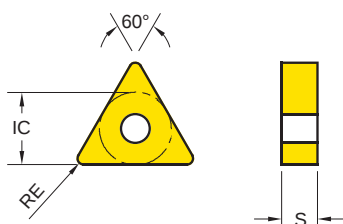
TURNING

PARTING & GROOVING

MILLING

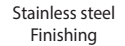
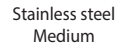
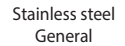
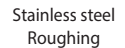
DRILLING

TECHNICAL INFORMATION



Series	IC	S
TN** 1604	9.525	4.76
TN** 2204	12.700	4.76

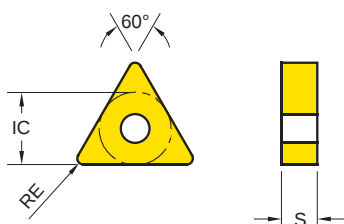
EDP 2200.. ● : Stock item ○ : Order made item

					CUTTING DATA																			
					K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N25
TNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-MF		TNMG 160404 - MF	0.4	0.07 - 0.3	0.2 - 1.5					●			●		●	●	●	●	●	○	●	○		
		TNMG 160408 - MF	0.8	0.07 - 0.3	0.2 - 1.5					●	○	○				●	●	●	●	○				
										2889	2871	3335	0963	2952		2788	3765	0824	0775	1457	1343	3141	3621	
																								
-MM		TNMG 160404 - MM	0.4	0.20 - 0.35	0.5 - 3.5													●	●	●	○			
		TNMG 160408 - MM	0.8	0.20 - 0.35	1.0 - 3.5													●	●	●	○			
		TNMG 160412 - MM	1.2	0.20 - 0.35	1.5 - 3.5													●	●	●	○			
																		0567	0568	1790	2297			
-MG		TNMG 160404 - MG	0.4	0.20 - 0.40	0.5 - 4.0											●	●	●	●	●				
		TNMG 160408 - MG	0.8	0.20 - 0.40	1.0 - 4.0											●	●	●	●	●				
		TNMG 160412 - MG	1.2	0.20 - 0.50	2.0 - 4.0											●	●	●	●	●				
																2472	3766	1455	1456	1219	1515			
-MR		TNMG 160408 - MR	0.8	0.30 - 0.55	2.0 - 5.5								○			●	●	●	●	●				
		TNMG 160412 - MR	1.2	0.30 - 0.55	2.0 - 5.5								○			●	●	●	●	●				
													1062			2493	3770	0826	0985	0726				
																2494	3773	0995	0827	0828				

Turning Inserts - Negative

TNMG / TNMG (60° Triangle)

Refer to
Turning holder
p. 95, 101, 116, 121, 125



Series	IC	S
TN** 1604	9.525	4.76
TN** 2204	12.700	4.76

EDP 2200.. ●: Stock item ○: Order made item

		RE		S		EDP 2200..																								
TNMG						RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10		
-SF		TNMG 160408 - SF	0.8	0.10-0.25	0.2-1.0																				● 1427					
-SM		TNMG 160408 - SM	0.8	0.15-0.30	0.5-3.0																	○ 1575	○ 1576	○ 1577	● 1228					
		TNMG 160412 - SM	1.2	0.15-0.30	0.5-3.0																		○ 1635	○ 1636	○ 1858	● 1508				
		TNMG 220412 - SM	1.2	0.18-0.33	1.0-6.0																				● 3161					
-SR		TNMG 160408 - SR	0.8	0.30-0.55	2.0-5.5																			● 1307						
		TNMG 160412 - SR	1.2	0.30-0.55	2.0-5.5																			● 1306						

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Negative
TNGG / TNMG (60° Triangle)

Refer to
Turning holder
p.95, 101, 116, 121, 125

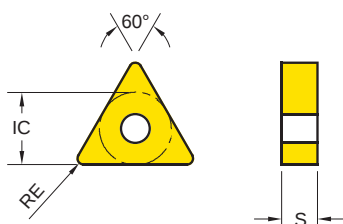
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series	IC	S
TN** 1604	9.525	4.76
TN** 2204	12.700	4.76

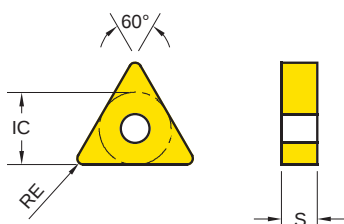
EDP 2200.. ● : Stock item ○ : Order made item

TNGG TNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-PSF Cermet Finishing	TNMG 160404 - PSF	0.4	0.07 - 0.30	0.4 - 2.5																	● 2535	○ 3580		
	TNMG 160408 - PSF	0.8	0.10 - 0.30	0.6 - 2.5																	● 2536	○ 3581		
NEW -S Cermet Finishing Left Hand Shown	TNGG 160402L - S	0.2	0.10 - 0.20	0.3 - 2.0																	● 2859			
	TNGG 160404L - S	0.4	0.10 - 0.20	0.4 - 2.0																	● 2860			
	TNGG 160408L - S	0.8	0.12 - 0.22	0.6 - 2.0																	● 2861			
NEW -S Cermet Finishing Right Hand Shown	TNGG 160402R - S	0.2	0.10 - 0.20	0.3 - 2.0																	● 2856			
	TNGG 160404R - S	0.4	0.10 - 0.20	0.4 - 2.0																	● 2857			
	TNGG 160408R - S	0.8	0.12 - 0.22	0.6 - 2.0																	● 2858			
-C Cermet Medium Left Hand Shown	TNGG 160402L - C	0.2	0.20 - 0.40	0.3 - 3.5																	○ 2524			
	TNGG 160404L - C	0.4	0.20 - 0.40	0.5 - 3.5																	○ 2526			
	TNGG 160408L - C	0.8	0.20 - 0.40	1.0 - 3.5																	○ 2528			
-C Cermet Medium Right Hand Shown	TNGG 160402R - C	0.2	0.20 - 0.40	0.3 - 3.5																	○ 2525			
	TNGG 160404R - C	0.4	0.20 - 0.40	0.5 - 3.5																	○ 2527			
	TNGG 160408R - C	0.8	0.20 - 0.40	1.0 - 3.5																	○ 2529			

Turning Inserts - Negative

TNMM - Heavy Turning (60° Triangle)

Refer to
Turning holder
p. 95, 101, 116, 121, 125



Series	IC	S
TN** 1604	9.525	4.76
TN** 2204	12.700	4.76

EDP 2200.. ● : Stock item ○ : Order made item

TNMM	Designation	RE	F _n (mm/rev.)	A _p (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
	TNMM 160412 - UH	1.2	0.30-0.50	2.0-5.0						● 2846														
	TNMM 220412 - UH	1.2	0.30-0.50	2.0-7.0						● 2848														

-UH



Low cutting force

TURNING

PARTING & GROOVING

MILLING

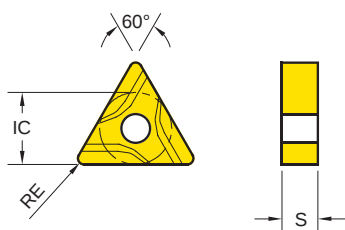
DRILLING

TECHNICAL INFORMATION

Turning Inserts - Negative TNUX (60° Triangle)

 **Refer to**
Turning holder
p. 95, 101, 116, 121, 125

Series	IC	S
TN** 1604	9.525	4.76



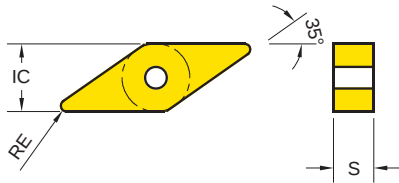
EDP 2200.. ●: Stock item ○: Order made item

