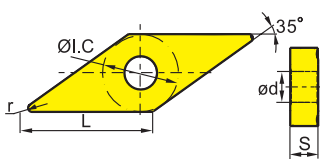


VN ☐ ☐ (Negative inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material

- P** Steel
- M** Stainless steel
- K** Cast iron
- N** Non-ferrous metal
- S** Heat resistant alloy, Ti alloy

[illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool

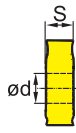
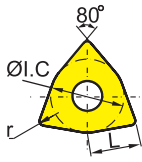
DVVNN
Kr:72°30'



DVJNR/L
Kr:93^o



WN (Negative inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide															Cermet	Coated cermet	Cemented carbide										
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201	
 DF For finishing	WNMG06T304-DF	6.5	9.525	3.97	3.81	0.4	★																											
	WNMG06T308-DF	6.5	9.525	3.97	3.81	0.8	★		★																									
	WNMG06T312-DF	6.5	9.525	3.97	3.81	1.2	★		★																									
	WNMG060404-DF	6.5	9.525	4.76	3.81	0.4	★	●	★											○														
	WNMG060408-DF	6.5	9.525	4.76	3.81	0.8	★	●	★											●														
	WNMG060412-DF	6.5	9.525	4.76	3.81	1.2	★	●	○											○														
	WNMG080404-DF	8.7	12.7	4.76	5.16	0.4	★	●	○											○														
	WNMG080408-DF	8.7	12.7	4.76	5.16	0.8	★	●	★											●														
	WNMG080412-DF	8.7	12.7	4.76	5.16	1.2	○	○	○																									
 WGF For finishing Wiper	WNMG060404-WGF	6.5	9.525	4.76	3.81	0.4	★												★		★													
	WNMG060408-WGF	6.5	9.525	4.76	3.81	0.8	★												★		★													
	WNMG080404-WGF	8.7	12.7	4.76	5.16	0.4	★												★		★													
	WNMG080408-WGF	8.7	12.7	4.76	5.16	0.8	★												★		★													
 SF For finishing	WNMG06T304-SF	6.5	9.525	3.97	3.81	0.4						○														○	★							
	WNMG06T308-SF	6.5	9.525	3.97	3.81	0.8						○														○								
	WNMG06T312-SF	6.5	9.525	3.97	3.81	1.2						○														○								
	WNMG060404-SF	6.5	9.525	4.76	3.81	0.4						○														○	★							
	WNMG060408-SF	6.5	9.525	4.76	3.81	0.8						○														○	★							
	WNMG080404-SF	8.7	12.7	4.76	5.16	0.4						○														○	★							
	WNMG080408-SF	8.7	12.7	4.76	5.16	0.8						○														○	★							
	WNMG080412-SF	8.7	12.7	4.76	5.16	1.2						○														○								

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

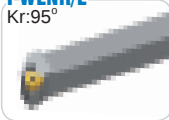
Applicable tool

DWLN/L
Kr:95°



Page A170

PWLN/L
Kr:95°



A182

PWLN/L
Kr:95°



A219

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

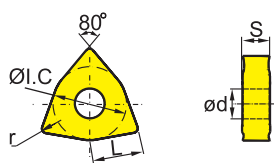
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

WN ☐ ☐ (Negative inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	Color
P Steel	Blue
M Stainless steel	Yellow
K Cast iron	Red
N Non-ferrous metal	Green
S Heat resistant alloy, Ti alloy	Orange

[illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool



Page A170

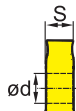
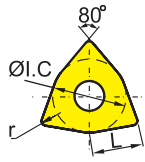


A182



A219

WN (Negative inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

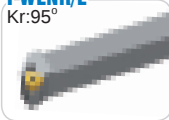
Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																		Cermet	Coated cermet	Cemented carbide							
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201	
 PM For semi-finishing	WNMG060408-PM	6.5	9.525	4.76	3.81	0.8	★	●	○	○													★		★									
	WNMG060412-PM	6.5	9.525	4.76	3.81	1.2	○		○														★		★									
	WNMG080404-PM	8.7	12.7	4.76	5.16	0.4	○	●	○	○																								
	WNMG080408-PM	8.7	12.7	4.76	5.16	0.8	★	●	★	●													★		★	★								
	WNMG080412-PM	8.7	12.7	4.76	5.16	1.2	★	●	★	●													★		★	★								
	WNMG080416-PM	8.7	12.7	4.76	5.16	1.6				○													○		○									
	WNMG080608-PM	8.7	12.7	6.35	5.16	0.8				○																								
 DM For semi-finishing	WNMG06T304-DM	6.5	9.525	3.97	3.81	0.4				○																								
	WNMG06T308-DM	6.5	9.525	3.97	3.81	0.8			○	○																								
	WNMG06T312-DM	6.5	9.525	3.97	3.81	1.2				○																								
	WNMG060408-DM	6.5	9.525	4.76	3.81	0.8	★	●	★	●										●														
	WNMG060412-DM	6.5	9.525	4.76	3.81	1.2			○	○																								
	WNMG080404-DM	8.7	12.7	4.76	5.16	0.4	★	●	★	○				○						○														
	WNMG080408-DM	8.7	12.7	4.76	5.16	0.8	★	●	★	●										○														
	WNMG080412-DM	8.7	12.7	4.76	5.16	1.2	★	●	★											○														
	WNMG080416-DM	8.7	12.7	4.76	5.16	1.6				○																								
 EM For semi-finishing	WNMG06T304-EM	6.5	9.525	3.97	3.81	0.4								○	★					★														
	WNMG06T308-EM	6.5	9.525	3.97	3.81	0.8								○	★					★														
	WNMG06T312-EM	6.5	9.525	3.97	3.81	1.2								○	★					★														
	WNMG060404-EM	6.5	9.525	4.76	3.81	0.4								○	★					★														
	WNMG060408-EM	6.5	9.525	4.76	3.81	0.8								●	★					★														
	WNMG080404-EM	8.7	12.7	4.76	5.16	0.4								●	★					★														
	WNMG080408-EM	8.7	12.7	4.76	5.16	0.8								●	★					★														
	WNMG080412-EM	8.7	12.7	4.76	5.16	1.2								●	★					★														

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool

DWLNR/L
Kr:95°

Page A170

PWLNR/L
Kr:95°

A182

PWLNR/L
Kr:95°

A219

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

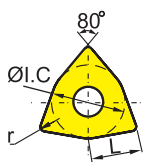
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

WN ☐ ☐ (Negative inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	Color
P Steel	Blue
M Stainless steel	Yellow
K Cast iron	Red
N Non-ferrous metal	Green
S Heat resistant alloy, Ti alloy	Orange

A 10x10 grid of empty squares for drawing.

