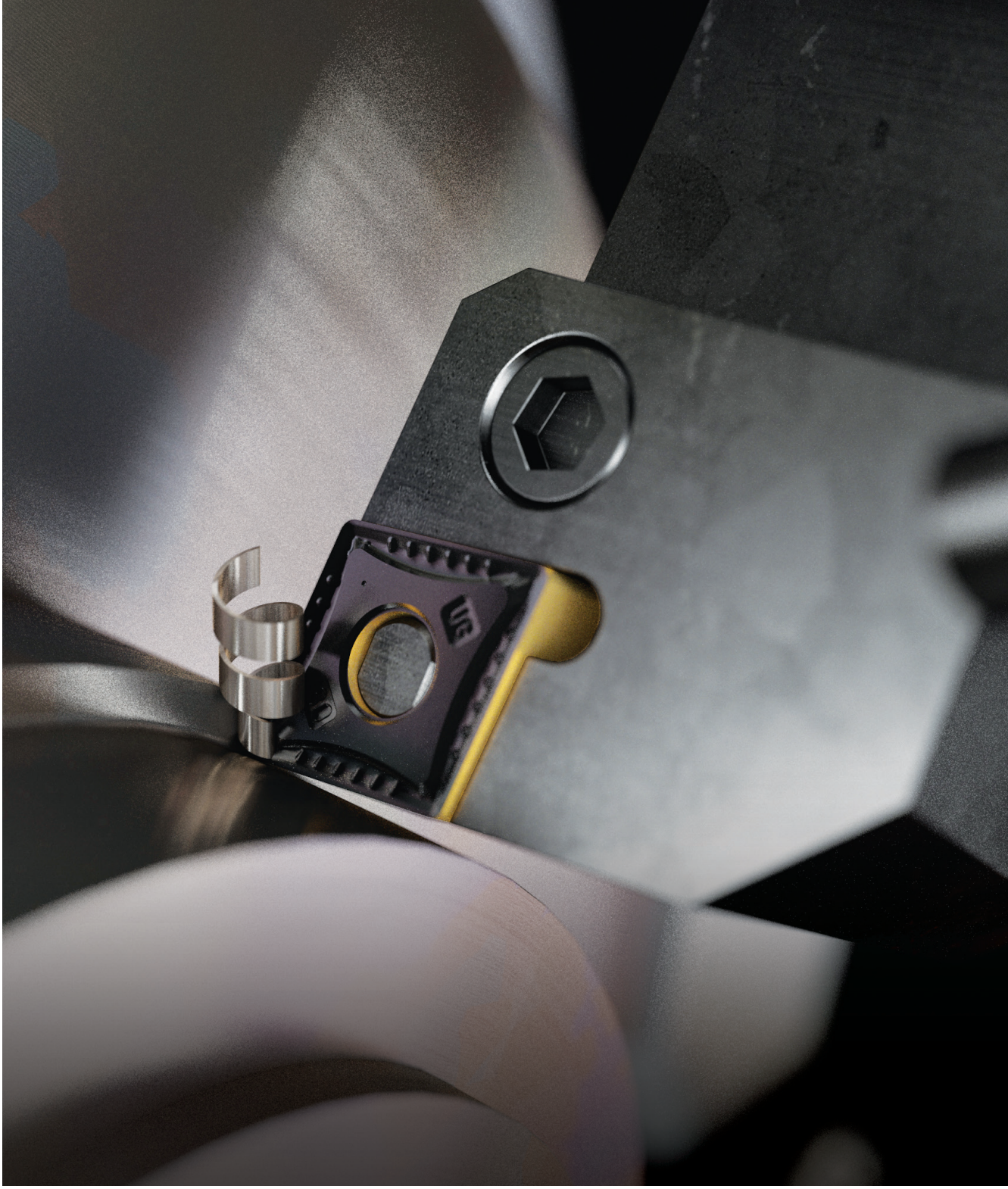


ISO TURNING (ISO 车削)

Product Overview	**产品概况**
Application Guide	**加工指南**
Turning Holders Overview	**车削刀柄概况**
Turning Holders	**车削刀柄**
Turning Inserts Overview	**车削刀片概况**
Turning Inserts	**车削刀片**

Turning - Name Code System

External Turning Holder Code (Metric)

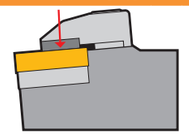
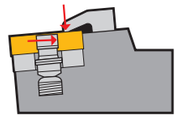
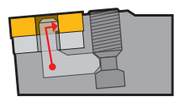
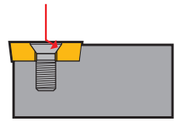
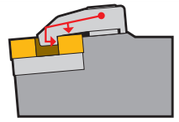
车削 - 编码系统

外圆车削刀柄编码(公制)

*Metric

1	2	3	4	5	6	7	8	9	10
P	**C**	**L**	**N**	**R**	**25**	**25**	**M**	**12**	**(C)**
Clamping System 夹紧系统	Insert Shape (1st Letter of Insert) 刀片形状(刀片的第一个字)	Tool Style 刀柄形式	Insert Clearance (2nd Letter of Insert) 刀片后角(刀片的第二个字)	Tool Hand 切削方向	Shank Height (H) 柄部高度(H)	Shank Width (B) 柄部宽度(B)	Length (LF) 长度(LF)	Insert Size 刀片尺寸	(Optional Clamp) 可选夹紧

1 - Clamping System 夹紧系统

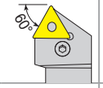
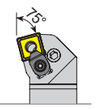
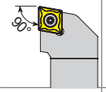
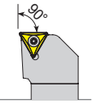
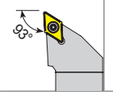
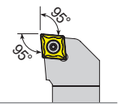
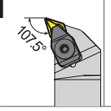
Symbol 代号	System 系统
C	 **Top Clamp 压板夹紧型** (No Clamping Hole Insert) (无夹紧孔)
M	 **Pin & Top Clamp 复合夹紧型** (Straight Clamping Hole Insert) (有直夹紧孔)
P	 **Lever Lock 杠杆夹紧型** (Straight Clamping Hole Insert) (有直夹紧孔)
S	 **Screw 螺钉夹紧型** (Screw Clamping Hole Insert) (有螺纹夹紧孔)
T (D, A)	 **Hole Clamp 双重夹紧型** (Straight Clamping Hole Insert) (有直夹紧孔)

2, 4 — Insert Compatibility * 刀片互换



* Related to Insert Designation to check compatibility
* 刀片型号和刀柄互换有关

3 - Tool Style 刀具形式

Approach Angle 主偏角 (KAPR)	Side Direction 侧向		End Direction 后向
	Straight Shank 直柄	Offset Shank 补偿柄	
45°	D 	S 	
60°		T 	
63°	N 		
72.5°	V 		
75°	B 	K 	
90°	A 	G 	F 
93°		J 	U
95°		L (Both Direction) 	
107.5°		H 	

YGTURN

Turning - Name Code System

External Turning Holder Code (Metric)

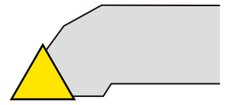
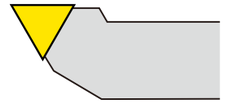
车削 - 编码系统

外圆车削刀柄编码(公制)

*Metric

1	2	3	4	5	6	7	8	9
S	**D**	**J**	**C**	**R**	**20**	**20**	**K**	**11**
Clamping System 夹紧系统	Insert Shape (1st Letter of Insert) 刀片形状(刀片的第一个字)	Tool Style 刀柄形式	Insert Clearance (2nd Letter of Insert) 刀片后角(刀片的第二个字)	Tool Hand 切削方向	Shank Height (H) 柄部高度(H)	Shank Width (B) 柄部宽度(B)	Length (LF) 长度(LF)	Insert Size 刀片尺寸

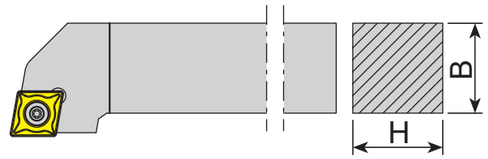
5 - Hand Direction 切削方向

Symbol 代号	Hand Direction 切削方向	
R	Right Hand 右手	
L	Left Hand 左手	
N	Neutral 右，左手	

8 - Length (LF) 长度(LF)

Symbol 代码	Length 长度 (mm)	Symbol 代码	Length 长度 (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) 柄部高度(H) Shank Width (B) 柄部宽度(B)



9 - Insert Size * 刀片尺寸

Examples 例子	is Compatible with… 跟…互换
PCLNR 2525M 12	CNMG 120408
SCLCR 2020K 09	CCMT 09T308
TWLNR 2525M 08	WNMG 080408

* Related to Insert Designation to check compatibility
* 刀片型号和刀柄互换有关

(10 - Optional Clamp) 可选夹紧

Symbol 代号	Optional Clamp 可选夹紧
C	**Included** 包含

Turning - Name Code System

Internal Turning Holder Code (Metric)

车削 - 编码系统

内圆车削刀柄编码(公制)

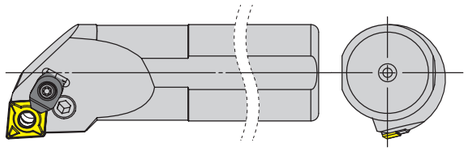
*Metric

1	2	3		4	5	6	7	8	9	10
A	32	S	-	P	W	L	N	R	12	(C)
Coolant & Material 内冷 & 材质	Shank Diameter (DCON) 柄径 (DCON)	Legth (LF) 长度 (LF)		Clamping System 夹紧系统	Insert Shape (1st Letter of Insert) 刀片形状 (刀片的第一个字)	Tool Style 刀柄形式	Insert Clearance (2nd Letter of Insert) 刀片后角 (刀片的第二个字)	Tool Hand 切削方向	Insert Size 刀片尺寸	(Optional Clamp) 可选夹紧

1 - Coolant and Tool Material 内冷和刀柄材质

Symbol 代号	Internal Coolant 内冷	Tool Material 刀柄材质
A	O	**Steel** 钢
S	X	
E	O	**Carbide** 硬质合金

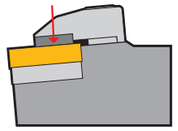
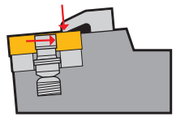
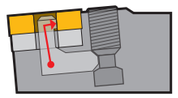
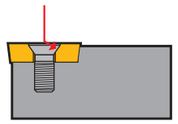
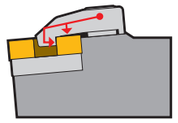
2 - Shank Diameter (DCON) 柄径



3 - Length (LF) 长度(LF)

Symbol 代码	Length 长度 (mm)	Symbol 代码	Length 长度 (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 夹紧系统

Symbol 代号	System 系统
C	 **Top Clamp 压板夹紧型** (No Clamping Hole Insert) (无夹紧孔)
M	 **Pin & Top Clamp 复合夹紧型** (Straight Clamping Hole Insert) (有直夹紧孔)
P	 **Lever Lock 杠杆夹紧型** (Straight Clamping Hole Insert) (有直夹紧孔)
S	 **Screw 螺钉夹紧型** (Screw Clamping Hole Insert) (有螺纹夹紧孔)
T (D, A)	 **Hole Clamp 双重夹紧型** (Straight Clamping Hole Insert) (有直夹紧孔)

YG TURN

Turning - Name Code System

Internal Turning Holder Code (Metric)

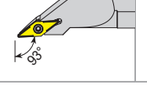
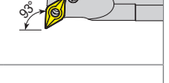
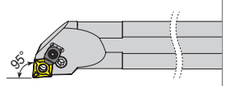
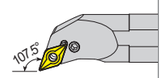
车削 - 编码系统

内圆车削刀柄编码(公制)

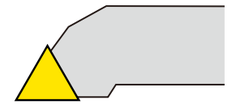
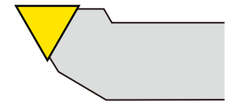
*Metric

1	2	3		4	5	6	7	8	9
A	25	R	-	S	C	L	C	R	09
Coolant & Material 内冷 & 材质	Shank Diameter (DCON) 柄径 (DCON)	Legth (LF) 长度 (LF)		Clamping System 夹紧系统	Insert Shape (1st Letter of Insert) 刀片形状 (刀片的第一个字)	Tool Style 刀柄形式	Insert Clearance (2nd Letter of Insert) 刀片后角 (刀片的第二个字)	Tool Hand 切削方向	Insert Size 刀片尺寸

6 - Tool Style 刀具形式

Approach Angle 主偏角 (KAPR)	Side Direction 侧向	End Direction 后向
	Offset Shank 补偿柄	
75°		K 
90°		F 
93°	J 	U 
95°	L (Both Direction) 	
107.5°		Q 

8 - Hand Direction 切削方向

Symbol 代号	Hand Direction 切削方向	
R	Right Hand 右手	
L	Left Hand 左手	
N	Neutral 右，左手	

9 - Insert Size * 刀片尺寸

Examples 例子	is Compatible with… 跟…互换
PCLNR 2525M **12**	CNMG **120408**
SCLCR 2020K **09**	CCMT **09T308**
TWLNR 2525M **08**	WNMG **080408**

* Related to Insert Designation to check compatibility
* 刀片型号和刀柄互换有关

5, 7 - Insert Compatibility * 刀片互换



* Related to Insert Designation to check compatibility
* 刀片型号和刀柄互换有关

(10 - Optional Clamp) 可选夹紧

Symbol	Optional Clamp
C	**Included**

Insert ISO Code System 刀片ISO编号系统

*Metric : According to ISO 1832

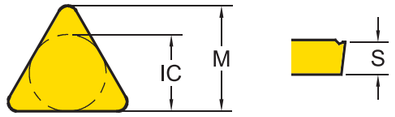
1	2	3	4	5	6	7	8	9
C	N	M	G	12	04	08	-UG	YG3020
Shape 形状	Clearance 后角	Tolerance 公差	Clamping & Chipbreaker 夹持 & 槽型	Insert Size 刀片尺寸	Insert Thickness 刀片厚度	Corner Radius 圆角	Chipbreaker Geometry 槽型	Grade 牌号
							page 14	page 12

1 - Shape 形状

Symbol 代码	Shape 形状	
H	Hexagonal 正六角形	
O	Octagonal 正八角形	
P	Pentagonal 正五边形	
S	Square 正方形	
T	Triangular 正三角形	
C	Rhombic 80° 菱形顶角 80°	
D	Rhombic 55° 菱形顶角 55°	
V	Rhombic 35° 菱形顶角35°	
W	Trigon 桃形	
L	Rectangular 长方形	
K	Parallelogram 55° 平行四边形55°	
R	Round 圆形	

2 - Relief Angle (AN) 后角

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



3 - Tolerance Class 公差等级

Symbol 代码	Inner Circle 内接圆 IC (mm)	Nose Height 高度 M (mm)	Thickness 厚度 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
* 刀片IC尺寸不同公差不同，详见ISO 1832

4 - Clamping & Chipbreaker 夹持 & 槽型

Symbol 代码	Clamping 夹紧	Chipbreaker 槽型	Figure 示意图
N	No clamping hole 无孔	X	
R		One Face 单面	
A	Cylindrical Clamping hole 圆柱孔	X	
M		One Face 单面	
G		Both Faces 双面	
W	Screw Hole 螺纹孔	X	
T		One Face 单面	
U		Both Faces 双面	
X	Special 订制		

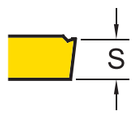
Insert ISO Code System 刀片ISO编号系统

*Inch

1	2	3	4	5	6	7	8	9
C	N	M	G	4	3	2	-UG	YG3020
Shape 形状	Clearance 后角	Tolerance 公差	Clamping & Chipbreaker 夹持 & 槽型	Insert Size 刀片尺寸	Insert Thickness 刀片厚度	Corner Radius 圆角	Chipbreaker Geometry 槽型	Grade 牌号
							page 14	page 12

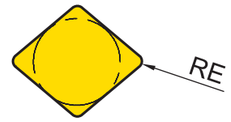
5 - Insert Size 刀片尺寸

Metric 公制							Inner Circle 内接圆 IC (mm)	Inch 英制
S	T	C	D	V	W	R		
06	11	06	07	11			6.35	2
07							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		16					15.875	5
19		19					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) 刀片厚度

Metric 公制	Thickness 厚度 - S (mm)	Inch 英制
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) 圆角

Metric 公制	Corner Radius 圆角 - RE (mm)	Inch 英制
01	0.1	0
02	0.2	0.5
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 材质命名说明

1	2	3	4	5	(6)
YG	**3**	**0**	**2**	**0**	**(G)**
YG Brand 不用翻译	Workpiece Material 工件 材料	Grade Version 材质等级	Application Range (1st Digit) 应用范 围（第一位）	Application Range (2nd Digit) 应用范 围（第二位）	Minor Variation 微小变化
Carbide CVD (4 Digits) 涂层4位编码	●	●	●	●	YG3020
Carbide PVD (3 Digits) 涂层3位编码	●	●	●		YG211
Carbide Uncoated (2 Digits) 无涂层2位编码	●	●			YG10

1 - YG Brand YG品牌

2 - Workpiece Material 工件材料

Symbol 代码	Workpiece Material	Turning 车削	Milling 铣削	Drilling 钻削	Parting 切断
1	K Cast Iron / 铸铁 or N Non-Ferrous / 非铁金属	●			
2	M Stainless Steel / 不锈钢	●			
3	P Steel / 钢	●			
4	S Superalloys / 超耐热合金	●			
5	K Cast Iron / 铸铁 or N Non-Ferrous / 非铁金属		●	●	●
6	M Stainless Steel / 不锈钢 or Universal		●	●	●
7	P Steel / 钢		●	●	●
8	Universal	●			

3 — Grade Version 等级版本

4 & 5 — Application Range 适用范围

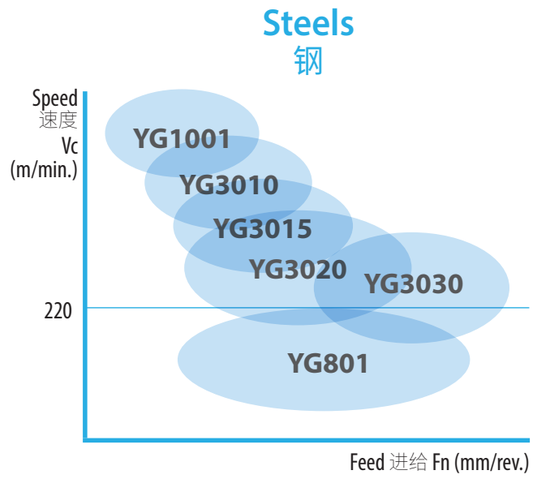
Symbol 代码	
05	Stable 稳定 — Wear Resistant Grade, Stable Application, Continuous Cut, Finishing 高耐磨性适应于稳定工况的连续加工
10	
15	
20	General 普通 — Balanced Grade, High Versatility, General Application 通用性适应于普通工况
25	
30	
35	
40	Unstable 不稳定 — Tougher Grade, Unstable Application, Interrupted Cut, Chipping Resistance, Roughing 高韧性适应于不稳定工况以及断续加工
45	

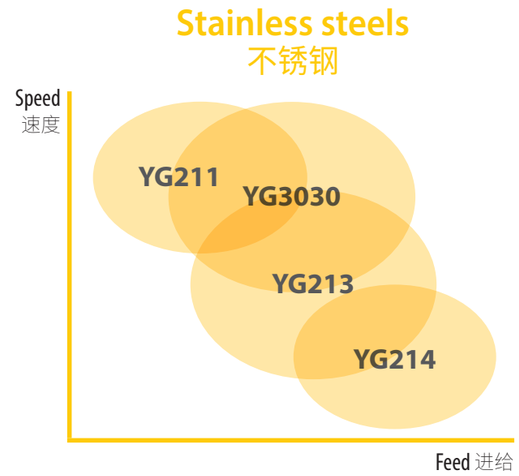
(6) — (Minor Variation) 微小变化

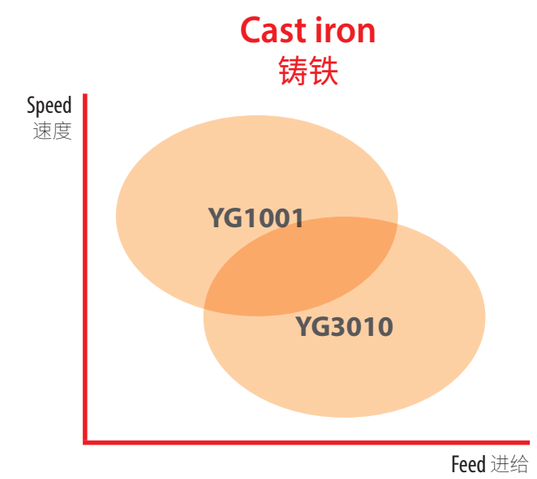
G — Gold Coated Version 金色涂层

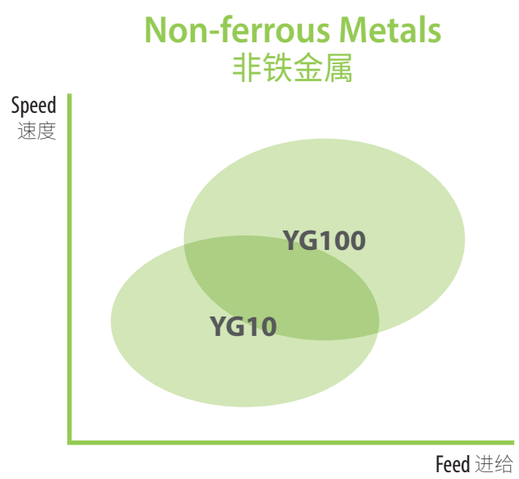
Product Overview 产品概况

Turning Grades Map 车削材质说明



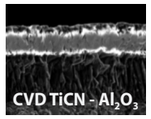






Turning Grades 车削材质		P Steel 钢				M Stainless steel 不锈钢			K Cast iron 铸铁			N Non-ferrous 非铁金属		S Superalloys 超耐热合金	
		P10	P20	P30	P40	M10	M20	M30	K10	K20	K30	N10	N20	S10	S20
CVD	YG1001	1001							1001						
	YG3010	3010							3010						
	YG3015	3015													
	YG3020	3020				3030									
	YG3030	3030													
PVD	YG801	801													
	YG211					211								211	
	YG213						213							213	
	YG214							214							214
DLC	YG100											100			
-	YG10											10			