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Turning Inserts - Negative

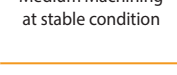
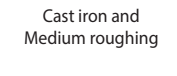
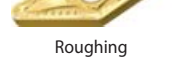
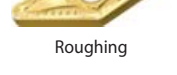
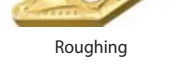
VNMA / VNMG (35° Rhombic)

Refer to
Turning holder
p. 102, 122



Series	IC	S
VN** 1604	9.525	4.76

EDP 2200.. ● : Stock item ○ : Order made item

						K10	P05 K20	K20 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20		
VNMA VNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
..MA		VNMA 160408	0.8	0.15-0.40	1.0-5.0	● 1573	○ 0162	● 3491	○ 1275																	
-UF		VNMG 160404 - UF	0.4	0.05-0.25	0.5-2.5				○ 0306		● 2205	● 3242	● 0307	● 0308	○ 0049											
		VNMG 160408 - UF	0.8	0.05-0.25	1.0-2.5				○ 0309		● 2207	● 3243	● 0310	● 0311												
-UL		VNMG 160404 - UL	0.4	0.10-0.30	0.5-3.0				○ 0886		● 2412	● 3327	● 0912	● 0723												
		VNMG 160408 - UL	0.8	0.10-0.30	1.0-3.0				○ 0428	○ 0790	● 2202	● 3273	● 0429	● 0853												
-UM		VNMG 160408 - UM	0.8	0.15-0.30	1.0-3.0		○ 1357		○ 1359		● 2424	● 3363	● 1361	● 1362												
		VNMG 160412 - UM	1.2	0.15-0.30	1.5-3.0		○ 1230		○ 0736	○ 0870	● 2701	● 3312	● 0737	● 1214												
NEW -GM		VNMG 160404 - GM	0.4	0.15-0.35	0.5-3.0						● 3641	● 3662					● 3792									
		VNMG 160408 - GM	0.8	0.17-0.35	0.8-3.0						● 3642	● 3663						● 3796								
-UG		VNMG 160412 - GM	1.2	0.20-0.40	1.0-3.0						● 3643	● 3664					● 3799									
-UC		VNMG 160404 - UG	0.4	0.20-0.40	0.5-3.0	● 1648	○ 1331	● 3521	○ 0993		● 2420	● 3332	● 0940	● 0994												
		VNMG 160408 - UG	0.8	0.20-0.40	1.0-3.0	● 1000	○ 0462	● 3455	○ 0312		● 2176	● 3244	● 0313	● 0314	○ 0050											
-UR		VNMG 160412 - UG	1.2	0.20-0.40	1.5-3.0	● 1659	○ 1345	● 3525	○ 0931		● 2407	● 3331	● 0927	● 0917												
-UR		VNMG 160404 - UC	0.4	0.20-0.40	0.5-3.5	● 1612	○ 0885	○ 3503	○ 0423		● 2366	● 3356	● 1276	● 1277												
		VNMG 160408 - UC	0.8	0.20-0.40	1.0-3.5	● 0980	○ 0094	○ 3454	○ 0424		● 2210	● 3272	● 0425	● 0426												
-UR		VNMG 160412 - UC	1.2	0.20-0.40	1.5-3.5	● 1587	○ 1381	○ 3497	○ 1392		● 2700	● 3367	● 1382	● 1384												
-UR		VNMG 160412 - UR	1.2	0.30-0.45	1.5-4.0	● 1638	○ 1231	○ 3515	○ 0430	○ 0871	● 2380	● 3274	● 0431	● 0432	○ 0051											

Turning Inserts - Negative
VNGG / VNMG (35° Rhombic)

Refer to
Turning holder
p. 102, 122

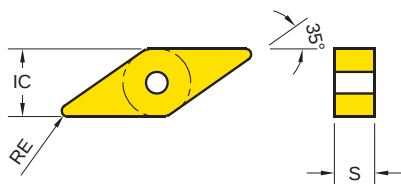
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series	IC	S
VN** 1604	9.525	4.76

EDP 2200.. ● : Stock item ○ : Order made item

	VNGG VNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
						YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-MF  Stainless steel Finishing		VNMG 160404 - MF	0.4	0.07 - 0.30	0.2 - 1.5						●														
		VNMG 160408 - MF	0.8	0.07 - 0.30	0.2 - 1.5						○										○				
-MM  Stainless steel Medium		VNMG 160404 - MM	0.4	0.20 - 0.35	0.5 - 3.5														●	●	●	○			
		VNMG 160408 - MM	0.8	0.20 - 0.35	1.0 - 3.5														●	●	●	○			
-MG  Stainless steel General		VNMG 160404 - MG	0.4	0.20 - 0.40	0.5 - 4.0													●	●						
		VNMG 160408 - MG	0.8	0.20 - 0.40	1.0 - 4.0													●	●						
		VNMG 160412 - MG	1.2	0.20 - 0.40	1.5 - 4.0													●	●						
-MR  Stainless steel Roughing		VNMG 160408 - MR	0.8	0.30 - 0.55	2.0 - 5.5									○				●	●	●	●				
		VNMG 160412 - MR	1.2	0.30 - 0.55	2.0 - 5.5													●	●						
-SF  HRSA Finishing		VNGG 160412 - SF	1.2	0.10 - 0.25	0.4 - 1.5																●				
																					3158				
-SR  HRSA Medium		VNMG 160408 - SR	0.8	0.30 - 0.55	2.0 - 5.5																●				
																					1449				
-PSF  Cermet Finishing		VNMG 160404 - PSF	0.4	0.07 - 0.30	0.3 - 2.0																	●	○		
		VNMG 160408 - PSF	0.8	0.10 - 0.35	0.5 - 2.0																	●	○		

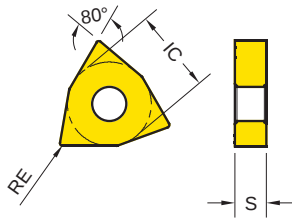
Turning Inserts - Negative

WNMA / WNMG (80° Trigon)



Refer to
Turning holder

p. 96, 103, 105, 117, 123, 126



Series	IC	S
WN** 0604	9.525	4.76
WN** 0804	12.700	4.76

EDP 2200..