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide								
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052			YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051
 For semi-finishing	WNMG080408-NM	8.7	12.7	4.76	5.16	0.8							○	★																			○
	WNMG080412-NM	8.7	12.7	4.76	5.16	1.2							○	★																		○	
 For roughing	WNMG060408-DR	6.5	9.525	4.76	3.81	0.8		○	○	○												○											
	WNMG060412-DR	6.5	9.525	4.76	3.81	1.2			○	○	○											○		○									
	WNMG080408-DR	8.7	12.7	4.76	5.16	0.8		○	○	★	○											●		●									
	WNMG080412-DR	8.7	12.7	4.76	5.16	1.2		○	○	★	○											●		●									
	WNMG080416-DR	8.7	12.7	4.76	5.16	1.6					○												○		○								
 Without chipbreaker	WNMA06T308	6.5	9.525	3.97	3.81	0.8															○		○										
	WNMA060404	6.5	9.525	4.76	3.81	0.4																			○								
	WNMA060408	6.5	9.525	4.76	3.81	0.8																★	○	○	○								
	WNMA060412	6.5	9.525	4.76	3.81	1.2																			○								
	WNMA080404	8.7	12.7	4.76	5.16	0.4																		○	○								
	WNMA080408	8.7	12.7	4.76	5.16	0.8																	★	★	●	★							
	WNMA080412	8.7	12.7	4.76	5.16	1.2																	★	★	●	★							
	WNMA080416	8.7	12.7	4.76	5.16	1.6																				★							

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

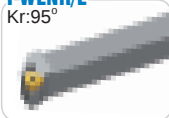
Applicable tool

DWLNR/L
Kr:95⁰



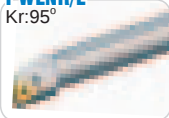
Page A170

PWLNR/L
Kr:95⁰



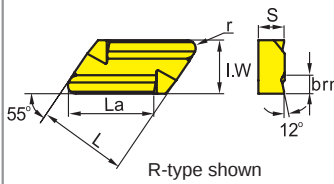
A182

PWLNR/L
Kr:95°



A219

KN (Negative inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)						Coated cemented carbide																Cermet	Coated cermet	Cemented carbide							
		La	L	I.W	S	brn	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101
Profile turning	KNUX160405L11	16	16.15	9.525	4.76	2.2	0.5	○	●	★	○										●									○			
	KNUX160410L11	16	16.15	9.525	4.76	2.2	1.0			●											○									○			
	KNUX160405L12	16	16.15	9.525	4.76	2.2	0.5	○	●												○												
	KNUX160410L12	16	16.15	9.525	4.76	2.2	1.0	○	○	●											○									○			
	KNUX160415L12	16	16.15	9.525	4.76	2.2	1.5				○																						
	KNUX160405R11	16	16.15	9.525	4.76	2.2	0.5	●		●	○	●									●									●			
	KNUX160410R11	16	16.15	9.525	4.76	2.2	1.0	○		●											○									○			
	KNUX160405R12	16	16.15	9.525	4.76	2.2	0.5	●		●											○												
	KNUX160410R12	16	16.15	9.525	4.76	2.2	1.0	○	○	●		○									○									●			
	KNUX160415R12	16	16.15	9.525	4.76	2.2	1.5				○																						

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Note: KNUX160405L11

Chipbreaker code: 11 → Declining chipbreaker 12 → Straight chipbreaker

General turning

Cemented carbide and cermet inserts

Applicable tool

CKJNR/L
Kr:93°

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CKNNR/L
Kr:63°

A201

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

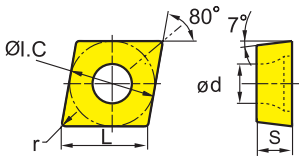
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

CC (Positive inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide									
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201	
USF  For extra finishing	CCGT09T301R-USF	9.7	9.525	3.97	4.4	0.1									○	○																		
	CCGT09T302R-USF	9.7	9.525	3.97	4.4	0.2									●	○																		
	CCGT09T304R-USF	9.7	9.525	3.97	4.4	0.4									○	○																		
USF  For extra finishing	CCGT09T301L-USF	9.7	9.525	3.97	4.4	0.1									○	○																		
	CCGT09T302L-USF	9.7	9.525	3.97	4.4	0.2									●	○																		
	CCGT09T304L-USF	9.7	9.525	3.97	4.4	0.4									○	○																		
SF  For extra finishing	CCGT060202-SF	6.4	6.35	2.38	2.8	0.2							○														○	○						
	CCGT060204-SF	6.4	6.35	2.38	2.8	0.4							○														○	○						
	CCGT09T304-SF	9.7	9.525	3.97	4.4	0.4							○														○	★						
HF  For finishing	CCMT060202-HF	6.4	6.35	2.38	2.8	0.2	★	●	★					●													○							○
	CCMT060204-HF	6.4	6.35	2.38	2.8	0.4	★	●	○	○				●											●	●						●		
	CCMT060208-HF	6.4	6.35	2.38	2.8	0.8	★	●		○				●					○						●	●								
	CCMT09T302-HF	9.7	9.525	3.97	4.4	0.2		●	○					●												●	●							○
	CCMT09T304-HF	9.7	9.525	3.97	4.4	0.4	★	●	★	○				●										●	●	●	●	○						○
	CCMT09T308-HF	9.7	9.525	3.97	4.4	0.8	★	●	○	○				●					○		○	○		○	○	●	●					○	○	
	CCMT120404-HF	12.9	12.7	4.76	5.56	0.4	●	○	●	○															●	○		○						
	CCMT120408-HF	12.9	12.7	4.76	5.56	0.8	○																											