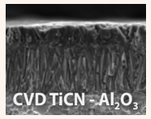
YG1001
P01 - P10
K10 - K25



First choice for stable machining of Cast iron
- Substrate especially designed for high wear resistance
- Thick Al_2O_3 layer ensures good wear resistance at high cutting speeds including dry machining

稳定工况加工铸铁的首选
- 高耐磨基体
- 硬厚的Al_2O_3涂层在高速加工及干切削提高耐磨性

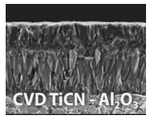
YG3010
P05 - P20
K15 - K35



First choice for Finishing Steels, and Ductile Cast iron
- Finishing and light machining of steel under in stable condition
- New Al_2O_3 coating technology and excellent surface smoothness increase wear resistance and chipping resistance

精加工钢&加工球墨铸铁的首选
- 适用于稳定工况下钢件的精加工
- 新Al_2O_3涂层及卓越表面处理提高耐磨性和抗崩刃性

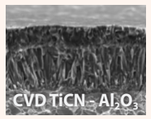
YG3015
P10 - P25



Balanced productivity for Continuous cut
- High wear resistance and improved toughness ensures high productivity with less trouble

适应于稳定工况& 不稳定工况钢件连续加工
- 高耐磨性&高韧性确保不同工况钢件连续加工的生产率

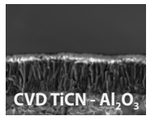
YG3020
P15 - P30



First Choice grade for general Steel application
- Substrate especially designed for good toughness
- Excellent surface smoothness increases wear resistance and reliability

普通工况加工钢件的首先
- 高韧性基体
- 卓越表面处理提高耐磨性和稳定性

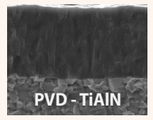
YG3030
P20 - P35
M10 - M30



Interrupted cut of Steel and Stainless steel
- Heavy interrupted cut for Steel
- High cutting speed for Stainless steel

断续加工钢&加工不锈钢用
- 适用于断续加工钢件的工况
- 适用于高速度加工不锈钢的工况

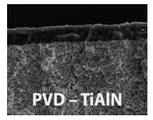
YG801
P10 - P30



for Carbon Steel with Low cutting speed
- Recommended for mild steel and boring application
- Substrate and special PVD coating for excellent wear resistance

低切削速度加工碳钢用
- 推荐用于软钢和镗削加工
- 基体和独特PVD涂层具提高耐磨性

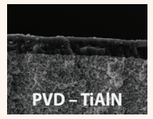
YG211
M05 - M25
S05 - S20



High wear resistance grade for Super alloys and Stainless steel
- Finishing Stainless steel

加工超耐热合金和不锈钢的高耐磨性材质
- 精加工不锈钢

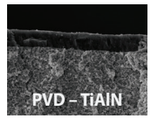
YG213
M20 - M35
S15 - S25



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

低切削速度加工不锈钢的首选
- 低切削速度加工不锈钢的首选
- 从中等切削速度到低切削速度

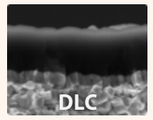
YG214
M30 - M40
S25 - S30



Heavy Interrupted cut for Stainless steel
- For Heavy Interrupted cut on Stainless steel
- Minimize risk of Mechanical fracture or Chipping

断续加工不锈钢用
- 断续加工不锈钢用
- 减少崩刃的可能性

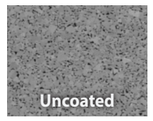
YG100
N05 - N25



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

DLC涂层，铝加工的首选
- 高耐磨的基体
- DLC涂层减少积屑瘤问题
- 加工非铁金属时延长刀具寿命

YG10
N05 - N25



Uncoated Grade for General Aluminum
- Substrate consisted of submicron carbide for high wear resistance
- Shining surface to prevent built up edge

非涂层产品，用于普通铝加工
- 基体采用极细微颗粒的硬质合金提高耐磨性
- 抛光表面处理减少积屑瘤问题

P	M	K	N	S			Feed 0 0.1 0.2 0.3 0.4 0.5 0.6 Fn (mm/rev.)
P					UF	Finishing 精加工	Fn 0.05~0.25; Ap 0.5~2.5
P					UL	Semi Finishing and sticky materials 半精加工&粘性材料	Fn 0.1~0.3; Ap 1~3
P					UM	For Medium & Unstable conditions 普通加工(不稳定工况)	Fn 0.15~0.3; Ap 1~3
P					UG	First Choice for Medium(Stable application) 普通加工的首选(稳定工况)	Fn 0.2~0.4; Ap 1.5~3
P		K			UC	Medium Roughing and First choice for Cast iron 半粗加工&加工铸铁的首选	Fn 0.2~0.4; Ap 1.5~4
P		K			UR	Roughing and Heavy interrupted cut 粗加工&断续加工	Fn 0.3~0.5; Ap 2~5
		K			..MA	Cast iron Heavy Roughing 铸铁重切削	Fn 0.15~0.5; Ap 1~5

Depth of Cut Ap (mm)

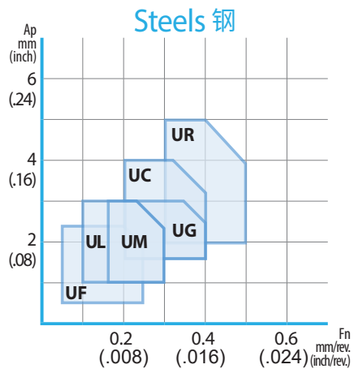
YGTURN

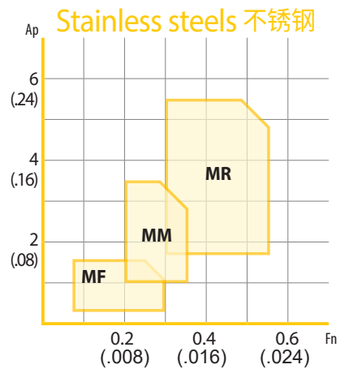
Product Overview
产品概况
Turning Chipbreakers - Negative
车削槽型 - 负角型

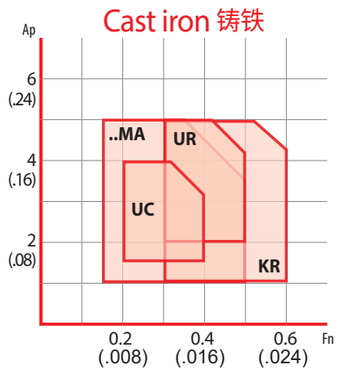
TURNING
PARTING & GROOVING
MILLING
DRILLING
TECHNICAL INFORMATION

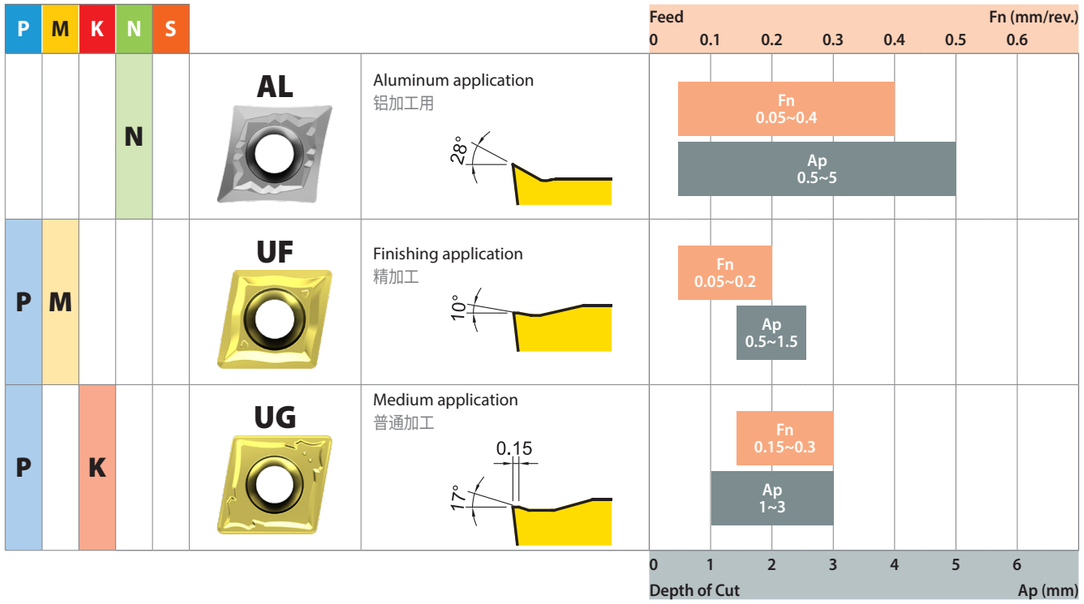
P	M	K	N	S			Feed 0 0.1 0.2 0.3 0.4 0.5 0.6 Fn (mm/rev.)
	M			S	MF	Stainless steel Finishing 精加工不锈钢	Fn 0.07~0.3; Ap 0.2~1.5
P	M			S	MM	Stainless steel Medium and Low Carbon Steel 普通加工不锈钢&碳钢	Fn 0.2~0.35; Ap 1~3.5
	M			S	MR	Roughing for Stainless steel 粗加工不锈钢	Fn 0.3~0.55; Ap 1.8~5.5
		K			KR	Cast Iron Heavy Roughing 铸铁重切削	Fn 0.3~0.6; Ap 1~5

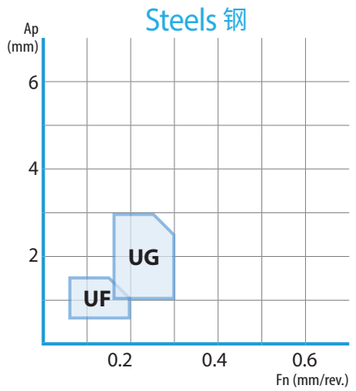
Depth of Cut Ap (mm)

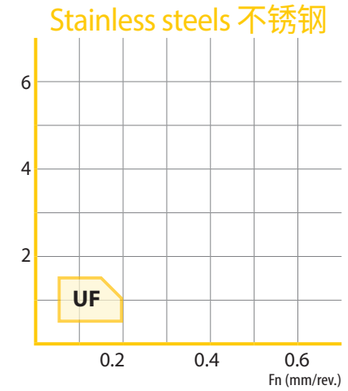


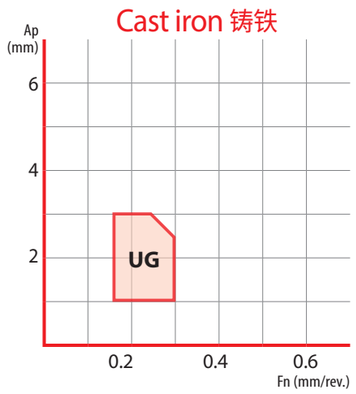


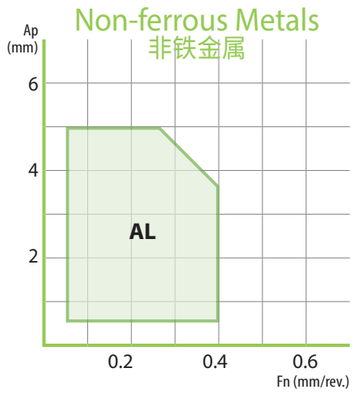






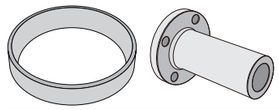






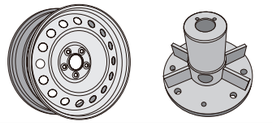
Grade Recommendation based on Workpiece Material Condition
基于工件种类的材质推荐

HARD



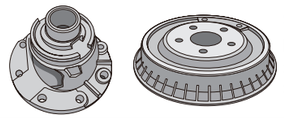
Pre Machined Condition
No Outer Skin
Uniform hardness on material
Has stable machining condition

预先加工工件
无黑皮表面
均匀的材料硬度，稳定工况



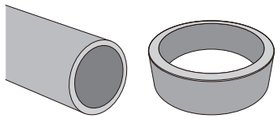
Welded Condition
Soft / NoOuter Skin
Weld Bead Could be of Different Hardness than Actual Part Stock on Part could even except weld Seam during Machining causing shock loads

焊接工件
软/无黑皮表面
焊接部跟其他部位可能不同硬度
加工过程中焊接部有可能带来冲击阻力



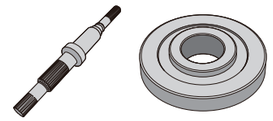
Cast Condition
Hard Outer Skin
Could have Sand Inclusion,- if Green Sand Cast
Component could have uneven Stock during machining

铸造工件
硬黑皮表面
可能会有沙子夹杂物 - 如果含有绿沙铸造组件
加工过程中工件可能存在不均匀的部位



Hot Rolled Condition
Soft / NoOuter Skin
Usually heat treated before machine to reduce Hardness
Component could have uneven Stock During Machining

热轧工件
软/无黑皮表面
通常加工之前进行热处理以降低硬度
加工过程中工件可能存在不均匀的部位



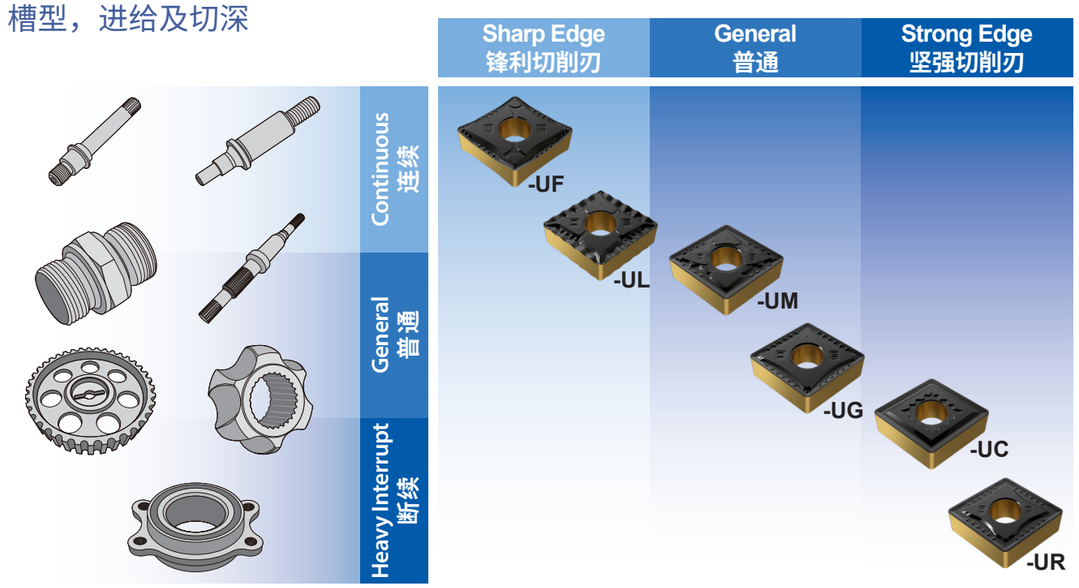
Forged Condition
Soft Outer Skin
Usually heat treated before machine to reduce Hardness
Component could have uneven Stock during machining

锻造工件
软皮表面
通常加工之前进行热处理以降低硬度
加工过程中工件可能存在不均匀的部位

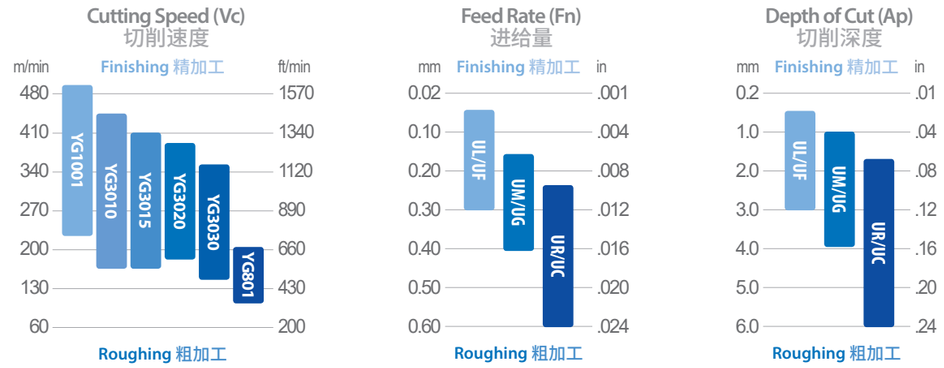
YG3010 YG3020 YG3030

TOUGH

Chipbreaker, Feed Rate and Depth of Cut
槽型，进给及切深



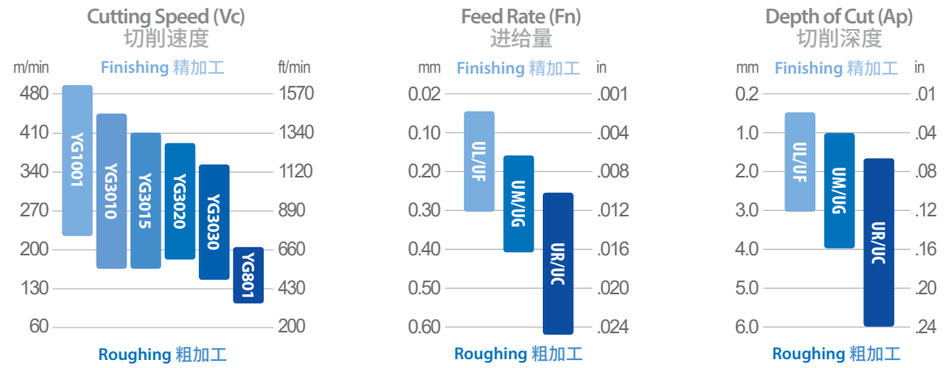
P	Non Alloy Steel, About 0.15% C (Low Carbon Steel) 非合金钢, 大约0.15%碳 (低碳钢)										
VDI	Mat'l No.	JIS	DIN	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST	GB
1	1.0401	S15C	CK15	1015	1350	XC18	C15	F.1110	080M15	15	15



First Choice Grade and Value
首选材质和速度

YG3010 - Vc 330m/min (1,080ft/min)
YG801 - Vc 170m/min (560ft/min)

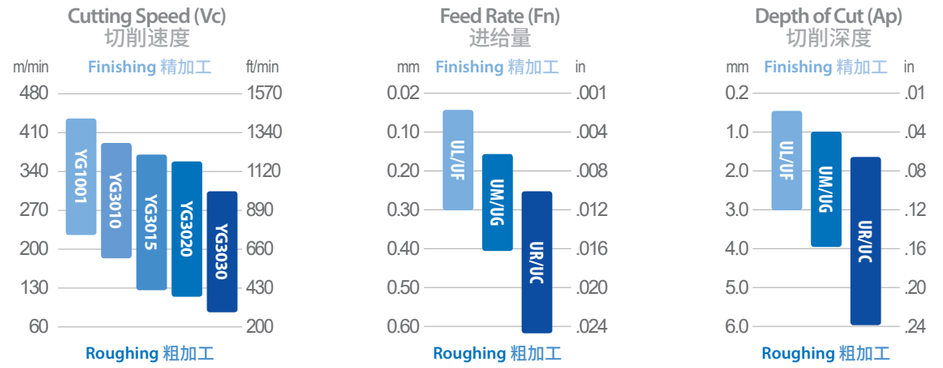
P	Non Alloy Steel, About 0.45% C (Medium Carbon Steel) 非合金钢,大约0.45%碳(普通碳钢)										
VDI	Mat'l No.	JIS	DIN	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST	GB
2~3	1.0503	S45C	C45	1045	1672	XC42H1TS	C45	F.1140	060A47	45	45



First Choice Grade and Value
首选材质和速度

YG3010 - Vc 330m/min (1,080ft/min)
YG801 - Vc 170m/min (560ft/min)

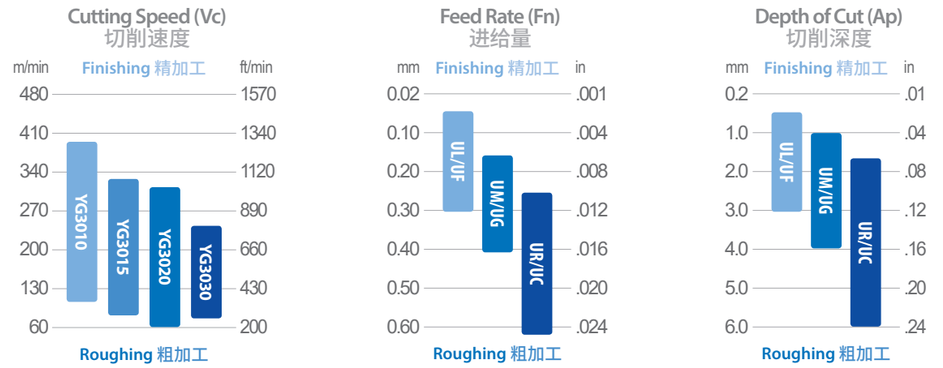
P	Low-alloyed Steel 低合金钢										
VDI	Mat'l No.	JIS	DIN	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST	GB
6~9	1.7225	SCM440	42CrMo4	4140	2244	42 CD 4	42CrMo4	F.1252	708M40	38HM	42CrMo, 42CrMnMo