● : Stock item ○ : Order made item

WNMA WNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05	K20	P10	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40	S10	P15	P10	N20	N20
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
..MA  Cast iron	WNMA 060412	1.2	0.15-0.50	1.5-4.0	● 2714																			
	WNMA 080404	0.4	0.15-0.50	0.5-5.0	● 0903	○ 0052	● 3442	○ 1262																
	WNMA 080408	0.8	0.15-0.50	1.0-5.0	● 0904	○ 0053	● 3443	○ 0433																
	WNMA 080412	1.2	0.15-0.50	1.5-5.0	● 0905	○ 0054	● 3444	○ 0434																
-UF  Finishing	WNMG 060404 - UF	0.4	0.05-0.20	0.5-2.0				○ 0435		● 2415	● 3275	● 0436	○ 0437	○ 0058										
	WNMG 080404 - UF	0.4	0.05-0.25	0.5-2.5				○ 0315		● 2389	● 3245	● 0316	○ 0317	○ 0055										
	WNMG 080408 - UF	0.8	0.05-0.25	1.0-2.5				○ 0321		● 2173	● 3247	● 0322	○ 0323											
	WNMG 080412 - UF	1.2	0.05-0.25	1.5-2.5				○ 1424		● 2708	● 3369	● 1410	○ 1411											
-UL  Light Machining and Sticky Material	WNMG 060408 - UL	0.8	0.10-0.30	1.0-2.5				○ 0439		● 2588	● 3277	● 0440	○ 0441											
	WNMG 080404 - UL	0.4	0.10-0.30	0.5-3.0				○ 1431		● 2703	● 3371	● 1434	○ 1438											
	WNMG 080408 - UL	0.8	0.10-0.30	1.0-3.0				○ 0324		● 2177	● 3248	● 0325	○ 0326											
	WNMG 080412 - UL	1.2	0.10-0.30	1.5-3.0						● 2448	● 3372	● 1435												
-UM  Medium Machining Unstable condition	WNMG 060404 - UM	0.4	0.15-0.30	0.5-2.5	○ 2106	○ 1259		○ 0741		● 2418	● 3319	● 0785	○ 0742											
	WNMG 060408 - UM	0.8	0.15-0.30	1.0-2.5	○ 1554	○ 1260		○ 0600		● 2402	● 3296	● 0601	○ 1271											
	WNMG 080404 - UM	0.4	0.15-0.30	0.5-3.0		○ 1313		○ 0786		● 2704	● 3320	● 0787	○ 0788											
	WNMG 080408 - UM	0.8	0.15-0.30	1.0-3.0		○ 0470		○ 0327	○ 0761	● 2170	● 3249	● 0328	○ 0329											
	WNMG 080412 - UM	1.2	0.15-0.30	1.5-3.0		○ 1210		○ 0649	○ 0762	● 2417	● 3295	● 0598	○ 0712											
	WNMG 080416 - UM	1.6	0.15-0.30	2.0-3.0		○ 1234		○ 0593	○ 0763	● 2574	● 3291	● 0584	○ 0713											
NEW -GM  Medium machining for steel & Stainless steel	WNMG 060404 - GM	0.4	0.15-0.40	0.5-3.0						● 3644	● 3665					● 3802								
	WNMG 060408 - GM	0.8	0.17-0.50	0.8-3.0						● 3645	● 3666					● 3806								
	WNMG 060412 - GM	1.2	0.20-0.55	1.0-3.0						● 3646	● 3667					● 3809								
	WNMG 080404 - GM	0.4	0.15-0.40	0.5-4.0						● 3647	● 3668					● 3812								
	WNMG 080408 - GM	0.8	0.17-0.50	0.8-4.0						● 3648	● 3669					● 3816								
	WNMG 080412 - GM	1.2	0.20-0.55	1.0-4.0						● 3649	● 3670					● 3819								
	WNMG 080416 - GM	1.6	0.23-0.55	1.3-4.0						● 3650	● 3671					● 3820								

TURNING

PARTING & GROOVING

MILLING

DRILLING

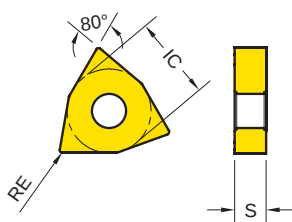
TECHNICAL INFORMATION

Turning Inserts - Negative WNMG (80° Trigon)



Refer to
Turning holder

Series	IC	S
WN** 0604	9.525	4.76
WN** 0804	12.700	4.76



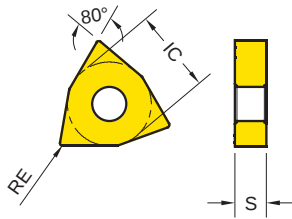
EDP 2200.. ●: Stock item ○: Order made item

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Turning Inserts - Negative

WNMG (80° Trigon)

Refer to
Turning holder
p. 96, 103, 105, 117, 123, 126



Series	IC	S
WN** 0604	9.525	4.76
WN** 0804	12.700	4.76

EDP 2200.. ● : Stock item ○ : Order made item

					K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
WNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-MF  Stainless steel Finishing	WNMG 060404 - MF	0.4	0.07-0.30	0.4-2.0				○ 0833	● 2874				○ 0996		● 2461	● 3800	● 1215	● 1217	● 2284	○ 2279				
	WNMG 060408 - MF	0.8	0.07-0.30	0.8-2.0					● 2890				● 2953		● 2789	● 3803	● 1216	● 1218	● 2285	○ 2280				
	WNMG 080404 - MF	0.4	0.07-0.30	0.4-2.5					● 2875				○ 0834		● 2462	● 3810	● 0667	● 0668	● 0970	○ 2281				
	WNMG 080408 - MF	0.8	0.07-0.30	0.8-2.5					● 2876				○ 1098		● 2463	● 3813	● 0617	● 0618	● 2268	○ 2282				
-MM  Stainless steel Medium	WNMG 080404 - MM	0.4	0.20-0.35	0.5-3.5														● 0571	● 0572	● 2300	○ 2301			
	WNMG 080408 - MM	0.8	0.20-0.35	1.0-3.5									○ 0491					● 0497	● 0498	● 0633	○ 2302			
	WNMG 080412 - MM	1.2	0.20-0.35	1.5-3.5														● 0612	● 0615	● 1926	○ 2303			
-MG  Stainless steel General	WNMG 060404 - MG	0.4	0.20-0.40	0.5-3.0											● 2487	● 3801								
	WNMG 060408 - MG	0.8	0.20-0.40	1.0-3.0												● 2476	● 3804							
	WNMG 060412 - MG	1.2	0.20-0.40	1.5-3.0												● 2477	● 3807							
	WNMG 080404 - MG	0.4	0.20-0.40	0.5-4.0												● 2488	● 3811							
	WNMG 080408 - MG	0.8	0.20-0.40	1.0-4.0												● 2478	● 3814	● 1496	● 1497	● 1160	● 1498			
	WNMG 080412 - MG	1.2	0.20-0.40	1.5-4.0												● 2479	● 3817	● 1499	● 1500	● 1161	● 1501			
-MR  Stainless steel Roughing	WNMG 060408 - MR	0.8	0.30-0.55	1.2-4.0											● 2793	● 3805								
	WNMG 060412 - MR	1.2	0.30-0.55	1.2-4.0									○ 1154		● 2498	● 3808	● 0616	● 1787	● 1896					
	WNMG 080408 - MR	0.8	0.30-0.55	2.0-5.5									○ 1099		● 2499	● 3815	● 0619	● 0620	● 0835					
	WNMG 080412 - MR	1.2	0.30-0.55	2.0-5.5									○ 0837		● 2482	● 3818	● 0665	● 0666	● 0836					

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Negative
WNGG / WNMG (80° Trigon)

Refer to
Turning holder

p. 96, 103, 105, 117, 123, 126

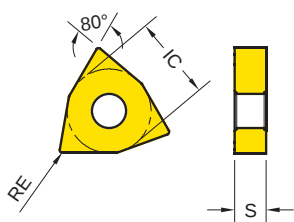
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series

IC

S

WN** 0604

9.525

4.76

WN** 0804

12.700

4.76

EDP 2200..