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

General turning

Cemented carbide and cermet inserts

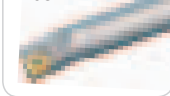
Applicable tool

SCACR/L
Kr:90°

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SCLCR/L
Kr:95°

A184

SCLCR/L
Kr:95°

A220

SCFCR
Kr:90°

A234

SCLCR
Kr:95°

A235

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

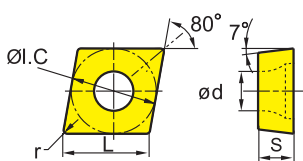
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

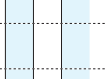
CC (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

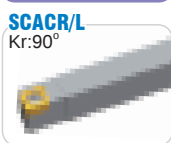
Workpiece material	Color
P Steel	Blue
M Stainless steel	Yellow
K Cast iron	Red
N Non-ferrous metal	Green
S Heat resistant alloy, Ti alloy	Orange

A 10x10 grid of empty squares, intended for drawing a picture.

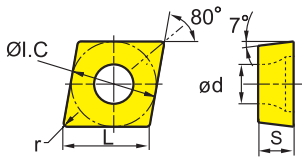
Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide								
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052			YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051
EF  For finishing	CCMT060202-EF	6.4	6.35	2.38	2.8	0.2							○	●	★			★															
	CCMT060204-EF	6.4	6.35	2.38	2.8	0.4							○	●	★			★															
	CCMT09T302-EF	9.7	9.525	3.97	4.4	0.2							○	●	★			★															
	CCMT09T304-EF	9.7	9.525	3.97	4.4	0.4							○	●	★			★															
	CCMT09T308-EF	9.7	9.525	3.97	4.4	0.8							○	●	★			○															
	CCMT120404-EF	12.9	12.7	4.76	5.56	0.4							○	●	★			★															
	CCMT120408-EF	12.9	12.7	4.76	5.56	0.8							○	●	★			○															
HM  For semi-finishing	CCMT060204-HM	6.4	6.35	2.38	2.8	0.4		★	●	★	○			●					●			●	●										●
	CCMT060208-HM	6.4	6.35	2.38	2.8	0.8		★	●	○	○			●					○			○		●									
	CCMT09T304-HM	9.7	9.525	3.97	4.4	0.4	●	★	●	★	●			●					●			●		●									
	CCMT09T308-HM	9.7	9.525	3.97	4.4	0.8		★	●	★	●			●					●			●		●		●							
	CCMT120404-HM	12.9	12.7	4.76	5.56	0.4		★	●	○	○									○			○		○								
	CCMT120408-HM	12.9	12.7	4.76	5.56	0.8		★	●	★	●			○					●			●		●		●							
	CCMT120412-HM	12.9	12.7	4.76	5.56	1.2		○	○														○										
EM  For semi-finishing	CCMT060204-EM	6.4	6.35	2.38	2.8	0.4								●	★				★														
	CCMT060208-EM	6.4	6.35	2.38	2.8	0.8									●	★				★													
	CCMT09T304-EM	9.7	9.525	3.97	4.4	0.4									●	★				★													
	CCMT09T308-EM	9.7	9.525	3.97	4.4	0.8									●	★				★													
	CCMT120404-EM	12.9	12.7	4.76	5.56	0.4									●	★				★													
	CCMT120408-EM	12.9	12.7	4.76	5.56	0.8									●	★				★													
	CCMT120412-EM	12.9	12.7	4.76	5.56	1.2									●	★				★													

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool



CC (Positive inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																	Cermet	Coated cermet	Cemented carbide								
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201	
HR  For roughing	CCMT060204-HR	6.4	6.35	2.38	2.8	0.4		○	●	○	○			○																				
	CCMT060208-HR	6.4	6.35	2.38	2.8	0.8		○	●		●									●						●								
	CCMT09T304-HR	9.7	9.525	3.97	4.4	0.4			●		○				○																			
	CCMT09T308-HR	9.7	9.525	3.97	4.4	0.8		★	●	★	●									●		●	●			●					○		●	
	CCMT120408-HR	12.9	12.7	4.76	5.56	0.8		★	●		●				○					●		●	●	●	●	●					○		●	●
	CCMT120412-HR	12.9	12.7	4.76	5.56	1.2		○	●		●									○				●		○								
LC  For AI machining	CCGX060202-LC	6.4	6.35	2.38	2.8	0.2																											★	
	CCGX060204-LC	6.4	6.35	2.38	2.8	0.4																											★	
	CCGX09T302-LC	9.7	9.525	3.97	4.4	0.2																											★	
	CCGX09T304-LC	9.7	9.525	3.97	4.4	0.4																											★	
	CCGX09T308-LC	9.7	9.525	3.97	4.4	0.8																											★	
	CCGX120404-LC	12.9	12.7	4.76	5.5	0.4																											★	
	CCGX120408-LC	12.9	12.7	4.76	5.5	0.8																											★	
LH  For AI machining	CCGX060202-LH	6.4	6.35	2.38	2.8	0.2																										★		
	CCGX060204-LH	6.4	6.35	2.38	2.8	0.4																										★	●	
	CCGX060208-LH	6.4	6.35	2.38	2.8	0.8																										★		
	CCGX09T302-LH	9.7	9.525	3.97	4.4	0.2																										★		