First Choice Grade and Value
首选材质和速度

YG3020 - Vc 240m/min (790ft/min)

P	High Alloyed Steel, and Tool Steel 高合金钢，工具钢										
VDI	Mat'l No.	JIS	DIN	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST	GB
10~11	1.2379	SKD11	X155CrVMo121	D2	2310	Z160CDV12	X165CrMoW12KU	F.5318	BD2	KH12MF	Cr12MoV

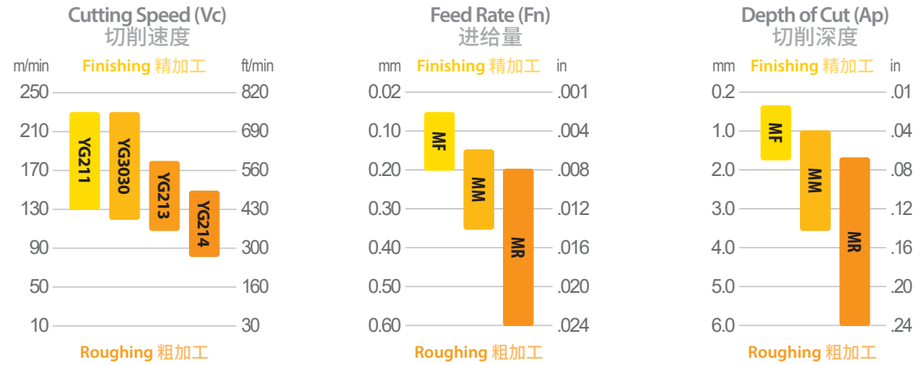


First Choice Grade and Value
首选材质和速度

YG3020 - Vc 230m/min (750ft/min)

Stainless steel Guide
不锈钢指南

M	Ferritic / Martensitic Stainless 铁素体 / 马氏体不锈钢										
VDI	Mat'l No.	JIS	DIN	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST	GB
12~13	1.4016	SUS430	X6Cr17	430	2320	Z8C17	Z8C17	F.3113	430S15	12C17	Cr17

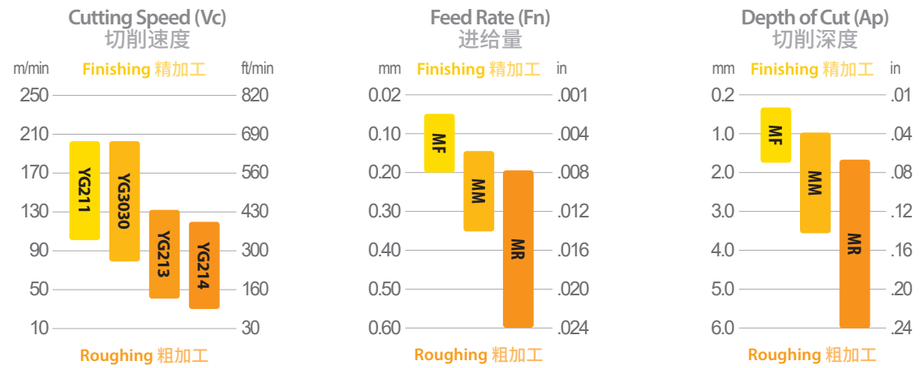


First Choice Grade and Value
首选材质和速度

Ferritic Stainless steel 铁素体不锈钢
YG3030 - Vc 200m/min (660ft/min)
YG213 - Vc 160m/min (520ft/min)

Martensitic 马氏体不锈钢
YG3030 - Vc 160m/min (520ft/min)
YG213 - Vc 130m/min (430ft/min)

M	Austenitic Stainless steel 奥氏体不锈钢										
VDI	Mat'l No.	JIS	DIN	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST	GB
14	1.4350	SUS304	X5CrNi18 9	304	2332	Z6CN18 09	X5CrNi18 10	F.3551	304S15	03KH18N11	OCr18Ni9

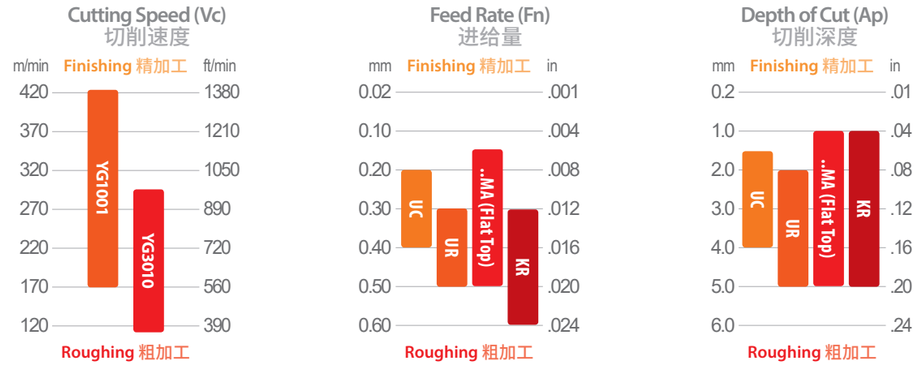


First Choice Grade and Value
首选材质和速度

YG3030 - Vc 180m/min (590ft/min)
YG213 - Vc 140m/min (460ft/min)

Cast iron Guide
铸铁指南

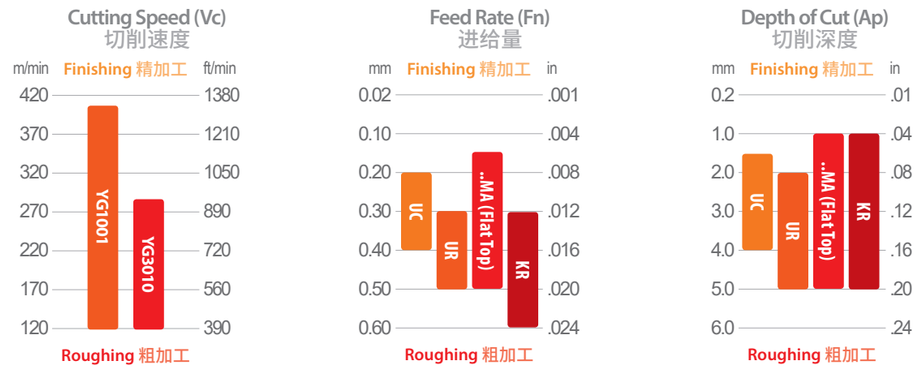
K	Grey cast iron 灰铸铁										
VDI	Mat'l No.	JIS	DIN	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST	GB
15~16	0.6025	FC250	GG25	A48 40 B	0125	Ft 25 D	G25	FG25	Grade 260	Sc 25	HT250



First Choice Grade and Value
首选材质和速度

YG1001 - Vc 350m/min (1,150ft/min)

K	Nodular cast iron 球墨铸铁										
VDI	Mat'l No.	JIS	DIN	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST	GB
17~18	0.7050	FCD500	GGG50	80-55-06	0.7050	FGS 500-7	GS 500-7	FGE50-7	SNG 500-7	Vc 50-2	QT500-7



First Choice Grade and Value
首选材质和速度

YG3010 - Vc 220m/min (720ft/min)

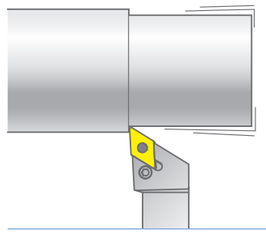
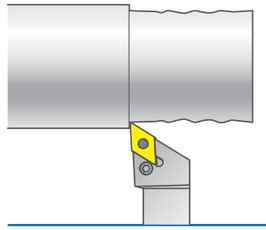
Formulas 公式

Cutting Speed 切削速度 (Vc)	**Metric** 公制 Vc = D × RPM × 0.0031 (m/min.) **Inch** 英制 Vc = D × RPM × .262 (ft/min.) **Metric** 公制 **Vc to Inch** 英制 **Vc** Inch Vc = Metric Vc × 3.28 (ft/min.) **Inch** 英制 **Vc to Metric** 公制 **Vc** Metric Vc = Inch Vc × .305 (m/min.)
Spindle Speed 主轴转速 (RPM)	**Metric** 公制 RPM = Vc × 318.3 ÷ D (rev./min.) **Inch** 英制 RPM = Vc × 3.82 ÷ D (rev./min.)
Feed Rate 进给速度 (Vf = Table Feed 加工进给)	Vf = Fn × RPM (mm/min. or in/min.)
Feed per Revolution 每转进给量 (Fn)	Fn = Vf ÷ RPM (mm/rev. or in/rev.)
Metal Removal Rate 金属切削率 (Q)	**Metric** 公制 Q = Vc × Fn × Ap (cm^3/min.) **Inch** 英制 Q = Vc × Fn × Ap × 12 (in^3/min.)
Cutting Time 切削时间	T = L ÷ Vf (min.)

Terms 术语

RPM (n)	Spindle Speed (Revolution per minute)	主轴转速(每分钟转数)
Vc	Cutting Speed	切削速度
D	Work Diameter	工件直径
Vf	Feed Rate (Table Feed)	进给速度
Fn	Feed per Revolution	每转进给量
Ap	Depth of Cut	切削深度
Q	Metal Removal Rate	金属切削率
L	Length of cut	切削长度
T	Cutting Time (min)	切削时间 (min.)

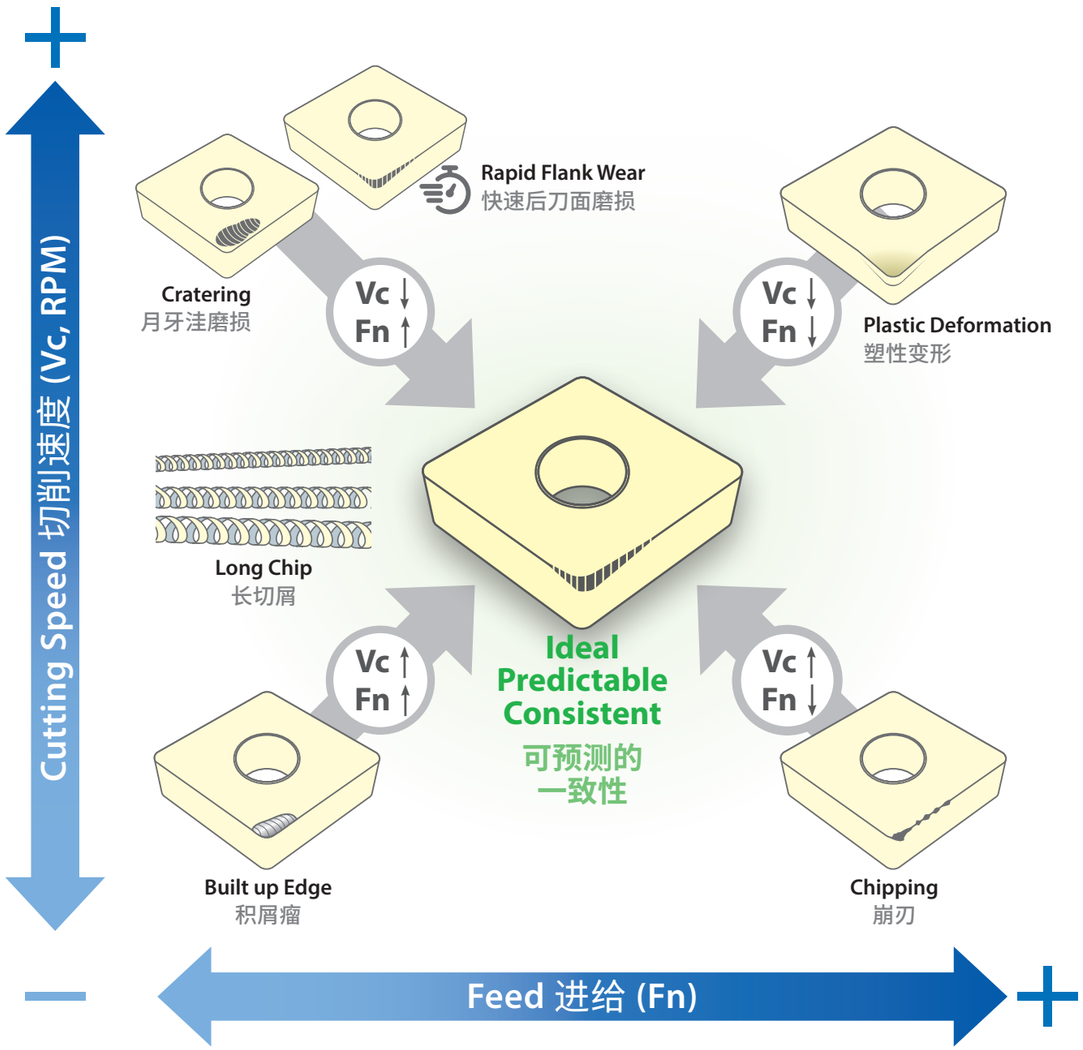
Trouble Shooting 问题解答

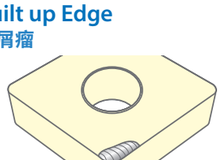
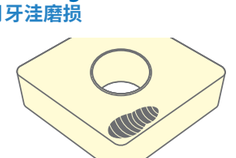
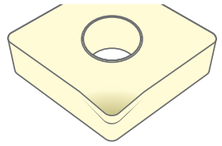
Pattern 问题	Reasons 原因	Solutions 方案
Vibration 振动 	- High radial or tangential force - Unstable condition - 径向或切向的切削阻力过高 - 不稳定工况	- Lower depth of cut (ap) - Use sharper chipbreaker - Check stability, and position of tool and workpiece - Reduce the overhang (bigger and shorter tool) - 降低切深 (Ap) - 选择更锋利的槽型 - 检查刀具，工件的稳定性 - 降低悬伸 (更大和更短的刀具)
Bad Surface 表面质量不良 	- Work material is damaged by chips - Feed is too high for corner radius - 工件被切屑损坏 - 对于选择刀尖半径，进给过高	- Different chipbreaker - Lower depth of cut (ap) - Lower feed - Bigger corner radius - 选择其他槽型 - 降低切深 (Ap) - 降低进给 - 选择更大刀尖半径

Theoretical Surface Roughness 理论上表面粗糙度

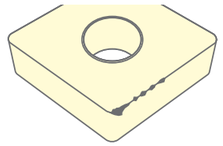
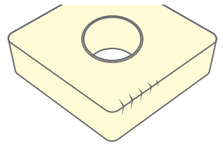
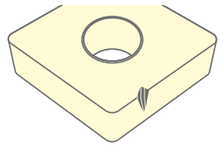
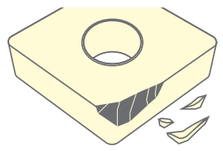
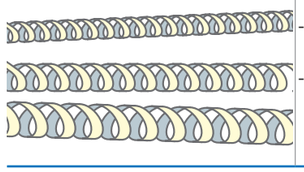
Ra / Rz µm (µ inch)	Insert Corner Radius Code ISO (ANSI) ISO 刀尖半径 (ANSI 刀尖半径)					
	02 (0)	04 (1)	08 (2)	12 (3)	16 (4)	24 (6)
	Feed Rate mm/rev (inch/rev)					
0.4 / 1.6 (16 / 64)	0.05 (.002)	0.07 (.003)	0.1 (.004)	0.12 (.005)	0.14 (.006)	0.18 (.007)
1.6 / 6.3 (64 / 256)	0.1 (.004)	0.14 (.006)	0.2 (.008)	0.25 (.010)	0.28 (.011)	0.35 (.014)
3.2 / 12.5 (128 / 512)	0.14 (.006)	0.2 (.008)	0.28 (.011)	0.35 (.014)	0.4 (.016)	0.49 (.019)
6.3 / 25 (250 / 1000)	-	0.28 (.011)	0.4 (.016)	0.49 (.019)	0.57 (.022)	0.69 (.027)
8 / 32 (320 / 1280)	-	-	0.45 (.018)	0.55 (.022)	0.64 (.025)	0.78 (.031)

Trouble Shooting Guide map
问题解答图

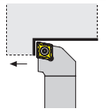
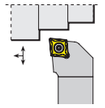
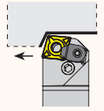
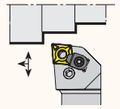
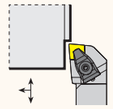
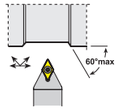
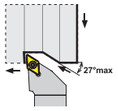
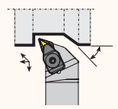
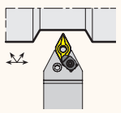
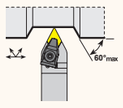
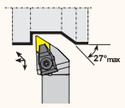
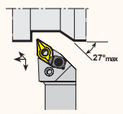
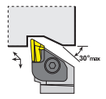
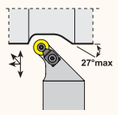
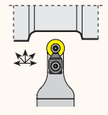
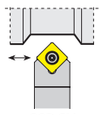
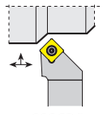


Pattern	Reasons	Solutions
General Flank Wear **普通后刀面磨损**  Flank face near by corner is abrased 靠近刀尖的磨损	- The most ideal wear - 最理想的正常磨损 - Consistent and predictable - 一致性及可预测性 - General wear behavior when machining condition is normal - 正常加工参数上的正常磨损	
Rapid Flank Wear **快速后刀面磨损**  Looks same as general flank wear, but happens quickly 跟正常磨损一样，但磨损快	**Grade** **材质** - Not enough wear resistance - 耐磨性不够 - Too tough grade - 材质的韧性过高 **Heat** **高温** - Cutting speed is too high - 切削速度过高 - Not enough coolant - 冷却液不足	- More wear resistant grade - 选择耐磨性更高的材质 - Reduce the cutting speed (Vc, SFM, RPM or SFPM) - 降低切削速度(Vc, SFM, RPM, SFPM) - Optimize coolant - 选择合适冷却液 - Increase Feed (Fn) if feed is low - 如果进给低，提高进给(Fn)
Plastic Deformation **塑性变形**  Deformed Edge 刀尖变形	- Excess thermal load - 过度热负载和阻力 - Excess mechanical load - 过度机械负载和阻力	- Reduce cutting temperature - 降低切削温度 - More wear resistant grade - 选择耐磨性更高的材质 - Reduce the cutting speed (Vc, SFM, RPM or SFPM) - 降低切削速度(Vc, SFM, RPM, SFPM) - Lower feed (Fn) - 降低进给(Fn) - Lower depth of cut (ap) - 降低切深(Ap) - Optimize coolant - 选择合适冷却液
Built up Edge **积屑瘤** Workpiece material is welded on the cutting edge 工件材料熔接在切削刃	- Sticky materials (low carbon steel, Stainless steel, non-ferrous metal, heat resistant super alloys) - 粘性材料(低碳钢，不锈钢，非铁金属，超耐热合金) - Too low cutting speed - 切削速度过低	- Increase cutting speed - 提高切削速度 - Lower feed rate - 降低进给 - Sharper chipbreaker & geometry - 选择更锋利的槽型&形状 - Use high pressure coolant - 用高压冷却液 - Use PVD grade - 选择PVD涂层材质 - Use Positive Insert - 选择正角型刀片
Cratering **月牙洼磨损** 	**Heat** **高温** - Cutting speed is too high - 切削速度过高 - Too tough grade - 材质的韧性过高	- Reduce cutting temperature - 降低切削温度 - Lower cutting speed (Vc, SFM, RPM or SFPM) - 降低切削速度(Vc, SFM, RPM, SFPM) - Adjust Feed (Fn) - 调整进给(Fn) - Harder grade - 选择更硬的材质

Trouble Shooting
问题解答

Pattern	Reasons	Solutions
Chipping **崩刃** 	- Unstable machining condition (Vibration) - 不稳定设备条件(振动) - 材质过硬/过脆 - 材质过锋利 - Grade is too hard / brittle - Grade is too sharp	- Focus on stabilizing cutting condition - 选择稳定的加工参数 - 降低悬伸 - Reduce overhang (shorter and bigger tool) - 选择韧性更高的材质(更大和更短的刀具) - Tougher grade - 选择韧性更高的槽型 - Tougher chipbreaker
Thermal Crack **热裂纹** 	- Thermal stress due to rapid change of temperature - 温度快速变化引起的热应力	- Tougher grade - 选择韧性更高的材质 - Lower cutting speed (Vc, SFM, RPM or SFPM) - 降低切削速度(Vc,SFM,RPM,SFPM) - Lower feed (Fn) - 降低进给(Fn) - Sharper chipbreaker - 选择更锋利的槽型 - Change coolant / dry cut - 换冷却液/干切
Notching **沟槽磨损** 	- Improved edge strength work piece has hardened skin - 加工硬化工件材料	- More wear resistant grade - 选择耐磨性更高的材质 -Reduce the cutting speed (Vc, SFM, RPM or SFPM) - 降低切削速度(Vc, SFM, RPM, SFPM) - Adjust Feed (Fn) - 调整进给(Fn) - Lower depth of cut (ap) - 降低切深(Ap) - Optimize coolant - 选择合适冷却液 - Go for tougher chipbreaker - 选择韧性更高的槽型
Breakage **(Mechanical Fracture)** **破裂 (机械断裂)** 	- Mechanical load is too heavy (feed or depth is too high) - 机械负载过重(进给或切深过高) - Heavy interrupted cut - 断续加工太大 - Grade is too hard for work material - 对于工件材料，刀片材质过硬 - Unstable machining (vibration) - 不稳定工况(振动) - Cutting speed is too low - 切削速度过低 - Impurities in work material - 工件含杂质	- Lower feed (Fn)or depth of cut (ap) - 降低进给(Fn)或切深(Ap) - Tougher grade - 选择韧性更高的材质 - Reduce overhang and check stability of tool and work material - 降低悬伸和检查刀片和工件的稳定性 - Higher cutting speed (Vc, SFM, RPM or SFPM) - 提高切削速度(Vc,SFM,RPM,SFPM)
Long Chip **长切屑** 	- Feed is too low for chipbreaker - 对于选择槽型，进给过低 - Depth of cut is too shallow for corner radius - 对于选择刀尖半径，切深过浅 - Chip area (Fn x Ap) too low - 切屑面积(Fn x Ap)过低	- Higher feed - 提高进给 - Sharper chipbreaker - 选择更锋利的槽型 - Higher depth of cut - 提高切深 - Select a smaller corner radius - 选择更小的刀尖半径