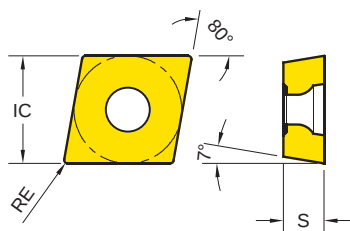
● : Stock item

○ : Order made item

WNGG WNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	K20	K30	S30	K15	K10	YG100	YG10
-SF		WNGG 080408 - SF	0.8	0.10 - 0.25	0.2 - 1.0								
	HRSA Finishing												
-SM		WNMG 080408 - SM	0.8	0.15 - 0.30	0.5 - 3.0								
	WNMG 080412 - SM	1.2	0.15 - 0.30	0.5 - 3.0									
	HRSA Medium												
-SR		WNMG 060412 - SR	1.2	0.30 - 0.55	2.0 - 4.0								
	WNMG 080408 - SR	0.8	0.30 - 0.55	2.0 - 5.5									
	WNMG 080412 - SR	1.2	0.30 - 0.55	2.0 - 5.5									
	WNMG 080416 - SR	1.6	0.30 - 0.55	2.0 - 5.5									
-PSF		WNMG 080404 - PSF	0.4	0.07 - 0.30	0.4 - 2.5								
	WNMG 080408 - PSF	0.8	0.10 - 0.35	0.6 - 2.5									
	Cermet Finishing												

Turning Inserts - Positive

 **Refer to**
Turning holder
p. 106, 128, 129



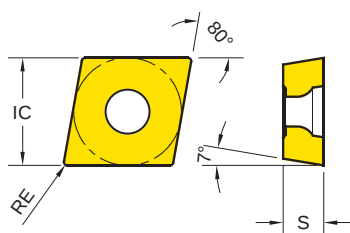
Series	IC	S
CC** 0602	6.350	2.38
CC** 09T3	9.525	3.97
CC** 1204	12.700	4.76

EDP 2200.. ●: Stock item ○: Order made item

					Order made item																			
					K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 K15	P10 K10	N20	N20
CCGT CCMT	Designation	RE	F _n (mm/rev.)	A _p (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-AL  Aluminum	CCGT 060202 - AL	0.2	0.01-0.12	0.05-3.0																				● 1398
	CCGT 060204 - AL	0.4	0.02-0.15	0.10-3.0																			● 1278	● 1320
	CCGT 09T302 - AL	0.2	0.02-0.20	0.05-3.0																			● 0340	● 0339
	CCGT 09T304 - AL	0.4	0.02-0.30	0.10-5.0																			● 0330	● 0081
	CCGT 09T308 - AL	0.8	0.03-0.50	0.10-5.0																			● 0331	● 0082
	CCGT 120402 - AL	0.2	0.02-0.30	0.05-4.0																			● 0474	● 0473
	CCGT 120404 - AL	0.4	0.03-0.50	0.10-5.0																			● 0476	● 0475
	CCGT 120408 - AL	0.8	0.04-0.80	0.10-5.5																			● 0478	● 0477
-UF  Finishing	CCMT 060204 - UF	0.4	0.05-0.20	0.5-2.0				○ 0163	○ 0866	● 2365	● 3195	● 0164	● 0165											
	CCMT 09T304 - UF	0.4	0.05-0.25	0.5-2.0				○ 0169		● 2371	● 3197	● 0170	● 0171											
	CCMT 09T308 - UF	0.8	0.05-0.25	1.0-2.0				○ 0964		● 2578	● 3333	● 0951	● 0953											
	CCMT 120404 - UF	0.4	0.10-0.25	1.0-5.0						● 2579	● 3361	● 1347	● 1337											
-UG  General	CCMT 060204 - UG	0.4	0.10-0.25	0.5-2.0	● 1377		● 3466	○ 0166		● 2357	● 3196	● 0167	○ 0168	○ 0006			○ 2224		○ 1900					
	CCMT 060208 - UG	0.8	0.10-0.25	0.8-2.0	● 1825	○ 0864	○ 3526	○ 0479		● 2378	● 3301	● 0683	○ 0684	○ 0009			○ 2225		○ 1901					
	CCMT 09T304 - UG	0.4	0.15-0.30	0.5-2.5	● 1844		○ 3541	○ 0172		● 2206	● 3198	● 0173	○ 0174	○ 0007					○ 1586					
	CCMT 09T308 - UG	0.8	0.15-0.30	0.8-2.5	● 1553	○ 0445	● 3487	○ 0150		● 2180	● 3191	● 0151	○ 0152	○ 0008			○ 1908		○ 1902					
	CCMT 120404 - UG	0.4	0.15-0.35	0.5-3.0	● 1845		○ 3542	○ 0175		● 2399	● 3199	● 0176	○ 0177											
	CCMT 120408 - UG	0.8	0.15-0.35	0.8-3.0	● 1462	○ 1461	● 3471	○ 0153	○ 0867	● 2183	● 3192	● 0154	○ 0155	○ 0005					○ 1125					
	CCMT 120412 - UG	1.2	0.15-0.35	1.2-3.0	● 1846		○ 3543	○ 0483		● 2580	● 3328	● 0915	○ 1135						○ 1126					

Turning Inserts - Positive

CCGT / CCMT (80° Rhombic)

Refer to
Turning holder
p. 106, 128, 129


Series	IC	S
CC** 0602	6.350	2.38
CC** 09T3	9.525	3.97
CC** 1204	12.700	4.76

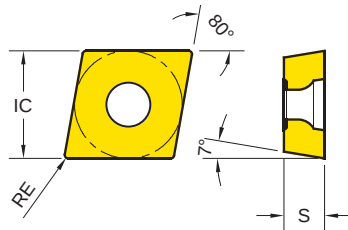
EDP 2200.. ● : Stock item ○ : Order made item

	CCGT CCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
						YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
TURNING	-SF HRSA Finishing	CCGT 060201 - SF	0.1	0.02 - 0.15	0.10 - 1.5																●				
		CCGT 060202 - SF	0.2	0.02 - 0.15	0.10 - 1.5																●				
		CCGT 060204 - SF	0.4	0.03 - 0.20	0.10 - 2.4																●				
		CCGT 09T301 - SF	0.1	0.02 - 0.15	0.10 - 2.5																●				
		CCGT 09T302 - SF	0.2	0.02 - 0.15	0.10 - 2.5																●				
		CCGT 09T304 - SF	0.4	0.03 - 0.20	0.10 - 2.5																●				
		CCGT 09T308 - SF	0.8	0.03 - 0.25	0.10 - 2.5																●				
PARTING & GROOVING	-MF Stainless steel Finishing	CCMT 060202 - MF	0.2	0.04 - 0.15	0.08 - 2.0											●	●	●	●	●					
		CCMT 060204 - MF	0.4	0.06 - 0.25	0.10 - 2.0											●	●	●	●	●					
		CCMT 060208 - MF	0.8	0.07 - 0.28	0.12 - 2.0												●	●	●	●					
		CCMT 09T302 - MF	0.2	0.04 - 0.15	0.08 - 2.0											●	●	●	●	●					
		CCMT 09T304 - MF	0.4	0.06 - 0.25	0.10 - 2.0											●	●	●	●	●					
		CCMT 09T308 - MF	0.8	0.08 - 0.30	0.15 - 2.0						○					●	●	●	●	●					
		CCMT 120404 - MF	0.4	0.07 - 0.25	0.20 - 2.4											●	●								
MILLING	-MM Stainless steel Medium	CCMT 120408 - MF	0.8	0.08 - 0.30	0.50 - 2.4											●	●								
		CCMT 060204 - MM	0.4	0.06 - 0.17	0.3 - 2.4											●	●								
		CCMT 060208 - MM	0.8	0.08 - 0.23	0.8 - 2.4											●	●								
		CCMT 09T304 - MM	0.4	0.08 - 0.25	0.25 - 3.0											●	●	●	●	●	●				
		CCMT 09T308 - MM	0.8	0.10 - 0.30	0.50 - 3.0											●	●	●	●	●	●				
		CCMT 09T312 - MM	1.2	0.12 - 0.35	1.0 - 3.0											●	●								
		CCMT 120404 - MM	0.4	0.09 - 0.27	0.4 - 4.2											●	●								
DRILLING	-MM Stainless steel Medium	CCMT 120408 - MM	0.8	0.12 - 0.36	0.8 - 4.2											●	●								
		CCMT 120412 - MM	1.2	0.14 - 0.43	1.2 - 4.2											●	●								
TECHNICAL INFORMATION	-MM Stainless steel Medium																								

Turning Inserts - Positive

CCMT (80° Rhombic)