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool

SCACR/L
Kr:90°

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SCLCR/L
Kr:95°

A184

SCLCR/L
Kr:95°

A220

SCFCR
Kr:90°

A234

SCLCR
Kr:95°

A235



Insert code key

A48-A49

Grade selection reference

A19/A34-A46

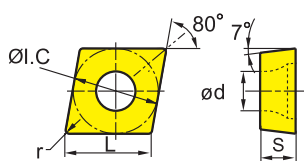
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

CC (Positive inserts)



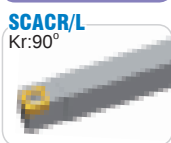
😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	Color
P Steel	Blue
M Stainless steel	Yellow
K Cast iron	Red
N Non-ferrous metal	Green
S Heat resistant alloy, Ti alloy	Orange

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermel	Coated cermel	Cemented carbide								
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052			YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051
LH  For AI machining	CCGX09T304-LH	9.7	9.525	3.97	4.4	0.4																										★	●
	CCGX09T308-LH	9.7	9.525	3.97	4.4	0.8																										★	
	CCGX120402-LH	12.9	12.7	4.76	5.56	0.2																											○
	CCGX120404-LH	12.9	12.7	4.76	5.56	0.4																										★	
	CCGX120408-LH	12.9	12.7	4.76	5.56	0.8																										★	
	CCGX120412-LH	12.9	12.7	4.76	5.56	1.2																											○
Without chipbreaker 	CCMW060204	6.4	6.35	2.38	2.8	0.4																						○	○	○	●		
	CCMW09T304	9.7	9.525	3.97	4.4	0.4																						○				●	●
	CCMW09T308	9.7	9.525	3.97	4.4	0.8	○																							○	○		
	CCMW120404	12.9	12.7	4.76	5.56	0.4																											●
	CCMW120408	12.9	12.7	4.76	5.56	0.8																						○			●	○	

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool



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A184



A220

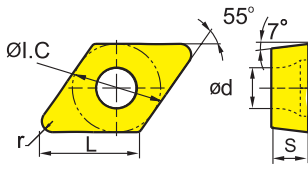


A234



A235

DC (Positive inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide															Cermet	Coated cermet	Cemented carbide									
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
 For extra finishing	DCGT0702005R-USF	7.8	6.35	2.38	2.8	0.05									●	○																	
	DCGT070201R-USF	7.8	6.35	2.38	2.8	0.1									●	○																	
	DCGT070202R-USF	7.8	6.35	2.38	2.8	0.2									●	○																	
	DCGT11T301R-USF	11.6	9.525	3.97	4.4	0.1										○	○																
	DCGT11T302R-USF	11.6	9.525	3.97	4.4	0.2										●	○																
 For extra finishing	DCGT0702005L-USF	7.8	6.35	2.38	2.8	0.05										○	○																
	DCGT070201L-USF	7.8	6.35	2.38	2.8	0.1										○	○																
	DCGT070202L-USF	7.8	6.35	2.38	2.8	0.2										●	○																
	DCGT11T301L-USF	11.6	9.525	3.97	4.4	0.1											○	○															
	DCGT11T302L-USF	11.6	9.525	3.97	4.4	0.2											●	○															
 For extra finishing	DCGT070202-SF	7.8	6.35	2.38	2.8	0.2							○														○						
	DCGT070204-SF	7.8	6.35	2.38	2.8	0.4							○															○					
	DCGT070208-SF	7.8	6.35	2.38	2.8	0.8							○																				
	DCGT11T302-SF	11.6	9.525	3.97	4.4	0.2							○														○	○					
	DCGT11T304-SF	11.6	9.525	3.97	4.4	0.4							○															★					
	DCGT11T308-SF	11.6	9.525	3.97	4.4	0.8							○															○	○				
 For finishing	DCMT070202-HF	7.8	6.35	2.38	2.8	0.2	★	●	○						○												○						
	DCMT070204-HF	7.8	6.35	2.38	2.8	0.4	★	●	★	○					●										○		○				●		
	DCMT070208-HF	7.8	6.35	2.38	2.8	0.8	○	○		○																							
	DCMT11T302-HF	11.6	9.525	3.97	4.4	0.2	★	●	○						●												○						○
	DCMT11T304-HF	11.6	9.525	3.97	4.4	0.4	★	●	★	○					●									○	○		●	○					○
	DCMT11T308-HF	11.6	9.525	3.97	4.4	0.8	★	●	○						○												○						

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool

SDACR/L
Kr:90°

Page A185

SDJCR/L
Kr:93°

A186

SDNCN
Kr:62°30'

A187

SDQCR/L
Kr:107°30'

A221

SDUCR/L
Kr:93°

A222

SDZCR/L
Kr:95°

A223

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

Chipbreaker selection reference

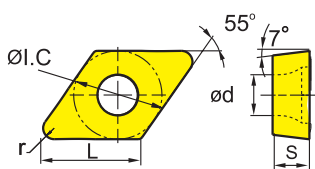
A22-A33

Recommended cutting parameters

A243-A245

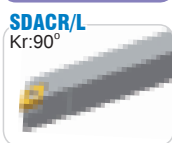
DC ☐ ☐ (Positive inserts)

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

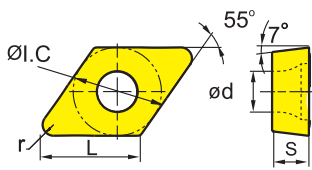
[illegible][illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool



DC (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

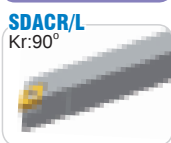
Workpiece material	Color
P Steel	Blue
M Stainless steel	Yellow
K Cast iron	Red
N Non-ferrous metal	Green
S Heat resistant alloy, Ti alloy	Orange

[illegible]