External Holders Overview
外圆刀柄概况

Series 系列	Turning Holder 车削刀柄				
 CCGT CCMT	 SCACR/L Screw	 SCLCR/L Screw			
p. 80	p. 31	p. 31			
 CNMA CNMG	 PCBNR/L Lever	 PCLNR/L Lever (+Clamp)	 TCLNR/L Hole Clamp		
p. 62	p. 32	p. 32	p. 32		
 DCGT DCMT	 SDNCN Screw	 SDJCR/L Screw			
p. 81	p. 33	p. 33			
 DNMA DNMG	 TDHNR/L Hole Clamp	 PDNNN Lever (+Clamp)	 TDNNN Hole Clamp	 TDJNR/L Hole Clamp	 PDJNR/L Lever (+Clamp)
p. 65	p. 34	p. 34	p. 34	p. 34	p. 34
 KNUX	 CKJNR/L Top Clamp				
p. 68	p. 35				
 RCMT	 SRGCR/L Screw	 SRDCN Screw			
p. 82	p. 36	p. 36			
 SCMT	 SSDCN Screw	 SSSCR/L Screw			
p. 83	p. 37	p. 37			

External Holders Overview

外圆刀柄概况

Series 系列	Turning Holder 车削刀柄						
SNMA SNMG	PSDNN Lever (+Clamp)	TSDNN Hole Clamp	PSSNR/L Lever (+Clamp)	TSSNR/L Hole Clamp	PSBNR/L Lever (+Clamp)	TSKNR/L Hole Clamp	PSKNR/L Lever (+Clamp)
p. 69	p. 38	p. 38	p. 38	p. 38	p. 38	p. 38	p. 38
TCGT TCMT	STFCR/L Screw	STGCR/L Screw	STJCR/L Screw	STUCR/L Screw			
p. 84	p. 39	p. 39	p. 39	p. 39			
TNMA TNMG TNUX	PTTNR/L Lever (+Clamp)	PTFNR/L Lever (+Clamp)	PTGNR/L Lever (+Clamp)	TTGNR/L Hole Clamp	MTJNR/L Pin + Clamp	PTJNR/L Lever (+Clamp)	TTJNR/L Hole Clamp
p. 71	p. 40	p. 40	p. 40	p. 40	p. 41	p. 41	p. 41
VBMT	SVHBR/L Screw	SVVBN Screw	SVJBR/L Screw				
p. 85	p. 42	p. 42	p. 42				
VCGT VCMT	SVHCR/L Screw	SVVCN Screw	SVJCR/L Screw				
p. 86	p. 43	p. 43	p. 43				
VNMA VNMG	TVVNN Hole Clamp	TVJNR/L Hole Clamp					
p. 75	p. 44	p. 44					
WNMA WNMG	MWLNR/L Pin + Clamp	PWLNR/L Lever (+Clamp)	TWLNR/L Hole Clamp				
p. 77	p. 45	p. 45	p. 45				

Internal Holders Overview

内圆刀柄概况

Series 系列	Turning Holder 车削刀柄			
CCGT CCMT	..-SCFCR/L Screw	..-SCLCR/L Screw	E..-SCLCR/L Screw	
p. 80	p. 46	p. 47	p. 47	
CNMA CNMG	..-PCLNR/L Lever (+Clamp)	..-TCLNR/L Hole Clamp		
p. 62	p. 48	p. 48		
DCGT DCMT	..-SDQCR/L Screw	..-SDUCR/L Screw	E..-SDUCR/L Screw	
p. 81	p. 49	p. 50	p. 50	
DNMA DNMG	..-PDQNR/L Lever (+Clamp)	..-TDQNR/L Hole Clamp	..-PDUNR/L Lever (+Clamp)	..-TDUNR/L Hole Clamp
p. 65	p. 51	p. 51	p. 51	p. 51
SNMA SNMG	..-PSKNR/L Lever (+Clamp)			
p. 69	p. 52			
TCGT TCMT	..-STFCR/L Screw	..-STUCR/L Screw		
p. 84	p. 53	p. 53		

Turning - Holder - Internal

Internal Holders Overview

车削 - 刀柄 - 内圆

内圆刀柄概况

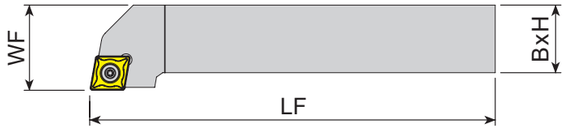
Series 系列	Turning Holder 车削刀柄			
TNMA TNMG TNUX	..-MTFNR/L Pin + Clamp	..-MTUNR/L Pin + Clamp	..-PTUNR/L Lever (+Clamp)	..-TTUNR/L Hole Clamp
p. 71	p. 54	p. 54	p. 55	p. 55
VBMT	..-SVQBR/L Screw	..-SVJBR/L Screw	..-SVUBR/L Screw	
p. 85	p. 56	p. 56	p. 56	
VCGT VCMT	..-SVQCR/L Screw	..-SVUCR/L Screw		
p. 86	p. 57	p. 57		
VNMA VNMG	..-TVUNR/L Hole Clamp			
p. 75	p. 58			
WNMA WNMG	..-MWLNR/L Pin + Clamp	..-PWLNR/L Lever (+Clamp)	..-TWLNR/L Hole Clamp	
p. 77	p. 59	p. 59	p. 60	

Turning - Holder - External

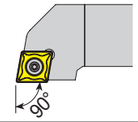
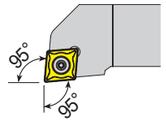
External Holders for CC** Insert

车削 - 刀柄 - 外圆

CC**刀片可用的外圆刀柄



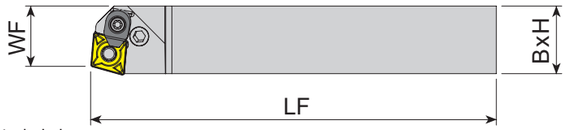
: p. 80 Unit(单位):mm

Series	Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
 SCACR/L (Screw Type 90°)	SCACR/L 0808E 06	0675	0676	08	08	10	70	CC0602
 SCLCR/L (Screw Type 95°)	SCLCR/L 0808E 06	0689	0690	08	08	10	70	CC0602
	SCLCR/L 1010E 06	0691	-	10	10	12	70	
	SCLCR/L 1010E 09	0692	0693	10	10	12	70	CC09T3
	SCLCR/L 1212F 09	0089	0090	12	12	16	80	
	SCLCR/L 1616H 09	0091	0092	16	16	20	100	
	SCLCR/L 2020K 09	0093	0094	20	20	25	125	
	SCLCR/L 2525M 09	0694	0695	25	25	32	150	
	SCLCR/L 1616H 12	0696	-	16	16	20	100	CC1204
	SCLCR/L 2020K 12	0095	0096	20	20	25	125	
	SCLCR/L 2525M 12	0097	0098	25	25	32	150	

Series	Size	Screw	Shim	Shim Screw	Torx Key
SCACR/L	..06	Y4008-M2.5x6	-	-	Y80-T08
SCLCR/L	..06	Y4008-M2.5x6	-	-	Y80-T08
	..1010..09	Y4015-M3x9	-	-	Y80-T15
	..1212..09	Y4015-M3.5x11	-	-	Y80-T15
	..1616~2525..09	Y4015-M3.5x14	YAACN-2-0001	YAAV-06-M3.5x11	Y80-T15
	..1616..12	Y1020-M5x11	-	-	Y80-T20
	..2020~2525..12	Y1020-M4.5x16	YAACN-2-0003	YAAV-07-M4.5x13	Y80-T20

External Holders for CN** Insert

CN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

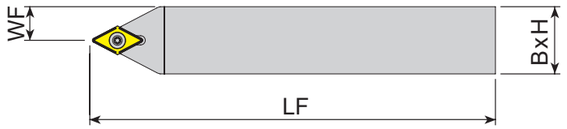
: p. 62 Unit(单位):mm

Series	Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
PCBNR/L (Lever Type 75°)	PCBNR/L 2525M 16C	0444	0445	25	25	22	150	CN1606
	PCBNR/L 3232P 16C	0446	0447	32	32	27	170	
	PCBNR/L 3232P 19C	0448	0449	32	32	37	170	CN1906
	PCBNR/L 4040S 19C	0450	0451	40	40	37	250	
PCLNR/L (Lever Type 95°)	PCLNR/L 1616H 12	0464	0465	16	16	20	100	CN1204
	PCLNR/L 2020K 12C	0466	0467	20	20	25	125	
	PCLNR/L 2525M 12C	0468	0469	25	25	32	150	
	PCLNR/L 3232P 12C	0470	0471	32	32	40	170	
	PCLNR/L 2525M 16C	0472	0473	25	25	32	150	CN1606
	PCLNR/L 3232P 16C	0474	0475	32	32	40	170	
	PCLNR/L 2525M 19C	0476	0477	25	25	32	150	CN1906
	PCLNR/L 3232P 19C	0478	0479	32	32	40	170	
	PCLNR/L 4040S 19C	0480	0481	40	40	50	250	
TCLNR/L (Hole Clamp Type 95°)	TCLNR/L 2020K 12	0482	0483	20	20	25	125	CN1204
	TCLNR/L 2525M 12	0484	0485	25	25	32	150	
	TCLNR/L 3232P 12	0486	0487	32	32	40	170	
	TCLNR/L 2525M 16	0492	0493	25	25	32	150	CN1606
	TCLNR/L 3232P 16	0494	-	32	32	40	170	

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
PCBNR/L	..16C	YAPL-04	YALV-04-M8x22	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0002	-	YAAY-03	YAAL-03-3
	..19C	YAPL-05	YALV-05-M10x27	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0003	-	YAAY-04	YAAL-05-4
PCLNR/L	..12	YAPL-02	YALV-03-M8x19	-	-	-	-	YAACN-3-0001	-	YAAY-02	YAAL-03-3
	..2020~3232..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAACN-3-0001	-	YAAY-02	YAAL-03-3
	..16C	YAPL-04	YALV-04-M8x22	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0002	-	YAAY-03	YAAL-03-3
	..19C	YAPL-05	YALV-05-M10x27	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0003	-	YAAY-04	YAAL-05-4
TCLNR/L	..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAACN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
	..16	-	-	YATK-04	YAKV-19-M7x25	YABPL-02	-	YAACN-3-0002	YAAV-05-M6x15	-	YAAL-05-4

External Holders for DC** Insert

DC**刀片可用的外圆刀柄



: p. 81 Unit(单位):mm

Series	Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
SDNCN (Screw Type 62.5°)	SDNCN 0808E 07	0723		08	08	4	70	DC0702
	SDNCN 1010E 07	0724		10	10	5	70	
	SDNCN 1212F 07	0123		12	12	6	80	
	SDNCN 1616H 07	0725		16	16	8	100	
	SDNCN 1616H 11	0124		16	16	8	100	DC11T3
	SDNCN 2020K 11	0125		20	20	10	125	
	SDNCN 2525M 11	0126		25	25	12.5	150	
	SDNCN 3232P 11	0726		32	32	16	170	
SDJCR/L (Screw Type 93°)	SDJCR/L 0808E 07	0713	0714	08	08	10	70	DC0702
	SDJCR/L 1010E 07	0715	0716	10	10	12	70	
	SDJCR/L 1212F 07	0113	0114	12	12	16	80	
	SDJCR/L 1616H 07	0717	0718	16	16	20	100	
	SDJCR/L 1616H 11	0117	0118	16	16	20	100	DC11T3
	SDJCR/L 2020K 11	0119	0120	20	20	25	125	
	SDJCR/L 2525M 11	0719	0720	25	25	32	150	
	SDJCR/L 3232P 11	0721	0722	32	32	40	170	

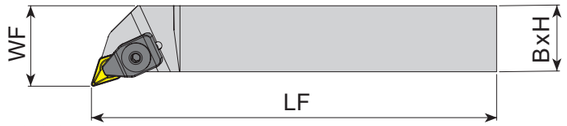
Series	Size	Screw	Shim	Shim Screw	Torx Key
SDNCN	..07	Y4008-M2.5x6	-	-	Y80-T08
	..11	Y4015-M3.5x14	YAADN-2-0001	YAAV-06-M3.5x11	Y80-T15
SDJCR/L	..07	Y4008-M2.5x6	-	-	Y80-T08
	..11	Y4015-M3.5x14	YAADN-2-0001	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - External

External Holders for DN** Insert

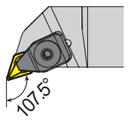
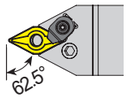
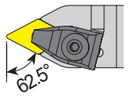
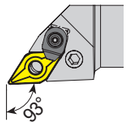
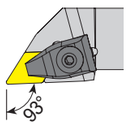
车削 - 刀柄 - 外圆

DN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 65 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
	**TDHNR/L** (Hole Clamp Type 107.5°)	TDHNR/L 2020K 15	0495	0496	20	20	25	125	DN1506
		TDHNR/L 2525M 15	0497	0498	25	25	32	150	
	**PDNNN** (Lever Type 62.5°)	PDNNN 2020K 15C	0515		20	20	10	125	DN1506
		PDNNN 2525M 15C	0516		25	25	12.5	150	
		PDNNN 3232P 15C	0517		32	32	16	170	
	**TDNNN** (Hole Clamp Type 62.5°)	TDNNN 2020K 15	0518		20	20	10	125	DN1506
		TDNNN 2525M 15	0519		25	25	12.5	150	
		TDNNN 3232P 15	0520		32	32	16	170	
	**PDJNR/L** (Lever Type 93°)	PDJNR/L 2020K 15C	0500	0501	20	20	25	125	DN1506
		PDJNR/L 2525M 15C	0502	0503	25	25	32	150	
		PDJNR/L 3232P 15C	0504	0505	32	32	40	170	
		PDJNR/L 4040S 15C	-	0506	40	40	50	250	
	**TDJNR/L** (Hole Clamp Type 93°)	TDJNR/L 2020K 15	0507	0508	20	20	25	125	DN1506
		TDJNR/L 2525M 15	0509	0510	25	25	32	150	
		TDJNR/L 3232P 15	0511	0512	32	32	40	170	
		TDJNR/L 4040S 15	0513	0514	40	40	50	250	

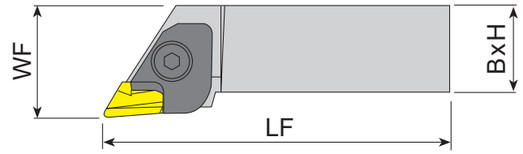
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
TDHNR/L	..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
PDNNN	..15C	YAPL-03	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAADN-3-0001	-	YAAY-02	YAAL-03-3
TDNNN	..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
PDJNR/L	..15C	YAPL-03	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAADN-3-0001	-	YAAY-02	YAAL-03-3
TDJNR/L	..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - External

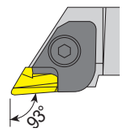
External Holders for KN** Insert

车削 - 刀柄 - 外圆

KN**刀片可用的外圆刀柄



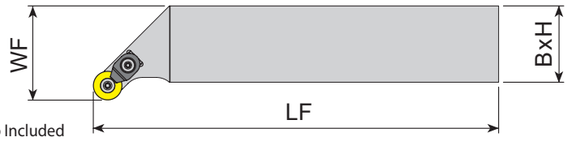
: p. 68 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
	**CKJNR/L** (Top Clamp Type 93°)	CKJNR/L 2020K 16	0521	0522	20	20	27.5	125	KNUX1604
		CKJNR/L 2525M 16	0152	0153	25	25	31.5	150	
		CKJNR/L 3232P 16	0154	0155	32	32	40	170	

Series	Size	Clamp	Clamp Screw	Spring	Upper Ring	Shim	Shim Screw	Allen Key
CKJNR	..16	YACK-01-R	YAKV-06-M6x20	YAKY-02	YABPL-01	YAKS-16-R	YAAV-01-M3x10	YAAL-05-4
CKJNL	..16	YACK-01-L	YAKV-06-M6x20	YAKY-02	YABPL-01	YAKS-16-L	YAAV-01-M3x10	YAAL-05-4

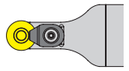
External Holders for RC** Insert

RC**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 82 Unit(单位):mm

Series	Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
 SRGCR/L (Screw Type 90°)	SRGCR/L 1616H 06	0739	0740	16	16	20	100	RC0602
	SRGCR/L 2020K 06	0741	0742	20	20	25	125	
	SRGCR/L 1616H 08C	0743	0744	16	16	32	100	RC0803
	SRGCR/L 2020K 08C	0745	0746	20	20	25	125	
	SRGCR/L 2525M 08C	0747	0748	25	25	32	150	
	SRGCR/L 1616H 10C	0749	0750	16	16	20	100	RC10T3
	SRGCR/L 2020K 10C	0751	0752	20	20	25	125	
	SRGCR/L 2525M 10C	0753	0754	25	25	32	150	
	SRGCR/L 3232P 10C	0755	0756	32	32	40	170	
	SRGCR/L 2020K 12C	0757	0758	20	20	25	125	RC1204
	SRGCR/L 2525M 12C	0759	0760	25	25	32	150	
	SRGCR/L 3232P 12C	0761	0762	32	32	40	170	
 SRDCN (Screw Type 90°)	SRDCN 1616H 06	0162		16	16	8	100	RC0602
	SRDCN 2020K 06	0163		20	20	10	125	
	SRDCN 2525M 06	0164		25	25	12.5	150	
	SRDCN 1616H 08C	0727		16	16	8	100	RC0803
	SRDCN 2020K 08C	0728		20	20	10	125	
	SRDCN 2525M 08C	0729		25	25	12.5	150	
	SRDCN 1616H 10C	0730		16	16	8	100	RC10T3
	SRDCN 2020K 10C	0731		20	20	10	125	
	SRDCN 2525M 10C	0732		25	25	12.5	150	
	SRDCN 3232P 10C	0733		32	32	16	170	
	SRDCN 2020K 12C	0734		20	20	10	125	RC1204
	SRDCN 2525M 12C	0735		25	25	12.5	150	
	SRDCN 3232P 12C	0736		32	32	16	170	

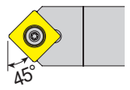
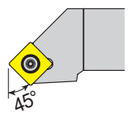
Series	Size	Clamp	Clamp Screw	Screw	Torx Key
SRGCR/L	..06	-	-	Y3008-M2.5x6	Y80-T08
	..1616..08C	YACK-15	Y4015-M3.5x11	Y3008-M3x8	Y80-T08
	..10C	YACK-15	Y4015-M3.5x11	Y3008-M3x8	Y80-T15
	..12C	YACK-05	Y4015-M4x11	Y4015-M3.5x11	Y80-T15
SRDCN	..06	-	-	Y3008-M2.5x6	Y80-T08
	..08C	YACK-15	Y4015-M3.5x11	Y3008-M3x8	Y80-T08
	..10C	YACK-15	Y4015-M3.5x11	Y4015-M3.5x11	Y80-T15
	..12C	YACK-05	Y4015-M4x11	Y4015-M3.5x11	Y80-T15

External Holders for SC** Insert

SC**刀片可用的外圆刀柄



: p. 83 Unit(单位):mm

Series	Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
 SSDCN (Screw Type 45°)	SSDCN 1212F 09	0148		12	12	6	80	SC09T3
	SSDCN 1616H 09	0149		16	16	8	100	
	SSDCN 2020K 09	0770		20	20	10	125	
	SSDCN 1616H 12	0771		16	16	8	100	SC1204
	SSDCN 2020K 12	0150		20	20	10	125	
	SSDCN 2525M 12	0151		25	25	12.5	150	
 SSSCR/L (Screw Type 45°)	SSSCR/L 1212F 09	0772	0773	12	12	16	80	SC09T3
	SSSCR/L 1616H 09	0774	0775	16	16	20	100	
	SSSCR/L 2020K 09	0776	0777	20	20	25	125	
	SSSCR/L 1616H 12	0778	0779	16	16	20	100	SC1204
	SSSCR/L 2020K 12	0780	0781	20	20	25	125	
	SSSCR/L 2525M 12	0782	0783	25	25	32	150	