Refer to
Turning holder
p. 106, 128, 129



Series	IC	S
CC** 0602	6.350	2.38
CC** 09T3	9.525	3.97
CC** 1204	12.700	4.76

EDP 2200.. ● : Stock item ○ : Order made item

					S																			
					K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
CCMT					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
- PF  Finishing	CCMT 060202 - PF	0.2	0.04-0.15	0.08-2.0						●			●								●	○		
	CCMT 060204 - PF	0.4	0.06-0.25	0.10-2.0						●			●								●	○		
	CCMT 09T302 - PF	0.2	0.04-0.15	0.08-2.0						●			●								●	○		
	CCMT 09T304 - PF	0.4	0.06-0.25	0.10-2.0						●			●								●	○		
	CCMT 09T308 - PF	0.8	0.08-0.30	0.15-2.0						●			●								●	○		
	CCMT 09T312 - PF	1.2	0.10-0.32	0.2-2.0						●											●	○		
	CCMT 120404 - PF	0.4	0.07-0.25	0.2-2.4						●			●											
	CCMT 120408 - PF	0.8	0.08-0.30	0.5-2.4						●			●											
- PM  Medium	CCMT 060204 - PM	0.4	0.06-0.17	0.25-2.4						●			●							●	○			
	CCMT 060208 - PM	0.8	0.08-0.23	0.8-2.4						●			●								●	○		
	CCMT 09T304 - PM	0.4	0.08-0.25	0.25-3.0						●			●								●	○		
	CCMT 09T308 - PM	0.8	0.10-0.30	0.50-3.0						●			●								●	○		
	CCMT 09T312 - PM	1.2	0.12-0.35	1.0-3.0						●			●											
	CCMT 120404 - PM	0.4	0.09-0.27	0.4-4.2						●			●											
	CCMT 120408 - PM	0.8	0.12-0.36	0.8-4.2						●			●											
	CCMT 120412 - PM	1.2	0.14-0.43	1.2-4.2						●			●											

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Positive

DCGT / DCMT (55° Rhombic)

Refer to
Turning holder
p. 107, 130, 131

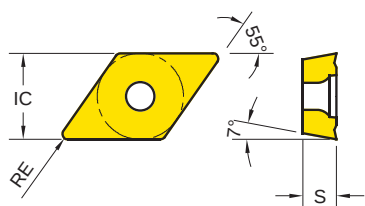
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series	IC	S
DC** 0702	6.350	2.38
DC** 11T3	9.525	3.97

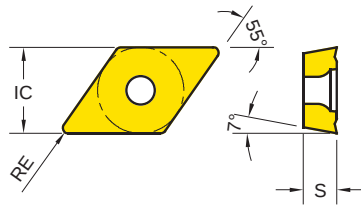
EDP 2200.. ● : Stock item ○ : Order made item

DCGT DCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-AL  Aluminum	DCGT 070202 - AL	0.2	0.01 - 0.20	0.05 - 3.0																				● 1399
	DCGT 070204 - AL	0.4	0.02 - 0.30	0.10 - 4.0																				● 1400
	DCGT 11T301 - AL	0.1	0.01 - 0.30	0.05 - 4.0																			● 2101	● 2100
	DCGT 11T302 - AL	0.2	0.02 - 0.30	0.05 - 4.0																			● 0342	● 0341
	DCGT 11T304 - AL	0.4	0.03 - 0.50	0.10 - 5.0																			● 0332	● 0083
	DCGT 11T308 - AL	0.8	0.03 - 0.50	0.10 - 5.0																			● 0333	● 0084
-UF  Finishing	DCMT 070204 - UF	0.4	0.05 - 0.20	0.50 - 2.0				○ 0207		● 2397	● 3209	● 0208	● 0209					○ 1909	○ 1903					
	DCMT 11T304 - UF	0.4	0.05 - 0.25	0.50 - 2.0		○ 1533		○ 0213		● 2208	● 3211	● 0214	● 0215					○ 1044	○ 1043	○ 1910				
	DCMT 11T308 - UF	0.8	0.05 - 0.25	1.00 - 2.0	● 2053			○ 0219		● 1897	● 3213	● 0220	● 0221											
-UG  General	DCMT 070204 - UG	0.4	0.10 - 0.25	0.50 - 2.0	● 1849		○ 3545	○ 0210		● 2391	● 3210	● 0211	○ 0212	○ 0013										
	DCMT 070208 - UG	0.8	0.10 - 0.25	0.80 - 2.0	● 1850		○ 3546	○ 0484		● 2386	● 3309	● 0717	● 1136											
	DCMT 11T304 - UG	0.4	0.15 - 0.30	0.50 - 2.5	● 1831	○ 0677	● 3529	○ 0216		● 2209	● 3212	● 0217	● 0218	○ 0014				○ 1520	○ 1522	○ 1521				
	DCMT 11T308 - UG	0.8	0.15 - 0.30	0.80 - 2.5	● 1832	○ 0678	● 3530	○ 0222		● 2215	● 3214	● 0223	● 0224	○ 0015										
	DCMT 11T312 - UG	1.2	0.15 - 0.35	1.50 - 3.0						● 2605	● 3393	● 2056												

Turning Inserts - Positive

DCGT / DCMT (55° Rhombic)

Refer to
Turning holder
p. 107, 130, 131



Series	IC	S
DC** 0702	6.350	2.38
DC** 11T3	9.525	3.97

EDP 2200..

● : Stock item ○ : Order made item

DCGT DCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-SF  HRSA Finishing	DCGT 070201 - SF	0.1	0.02 - 0.15	0.10 - 1.5															●	●				
	DCGT 070202 - SF	0.2	0.02 - 0.15	0.10 - 1.5															●	●				
	DCGT 070204 - SF	0.4	0.03 - 0.20	0.10 - 1.5														○	●	●				
	DCGT 11T301 - SF	0.1	0.01 - 0.05	0.10 - 2.5															●	●				
	DCGT 11T302 - SF	0.2	0.02 - 0.15	0.10 - 2.5														○	●	●				
	DCGT 11T304 - SF	0.4	0.03 - 0.20	0.10 - 2.5														○	●	●				
	DCGT 11T308 - SF	0.8	0.03 - 0.20	0.10 - 2.5															●	●				
-MF  Stainless steel Finishing	DCMT 070202 - MF	0.2	0.05 - 0.15	0.05 - 1.5										●	●									
	DCMT 070204 - MF	0.4	0.05 - 0.17	0.08 - 1.5										●	●				●	●				
	DCMT 11T302 - MF	0.2	0.04 - 0.15	0.08 - 2.0										●	●	●	●	●	●	●				
	DCMT 11T304 - MF	0.4	0.06 - 0.25	0.10 - 2.0										●	●	●	●	●	●	●				
	DCMT 11T308 - MF	0.8	0.08 - 0.30	0.15 - 2.0										●	●	●	●	●	●	●				
-MM  Stainless steel Medium	DCMT 070204 - MM	0.4	0.06 - 0.17	0.20 - 2.3										●	●									
	DCMT 070208 - MM	0.8	0.08 - 0.25	0.5 - 2.3								○		●	●									
	DCMT 11T304 - MM	0.4	0.06 - 0.17	0.25 - 3.0										●	●	●	●	●	●	●				
	DCMT 11T308 - MM	0.8	0.08 - 0.25	0.50 - 3.0										●	●	●	●	●	●	●				
	DCMT 11T312 - MM	1.2	0.12 - 0.36	1.2 - 3.0										●	●									
-PF  Finishing	DCMT 070202 - PF	0.2	0.05 - 0.15	0.05 - 1.5					●				●							●	○			
	DCMT 070204 - PF	0.4	0.05 - 0.17	0.08 - 1.5					●				●							●	○			
	DCMT 11T302 - PF	0.2	0.04 - 0.15	0.08 - 2.0					●				●							●	○			
	DCMT 11T304 - PF	0.4	0.06 - 0.25	0.10 - 2.0					●				●							●	○			
	DCMT 11T308 - PF	0.8	0.07 - 0.20	0.15 - 2.0					●				●							●	○			
-PM  Medium	DCMT 070204 - PM	0.4	0.08 - 0.30	0.20 - 2.3					●				●							●	○			
	DCMT 070208 - PM	0.8	0.08 - 0.25	0.5 - 2.3					●	○			●											
	DCMT 11T304 - PM	0.4	0.06 - 0.17	0.25 - 3.0					●				●							●	○			
	DCMT 11T308 - PM	0.8	0.08 - 0.25	0.50 - 3.0					●				●							●	○			
	DCMT 11T312 - PM	1.2	0.12 - 0.36	1.2 - 3.0					●				●											