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide															Cermet	Coated cermet	Cemented carbide									
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
HR  For roughing	DCMT11T304-HR	11.6	9.525	3.97	4.4	0.4	○	●	○	○									○			○		●									
	DCMT11T308-HR	11.6	9.525	3.97	4.4	0.8	●	●	★	○									○		○	●		●						○			
	DCMT11T312-HR	11.6	9.525	3.97	4.4	1.2	○	●																									
LC  For AI machining	DCGX070201-LC	7.8	6.35	2.38	2.8	0.1																										★	
	DCGX070202-LC	7.8	6.35	2.38	2.8	0.2																										★	
	DCGX070204-LC	7.8	6.35	2.38	2.8	0.4																										★	
	DCGX11T304-LC	11.6	9.525	3.97	4.4	0.4																										★	
	DCGX11T308-LC	11.6	9.525	3.97	4.4	0.8																										★	
LH  For AI machining	DCGX070202-LH	7.8	6.35	2.38	2.8	0.2																										★	
	DCGX070204-LH	7.8	6.35	2.38	2.8	0.4																										★	○
	DCGX11T302-LH	11.6	9.525	3.97	4.4	0.2																										★	○
	DCGX11T304-LH	11.6	9.525	3.97	4.4	0.4																										★	●
	DCGX11T308-LH	11.6	9.525	3.97	4.4	0.8																										★	
Without chipbreaker	DCMW070204	7.8	6.35	2.38	2.8	0.4																	○										
	DCMW11T304	11.6	9.525	3.97	4.4	0.4																		●				○			●		
	DCMW11T308	11.6	9.525	3.97	4.4	0.8																		○				○		●			

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool



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A187



A221



A222



A223

Insert code key

A48–A49

Grade selection reference

A19/A34–A46

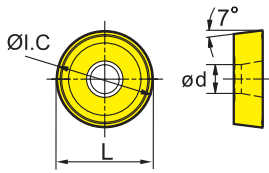
Chipbreaker selection reference

A22–A33

Recommended cutting parameters

A243–A245

RC ☐ ☐ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

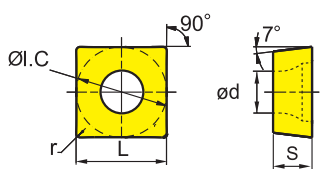
[illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

General turning

Cemented carbide and cermet inserts

SC ☐ ☐ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	Color
P Steel	Blue
M Stainless steel	Yellow
K Cast iron	Red
N Non-ferrous metal	Green
S Heat resistant alloy, Ti alloy	Orange

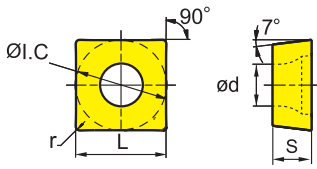
[illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool



SC ☐ ☐ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

[illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool



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A193



A194



A194



A224

Insert code key

A48–A49

Grade selection reference

A19/A34-A46

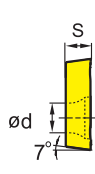
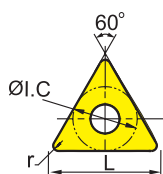
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243–A245

TC ☐ ☐ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

[illegible][illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

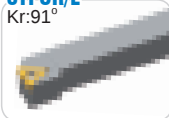
Applicable tool

STACR/L
Kr:90°



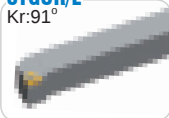
Page A195

STFCR/L
Kr:91⁰



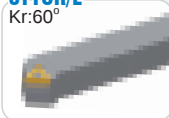
A195

STGCR/L
Kr:91°



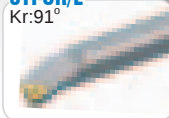
A196

STTCR/L
Kr:60°



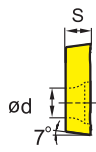
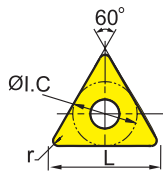
A197

STFCR/L
Kr:91^o



A225

TC (Positive inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide									
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201	
HF  For finishing	TCMT06T104-HF	6.4	3.97	1.98	2.2	0.4	○																											
	TCMT06T108-HF	6.4	3.97	1.98	2.2	0.8	○																											
	TCMT090202-HF	9.6	5.56	2.38	2.5	0.2	★	●												○							○					○		
	TCMT090204-HF	9.6	5.56	2.38	2.5	0.4	★	●																			●		○					
	TCMT090208-HF	9.6	5.56	2.38	2.5	0.8		○																	○									
	TCMT110202-HF	11	6.35	2.38	2.8	0.2			●						●						○													
	TCMT110204-HF	11	6.35	2.38	2.8	0.4	●	★	●	★										●					●	○								
	TCMT110208-HF	11	6.35	2.38	2.8	0.8	○	●	○						●					○			○									○		
	TCMT16T302-HF	16.5	9.525	3.97	4.4	0.2	○																											
	TCMT16T304-HF	16.5	9.525	3.97	4.4	0.4	●	●							○											●	●							
	TCMT16T308-HF	16.5	9.525	3.97	4.4	0.8	○	●																			○						○	

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

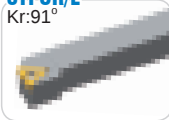
General turning

Cemented carbide and cermet inserts

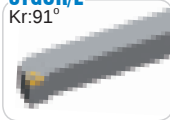
Applicable tool

STACR/L
Kr:90°

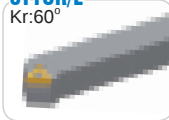
Page A195

STGCR/L
Kr:91°

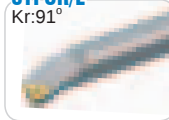
A195

STGCR/L
Kr:91°

A196

STTCR/L
Kr:60°

A197

STFCR/L
Kr:91°

A225

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

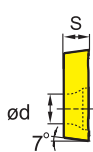
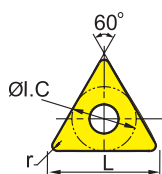
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

TC ☐ ☐ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	Tool
P Steel	High speed steel
M Stainless steel	Coated carbide
K Cast iron	Coated carbide
N Non-ferrous metal	Aluminum nitride coated carbide
S Heat resistant alloy, Ti alloy	Cubic boron nitride coated carbide

[illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

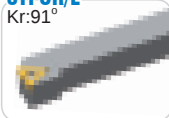
Applicable tool

STACR/L
Kr:90°



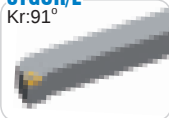
Page A195

STFCR/L
Kr:91⁰



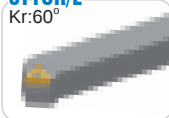
A195

STGCR/L
Kr:91°



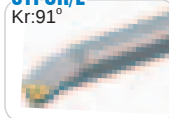
A196

STTCR/L
Kr:60°



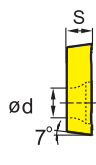
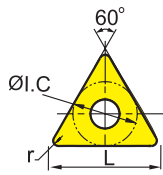
A197

STFCR/L
Kr:91°



A225

TC (Positive inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide															Cermet	Coated cermet	Cemented carbide									
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
 For semi-finishing	TCMT090204-HM	9.6	5.56	2.38	2.5	0.4	★	●		○										○					●								
	TCMT090208-HM	9.6	5.56	2.38	2.5	0.8	○	●		○																							
	TCMT110204-HM	11	6.35	2.38	2.8	0.4	★	●		○	○			●						●			●		●		○						
	TCMT110208-HM	11	6.35	2.38	2.8	0.8	★	●		○															●								
	TCMT16T304-HM	16.5	9.525	3.97	4.4	0.4	★	●	★	●										●			○		●								
	TCMT16T308-HM	16.5	9.525	3.97	4.4	0.8	★	●	★	●										●				●		●					○		
	TCMT16T312-HM	16.5	9.525	3.97	4.4	1.2			●		●										○												
 For roughing	TCMT090204-HR	9.6	5.56	2.38	2.5	0.4			○																								
	TCMT090208-HR	9.6	5.56	2.38	2.5	0.8																			○							●	
	TCMT110204-HR	11	6.35	2.38	2.8	0.4			○																								
	TCMT110208-HR	11	6.35	2.38	2.8	0.8			○																								
	TCMT16T304-HR	16.5	9.525	3.97	4.4	0.4	○	●																									
	TCMT16T308-HR	16.5	9.525	3.97	4.4	0.8	●	●		●														●		●							
	TCMT16T312-HR	16.5	9.525	3.97	4.4	1.2	○	●																●		●						○	
	TCMT220408-HR	22	12.7	4.76	5.5	0.8	○	●		○										●													
 For Al machining	TCGX090202-LC	9.6	5.56	2.38	2.5	0.2																										★	
	TCGX090204-LC	9.6	5.56	2.38	2.5	0.4																										★	
	TCGX110202-LC	11	6.35	2.38	2.8	0.2																										★	
	TCGX110204-LC	11	6.35	2.38	2.8	0.4																										★	
	TCGX110208-LC	11	6.35	2.38	2.8	0.8																										★	
	TCGX16T304-LC	16.5	9.525	3.97	4.4	0.4																										★	
	TCGX16T308-LC	16.5	9.525	3.97	4.4	0.8																										★	

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool

STACR/L
Kr:90°

Page A195

STFCR/L
Kr:91°

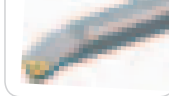
A195

STGCR/L
Kr:91°

A196

STTCR/L
Kr:60°

A197

STFCR/L
Kr:91°

A225

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

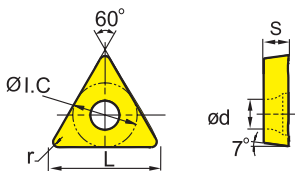
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

TC ☐ ☐ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material

- P** Steel
- M** Stainless steel
- K** Cast iron
- N** Non-ferrous metal
- S** Heat resistant alloy, Ti alloy

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide							
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101
 For AI machining	TCGX090202-LH	9.6	5.56	2.38	2.5	0.2																										★
	TCGX090204-LH	9.6	5.56	2.38	2.5	0.4																										★
	TCGX110202-LH	11	6.35	2.38	2.8	0.2																										★
	TCGX110204-LH	11	6.35	2.38	2.8	0.4																										★
	TCGX110208-LH	11	6.35	2.38	2.8	0.8																										★
	TCGX16T302-LH	16.5	9.525	3.97	4.4	0.2																										○
	TCGX16T304-LH	16.5	9.525	3.97	4.4	0.4																										★
	TCGX16T308-LH	16.5	9.525	3.97	4.4	0.8																										★
	TCMT220408	22	12.7	4.76	5.5	0.8	○	●															○							○		○
	TCMW110204	11	6.35	2.38	2.8	0.4																		○					○		●	○
	TCMW16T304	16.5	9.525	3.97	4.4	0.4																						○				
	TCMW16T308	16.5	9.525	3.97	4.4	0.8																		○								
	TCMW16T312	16.5	9.525	3.97	4.4	1.2	○																	○								
	TCMW220408	22	12.7	4.76	5.5	0.8	○																		○	○						

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

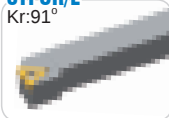
Applicable tool

STACR/L
Kr:90°



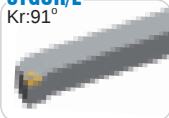
Page A195

STFCR/L
Kr:91⁰



A195

STGCR/L
Kr:91°



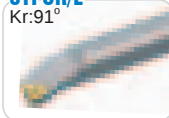
A196

STTCR/L
Kr:60°



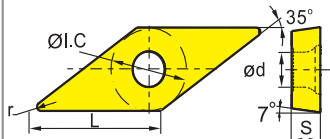
A197

STFCR/L
Kr:91^o



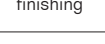
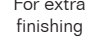
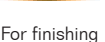
A225