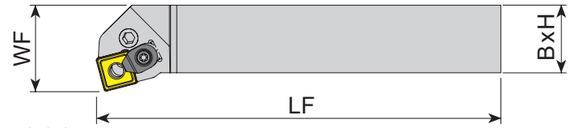
Series	Size	Screw	Shim	Shim Screw	Torx Key
SSDCN	..1212..09	Y4015-M3.5x11	-	-	Y80-T15
	..1616~2020..09	Y4015-M3.5x14	YAASN-2-0001	YAAV-06-M3.5x11	Y80-T15
	..1616..12	Y4020-M4.5x12	YAASN-2-0004	YAAV-10-M4.5x8	Y80-T20
	..2020~2525..12	Y1020-M4.5x16	YAASN-2-0004	YAAV-07-M4.5x13	Y80-T20
SSSCR/L	..1212..09	Y4015-M3.5x11	-	-	Y80-T15
	..1616~2020..09	Y4015-M3.5x14	YAASN-2-0001	YAAV-06-M3.5x11	Y80-T15
	..1616..12	Y4020-M4.5x12	YAASN-2-0004	YAAV-10-M4.5x8	Y80-T20
	..2020~2525..12	Y1020-M4.5x16	YAASN-2-0004	YAAV-07-M4.5x13	Y80-T20

Turning - Holder - External

External Holders for SN** Insert

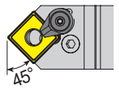
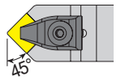
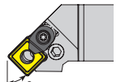
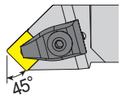
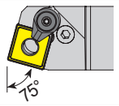
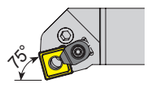
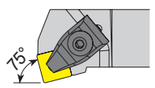
车削 - 刀柄 - 外圆

SN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 69 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
	**PSDNN** (Lever Type 45°)	PSDNN 2020K 12C	0530		20	20	10	125	SN1204
		PSDNN 2525M 12C	0531		25	25	12.5	150	
		PSDNN 3232P 12C	0532		32	32	16	170	
	**TSDNN** (Hole Clamp Type 45°)	TSDNN 1616H 12	0533		16	16	8	100	SN1204
		TSDNN 2020K 12	0534		20	20	10	125	
		TSDNN 2525M 12	0535		25	25	12.5	150	
		TSDNN 3232P 12	0536		32	32	16	170	
	**PSSNR/L** (Lever Type 45°)	PSSNR/L 2020K 12C	0548	0549	20	20	25	125	SN1204
		PSSNR/L 2525M 12C	0550	0551	25	25	32	150	
		PSSNR/L 3232P 12C	0552	0553	32	32	40	170	
	**TSSNR/L** (Hole Clamp Type 45°)	TSSNR/L 2020K 12	0554	0555	20	20	25	125	SN1204
		TSSNR/L 2525M 12	0556	0557	25	25	32	150	
		TSSNR/L 3232P 12	0558	0559	32	32	40	170	
	**PSBNR/L** (Lever Type 75°)	PSBNR/L 2020K 12	0430	0525	20	20	17	125	SN1204
		PSBNR/L 2525M 12C	0526	0527	25	25	22	150	
	**PSKNR/L** (Lever Type 75°)	PSKNR/L 2020K 12C	0537		20	20	25	125	SN1204
		PSKNR/L 2525M 12C	0538	0539	25	25	32	150	
		PSKNR/L 3232P 12C	0540	0541	32	32	40	170	
	**TSKNR/L** (Hole Clamp Type 75°)	TSKNR/L 2020K 12	0542	0543	20	20	25	125	SN1204
		TSKNR/L 2525M 12	0544	0545	25	25	32	150	
		TSKNR/L 3232P 12	0546	0547	32	32	40	170	

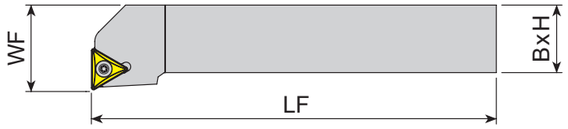
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
PSDNN	..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
TSDNN	..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAASN-3-0004	YAAV-02-M5x12	-	YAAL-03-3
PSSNR/L	..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
TSSNR/L	..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAASN-3-0004	YAAV-02-M5x12	-	YAAL-03-3
PSBNR/L	..12	YAPL-02	YALV-03-M8x19	-	-	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
	..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
PSKNR/L	..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
TSKNR/L	..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAASN-3-0004	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - External

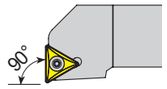
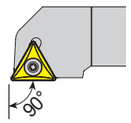
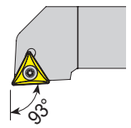
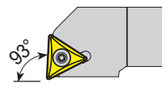
External Holders for TC** Insert

车削 - 刀柄 - 外圆

TC**刀片可用的外圆刀柄



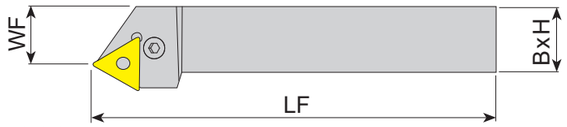
: p. 84 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
	**STFCR/L** (Screw Type 90°)	STFCR/L 1212F 11	0099	0100	12	12	16	80	TC1102
		STFCR/L 1616H 11	0101	0102	16	16	20	100	
		STFCR/L 1616H 16	0105	0106	16	16	20	100	TC16T3
		STFCR/L 2020K 16	0107	0108	20	20	25	125	
		STFCR/L 2525M 16	0109	0110	25	25	32	150	
		STFCR/L 3232P 16	0784	0785	32	32	40	170	
	**STGCR/L** (Screw Type 90°)	STGCR/L 1212F 11	0786	0787	12	12	16	80	TC1102
		STGCR/L 1616H 11	0433	0788	16	16	20	100	
		STGCR/L 1616H 16	0789	0790	16	16	20	100	TC16T3
		STGCR/L 2020K 16	0434	0791	20	20	25	125	
		STGCR/L 2525M 16	0792	0793	25	25	32	150	
		STGCR/L 3232P 16	0794	0795	32	32	40	170	
	**STJCR/L** (Screw Type 93°)	STJCR/L 1212F 11	0796	0797	12	12	16	80	TC1102
		STJCR/L 1616H 11	0798	0799	16	16	20	100	
		STJCR/L 1616H 16	0800	0801	16	16	20	100	TC16T3
		STJCR/L 2020K 16	0802	0803	20	20	25	125	
		STJCR/L 2525M 16	0804	0805	25	25	32	150	
		STJCR/L 3232P 16	0806	0807	32	32	40	170	
	**STUCR/L** (Screw Type 93°)	STUCR/L 1212F 11	0808	0809	12	12	16	80	TC1102
		STUCR/L 1616H 11	0810	0811	16	16	20	100	
		STUCR/L 2020K 16	0812	0813	20	20	25	125	TC16T3
		STUCR/L 2525M 16	0814	0815	25	25	32	150	
		STUCR/L 3232P 16	0816	0817	32	32	40	170	

Series	Size	Screw	Shim	Shim Screw	Torx Key
STFCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15
STGCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15
STJCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15
STUCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15

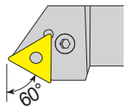
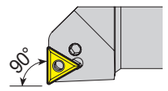
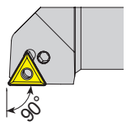
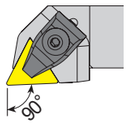
External Holders for TN** Insert

TN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 71 Unit(单位):mm

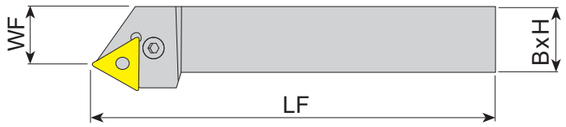
Series		Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
	**PTTNR/L** (Lever Type 60˚)	PTTNR/L 2020K 16	0429	0621	20	20	17	125	TN1604
		PTTNR/L 2525M 16	0622	0623	25	25	21.5	150	
		PTTNR/L 2525M 22C	0626	0627	25	25	20.5	150	TN2204
		PTTNR/L 3232P 22C	0628	0629	32	32	29	170	
	**PTFNR/L** (Lever Type 90˚)	PTFNR/L 1616H 16	0560	0561	16	16	20	100	TN1604
		PTFNR/L 2020K 16	0049	0050	20	20	25	125	
		PTFNR/L 2525M 16	0051	0052	25	25	32	150	
		PTFNR/L 3232P 16	0562	0563	32	32	40	170	
		PTFNR/L 3232P 22C	0566	0567	32	32	40	170	TN2204
	**PTGNR/L** (Lever Type 90˚)	PTGNR/L 1616H 16	0568	0569	16	16	20	100	TN1604
		PTGNR/L 2020K 16	0055	0056	20	20	25	125	
		PTGNR/L 2525M 16	0057	0058	25	25	32	150	
		PTGNR/L 2525M 22C	0570	0571	25	25	32	150	TN2204
		PTGNR/L 3232P 22C	0572	0573	32	32	40	170	
	**TTGNR/L** (Hole Clamp Type 90˚)	TTGNR/L 2020K 16	0574	0575	20	20	25	125	TN1604
		TTGNR/L 2525M 16	0576	0577	25	25	32	150	
		TTGNR/L 3232P 16	0578	0579	32	32	40	170	
		TTGNR/L 2525M 22	0580	0581	25	25	32	150	TN2204
		TTGNR/L 3232P 22	0582	0583	32	32	40	170	
		TTGNR/L 4040S 22	0584	-	40	40	50	250	

▶ NEXT PAGE

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
PTTNR/L	..16	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-03-3
PTFNR/L	..16	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-03-3
PTGNR/L	..16	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-02-2.5
TTGNR/L	..16	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAATN-2-0002	YAAV-03-M5x12	-	YAAL-03-3
	..22	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAATN-3-0015	YAAV-02-M5x12	-	YAAL-03-3

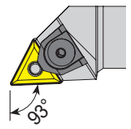
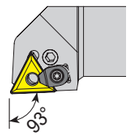
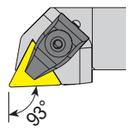
External Holders for TN** Insert

TN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 71 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
	**MTJNR/L** (Pin + Top Clamp Type 93˚)	MTJNR/L 2020K 16	0585	0586	20	20	25	125	TN1604
		MTJNR/L 2525M 16	0587	0588	25	25	32	150	
		MTJNR/L 3232P 16	0589	0590	32	32	40	170	
		MTJNR/L 2525M 22	0591	0592	25	25	32	150	TN2204
		MTJNR/L 3232P 22	0593	0594	32	32	40	170	
		MTJNR/L 4040S 22	0595	0596	40	40	50	250	
	**PTJNR/L** (Lever Type 93˚)	PTJNR/L 1616H 16	0597	0598	16	16	20	100	TN1604
		PTJNR/L 2020K 16	0599	0600	20	20	25	125	
		PTJNR/L 2525M 16	0601	0602	25	25	32	150	
		PTJNR/L 3232P 16	0603	0604	32	32	40	170	
		PTJNR/L 2525M 22C	0605	0606	25	25	32	150	TN2204
		PTJNR/L 3232P 22C	0607	0608	32	32	40	170	
	**TTJNR/L** (Hole Clamp Type 93˚)	TTJNR/L 2020K 16	0609	0610	20	20	25	125	TN1604
		TTJNR/L 2525M 16	0611	0612	25	25	32	150	
		TTJNR/L 3232P 16	0613	0614	32	32	40	170	
		TTJNR/L 2525M 22	0615	0616	25	25	32	150	TN2204
		TTJNR/L 3232P 22	0617	0618	32	32	40	170	

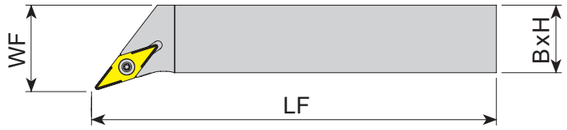
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
MTJNR/L	..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-01	YAATN-2-0002	-	-	YAAL-03-3
	..22	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-02	YAATN-3-0015	-	-	YAAL-03-3
PTJNR/L	..16	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-03-3
TTJNR/L	..16	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAATN-2-0002	YAAV-03-M5x12	-	YAAL-03-3
	..22	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAATN-3-0015	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - External

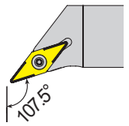
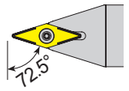
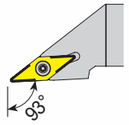
External Holders for VB** Insert

车削 - 刀柄 - 外圆

VB**刀片可用的外圆刀柄



: p. 85 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
	SVHBR/L (Screw Type 107.5°)	SVHBR/L 2020K 16	0818	0819	20	20	25	125	VB1604
		SVHBR/L 2525M 16	0820	0821	25	25	32	150	
		SVHBR/L 3232P 16	0822	0823	32	32	40	170	
	SVVBN (Screw Type 72.5°)	SVVBN 2020K 16	0131		20	20	10	125	VB1604
		SVVBN 2525M 16	0132		25	25	12.5	150	
		SVVBN 3232P 16	0827		32	32	16	170	
	SVJBR/L (Screw Type 93°)	SVJBR/L 1616H 16	0824	0825	16	16	20	100	VB1604
		SVJBR/L 2020K 16	0127	0128	20	20	25	125	
		SVJBR/L 2525M 16	0129	0130	25	25	32	150	
		SVJBR/L 3232P 16	0436	0826	32	32	40	170	

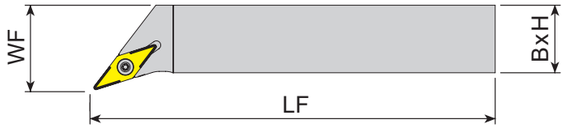
Series	Size	Screw	Shim	Shim Screw	Torx Key
SVHBR/L	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
SVVBN	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
SVJBR/L	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - External

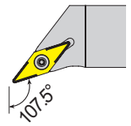
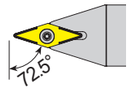
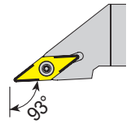
External Holders for VC** Insert

车削 - 刀柄 - 外圆

VC**刀片可用的外圆刀柄



: p. 86 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
	SVHCR/L (Screw Type 107.5°)	SVHCR/L 2020K 16	0828	0829	20	20	25	125	VC1604
		SVHCR/L 2525M 16	0830	0831	25	25	32	150	
		SVHCR/L 3232P 16	0832	0833	32	32	40	170	
	SVVCN (Screw Type 72.5°)	SVVCN 2525M 16	0147		25	25	12.5	150	VC1604
		SVVCN 3232P 16	0838		32	32	16	170	
	SVJCR/L (Screw Type 93°)	SVJCR/L 1212F 16	0834	0835	12	12	16	80	VC1604
		SVJCR/L 2020K 16	0139	0140	20	20	25	125	
		SVJCR/L 2525M 16	0141	0142	25	25	32	150	
		SVJCR/L 3232P 16	0836	0837	32	32	40	170	

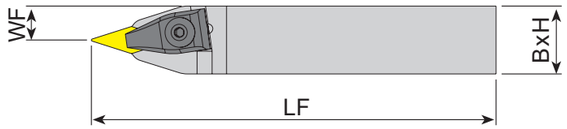
Series	Size	Screw	Shim	Shim Screw	Torx Key
SVHCR/L	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
SVVCN	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
SVJCR/L	..1212..16	Y4015-M3.5x11	-	-	Y80-T15
	..2020~3232..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - External

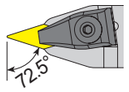
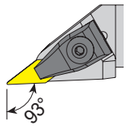
External Holders for VN** Insert

车削 - 刀柄 - 外圆

VN**刀片可用的外圆刀柄



: p. 75 Unit(单位):mm

Series	Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
 **TVVNN** (Hole Clamp Type 72.5°)	TVVNN 2020K 16	0642		20	20	10	125	VN1604
	TVVNN 2525M 16	0643		25	25	12.5	150	
	TVVNN 3232P 16	0644		32	32	16	170	
 **TVJNR/L** (Hole Clamp Type 93°)	TVJNR/L 2020K 16	0636	0637	20	20	25	125	VN1604
	TVJNR/L 2525M 16	0638	0639	25	25	32	150	
	TVJNR/L 3232P 16	0640	0641	32	32	40	170	

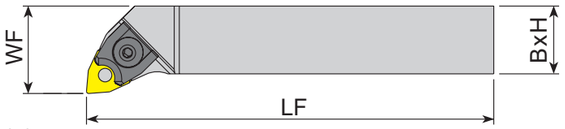
Series	Size	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Allen Key
TVVNN	..16	YATK-03	YAKV-30-M6x22	YABPL-01	YAS-01	YAAVN-2-0002	YAAV-04-M5x12	YAAL-03-3
TVJNR/L	..16	YATK-03	YAKV-30-M6x22	YABPL-01	YAS-01	YAAVN-2-0002	YAAV-04-M5x12	YAAL-03-3

Turning - Holder - External

External Holders for WN** Insert

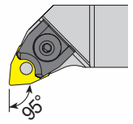
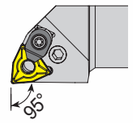
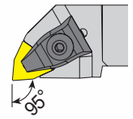
车削 - 刀柄 - 外圆

WN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 77 Unit(单位):mm

Series	Designation	EDP 2700.. R	EDP 2700.. L	H	B	WF	LF	Insert
 **MWLNR/L** (Pin + Top Clamp Type 95°)	MWLNR/L 1616H 06	0645	0646	16	16	20	100	WN0604
	MWLNR/L 2020K 06	0021	0022	20	20	25	125	
	MWLNR/L 2525M 06	0023	0024	25	25	32	150	
	MWLNR/L 2020K 08	0025	0026	20	20	25	125	WN0804
	MWLNR/L 2525M 08	0027	0028	25	25	32	150	
	MWLNR/L 3232P 08	0029	0030	32	32	40	170	
 **PWLNR/L** (Lever Type 95°)	PWLNR/L 1616H 06	0647	0648	16	16	20	100	WN0604
	PWLNR/L 2020K 06	0649	0650	20	20	25	125	
	PWLNR/L 2525M 06	0651	0652	25	25	32	150	
	PWLNR/L 1616H 08	0653	0654	16	16	20	100	WN0804
	PWLNR/L 2020K 08C	0655	0656	20	20	25	125	
	PWLNR/L 2525M 08C	0657	0658	25	25	32	150	
	PWLNR/L 3232P 08C	0659	0660	32	32	40	170	
 **TWLNR/L** (Hole Clamp Type 95°)	TWLNR/L 1616H 06	0661	0662	16	16	20	100	WN0604
	TWLNR/L 2020K 06	0663	0664	20	20	25	125	
	TWLNR/L 2525M 06	0665	0666	25	25	32	150	
	TWLNR/L 2020K 08	0667	0668	20	20	25	125	WN0804
	TWLNR/L 2525M 08	0669	0670	25	25	32	150	
	TWLNR/L 3232P 08	0671	0672	32	32	40	170	
	TWLNR/L 4040S 08	0673	0674	40	40	50	250	

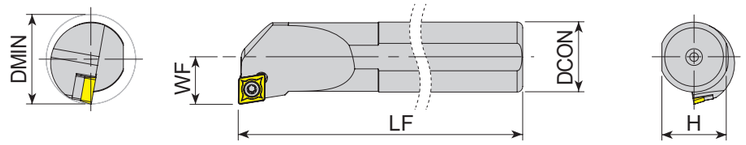
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
MWLNR/L	..06	-	-	YAMK-01	YAKV-04-M5x17	-	-	YAPM-08	-	-	-	YAAL-03-3
	..08	-	-	YAMK-05	YAKV-03-M6x22	YABPL-01	YAS-01	YAPM-02	YAAWN-3-0001	-	-	YAAL-03-3
PWLNR/L	..06	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAAWN-SW317	-	YAAY-01	YAAL-02-2.5
	..08	YAPL-02	YALV-03-M8x19	-	-	-	-	-	YAAWN-3-0001	-	YAAY-02	YAAL-03-3
	..08C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAAWN-3-0001	-	YAAY-02	YAAL-03-3
TWLNR/L	..06	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAAWN-SW317	YAAV-01-M3x10	-	YAAL-03-3
	..08	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAAWN-3-0001	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - Internal

Internal Holders for CC** Insert

车削 - 刀柄 - 内圆

CC**刀片可用的外圆刀柄



: p. 80 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
..-SCFCR/L (Screw Type 90°)	X	S08H - SCFCR/L 06	1102	1103	11	08	7.3	6	100	CC0602
	X	S10K - SCFCR/L 06	1104	1105	13	10	9	7	125	
		S12K - SCFCR/L 06	1106	1107	16	12	11	9	125	
		S12K - SCFCR/L 09	1108	1109	16	12	11	9	125	CC09T3
	X	S16P - SCFCR/L 09	1110	1111	20	16	14.8	11	170	
		S20R - SCFCR/L 09	1112	1113	25	20	18.3	13	200	
		S25S - SCFCR/L 09	1114	1115	32	25	23	17	250	
	X	S25S - SCFCR/L 12	1116	-	32	25	23	17	250	CC1204

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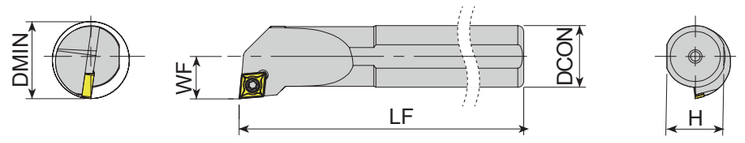
Series	Size	Screw	Shim	Shim Screw	Torx Key
..SCFCR/L	..06	Y4008-M2.5x6	-	-	Y80-T08
	..12..09	Y4015-M3.5x8	-	-	Y80-T15
	..16~20..09	Y4015-M3.5x9	-	-	Y80-T15
	..25..09	Y4015-M3.5x12	YAACN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..12	Y4020-M4.5x12	YAACN-2-0003	YAAV-10-M4.5x8	Y80-T20