TURNING

PARTING & GROOVING

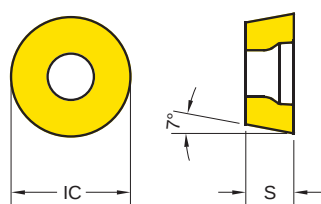
MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Positive RCMT (Round)

Refer to
Turning holder
p. 108, 132



Series	IC	S	Series	IC	S
RC** 0602	6	2.38	RC** 10T3	10	3.97
RC** 0803	8	3.18	RC** 1204	12	4.76

EDP 2200.. ●: Stock item ○: Order made item

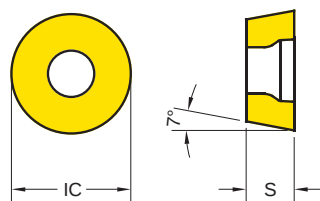
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					K10										P05										K20										P10										P15										P10										P25										P20										P30										P20										M25										M35										M15										M30										M40										S10										P15										P10										M15										M10										N20										N25									
					K10										P05										K20										P10										P15										P10										P25										P20										P30										P20										M25										M35										M15										M30										M40										S10										P15										P10										M15										M10										N20										N25									
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					K10										P05										K20										P10										P15										P10										P25										P20										P30										P20										M25										M35										M15										M30										M40										S10										P15										P10										M15										M10										N20										N25									
					K10										P05										K20										P10										P15										P10										P25										P20										P30										P20										M25										M35										M15										M30										M40										S10										P15										P10										M15										M10										N20										N25									
					K10										P05										K20										P10										P15										P10										P25										P20										P30										P20										M25										M35										M15										M30										M40										S10										P15										P10										M15										M10										N20										N25									
					K10										P05										K20										P10										P15										P10										P25										P20										P30										P20										M25										M35										M15										M30										M40										S10										P15										P10										M15										M10										N20										N25									
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					K10										P05										K20										P10										P15										P10										P25										P20										P30										P20										M25										M35										M15										M30										M40										S10										P15										P10										M15										M10										N20										N25									
					K10										P05										K20										P10										P15										P10										P25										P20										P30										P20										M25										M35										M15										M30										M40										S10										P15										P10										M15										M10										N20										N25									
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Turning Inserts - Positive

RCMX - Heavy Turning (Round)



Refer to
Turning holder
p. 108, 132



Series	IC	S	Series	IC	S
RC** 1606	16	6.35	RC** 2507	25	7.94
RC** 2006	20	6.35	RC** 3209	32	9.52

EDP 2200.. ● : Stock item ○ : Order made item

-UT	 Heavy Roughing	RCMX	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
							●					●					●	●									
			RCMX 1606M0 - UT	8.0	0.3-0.8	1.0-7.0	2441						2719					3160	3734								
			RCMX 2006M0 - UT	10.0	0.4-0.9	1.5-9.0	3564				●		2169	3423	2844	2845											
			RCMX 2507M0 - UT	12.5	0.5-1.2	2.5-12.0	3837		●				3146	3840		3839											
			RCMX 3209M0 - UT	16.0	0.6-1.5	3.5-15.0	3841		●			3147	3844		3843												

TURNING

PARTING & GROOVING

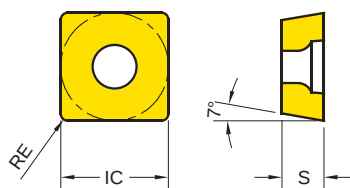
MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Positive

SCGT / SCMT (Square)

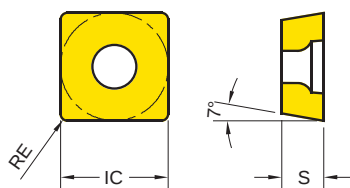

Refer to
Turning holder
p. 109, 133


Series	IC	S
SC** 09T3	9.525	3.97
SC** 1204	12.700	4.76

EDP 2200.. ● : Stock item ○ : Order made item

						K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
SCGT SCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
-AL  Aluminium	SCGT 09T304 - AL	0.4	0.03-0.40	0.1-5.0																				● 1516	
	SCGT 09T308 - AL	0.8	0.04-0.40	0.1-5.0																				● 1517	
-UF  Finishing	SCMT 09T304 - UF	0.4	0.05-0.25	0.5-2.0				○ 0386		● 2628	● 3260	● 0387	● 0783												
	SCMT 09T308 - UF	0.8	0.05-0.25	1.0-2.0	● 2083			○ 1021		● 2629	● 3339	● 1022	● 0997												
-UG  General	SCMT 09T304 - UG	0.4	0.15-0.30	0.5-2.5	● 1834	○ 0455	● 3532	○ 0482		● 2414	● 3329	● 0916	● 1171	○ 0025			○ 2235								
	SCMT 09T308 - UG	0.8	0.15-0.30	0.8-2.5	● 1835	○ 0456	● 3533	○ 0159		● 2383	● 3194	● 0160	● 0161	○ 0026			○ 2236		○ 1904						
	SCMT 120408 - UG	0.8	0.15-0.35	0.8-3.0	● 1836	○ 0674	● 3534	○ 0255		● 2393	● 3225	● 0256	● 0257						○ 1911						
	SCMT 120412 - UG	1.2	0.15-0.35	1.5-3.0	● 2098																				
-MF  Stainless steel Finishing	SCMT 09T304 - MF	0.4	0.06-0.22	0.1-2.0											● 2800	● 3735									
	SCMT 09T308 - MF	0.8	0.09-0.30	0.3-2.0											● 2801	● 3737				● 2564					
	SCMT 120404 - MF	0.4	0.09-0.28	0.3-4.2											● 2802	● 3740									
	SCMT 120408 - MF	0.8	0.10-0.30	0.6-4.2											● 2803	● 3742									
-MM  Stainless steel Medium	SCMT 09T304 - MM	0.4	0.08-0.24	0.4-3.2											● 2819	● 3736									
	SCMT 09T308 - MM	0.8	0.10-0.30	0.8-3.2											● 2820	● 3738									
	SCMT 09T312 - MM	1.2	0.12-0.35	0.9-3.2											● 2821	● 3739									
	SCMT 120404 - MM	0.4	0.09-0.28	0.3-4.2											● 2822	● 3741									
	SCMT 120408 - MM	0.8	0.10-0.30	0.6-4.2											● 2519	● 3743	● 1973	● 1974	● 1975	● 1976					
	SCMT 120412 - MM	1.2	0.16-0.45	1.2-4.2											● 2823	● 3744									

Turning Inserts - Positive SCMT (Square)