VC□□ (Positive inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition ☹ Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide															Cermet	Coated cermet	Cemented carbide										
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201	
 USF For extra finishing	VCGT080201R-USF	8	4.76	2.38	2.3	0.1									○	○																		
	VCGT080202R-USF	8	4.76	2.38	2.3	0.2									●	○																		
	VCGT110301R-USF	11	6.35	3.18	2.8	0.1									●	○																		
	VCGT110302R-USF	11	6.35	3.18	2.8	0.2									●	○																		
 USF For extra finishing	VCGT080201L-USF	8	4.76	2.38	2.3	0.1									○	○																		
	VCGT080202L-USF	8	4.76	2.38	2.3	0.2									○	○																		
	VCGT110301L-USF	11	6.35	3.18	2.8	0.1									○	○																		
	VCGT110302L-USF	11	6.35	3.18	2.8	0.2									●	○																		
 SF For extra finishing	VCGT110302-SF	11	6.35	3.18	2.8	0.2						○														○	★							
	VCGT110304-SF	11	6.35	3.18	2.8	0.4						○														○	★							
 HF For finishing	VCGT110304-HF	11	6.35	3.18	2.8	0.4		●																										
 NF For finishing	VCGT160408-NF	16.5	9.525	4.76	4.4	0.8						●	★																					

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

General turning

Cemented carbide and cermet inserts

Applicable tool



Page A226

A227

A191

A192

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

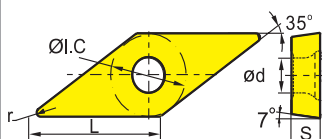
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

VC ☐ ☐ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	
P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

The heatmap consists of a 10x10 grid of smiley faces. The emotions are distributed as follows:

- Row 1:** 10 blue faces (sad).
- Row 2:** 1 yellow face (happy) at column 3, 2 yellow faces (happy) at columns 4 and 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.
- Row 3:** 1 yellow face (happy) at column 3, 1 yellow face (happy) at column 4, 1 yellow face (happy) at column 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.
- Row 4:** 1 yellow face (happy) at column 3, 1 yellow face (happy) at column 4, 1 yellow face (happy) at column 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.
- Row 5:** 1 yellow face (happy) at column 3, 1 yellow face (happy) at column 4, 1 yellow face (happy) at column 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.
- Row 6:** 1 yellow face (happy) at column 3, 1 yellow face (happy) at column 4, 1 yellow face (happy) at column 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.
- Row 7:** 1 yellow face (happy) at column 3, 1 yellow face (happy) at column 4, 1 yellow face (happy) at column 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.
- Row 8:** 1 yellow face (happy) at column 3, 1 yellow face (happy) at column 4, 1 yellow face (happy) at column 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.
- Row 9:** 1 yellow face (happy) at column 3, 1 yellow face (happy) at column 4, 1 yellow face (happy) at column 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.
- Row 10:** 1 yellow face (happy) at column 3, 1 yellow face (happy) at column 4, 1 yellow face (happy) at column 5, 1 yellow face (happy) at column 6, 1 yellow face (happy) at column 7, 1 yellow face (happy) at column 8, 1 yellow face (happy) at column 9, 1 yellow face (happy) at column 10.

[illegible]

★Recommended grade (always stock available)

● Available grade (always stock available)

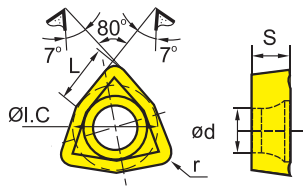
☐ Make-to-order

Applicable tool

SVQCR/L
Kr:107°30'SVUCR/L
Kr:93⁰

SVVCN
Kr:72°30'

SVJCR/L
Kr:93⁰

WC (Positive inserts)

P Steel
M Stainless steel
K Cast iron
N Non-ferrous metal
S Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide															Cermet	Coated cermet	Cemented carbide									
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
53 	WCMX040208R-53	4.3	6.35	2.38	3.1	0.8			●															○									○
	WCMX06T308R-53	6.5	9.525	3.97	3.7	0.8	●		○															○								○	
	WCMX080412R-53	8.7	12.7	4.76	4.3	1.2																						○					

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

General turning

Cemented carbide and cermet inserts



Applicable tool

SWACR/L
Kr:90°



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Insert code key

A48-A49

Grade selection reference

A19/A34-A46

Chipbreaker selection reference

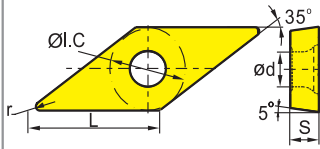
A22-A33

Recommended cutting parameters

A243-A245

A 105

VB (Positive inserts)



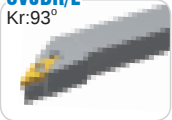
P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide								
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
 For semi-finishing	VBMT110304-EM	11	6.35	3.18	2.8	0.4									●	★				★													
	VBMT110308-EM	11	6.35	3.18	2.8	0.8									●	★				★													
 For semi-finishing	VBMT160404-HM	16.5	9.525	4.76	4.4	0.4	★	●	★	●				●					●		●												○
	VBMT160408-HM	16.5	9.525	4.76	4.4	0.8	★	●	★	●				●					●		●		●										
	VBMT160412-HM	16.5	9.525	4.76	4.4	1.2		●						○					○					○						○		○	
 For roughing	VBMT160404-HR	16.5	9.525	4.76	4.4	0.4	★	●	○	●																							
	VBMT160408-HR	16.5	9.525	4.76	4.4	0.8	○	●	○	●														○									
	VBMT160412-HR	16.5	9.525	4.76	4.4	1.2					○																						
	VBGT160408-HR	16.5	9.525	4.76	4.4	0.8		○																									

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool

SVJBR/L
Kr:93°

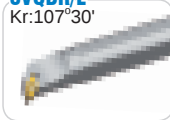
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SVABR/L
Kr:90°

A189

SVVBN
Kr:72°30'

A190

SVQBR/L
Kr:107°30'

A228

SVUBR/L
Kr:93°

A229

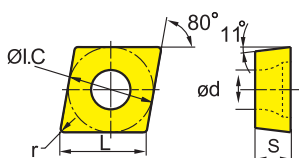
Insert code key
A48-A49

Grade selection reference
A19/A34-A46

Chipbreaker selection reference
A22-A33

Recommended cutting parameters
A243-A245

CP (Positive inserts)