Turning - Holder - Internal

Internal Holders for CC** Insert

车削 - 刀柄 - 内圆

CC**刀片可用的外圆刀柄



: p. 80 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
..-SCLCR/L (Screw Type 95°)		A08H - SCLCR/L 06	1117	1118	11	08	7.3	6	100	CC0602
	●	A10H - SCLCR/L 06	1119	1120	13	10	9	7	100	
		A12H - SCLCR/L 06	1121	1122	16	12	11	9	100	
		S08H - SCLCR/L 06	1133	1134	11	08	7.3	6	100	
	X	S10K - SCLCR/L 06	1135	1136	13	10	9	7	125	
		S12K - SCLCR/L 06	1137	1138	16	12	11	9	125	
		S16P - SCLCR/L 06	1139	1140	20	16	14.8	11	170	
		A16M - SCLCR/L 09	1123	1124	20	16	14.8	11	150	CC09T3
	●	A20P - SCLCR/L 09	1125	1126	25	20	18.3	13	170	
		A25R - SCLCR/L 09	1127	1128	32	25	23	17	200	
		A32S - SCLCR/L 09	1129	1130	40	32	30	22	250	
		S12K - SCLCR/L 09	1141	1142	16	12	11	9	125	
		S16P - SCLCR/L 09	1474	1143	20	16	14.8	11	170	
	X	S20R - SCLCR/L 09	1144	1145	25	20	18.3	13	200	
		S25S - SCLCR/L 09	1146	1147	32	25	23	17	250	
		S32T - SCLCR/L 09	1148	1149	40	32	30	22	300	
	●	A25R - SCLCR/L 12	1131	1132	32	25	23	17	200	CC1204
		S25S - SCLCR/L 12	1150	1151	32	25	23	17	250	
	X	S32T - SCLCR/L 12	1152	1153	40	32	30	22	300	
		S40U - SCLCR/L 12	1154	1155	50	40	37.5	27	350	
E..-SCLCR/L (Screw Type 95° Carbide)	●	E08K - SCLCR/L 06	0325	1156	11	08	7.3	6	125	CC0602
		E12Q - SCLCR/L 06	1157	1158	16	12	11	9	180	
	●	E16R - SCLCR/L 09	0329	1159	20	16	14.8	11	200	CC09T3
		E20S - SCLCR/L 09	1160	1161	24	20	18.3	13	250	

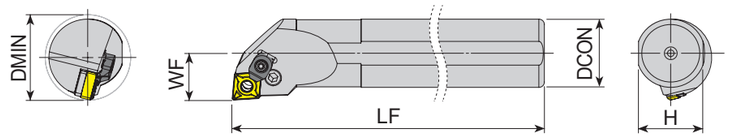
Series	Size	Screw	Shim	Shim Screw	Torx Key
..SCLCR/L	..06	Y4008-M2.5x6	-	-	Y80-T08
	..12..09	Y4015-M3.5x8	-	-	Y80-T15
	..16~20..09	Y4015-M3.5x9	-	-	Y80-T15
	..25~32..09	Y4015-M3.5x12	YAACN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..25~32..12	Y4020-M4.5x12	YAACN-2-0003	YAAV-10-M4.5x8	Y80-T20
	..40..12	Y1020-M4.5x16	YAACN-2-0003	YAAV-07-M4.5x13	Y80-T20
E..SCLCR/L	..06	Y4008-M2.5x6	-	-	Y80-T08
	..09	Y4015-M3.5x9	-	-	Y80-T15

Turning - Holder - Internal

Internal Holders for CN** Insert

车削 - 刀柄 - 内圆

CN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 62 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
..-PCLNR/L (Lever Type 95°)	●	A25R - PCLNR/L 12C	0839	0840	32	25	23	17	200	CN1204
	●	A32S - PCLNR/L 12C	0841	0842	40	32	30	22	250	CN1204
	●	A40T - PCLNR/L 12C	0843	0844	50	40	37.5	27	300	CN1204
	●	A50U - PCLNR/L 12C	0845	0846	63	50	47	35	350	CN1204
	X	S25S - PCLNR/L 12C	0863	0864	32	25	23	17	250	CN1204
	X	S32T - PCLNR/L 12C	0865	0866	40	32	30	22	300	CN1204
	X	S40U - PCLNR/L 12C	0867	0868	50	40	37.5	27	350	CN1204
	X	S50V - PCLNR/L 12C	0869	0870	63	50	47	35	400	CN1204
	●	A32S - PCLNR/L 16C	0847	0848	40	32	30	22	250	CN1606
	●	A40T - PCLNR/L 16C	0849	0850	50	40	37.5	27	300	CN1606
	●	A50U - PCLNR/L 16C	0851	0852	63	50	47	35	350	CN1606
	X	S32T - PCLNR/L 16C	0871	0872	40	32	30	22	300	CN1606
	X	S40U - PCLNR/L 16C	0873	0874	50	40	37.5	27	350	CN1606
	X	S50V - PCLNR/L 16C	0875	0876	63	50	47	35	400	CN1606
	●	A40T - PCLNR/L 19C	0853	0854	50	40	37.5	27	300	CN1906
	●	A50U - PCLNR/L 19C	0855	0856	63	50	47	35	350	CN1906
	X	S40U - PCLNR/L 19C	0877	0878	50	40	37.5	27	350	CN1906
	X	S50V - PCLNR/L 19C	0879	0880	63	50	47	35	400	CN1906
..-TCLNR/L (Hole Clamp Type 95°)	X	S25S - TCLNR/L 12	0881	0882	32	25	23	17	250	CN1204
	X	S32T - TCLNR/L 12	0883	0884	40	32	30	22	300	CN1204
	X	S40U - TCLNR/L 12	0885	0886	50	40	37.5	27	350	CN1204
	X	S50V - TCLNR/L 12	0887	0888	63	50	47	35	400	CN1204
	X	S32T - TCLNR/L 16	0889	0890	40	32	30	22	300	CN1606
	X	S40U - TCLNR/L 16	0891	0892	50	40	37.5	27	350	CN1606
	X	S50V - TCLNR/L 16	0893	0894	63	50	47	35	400	CN1606

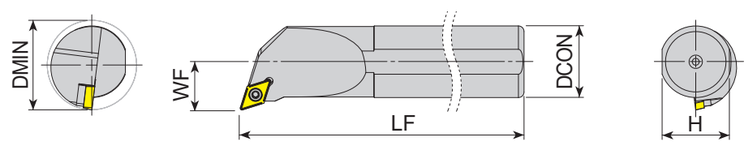
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
..PCLNR/L	..25..12C	YAPL-02	YALV-08-M8x16	YACK-05	Y4015-M4x11	-	-	YAACN-3-0001	-	YAAY-02	YAAL-03-3
	..32~50..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAACN-3-0001	-	YAAY-02	YAAL-03-3
	..16C	YAPL-04	YALV-04-M8x22	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0002	-	YAAY-03	YAAL-03-3
	..19C	YAPL-05	YALV-05-M10x27	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0003	-	YAAY-04	YAAL-05-4
..TCLNR/L	..25..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAACN-3-0001	YAAV-13-M5x8	-	YAAL-03-3
	..32~50..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAACN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
	..16	-	-	YATK-04	YAKV-19-M7x25	YABPL-02	-	YAACN-3-0002	YAAV-05-M6x15	-	YAAL-05-4

Turning - Holder - Internal

Internal Holders for DC** Insert

车削 - 刀柄 - 内圆

DC**刀片可用的外圆刀柄



: p. 81 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
..-SDQCR/L (Screw Type 107.5°)	●	A10H - SDQCR/L 07	1172	1173	13	10	9	7	100	DC0702
	●	A12H - SDQCR/L 07	1174	1175	16	12	11	9	100	DC0702
	●	A16M - SDQCR/L 07	1176	1177	20	16	14.8	11	150	DC0702
	●	A20P - SDQCR/L 07	1178	1179	25	20	18.3	13	170	DC0702
	X	S10K - SDQCR/L 07	1188	1189	13	10	9	7	125	DC0702
	X	S12K - SDQCR/L 07	1190	1191	16	12	11	9	125	DC0702
	X	S16P - SDQCR/L 07	1192	1193	20	16	14.8	11	170	DC0702
	X	S20R - SDQCR/L 07	1194	1195	25	20	18.3	13	200	DC0702
	●	A16M - SDQCR/L 11	1180	1181	20	16	14.8	11	150	DC11T3
	●	A20P - SDQCR/L 11	1182	1183	25	20	18.3	13	170	DC11T3
	●	A25R - SDQCR/L 11	1184	1185	32	25	23	17	200	DC11T3
	●	A32S - SDQCR/L 11	1186	1187	40	32	30	22	250	DC11T3
	X	S16P - SDQCR/L 11	1196	1197	20	16	14.8	11	170	DC11T3
	X	S20R - SDQCR/L 11	1198	1199	25	20	18.3	13	200	DC11T3
	X	S25S - SDQCR/L 11	1200	1201	32	25	23	17	250	DC11T3
	X	S32T - SDQCR/L 11	1202	1203	40	32	30	22	300	DC11T3
	X	S40U - SDQCR/L 11	1204	1205	50	40	37.5	27	350	DC11T3

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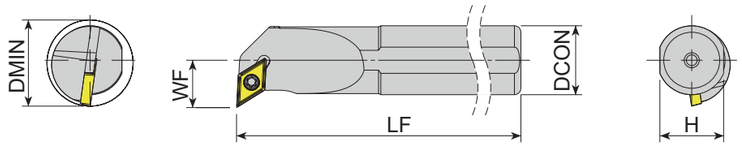
Series	Size	Screw	Shim	Shim Screw	Torx Key
..SDQCR/L	..07	Y4008-M2.5x6	-	-	Y80-T08
	..16..11	Y4015-M3.5x9	-	-	Y80-T15
	..20..11	Y4015-M3.5x11	-	-	Y80-T15
	..25..11	Y4015-M3.5x12	YAADN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..32..11	Y4015-M3.5x14	YAADN-2-0001	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - Internal

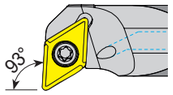
Internal Holders for DC** Insert

车削 - 刀柄 - 内圆

DC**刀片可用的外圆刀柄



: p. 81 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
 ..-SDUCR/L (Screw Type 93°)	●	A10H - SDUCR/L 07	1206	1207	13	10	9	8	100	DC0702
	●	A12H - SDUCR/L 07	1208	1209	16	12	11	9	100	
	●	A16M - SDUCR/L 07	1210	1211	20	16	14.8	11	150	
	●	A20P - SDUCR/L 07	1212	1213	25	20	18.3	13	170	
	X	S10K - SDUCR/L 07	1222	1223	13	10	9	8	125	
	X	S12K - SDUCR/L 07	1224	1225	16	12	11	9	125	
	X	S16P - SDUCR/L 07	1226	1227	20	16	14.8	11	170	
	X	S20R - SDUCR/L 07	1228	1229	25	20	18.3	13	200	
	●	A16M - SDUCR/L 11	1214	1215	20	16	14.8	11	150	DC11T3
	●	A20P - SDUCR/L 11	1216	1217	25	20	18.3	13	170	
	●	A25R - SDUCR/L 11	1218	1219	32	25	23	17	200	
	●	A32S - SDUCR/L 11	1220	1221	40	32	30	22	250	
	X	S16P - SDUCR/L 11	1230	1231	20	16	14.8	11	170	
	X	S20R - SDUCR/L 11	1232	1233	25	20	18.3	13	200	
	X	S25S - SDUCR/L 11	1234	1235	32	25	23	17	250	
	X	S32T - SDUCR/L 11	1236	1237	40	32	30	22	300	
	X	S40U - SDUCR/L 11	1238	1239	50	40	37.5	27	350	
	X	S50V - SDUCR/L 11	-	1240	63	50	47	35	400	
 E..-SDUCR/L (Screw Type 93° Carbide)	●	E10M - SDUCR/L 07	1241	1242	13	10	9	8	150	DC0702
	●	E12Q - SDUCR/L 07	1243	1244	16	12	11	9	180	
	●	E16R - SDUCR/L 11	0339	1245	20	16	14.8	11	200	DC11T3
	●	E20S - SDUCR/L 11	1246	1247	23	20	18.3	12	250	

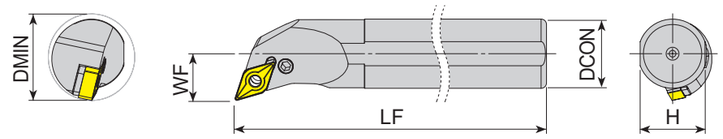
Series	Size	Screw	Shim	Shim Screw	Torx Key
..SDUCR/L	..07	Y4008-M2.5x6	-	-	Y80-T08
	..16..11	Y4015-M3.5x9	-	-	Y80-T15
	..20..11	Y4015-M3.5x11	-	-	Y80-T15
	..25..11	Y4015-M3.5x12	YAADN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..32..11	Y4015-M3.5x14	YAADN-2-0001	YAAV-06-M3.5x11	Y80-T15
E..SDUCR/L	..07	Y4008-M2.5x6	-	-	Y80-T08
	..11	Y4015-M3.5x9	-	-	Y80-T15

Turning - Holder - Internal

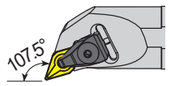
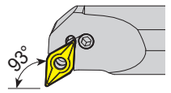
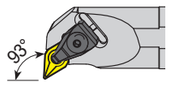
Internal Holders for DN** Insert

车削 - 刀柄 - 内圆

DN**刀片可用的外圆刀柄



: p. 65 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
 ..-PDQNR/L (Lever Type 107.5°)	●	A32S - PDQNR/L 1504	0895	-	40	32	30	22	250	DN1504
	●	A40T - PDQNR/L 1504	0896	-	50	40	37.5	27	300	
	X	S32T - PDQNR/L 1504	0903	-	40	32	30	22	300	
	X	S40U - PDQNR/L 1504	0904	-	50	40	37.5	27	350	
	X	S50V - PDQNR/L 1504	0905	-	63	50	47	35	400	
	●	A32S - PDQNR/L 15	0897	0898	40	32	30	22	250	DN1506
	●	A40T - PDQNR/L 15	0899	0900	50	40	37.5	27	300	
	●	A50U - PDQNR/L 15	0901	0902	63	50	47	35	350	
	X	S32T - PDQNR/L 15	0906	0907	40	32	30	22	300	
	X	S40U - PDQNR/L 15	0908	0909	50	40	37.5	27	350	
	X	S50V - PDQNR/L 15	0910	0911	63	50	47	35	400	
 ..-TDQNR/L (Hole Clamp Type 107.5°)	X	S25S - TDQNR/L 15	0912	0913	32	25	23	17	250	DN1506
	X	S32T - TDQNR/L 15	0914	0915	40	32	30	22	300	
	X	S40U - TDQNR/L 15	0916	0917	50	40	37.5	27	350	
	X	S50V - TDQNR/L 15	0918	0919	63	50	47	35	400	
 ..-PDUNR/L (Lever Type 93°)	●	A32S - PDUNR/L 15	0920	0921	40	32	30	22	250	DN1506
	●	A40T - PDUNR/L 15	0922	0923	50	40	37.5	27	300	
	●	A50U - PDUNR/L 15	0924	0925	63	50	47	35	350	
	X	S25S - PDUNR/L 15	0934	0935	32	25	23	19	250	
	X	S32T - PDUNR/L 15	0936	0937	40	32	30	22	300	
	X	S40U - PDUNR/L 15	0938	0939	50	40	37.5	27	350	
	X	S50V - PDUNR/L 15	0940	0941	63	50	47	35	400	
 ..-TDUNR/L (Hole Clamp Type 93°)	X	S25S - TDUNR/L 15	0942	0943	34	25	23	17	250	DN1506
	X	S32T - TDUNR/L 15	0944	0945	40	32	30	22	300	
	X	S40U - TDUNR/L 15	0946	0947	50	40	37.5	27	350	
	X	S50V - TDUNR/L 15	0948	0949	63	50	47	35	400	

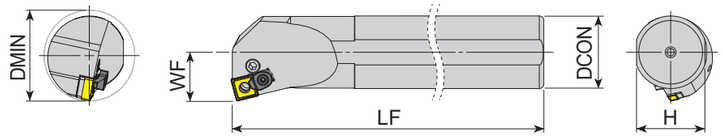
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
..PDQNR/L	..15	YAPL-03	YALV-03-M8x19	-	-	-	-	YAADN-3-0001	-	YAAY-02	YAAL-03-3
	..1504	YAPL-03	YALV-03-M8x19	-	-	-	-	YAADN-2-0003	-	YAAY-02	YAAL-03-3
..TDQNR/L	..25..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	-	YAADN-3-0001	YAAV-13-M5x8	-	YAAL-03-3
	..32~50..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
..PDUNR/L	..25..15	YAPL-03	YALV-08-M8x16	-	-	-	-	YAADN-3-0001	-	YAAY-02	YAAL-03-3
	..32~50..15	YAPL-03	YALV-03-M8x19	-	-	-	-	YAADN-3-0001	-	YAAY-02	YAAL-03-3
..TDUNR/L	..25..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-13-M5x8	-	YAAL-03-3
	..32~50..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - Internal

Internal Holders for SN** Insert

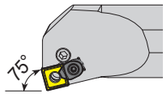
车削 - 刀柄 - 内圆

SN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 69 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
 ..-PSKNR/L (Lever Type 75°)	X	S25S - PSKNR/L 12C	0958	0959	32	25	23	17	250	SN1204
		S32T - PSKNR/L 12C	0960	0961	40	32	30	22	300	

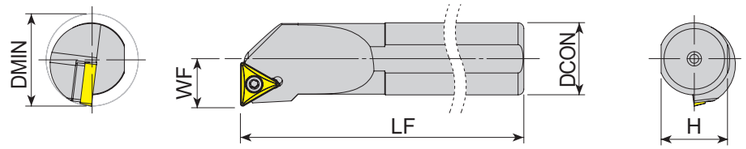
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Shim	Shim Pin	Allen Key
..PSKNR/L	..25..12C	YAPL-02	YALV-08-M8x16	YACK-05	Y4015-M4x11	YAASN-3-0004	YAAY-02	YAAL-03-3
	..32..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	YAASN-3-0004	YAAY-02	YAAL-03-3

Turning - Holder - Internal

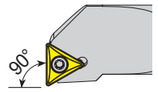
Internal Holders for TC** Insert

车削 - 刀柄 - 内圆

TC**刀片可用的外圆刀柄



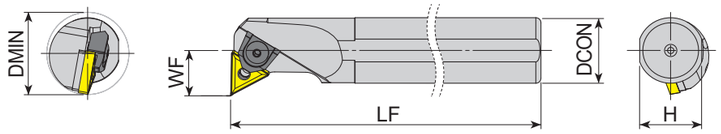
: p. 84 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
 ..-STFCR/L (Screw Type 90°)	X	S12K - STFCR/L 11	1264	1265	17	12	11	9	125	TC1102
		S16P - STFCR/L 11	1266	1267	20	16	14.8	11	170	
		S20R - STFCR/L 11	1268	1269	25	20	18.3	13	200	
		S16P - STFCR/L 16	1270	1271	20	16	14.8	11	170	TC16T3
		S20R - STFCR/L 16	1272	1273	25	20	18.3	13	200	
	X	S25S - STFCR/L 16	1274	1275	32	25	23	17	250	
		S32T - STFCR/L 16	1276	1277	40	32	30	22	300	
		S40U - STFCR/L 16	1278	-	50	40	37.5	27	350	
..-STUCR/L (Screw Type 93°)	X	S12K - STUCR/L 11	1279	1280	17	12	11	9	125	TC1102
		S16P - STUCR/L 11	1281	1282	20	16	14.8	11	170	
		S20R - STUCR/L 11	1283	1284	25	20	18.3	13	200	
		S16P - STUCR/L 16	1285	1286	20	16	14.8	11	170	TC16T3
		S20R - STUCR/L 16	1287	1288	25	20	18.3	13	200	
	X	S25S - STUCR/L 16	1289	1290	32	25	23	17	250	
		S32T - STUCR/L 16	1291	1292	40	32	30	22	300	
		S40U - STUCR/L 16	1293	1294	50	40	37.5	27	350	

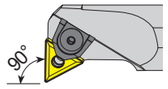
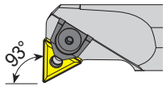
Series	Size	Screw	Shim	Shim Screw	Torx Key
..STFCR/L	..12~20..11	Y4008-M2.5x6	-	-	Y80-T08
	..16..16	Y4015-M3.5x9	-	-	Y80-T15
	..20..16	Y4015-M3.5x11	-	-	Y80-T15
	..25..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..32~40..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15
..STUCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16..16	Y4015-M3.5x9	-	-	Y80-T15
	..20..16	Y4015-M3.5x11	-	-	Y80-T15
	..25..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..32~40..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15