Refer to
Turning holder
p. 109, 133


Series	IC	S
SC** 09T3	9.525	3.97
SC** 1204	12.700	4.76

EDP 2200.. ● : Stock item ○ : Order made item

					K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N25	
SCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
-PF  Finishing	SCMT 09T304 - PF	0.4	0.06-0.22	0.1-2.0						● 2897			● 2960												
	SCMT 09T308 - PF	0.8	0.09-0.30	0.3-2.0						● 2898			● 2961												
	SCMT 120404 - PF	0.4	0.09-0.28	0.3-4.2						● 2899			● 2962												
	SCMT 120408 - PF	0.8	0.10-0.30	0.6-4.2						●			●												
-PM  Medium	SCMT 09T304 - PM	0.4	0.08-0.24	0.4-3.2						● 2925			● 2989												
	SCMT 09T308 - PM	0.8	0.10-0.30	0.8-3.2						● 2926			● 2990								● 2853	○ 3617			
	SCMT 09T312 - PM	1.2	0.12-0.35	0.9-3.2						● 2927			● 2991												
	SCMT 120404 - PM	0.4	0.09-0.28	0.3-4.2						● 2928			● 2992												
	SCMT 120408 - PM	0.8	0.10-0.30	0.6-4.2						● 2929			● 2993								● 2530	○ 3575			
	SCMT 120412 - PM	1.2	0.16-0.45	1.2-4.2						● 2930			● 2994												

TURNING

PARTING & GROOVING

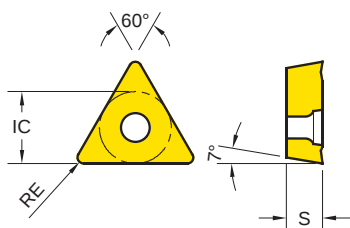
MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Positive

TCGT / TCMT (Triangle)

Refer to
Turning holder
p. 110, 134


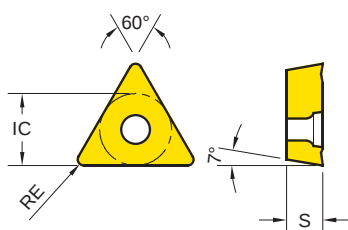
Series	IC	S
TC** 0902	5.56	2.38
TC** 1102	6.350	2.38
TC** 16T3	9.525	3.97

EDP 2200.. ● : Stock item ○ : Order made item

						S																				
TCGT TCMT		Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 K15	P10 K10	N20	N20	
-AL  Aluminum	TCGT 110204 - AL	0.4	0.03-0.30	0.10-4.0		YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
	TCGT 16T302 - AL	0.2	0.02-0.30	0.05-5.0																					●●	1333
	TCGT 16T304 - AL	0.4	0.03-0.40	0.10-5.5																					●●	0344 0343
	TCGT 16T308 - AL	0.8	0.03-0.50	0.10-5.5																					●●	0334 0085
-UF  Finishing	TCMT 090204 - UF	0.4	0.05-0.20	0.5-1.5	●	3163					●			●												
	TCMT 110204 - UF	0.4	0.05-0.20	0.5-2.0					○		●	●	●	●					○	○	○					
	TCMT 16T304 - UF	0.4	0.05-0.25	0.5-2.0					○		●	●	●	●	○					○	○	○				
	TCMT 16T308 - UF	0.8	0.05-0.25	0.8-2.0					○		●	●	●	●							○	○				
-UG  General	TCMT 090204 - UG	0.4	0.10-0.25	0.5-1.5	●	3166					●			●												
	TCMT 090208 - UG	0.8	0.10-0.25	0.8-1.5	●	3169					●			●												
	TCMT 110204 - UG	0.4	0.10-0.25	0.5-2.0	●	○	●	○			●	●	●	●	○				○							
	TCMT 110208 - UG	0.8	0.10-0.25	0.8-2.0	●	○	○	○			●	●	●	●												
	TCMT 16T304 - UG	0.4	0.15-0.30	0.5-2.5	●	○	●	○			●	●	●	●												
	TCMT 16T308 - UG	0.8	0.15-0.30	0.8-2.5	●	○	●	○			●	●	●	●	○				○	○						

Turning Inserts - Positive TCMT (Triangle)

Refer to
Turning holder
p. 110, 134



Series	IC	S
TC** 1102	6.350	2.38
TC** 16T3	9.525	3.97

EDP 2200.. ● : Stock item ○ : Order made item

TCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)																				
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-MF  Stainless steel Finishing	TCMT 110202 - MF	0.2	0.04-0.14	0.1-1.7											●	●								
	TCMT 110204 - MF	0.4	0.07-0.20	0.2-1.7											●	●				●				
	TCMT 110208 - MF	0.8	0.07-0.25	0.3-1.7											●	●				●				
	TCMT 16T304 - MF	0.4	0.06-0.25	0.10-2.0											●	●	●	●	●	●				
	TCMT 16T308 - MF	0.8	0.08-0.30	0.15-2.0											●	●	●	●	●	●				
-MM  Stainless steel Medium	TCMT 110204 - MM	0.4	0.06-0.19	0.25-2.2											●	●								
	TCMT 110208 - MM	0.8	0.09-0.26	0.5-2.2											●	●								
	TCMT 16T304 - MM	0.4	0.08-0.25	0.25-3.0											●	●	●	●	●	●				
	TCMT 16T308 - MM	0.8	0.10-0.30	0.50-3.0											●	●	●	●	●	●				
	TCMT 16T312 - MM	1.2	0.12-0.36	0.9-3.0											●	●								
-PF  Medium	TCMT 110202 - PF	0.2	0.04-0.14	0.1-1.7					●				●											
	TCMT 110204 - PF	0.4	0.07-0.20	0.2-1.7					●				●								●	○		
	TCMT 110208 - PF	0.8	0.07-0.25	0.3-1.7					●				●											
	TCMT 16T304 - PF	0.4	0.06-0.25	0.10-2.0					●				●								●	○		
	TCMT 16T308 - PF	0.8	0.08-0.30	0.15-2.0					●				●								●	○		
-PM  Medium	TCMT 110204 - PM	0.4	0.06-0.19	0.25-2.2					●				●											
	TCMT 110208 - PM	0.8	0.09-0.26	0.5-2.2					●				●											
	TCMT 16T304 - PM	0.4	0.08-0.25	0.25-3.0					●				●								●	○		
	TCMT 16T308 - PM	0.8	0.10-0.30	0.50-3.0					●				●								●	○		
	TCMT 16T312 - PM	1.2	0.12-0.36	0.9-3.0					●				●								●	○		

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

Turning Inserts - Positive

VBGT / VBMT (35° Rhombic)



Refer to
Turning holder
p. 111, 135

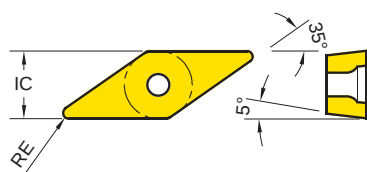
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series	IC	S
VB** 1103	6.350	3.18
VB** 1604	9.525	4.76

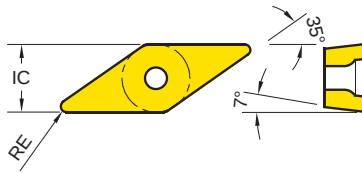
EDP 2200.. ● : Stock item ○ : Order made item