P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide								
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
SF  For extra finishing	CPGT060202-SF	6.4	6.35	2.38	2.8	0.2							○														○						
	CPGT060204-SF	6.4	6.35	2.38	2.8	0.4							○														○						
	CPGT09T304-SF	9.7	9.525	3.97	4.4	0.4							○														○	○					

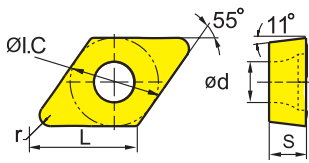
★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Applicable tool

SCLPR/L
Kr:95°



DP ☐ ☐ (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

[illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

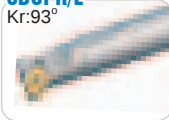
Applicable tool

SDQPR/L
Kr:107°30'



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SDUPR/L
Kr:93⁰



A232

Insert code key

A48–A49

Grade selection reference

A19/A34–A46

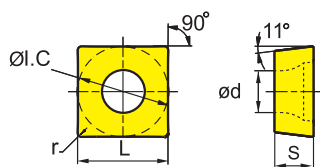
Chipbreaker selection reference

A22–A33

Recommended cutting parameters

A243–A245

SP (Positive inserts)

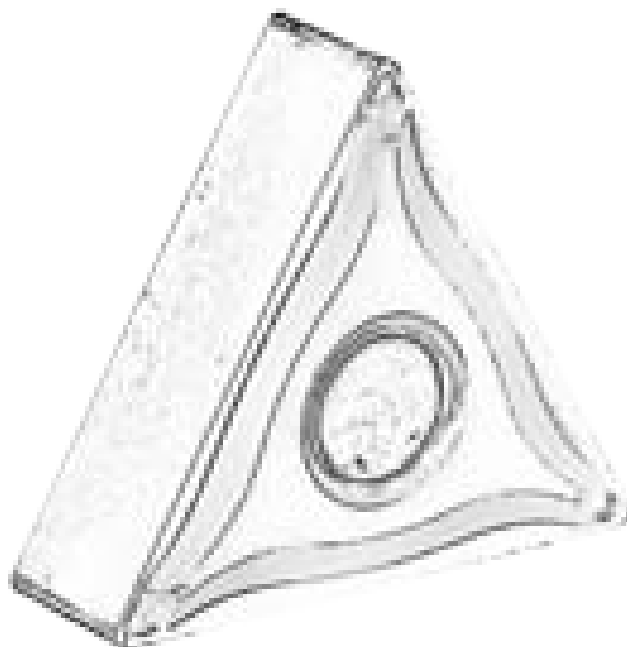


P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy, Ti alloy

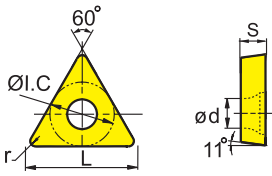
😊 Good working condition 😐 Normal working condition ☹️ Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide								
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
Without chipbreaker 	SPMW09T304	9.525	9.525	3.97	4.4	0.4			○																								
	SPMW09T308	9.525	9.525	3.97	4.4	0.8	●																							●			
	SPMW120408	12.7	12.7	4.76	5.56	0.8																		●								○	

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order



TP (Positive inserts)



P Steel
M Stainless steel
K Cast iron
N Non-ferrous metal
S Heat resistant alloy, Ti alloy

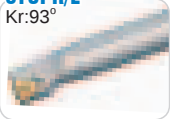
😊 Good working condition 😐 Normal working condition ☹️ Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide									
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201	
 For extra finishing	TPGT090202-SF	9.6	5.56	2.38	2.5	0.2																						○						
	TPGT090204-SF	9.6	5.56	2.38	2.5	0.4																					○	★						
	TPGT090208-SF	9.6	5.56	2.38	2.5	0.8																					○							
	TPGT110302-SF	11	6.35	3.18	2.8	0.2																					○							
	TPGT110304-SF	11	6.35	3.18	2.8	0.4																					○	○						
	TPGT110308-SF	11	6.35	3.18	2.8	0.8																						○						
 For extra finishing	TPGH090202L	9.6	5.56	2.38	2.8	0.2							●														○							
	TPGH090204L	9.6	5.56	2.38	2.8	0.4							●														●							
	TPGH110302L	11	6.35	3.18	3.18	0.2								○													●							
	TPGH110304L	11	6.35	3.18	3.18	0.4							●														●	○						

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

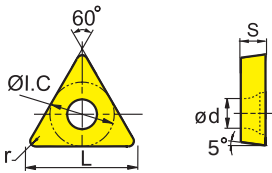
Applicable tool

STUPR/L
Kr:93°



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TB (Positive inserts)



P Steel
M Stainless steel
K Cast iron
N Non-ferrous metal
S Heat resistant alloy, Ti alloy

😊 Good working condition 😐 Normal working condition ☹️ Bad working condition

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet	Coated cermet	Cemented carbide								
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG302	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YC10	YC40	YD051	YD101	YD201
 For extra finishing	TBGH060102L	6.4	3.97	1.59	2.2	0.2						★															★						
	TBGH060104L	6.4	3.97	1.59	2.2	0.4						★																					

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order

Insert code key

A48-A49

Grade selection reference

A19/A34-A46

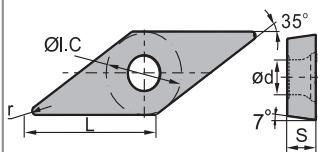
Chipbreaker selection reference

A22-A33

Recommended cutting parameters

A243-A245

VP (Positive inserts)



😊 Good working condition 😐 Normal working condition 😞 Bad working condition

Workpiece material	Color
P Steel	Blue
M Stainless steel	Yellow
K Cast iron	Red
N Non-ferrous metal	Green
S Heat resistant alloy, Ti alloy	Orange

[illegible]

★ Recommended grade (always stock available) ● Available grade (always stock available) ○ Make-to-order