Internal Holders for TN** Insert

TN**刀片可用的外圆刀柄



: p. 71 Unit(单位):mm

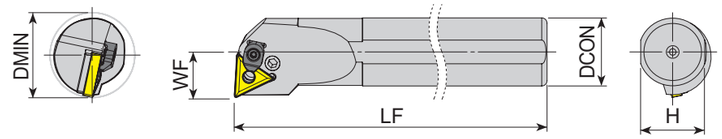
Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
 ..-MTFNR/L (Pin + Top Clamp Type 90˚)	X	S20R - MTFNR/L 16	0972	-	25	20	18.3	14	200	TN1604
		S25S - MTFNR/L 16	0973	0974	32	25	23	17	250	
		S32T - MTFNR/L 16	0975	0976	40	32	30	22	300	
		S40U - MTFNR/L 16	0977	0978	50	40	37.5	27	350	
	X	S32T - MTFNR/L 22	0979	0980	40	32	30	22	300	TN2204
		S40U - MTFNR/L 22	0981	0982	50	40	37.5	27	350	
		S50V - MTFNR/L 22	0983	-	63	50	47	35	400	
 ..-MTUNR/L (Pin + Top Clamp Type 93˚)	X	S20R - MTUNR/L 16	0998	0999	25	20	18.3	13	200	TN1604
		S25S - MTUNR/L 16	1000	1001	32	25	23	17	250	
		S32T - MTUNR/L 16	1002	1003	40	32	30	22	300	
		S40U - MTUNR/L 16	1004	1005	50	40	37.5	27	350	
		S50V - MTUNR/L 16	1006	1007	63	50	47	35	400	

▶ NEXT PAGE

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
..MTFNR/L	..20..16	-	-	YAMK-02	YAKV-17-M5x15	-	-	YAPM-03	-	-	-	YAAL-03-3
	..25..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-14	YAATN-2-0002	-	-	YAAL-03-3
	..32~40..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-01	YAATN-2-0002	-	-	YAAL-03-3
	..22	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-02	YAATN-3-0015	-	-	YAAL-03-3
..MTUNR/L	..20..16	-	-	YAMK-02	YAKV-17-M5x15	-	-	YAPM-03	-	-	-	YAAL-03-3
	..25..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-14	YAATN-2-0002	-	-	YAAL-03-3
	..32~50..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-01	YAATN-2-0002	-	-	YAAL-03-3

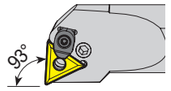
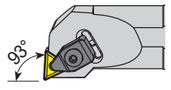
Internal Holders for TN** Insert

TN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 71 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
 ..-PTUNR/L (Lever Type 93˚)	X	S16P - PTUNR/L 16	1014	1015	20	16	14.8	11	170	TN1604
		S20R - PTUNR/L 16	1016	1017	25	20	18.3	13	200	
		S25S - PTUNR/L 16C	1018	1019	32	25	23	17	250	
		S32T - PTUNR/L 16C	1020	1021	40	32	30	22	300	
		S40U - PTUNR/L 16C	1022	1023	50	40	37.5	27	350	
	X	S32T - PTUNR/L 22C	1024	1025	40	32	30	22	300	TN2204
		S40U - PTUNR/L 22C	1026	1027	50	40	37.5	27	350	
		S50V - PTUNR/L 22C	1028	1029	63	50	47	35	400	
 ..-TTUNR/L (Hole Clamp Type 93˚)	X	S25S - TTUNR/L 16	1030	1031	32	25	23	17	250	TN1604
		S32T - TTUNR/L 16	1032	1033	40	32	30	22	300	
	X	S25S - TTUNR/L 22	1034	1035	32	25	23	17	250	TN2204
		S32T - TTUNR/L 22	1036	1037	40	32	30	22	300	
		S40U - TTUNR/L 22	1038	1039	50	40	37.5	27	350	
		S50V - TTUNR/L 22	1040	1041	63	50	47	35	400	

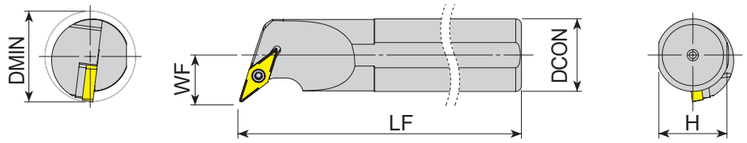
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
..PTUNR/L	..16..16	YAPL-08	YALV-07-M6x13	-	-	-	-	-	-	-	YAAY-07	YAAL-02-2.5
	..20..16	YAPL-01	YALV-01-M6x14	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..16C	YAPL-01	YALV-02-M6x17	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-03-3
..TTUNR/L	..16	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAATN-2-0002	YAAV-03-M5x12	-	YAAL-03-3
	..22	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAATN-3-0015	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - Internal

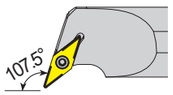
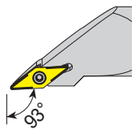
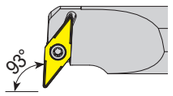
车削 - 刀柄 - 内圆

Internal Holders for VB** Insert

VB**刀片可用的外圆刀柄



: p. 85 Unit(单位):mm

Series			Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
	..-SVQBR/L (Screw Type 107.5°)	●	A20Q - SVQBR/L 16	1299	1300	30	20	18.3	20	180	VB1604
		●	A25S - SVQBR/L 16	1301	1302	32	25	23	17	250	
		●	A32S - SVQBR/L 16	1303	1304	40	32	30	22	250	
		X	S25S - SVQBR/L 16	1305	1306	32	25	23	17	250	
		X	S32T - SVQBR/L 16	1307	1308	40	32	30	22	300	
		X	S40U - SVQBR/L 16	1309	1310	50	40	37.5	27	350	
	..-SVJBR/L (Screw Type 93°)	X	S25S - SVJBR/L 16	1295	1296	32	25	23	17	250	VB1604
		X	S32T - SVJBR/L 16	1297	1298	40	32	30	22	300	
	..-SVUBR/L (Screw Type 93°)	●	A20Q - SVUBR/L 16	1311	-	30	20	18.3	20	180	VB1604
		●	A32S - SVUBR/L 16	1312	1313	40	32	30	22	250	
		X	S25S - SVUBR/L 16	1314	1315	32	25	23	19	250	
		X	S32T - SVUBR/L 16	1316	1317	40	32	30	22	300	
		X	S40U - SVUBR/L 16	1318	1319	50	40	37.5	27	350	

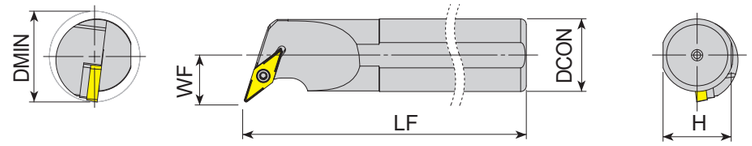
Series	Size	Screw	Shim	Shim Screw	Torx Key
..SVQBR/L	..20..16	Y4015-M3.5x11	-	-	Y80-T15
	A - ..25..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
	S - ..25..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-08-M3.5x8	Y80-T15
	..32~40..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
..SVJBR/L	..16	Y4015-M3.5x12	YAAVN-2-0002	YAAV-08-M3.5x8	Y80-T15
..SVUBR/L	..20..16	Y4015-M3.5x11	-	-	Y80-T15
	..25~40..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - Internal

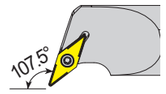
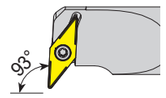
车削 - 刀柄 - 内圆

Internal Holders for VC** Insert

VC**刀片可用的外圆刀柄



: p. 86 Unit(单位):mm

Series			Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
	..-SVQCR/L (Screw Type 107.5°)	X	S25S - SVQCR/L 16	1320	1321	32	25	23	17	250	VC1604
		X	S32T - SVQCR/L 16	1322	1323	40	32	30	22	300	
		X	S40U - SVQCR/L 16	1324	1325	50	40	37.5	27	350	
	..-SVUCR/L (Screw Type 93°)	●	A25R - SVUCR/L 16	1326	-	32	25	23	19	200	VC1604
		X	S25S - SVUCR/L 16	1327	1328	32	25	23	19	250	
		X	S32T - SVUCR/L 16	1329	1330	40	32	30	22	300	
		X	S40U - SVUCR/L 16	1331	1332	50	40	37.5	27	350	

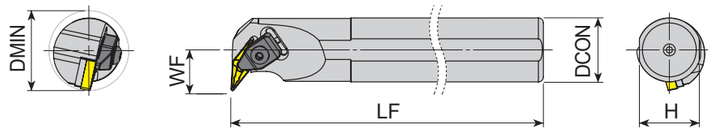
Series	Size	Screw	Shim	Shim Screw	Torx Key
..SVQCR/L	..25..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-08-M3.5x8	Y80-T15
	..32~40..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
..SVUCR/L	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - Internal

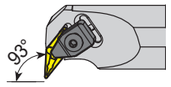
Internal Holders for VN** Insert

车削 - 刀柄 - 内圆

VN**刀片可用的外圆刀柄



: p. 75 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
 ..-TVUNR/L (Hole Clamp Type 93°)	X	S25S - TVUNR/L 16	1042	1043	36	25	23	20	250	VN1604
		S32T - TVUNR/L 16	1044	1045	40	32	30	22	300	
		S40U - TVUNR/L 16	1046	1047	50	40	37.5	27	350	

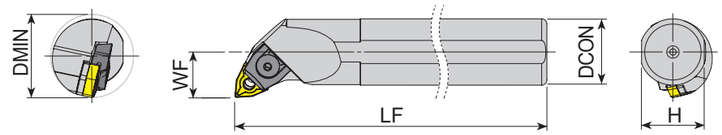
Series	Size	Clamp	Clamp Screw	Upper Ring	Shim	Shim Screw	Allen Key
..TVUNR/L	..16	YATK-01	YAKV-01-M5x22	YABPL-01	YAAVN-2-0002	YAAV-04-M5x12	YAAL-03-3

Turning - Holder - Internal

Internal Holders for WN** Insert

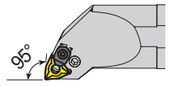
车削 - 刀柄 - 内圆

WN**刀片可用的外圆刀柄



* 'C' Letter at Last : Optional Clamp Included
* 最后带'C'：包含可选夹紧

: p. 77 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
 ..-MWLNR/L (Pin + Top Clamp Type 95°)	X	S16P - MWLNR/L 06	1064	1065	20	16	14.8	11	170	WN0604
		S20R - MWLNR/L 06	1066	1067	25	20	18.3	13	200	
		S25S - MWLNR/L 06	1068	1069	32	25	23	17	250	
	X	S25S - MWLNR/L 08	1070	1071	32	25	23	17	250	WN0804
		S32T - MWLNR/L 08	1072	1073	40	32	30	22	300	
		S40U - MWLNR/L 08	1074	1075	50	40	37.5	27	350	
 ..-PWLNR/L (Lever Type 95°)	●	A20P - PWLNR/L 06	1048	1049	25	20	18.3	13	170	WN0604
		A25R - PWLNR/L 06	1050	1051	32	25	23	17	200	
		A32S - PWLNR/L 06	1052	1053	40	32	30	22	250	
	X	S20R - PWLNR/L 06	1076	1077	25	20	18.3	13	200	
		S25S - PWLNR/L 06	1078	1079	32	25	23	17	250	
		S32T - PWLNR/L 06	1080	1081	40	32	30	22	300	
	●	A25R - PWLNR/L 08C	1054	1055	32	25	23	17	200	WN0804
		A32S - PWLNR/L 08C	1056	1057	40	32	30	22	250	
		A40T - PWLNR/L 08C	1058	1059	50	40	37.5	27	300	
		A50U - PWLNR/L 08C	1060	1061	63	50	47	35	350	
	X	S25S - PWLNR/L 08C	1082	1083	32	25	23	17	250	
		S32T - PWLNR/L 08C	1084	1085	40	32	30	22	300	
		S40U - PWLNR/L 08C	1086	1087	50	40	37.5	27	350	
		S50V - PWLNR/L 08C	1088	1089	63	50	47	35	400	

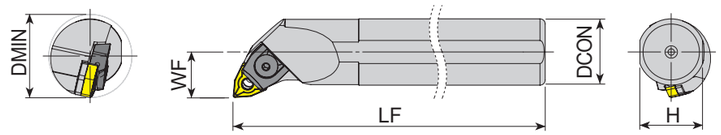
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
..MWLNR/L	..16..06	-	-	YAMK-01	YAKV-17-M5x15	-	-	YAPM-09	-	-	-	-
	..20..06	-	-	YAMK-01	YAKV-04-M5x17	-	-	YAPM-10	-	-	-	-
	..25..06	-	-	YAMK-01	YAKV-04-M5x17	-	-	YAPM-08	-	-	-	-
	..25..08	-	-	YAMK-05	YAKV-27-M6x20	YABPL-01	YAS-01	YAPM-04	YAAWN-3-0001	-	-	YAAL-03-3
	..32~40..08	-	-	YAMK-05	YAKV-03-M6x22	YABPL-01	YAS-01	YAPM-02	YAAWN-3-0001	-	-	YAAL-03-3
..PWLNR/L	..20..06	YAPL-01	YALV-01-M6x14	-	-	-	-	-	YAAWN-SW317	-	YAAY-01	YAAL-02-2.5
	..25~32..06	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAAWN-SW317	-	YAAY-01	YAAL-02-2.5
	..08C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAAWN-3-0001	-	YAAY-02	YAAL-03-3

Turning - Holder - Internal

Internal Holders for WN** Insert

车削 - 刀柄 - 内圆

WN**刀片可用的外圆刀柄



: p. 77 Unit(单位):mm

Series		Designation	EDP 2700.. R	EDP 2700.. L	DMIN	DCON	H	WF	LF	Insert
..-TWLNR/L (Hole Clamp Type 95°)	X	S25S - TWLNR/L 06	1090	1091	32	25	23	17	250	WN0604
	X	S32T - TWLNR/L 06	1092	1093	40	32	30	22	300	WN0604
	●	A40T - TWLNR/L 08	1062	-	50	40	37.5	27	300	WN0804
	●	A50U - TWLNR/L 08	1063	-	63	50	47	35	350	WN0804
	X	S25S - TWLNR/L 08	1094	1095	32	25	23	17	250	WN0804
	X	S32T - TWLNR/L 08	1096	1097	40	32	30	22	300	WN0804
	X	S40U - TWLNR/L 08	1098	1099	50	40	37.5	27	350	WN0804
	X	S50V - TWLNR/L 08	1100	1101	63	50	47	35	400	WN0804

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
..TWLNR/L	..06	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAAWN-SW317	YAAV-01-M3x10	-	YAAL-03-3
	..25..08	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAAWN-3-0001	YAAV-13-M5x8	-	YAAL-03-3
	..32~50..08	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAAWN-3-0001	YAAV-02-M5x12	-	YAAL-03-3

Turning Inserts Overview

车削刀片概况

Negative Inserts 负角型刀片

Shape 形状		Series 系列	Size & Thickness 尺寸 & 厚度									Page 页数
C		CNMA			1204				1606	1906		62
		CNMG			1204				1606	1906		62
D		DNMA				1504	1506					65
		DNMG				1504	1506					65
K		KNUX						1604				68
S		SNMA			1204		1506					69
		SNMG			1204							69
T		TNMA						1604				71
		TNMG						1604			2204	71
		TNUX						1604				74
V		VNMA						1604				75
		VNMG						1604				75
W		WNMA		0804								77
		WNMG	0604	0804								77

Positive Inserts 正角型刀片

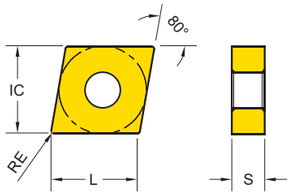
Shape 形状		Series 系列	Size & Thickness 尺寸 & 厚度									Page 页数
C		CCGT				09T3				1204		80
		CCMT	0602			09T3				1204		80
D		DCGT							11T3			81
		DCMT		0702					11T3			81
R		RCMT	0602		0803		10T3			1204		82
S		SCMT				09T3				1204		83
T		TCGT									16T3	84
		TCMT						1102			16T3	84
V		VBMT								1604		85
		VCGT / VCMT								1604		86

Turning Inserts - Negative

CNMG / CNMA (80° Negative)

车削刀片 - 负角型

CNMG/CNMA (80°负角型)



Series	L	IC	S
CN** 1204	12	12.7	4.76
CN** 1606	16	15.875	6.35
CN** 1906	19	19.05	6.35

●: Stock item 常备库存
○: Order made item 按订单生产

EDP 2200..

CNMA CNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
..MA	Cast iron 铸铁	CNMA 120404	0.4	0.15 ~ 0.5	0.5 ~ 2.5	● 0089	● 0354									
		CNMA 120408	0.8	0.15 ~ 0.5	1.0 ~ 3.5	● 0010	● 0355									
		CNMA 120412	1.2	0.15 ~ 0.5	1.5 ~ 5.0	● 0011	● 0356									
		CNMA 120416	1.6	0.15~0.5	1.5 ~ 5.0	● 1188										
		CNMA 160612	1.2	0.15 ~ 0.5	1.5 ~ 5.0	● 0012	● 0357									
		CNMA 160616	1.6	0.15 ~ 0.5	2.0 ~ 5.0	● 0446	● 0447									
		CNMA 190612	1.2	0.15~0.5	1.5~9.0	● 0989	● 0990									
		CNMA 190616	1.6	0.15 ~ 1.0	3.0 ~ 10.0	● 0448	● 0449									
-UF	Finishing 精加工	CNMG 120404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 1.5		● 0178		● 0179	● 0180	● 0003					
		CNMG 120408 - UF	0.8	0.05 ~ 0.25	1.0 ~ 2.5		● 0189	● 1027	● 0190	● 0191						
-UL	Light Machining and Sticky Material 半精加工，粘性材料	CNMG 120404 - UL	0.4	0.1 ~ 0.3	0.5 ~ 2.0		● 0358		● 0359	● 0524						
		CNMG 120408 - UL	0.8	0.1 ~ 0.3	1.0 ~ 3.0		● 0192		● 0193	● 0194						
		CNMG 120412 - UL	1.2	0.1 ~ 0.3	1.5 ~ 3.5		● 0201		● 0202	● 0203						
-UM	Medium Machining Unstable condition 普通加工 (不稳定工况)	CNMG 120404 - UM	0.4	0.15 ~ 0.3	0.5 ~ 1.5		● 0184		● 0185	● 0186						
		CNMG 120408 - UM	0.8	0.15 ~ 0.3	0.5 ~ 2.0	● 0338	● 0114	● 0843	● 0100	● 0140						
		CNMG 120412 - UM	1.2	0.15 ~ 0.3	1.5 ~ 3.0		● 0525		● 0486	● 0526						

Cutting Speed 切削速度

Vc (m/min.)

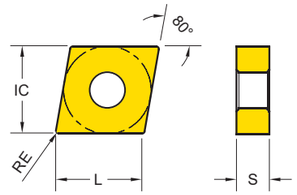
ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative

CNMG / CNMA (80° Negative)

车削刀片 - 负角型

CNMG/CNMA (80°负角型)



Series	L	IC	S
CN** 1204	12	12.7	4.76
CN** 1606	16	15.875	6.35
CN** 1906	19	19.05	6.35

●: Stock item 常备库存
○: Order made item 按订单生产

EDP 2200..

CNMA CNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-UG	Medium Machining at stable condition 普通加工 (稳定工况)	CNMG 120404 - UG	0.4	0.2 ~ 0.4	0.5 ~ 2.0		● 0181		● 0182	● 0183						
		CNMG 120408 - UG	0.8	0.2 ~ 0.4	1.0 ~ 3.0	● 0337	● 0113	1001	● 0099	● 0139	0001					
		CNMG 120412 - UG	1.2	0.2 ~ 0.4	1.5 ~ 4.0	● 0685	● 0198		● 0199	● 0200						
		CNMG 160608 - UG	0.8	0.20 ~ 0.40	1.5 ~ 5.0	● 1077			● 0748	● 0749						
		CNMG 160612 - UG	1.2	0.2 ~ 0.4	1.5 ~ 5.0	● 0791	● 0530		● 0508	● 0531						
		CNMG 160616 - UG	1.6	0.2 ~ 0.4	1.8 ~ 5.0	● 1229	● 0534		● 0510	● 0535						
		CNMG 190608 - UG	0.8	0.20 ~ 0.50	3.0 ~ 7.0		● 0801		● 0802	● 0803						
-UC	Cast iron and Medium roughing 铸铁，半粗加工	CNMG 120404 - UC	0.4	0.2 ~ 0.4	0.5 ~ 2.5	● 0096	● 0115		● 0101	● 0116						
		CNMG 120408 - UC	0.8	0.2 ~ 0.4	1.0 ~ 4.0	● 0062	● 0117		● 0102	● 0118						
		CNMG 120412 - UC	1.2	0.2 ~ 0.4	1.5 ~ 4.5	● 0088	● 0119		● 0103	● 0120						
-UR	Roughing 粗加工	CNMG 120408 - UR	0.8	0.3 ~ 0.5	1.0 ~ 4.0	● 1050	● 0195		● 0196	● 0197						
		CNMG 120412 - UR	1.2	0.3 ~ 0.5	1.5 ~ 5.0	● 1051	● 0204		● 0205	● 0206	● 0004					
		CNMG 120416 - UR	1.6	0.3 ~ 0.5	2.0 ~ 5.0		● 0707		● 0623	● 0847						
		CNMG 160608 - UR	0.8	0.3 ~ 0.5	1.0 ~ 5.0				● 0750	● 0751						
		CNMG 160612 - UR	1.2	0.3 ~ 0.5	1.5 ~ 5.0	● 0792	● 0532		● 0509	● 0533						
		CNMG 160616 - UR	1.6	0.3 ~ 0.5	2.0 ~ 5.0	● 0676	● 0536		● 0511	● 0537						
		CNMG 190608 - UR	0.8	0.3 ~ 0.8	3.0 ~ 9.0		● 0804		● 0805	● 0806						
		CNMG 190612 - UR	1.2	0.3 ~ 0.8	3.0 ~ 9.0	● 0450	● 0451		● 0698	● 0699						
		CNMG 190616 -UR	1.6	0.3 ~ 0.8	3.0 ~ 9.0	● 0480	● 0481		● 0734	● 0735						

Cutting Speed 切削速度

Vc (m/min.)