	VBGT VBMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
						YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-SF	 HRSA Finishing	VBGT 110301 - SF	0.1	0.01 - 0.20	0.10 - 1.5																				
		VBGT 110302 - SF	0.2	0.02 - 0.20	0.10 - 1.5																●				
		VBGT 110304 - SF	0.4	0.05 - 0.20	0.20 - 1.5																●				
		VBGT 160404 - SF	0.4	0.05 - 0.20	0.20 - 2.0																●				
		VBGT 160408 - SF	0.8	0.05 - 0.20	0.4 - 2.0																●				
-UF	 Finishing	VBMT 110304 - UF	0.4	0.04 - 0.16	0.10 - 0.8						●														
		VBMT 110308 - UF	0.4	0.04 - 0.16	0.40 - 1.0						●														
		VBMT 160404 - UF	0.4	0.05 - 0.25	0.50 - 2.0				○		●	●	●	●											
		VBMT 160408 - UF	0.8	0.05 - 0.25	0.80 - 2.0				○		●	●	●	●											
-UG	 General	VBMT 160404 - UG	0.4	0.15 - 0.30	0.50 - 2.5	●	○	●	○		●	●	●	●	○										
		VBMT 160408 - UG	0.8	0.15 - 0.30	0.80 - 2.5	●	○	●	○		●	●	●	●	○										
-MF	 Stainless steel Finishing	VBMT 110304 - MF	0.4	0.05 - 0.20	0.1 - 1.7											●	●								
		VBMT 110308 - MF	0.8	0.07 - 0.23	0.3 - 1.7											●	●								
		VBMT 160402 - MF	0.2	0.04 - 0.15	0.10 - 2.0											●	●	●	●	●	●				
		VBMT 160404 - MF	0.4	0.05 - 0.20	0.20 - 2.0						○					●	●	●	●	●	●				
		VBMT 160408 - MF	0.8	0.07 - 0.27	0.30 - 2.0											●	●	●	●	●	●				
-MM	 Stainless steel Medium	VBMT 110304 - MM	0.4	0.06 - 0.18	0.25 - 2.2											●	●								
		VBMT 110308 - MM	0.8	0.07 - 0.23	0.5 - 2.2											●	●								
		VBMT 160404 - MM	0.4	0.07 - 0.21	0.25 - 2.7											●	●	●	●	●	●				
		VBMT 160408 - MM	0.8	0.08 - 0.27	0.50 - 2.7											●	●	●	●	●	●				
																●	●	●	●	●	●				
-PF	 Cermet Medium	VBMT 110304 - PF	0.4	0.05 - 0.20	0.1 - 1.7						●			●							●	○			
		VBMT 110308 - PF	0.8	0.07 - 0.23	0.3 - 1.7						●			●											
		VBMT 160402 - PF	0.2	0.04 - 0.15	0.10 - 2.0						●			●							●	○			
		VBMT 160404 - PF	0.4	0.05 - 0.20	0.20 - 2.0						●			●							●	○			
		VBMT 160408 - PF	0.8	0.07 - 0.27	0.30 - 2.0						●			●							●	○			
-PM	 Cermet Medium	VBMT 110304 - PM	0.4	0.06 - 0.18	0.25 - 2.2						●			●											
		VBMT 110308 - PM	0.8	0.07 - 0.23	0.5 - 2.2						●			●							●	○			
		VBMT 160404 - PM	0.4	0.07 - 0.21	0.25 - 2.7						●			●							●	○			
		VBMT 160408 - PM	0.8	0.08 - 0.27	0.50 - 2.7						●			●							●	○			
											●			●							●	○			

Turning Inserts - Positive

VCGT / VCMT (35° Rhombic)

Refer to
Turning holder
p. 112, 136



Series	IC	S
VC** 1103	6.350	3.18
VC** 1604	9.525	4.76

EDP 2200..

● : Stock item ○ : Order made item

					K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20	
VCGT VCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10	
-AL  Aluminum	VCGT 110301 - AL	0.1	0.02-0.15	0.05-3.0																			●	●	
	VCGT 110302 - AL	0.2	0.02-0.20	0.05-3.0																				●	●
	VCGT 110304 - AL	0.4	0.02-0.25	0.10-4.0																				●	●
	VCGT 160402 - AL	0.2	0.02-0.30	0.05-5.0																				●	●
	VCGT 160404 - AL	0.4	0.03-0.40	0.10-5.0																				●	●
	VCGT 160408 - AL	0.8	0.03-0.50	0.10-5.0																				●	●
	VCGT 160412 - AL	1.2	0.03-0.50	0.10-5.0																				●	●
-SF  HRSA Finishing	VCGT 110301 - SF	0.1	0.01-0.20	0.1-1.5															●	●					
	VCGT 110302 - SF	0.2	0.02-0.20	0.1-1.5														○	○	●	●				
	VCGT 110304 - SF	0.4	0.05-0.20	0.2-1.5																●	●				
	VCGT 110308 - SF	0.8	0.05-0.20	0.4-1.5																●	●				
-UF  Finishing	VCGT 110301 - SF	0.1	0.01-0.20	0.1-1.5															●	●					
	VCGT 110302 - SF	0.2	0.02-0.20	0.1-1.5																●	●				
	VCGT 110304 - SF	0.4	0.05-0.20	0.2-1.5																●	●				
-UF  Finishing	VCMT 160404 - UF	0.4	0.05-0.25	0.5-2.0				○	●	●	●	●													
	VCMT 160408 - UF	0.8	0.05-0.25	1.0-2.0				○	●	●	●	●													
-UG  General	VCMT 160404 - UG	0.4	0.10-0.20	0.3-2.5										○											
	VCMT 160408 - UG	0.8	0.15-0.30	0.8-2.5	●	●	○		●	●	●	●	●	○											

Turning Inserts - Positive

VCMT (35° Rhombic)

Refer to
Turning holder
p. 112, 136

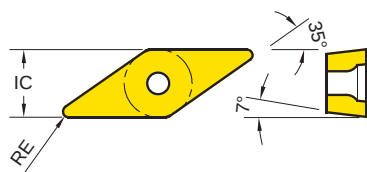
TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION



Series	IC	S
VC** 1103	6.350	3.18
VC** 1604	9.525	4.76

EDP 2200.. ● : Stock item ○ : Order made item

VCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05 K20	K20	P10 K30	P15	P10	P25	P20	P30	P20	M25	M35	M15	M30	M40 S30	S10	P15 M15 K15	P10 M10 K10	N20	N20
					YG1010	YG1001	YG1020	YG3010	YG3015	YG3115	YG3125	YG3020	YG3030	YG801	YG2025	YG2035	YG211	YG213	YG214	YG401	YT100	YT100G	YG100	YG10
-MF  Stainless steel Finishing	VCMT 110304 - MF	0.4	0.05 - 0.20	0.1 - 1.7											●	●	●	●	●	●				
	VCMT 160404 - MF	0.4	0.05 - 0.20	0.2 - 2.0											●	●	●	●	●	●				
	VCMT 160408 - MF	0.8	0.07 - 0.27	0.3 - 2.0											●	●	●	●	●	●				
-MM  Stainless steel Medium	VCMT 110304 - MM	0.4	0.06 - 0.18	0.25 - 2.2											●	●	●	●	●	●				
	VCMT 160404 - MM	0.4	0.07 - 0.21	0.25 - 2.7											●	●	●	●	●	●				
	VCMT 160408 - MM	0.8	0.08 - 0.27	0.5 - 2.7											●	●	●	●	●	●				
-PF  Finishing	VCMT 110304 - PF	0.4	0.05 - 0.20	0.1 - 1.7					●				●							●	○			
	VCMT 160404 - PF	0.4	0.05 - 0.20	0.2 - 2.0					●				●											
	VCMT 160408 - PF	0.8	0.07 - 0.27	0.3 - 2.0					●				●											
-PM  Medium	VCMT 110304 - PM	0.4	0.06 - 0.18	0.25 - 2.2					●				●											
	VCMT 160404 - PM	0.4	0.07 - 0.21	0.25 - 2.7					●				●											
	VCMT 160408 - PM	0.8	0.08 - 0.27	0.5 - 2.7					●				●											