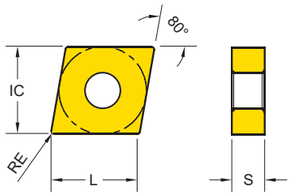
ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative

CNMG / CNMA (80° Negative)

车削刀片 - 负角型

CNMG/CNMA (80°负角型)



Series	L	IC	S
CN** 1204	12	12.7	4.76
CN** 1606	16	15.875	6.35
CN** 1906	19	19.05	6.35

● : Stock item 常备库存
○ : Order made item 按订单生产

CNMA CNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..										
						P05 K10	P10 K20	P15	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20
						YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
-MF	Stainless steel Finishing 不锈钢精加工	CNMG 120404 - MF	0.4	0.07 ~ 0.3	0.2 ~ 1.5					● 1237		● 0609	● 0613			
		CNMG 120408 - MF	0.8	0.07 ~ 0.3	0.2 ~ 1.5					● 0652		● 0538	● 0539	● 0627		
		CNMG 120412 -MF	1.2	0.07~0.3	0.2~1.5					● 1025						
-MM	Stainless steel Medium 不锈钢普通加工	CNMG 120404 - MM	0.4	0.2 ~ 0.35	0.5 ~ 3.0							● 0547	● 0548			
		CNMG 120408 - MM	0.8	0.2 ~ 0.35	1.0 ~ 3.5				● 0360	● 0188	● 0187	● 0494	● 0495	● 0607		
		CNMG 120412 - MM	1.2	0.2 ~ 0.35	1.5 ~ 3.5					● 0521		● 0549	● 0550	● 0626		
-MR	Stainless steel Roughing 不锈钢粗加工	CNMG 120408 - MR	0.8	0.3 ~ 0.55	1.2 ~ 5.5					● 0594		● 0540	● 0541	● 0608		
		CNMG 120412 - MR	1.2	0.3 ~ 0.55	1.5 ~ 5.5					● 0840		● 0610	● 0614	● 0628		
-KR	Cast Iron Heavy Roughing 铸铁重切削	CNMG 120408 - KR	0.8	0.30 ~ 0.60	1.0 ~ 5.0	● 0718	● 0800									
		CNMG 120412 - KR	1.2	0.30 ~ 0.60	1.5 ~ 5.0	● 0719	● 1100									

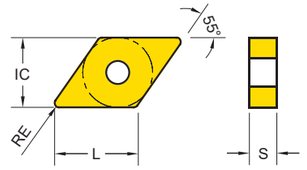
Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative

DNMG / DNMA (55° Negative)

车削刀片 - 负角型

DNMG / DNMA (55°负角型)



Series	L	IC	S
DN** 1504	14	12.7	4.76
DN** 1506	14	12.7	6.35

● : Stock item 常备库存
○ : Order made item 按订单生产

DNMA DNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..										
						P05 K10	P10 K20	P15	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20
						YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
..MA	Cast iron 铸铁	DNMA 150408	0.8	0.15 ~ 0.5	1.0 ~ 3.0	● 0573	● 0574									
		DNMA 150412	1.2	0.15 ~ 0.5	1.5 ~ 4.0	● 0575	● 0576									
		DNMA 150608	0.8	0.15 ~ 0.5	1.0 ~ 3.0	● 0091	● 1129									
		DNMA 150612	1.2	0.15 ~ 0.5	1.5 ~ 4.0	● 0092	● 1130									
-UF	Finishing 精加工	DNMG 150404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 1.5		● 0363		● 0364	● 0365	● 0016					
		DNMG 150408 -UF	0.8	0.05 ~ 0.25	1.0 ~ 2.5		● 0856	● 1030	● 0774	● 0857						
		DNMG 150604 - UF	0.4	0.05 ~ 0.25	1.0 ~ 2.0		● 0225		● 0226	● 0227	● 0018					
		DNMG 150608 - UF	0.8	0.05 ~ 0.25	1.5 ~ 3.5		● 0231		● 0232	● 0233						
-UL	Light Machining and Sticky Material 半精加工，粘性材料	DNMG 110404 -UL	0.4	0.1~0.3	0.5 ~ 2.5		● 1239		● 1240	● 1241						
		DNMG 110408 -UL	0.8	0.1~0.3	0.5 ~ 2.5		● 1242		● 1243	● 1244						
		DNMG 150404 - UL	0.4	0.10 ~ 0.3	0.5 ~ 3.0		● 0686		● 0687	● 0708						
		DNMG 150408 - UL	0.8	0.10 ~ 0.3	1.0 ~ 3.0		● 0489	● 1028	● 0504	● 0505						
		DNMG 150412 - UL	1.2	0.10 ~ 0.3	1.5 ~ 3.0		● 0709	● 1029	● 1108	● 1109						
		DNMG 150604 - UL	0.4	0.1 ~ 0.3	0.5 ~ 2.0		● 0369		● 0370	● 1110						
		DNMG 150608 - UL	0.8	0.1 ~ 0.3	1.5 ~ 3.0		● 0237		● 0238	● 0239						
		DNMG 150612 - UL	1.2	0.10 ~ 0.3	1.5 ~ 3.0		● 0246		● 0247	● 0248						

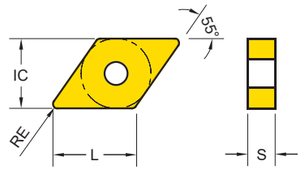
Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative

DNMG / DNMA (55° Negative)

车削刀片 - 负角型

DNMG / DNMA (55°负角型)



Series	L	IC	S
DN** 1504	14	12.7	4.76
DN** 1506	14	12.7	6.35

●: Stock item 常备库存
○: Order made item 按订单生产

DNMA DNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..										
						P05 K10	P10 K20	P15	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20
						YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
-UM	 Medium Machining Unstable condition 普通加工 (不稳定工况)	DNMG 150408 -UM	0.8	0.15~0.3	1.0 ~ 3.0	● 1106	● 0688		● 0689	● 0701						
		DNMG 150412 - UM	1.2	0.15 ~ 0.3	1.5 ~ 4.0	● 0604	● 0512		● 0488	● 0705						
		DNMG 150608 - UM	0.8	0.15 ~ 0.3	0.5 ~ 2.0		● 0240		● 0241	● 0242						
		DNMG 150612 - UM	1.2	0.15 ~ 0.3	1.5 ~ 3.0	● 1149	● 1132		● 0695	● 0706						
-UG	 Medium Machining at stable condition 普通加工 (稳定工况)	DNMG 150404 - UG	0.4	0.2 ~ 0.4	0.5 ~ 3.0		● 1131		● 0772	● 1137						
		DNMG 150408 - UG	0.8	0.2 ~ 0.4	1.0 ~ 2.5	● 0452	● 0366		● 0367	● 0368	● 0017					
		DNMG 150412 - UG	1.2	0.2 ~ 0.4	1.5 ~ 3.0	● 0703	● 1107		● 0487	● 0704						
		DNMG 150604 - UG	0.4	0.2 ~ 0.4	0.5 ~ 2.0		● 0228		● 0229	● 0230						
		DNMG 150608 - UG	0.8	0.2 ~ 0.4	1.0 ~ 3.0	● 0453	● 0234		● 0235	● 0236	● 0019					
		DNMG 150612 - UG	1.2	0.2 ~ 0.4	1.5 ~ 3.5	● 0454	● 0243		● 0244	● 0245						
-UC	 Cast iron and Medium roughing 铸铁，半粗加工	DNMG 150408 - UC	0.8	0.2 ~ 0.4	1.0 ~ 3.0	● 0577	● 0578	● 1273	● 1193	● 0700						
		DNMG 150412 - UC	1.2	0.2 ~ 0.4	1.5 ~ 3.5	● 0579	● 0580		● 1168	● 0702						
		DNMG 150608 - UC	0.8	0.2 ~ 0.4	1.0 ~ 3.0	● 0090	● 0121	● 1272	● 0104	● 0122						
		DNMG 150612 - UC	1.2	0.2 ~ 0.4	1.5 ~ 3.5	● 0098	● 0123		● 0105	● 0124						
-UR	 Roughing 粗加工	DNMG 150408 - UR	0.8	0.3 ~ 0.5	1.0 ~ 3.5		● 0585									
		DNMG 150412 - UR	1.2	0.3 ~ 0.5	1.5 ~ 4.0	● 1127	● 0581		● 1134							
		DNMG 150608 - UR	0.8	0.3 ~ 0.5	1.0 ~ 5.0	● 0691	● 0692		● 0693	● 0854						
		DNMG 150612 - UR	1.2	0.3 ~ 0.5	1.5 ~ 4.0	● 1258	● 0371		● 0372	● 0373	● 0020					

Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

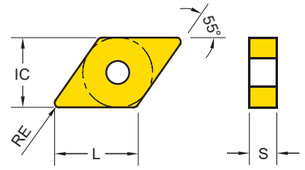
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Turning Inserts - Negative

DNMG / DNMA (55° Negative)

车削刀片 - 负角型

DNMG / DNMA (55°负角型)



Series	L	IC	S
DN** 1504	14	12.7	4.76
DN** 1506	14	12.7	6.35

●: Stock item 常备库存
○: Order made item 按订单生产

DNMA DNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..										
						P05 K10	P10 K20	P15	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20
						YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
-MF	 Stainless steel Finishing 不锈钢精加工	DNMG 150404 - MF	0.4	0.07 ~ 0.3	0.2 ~ 1.5							● 0848	● 0771			
		DNMG 150408 - MF	0.8	0.07 ~ 0.3	0.2 ~ 1.5					● 0807		● 0849	● 0773			
		DNMG 150604 - MF	0.4	0.07 ~ 0.3	0.2 ~ 1.5							● 0811	● 0850			
		DNMG 150608 - MF	0.8	0.07 ~ 0.3	0.2 ~ 1.5					● 0813		● 0812	● 0859			
-MM	 Stainless steel Medium 不锈钢普通加工	DNMG 150404 - MM	0.4	0.2 ~ 0.35	0.5 ~ 3.0					● 0527		● 0551	● 0552			
		DNMG 150408 - MM	0.8	0.2 ~ 0.35	1.0 ~ 3.5					● 0506		● 0513	● 0514			
		DNMG 150412 - MM	1.2	0.2 ~ .35	1.5 ~ 3.5					● 0529		● 0561	● 0562			
		DNMG 150604 - MM	0.4	0.2 ~ 0.35	0.5 ~ 3.0					● 0528		● 0553	● 0554			
		DNMG 150608 - MM	0.8	0.2 ~ 0.35	1.0 ~ 3.5					● 0507		● 0515	● 0516	● 0690		
		DNMG 150612 - MM	1.2	0.2 ~ 0.35	1.5 ~ 3.5					● 0496		● 0563	● 0564			
-MR	 Stainless steel Roughing 不锈钢粗加工	DNMG 150408 - MR	0.8	0.3 ~ 0.55	2.0 ~ 5.5					● 1036		● 0914	● 0808	● 0809		
		DNMG 150412 - MR	1.2	0.3 ~ 0.55	2.0 ~ 5.5							● 0929	● 0930	● 0810		
		DNMG 150608 - MR	0.8	0.3 ~ 0.55	2.0 ~ 5.5					● 1037		● 0860	● 0814	● 0815		
		DNMG 150612 - MR	1.2	0.3 ~ 0.55	2.0 ~ 5.5							● 0861	● 0862	● 0816		

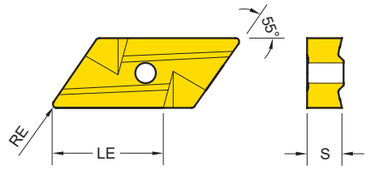
Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative

KNUX (55° - 2 Corners Single Side)

车削刀片 - 负角型

KNUX (55°2刀尖 单面)



Series	LE	S
KN** 1604	15	4.76

EDP 2200..

● : Stock item 常备库存
○ : Order made item 按订单生产

KNUX	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
..UX Left	KNUX 160405 L	0.5	0.1 ~ 0.4	0.5 ~ 6.0		● 0249		● 0250	● 0251	● 0079					
..UX Right	KNUX 160405 R	0.5	0.1 ~ 0.4	0.5 ~ 6.0		● 0252		● 0253	● 0254	● 0080					
	KNUX 160410 R	1.0	0.1~0.4	0.5 ~ 6.0				● 1155	● 1156						

Cutting Speed 切削速度

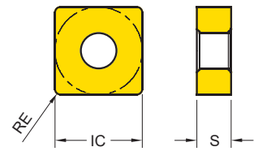
ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
				Vc (m/min.)																					
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative

SNMG / SNMA (90° Negative)

车削刀片 - 负角型

SNMG/SNMA (90°负角型)



Series	IC	S
SN** 1204	12.7	4.76
SN** 1506	15.875	6.35

EDP 2200..

● : Stock item 常备库存
○ : Order made item 按订单生产

SNMA SNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
..MA	Cast iron 铸铁	SNMA 120408	0.8	0.15 ~ 0.5	1 ~ 3.5	● 0027	● 1166									
		SNMA 120412	1.2	0.15 ~ 0.5	1.5 ~ 5.0	● 0028	● 1133									
		SNMA 150612	1.2	0.15 ~ 0.5	1.5 ~ 5.0	● 729	● 1150									
		SNMA 190616	1.6	0.15~0.5	3~10	● 1184	● 1261									
-UF	Finishing 精加工	SNMG 120404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 1.5						● 0029					
-UL	Light Machining and Sticky Material 半精加工，粘性材料	SNMG 120404 - UL	0.4	0.10 ~ 0.30	0.5 ~ 3.0		● 1167		● 0747	● 1194						
		SNMG 120408 - UL	0.8	0.1 ~ 0.3	1.0 ~ 3.0		● 0389		● 0390	● 0391						
-UM	Medium Machining Unstable condition 普通加工 (不稳定工况)	SNMG 120408 - UM	0.8	0.15 ~ 0.30	1.0 ~ 3.0	● 0983	● 0739		● 0784	● 0740						
-UG	Medium Machining at stable condition 普通加工 (稳定工况)	SNMG 120408 - UG	0.8	0.2 ~ 0.4	1.0 ~ 3.0	● 1190	● 0141		● 0142	● 0143	● 0030					
		SNMG 120412 - UG	1.2	0.2 ~ 0.4	1.5 ~ 4.0	● 1164	● 0258		● 0259	● 0260						
		SNMG 120416 - UG	1.6	0.2 ~ 0.40	2.0 ~ 3.0	● 1165	● 0744	● 0789	● 1169							
-UC	Cast iron and Medium roughing 铸铁，半粗加工	SNMG 120408 - UC	0.8	0.2 ~ 0.4	1.0 ~ 4.0	● 0073	● 0125		● 0106	● 0126						
		SNMG 120412 - UC	1.2	0.2 ~ 0.4	1.5 ~ 4.5	● 0074	● 0127		● 0107	● 0128						

Cutting Speed 切削速度

ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
				Vc (m/min.)																					
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

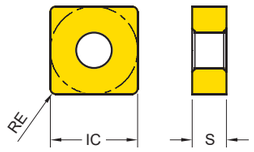
Turning Inserts - Negative

SNMG / SNMA (90° Negative)

车削刀片 - 负角型

SNMG/SNMA (90°负角型)

Series	IC	S
SN** 1204	12.7	4.76



● : Stock item 常备库存
○ : Order made item 按订单生产

SNMA SNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200.. P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-UR	Roughing 粗加工	SNMG 120408 - UR	0.8	0.3 ~ 0.5	1 ~ 4.5	● 1163	● 0392		● 0393	● 0394						
		SNMG 120412 - UR	1.2	0.3 ~ 0.5	1.5 ~ 5.0	● 1052	● 0261		● 0262	● 0263	● 0031					
		SNMG 120416 -UR	1.6	0.3~0.5	2~5	● 0988	● 0974	● 0975	● 0971	● 0977						
-MF	Stainless steel Finishing 不锈钢精加工	SNMG 120404 - MF	0.4	0.07~0.3	0.2~1.5							● 0978	● 0979	● 0981		
		SNMG 120408 - MF	0.8	0.07 ~ 0.3	0.2 ~ 1.5					● 0818		● 0653	● 0654	● 0817		
		SNMG 120412 - MF	1.2	0.07 ~ 0.3	0.2 ~ 1.5					● 0821		● 0655	● 0656	● 0820		
-MM	Stainless steel Medium 不锈钢普通加工	SNMG 120408 - MM	0.8	0.2 ~ 0.35	1.0 ~ 3.5							● 0555	● 0556	● 1014		
		SNMG 120412 - MM	1.2	0.2 ~ 0.35	1.5 ~ 3.5							● 0565	● 0566			
-MR	Stainless steel Roughing 不锈钢粗加工	SNMG 120408 - MR	0.8	0.3 ~ 0.55	0.15 ~ 5.5					● 1059		● 0657	● 0658	● 0819		
		SNMG 120412 - MR	1.2	0.3 ~ 0.55	0.15 ~ 5.5					● 0823		● 0659	● 0660	● 0822		
-KR	Cast Iron Heavy Roughing 铸铁重切削	SNMG 120412 -KR	1.2	0.3 ~ 0.6	1.5 ~ 5.0	● 1063	● 1065									
		SNMG 120416 - KR	1.6	0.30 ~ 0.60	2.0 ~ 5.0	● 0730	● 0950	● 0965								

Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

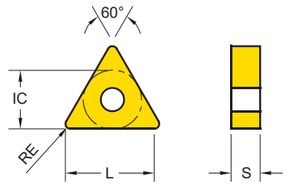
Turning Inserts - Negative

TNMG / TNMA (60° Negative)

车削刀片 - 负角型

TNMG / TNMA (60°负角型)

Series	L	IC	S
TN** 1604	15.7	9.525	4.76
TN** 2204	22	12.7	4.76



● : Stock item 常备库存
○ : Order made item 按订单生产

TNMA TNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200.. P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
..MA	Cast iron 铸铁	TNMA 160408	0.8	0.15 ~ 0.5	1.0 ~ 3.0	● 0035	● 1191									
		TNMA 160412	1.2	0.15 ~ 0.5	1.5 ~ 4.0	● 0036	● 1192									
-UF	Finishing 精加工	TNMG 160404 - UF	0.4	0.05 ~ 0.25	1.0 ~ 2.0		● 0270		● 0271	● 0272	● 0039					
		TNMG 160408 - UF	0.8	0.05 ~ 0.25	1.5 ~ 3.5		● 0276		● 0277	● 0278						
		TNMG 160412 - UF	1.2	0.05 ~ 0.25	1.5 ~ 3.5		● 0721		● 0588	● 1197						
		TNMG 220404 - UF	0.4	0.1 ~ 0.35	1.0 ~ 4.0		● 0407		● 1203	● 1205	● 0042					
-UL	Light Machining and Sticky Material 半精加工，粘性材料	TNMG 160408 - UL	0.8	0.1 ~ 0.3	1.0 ~ 3.0		● 0279	● 0752	● 0280	● 0281						
		TNMG 160412 - UL	1.2	0.1 ~ 0.3	1.5 ~ 3.5		● 0884	● 0868	● 0621	● 1198						
-UM	Medium Machining Unstable condition 普通加工 (不稳定工况)	TNMG 160404 - UM	0.4	0.15~0.3	0.5 ~ 3.0	● 0949	● 0948	● 0844	● 0952	● 0954						
		TNMG 160408 - UM	0.8	0.15 ~ 0.3	0.5 ~ 2.0	● 1053	● 0282	● 0758	● 0283	● 0284						
		TNMG 160412 - UM	1.2	0.15 ~ 0.3	1.5 ~ 3.0	● 0596	● 0597	● 0760	● 0586	● 0710						

Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

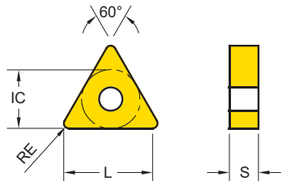
Turning Inserts - Negative

TNMG / TNMA (60° Negative)

车削刀片 - 负角型

TNMG / TNMA (60°负角型)

Series	L	IC	S
TN** 1604	15.7	9.525	4.76
TN** 2204	22	12.7	4.76



● : Stock item 常备库存
○ : Order made item 按订单生产

TNMA TNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..										
						P05 P10 K10 K20	P15	P20	P30 M20	P20	M15 M30 S10 S20	M40 S30	N20	N20		
						YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
-UG	Medium Machining at stable condition 普通加工 (稳定工况)	TNMG 160404 - UG	0.4	0.2 ~ 0.4	0.5 ~ 2	● 0458	● 0273		● 0274	● 0275						
		TNMG 160408 - UG	0.8	0.2 ~ 0.4	1.0 ~ 3.0	● 0459	● 0144	● 0757	● 0145	● 0146	● 0037					
		TNMG 160412 - UG	1.2	0.2 ~ 0.4	1.5 ~ 3.0	● 0605	● 0606	● 0759	● 0587	● 0939						
		TNMG 220408 - UG	0.8	0.25 ~ 0.6	1.0 ~ 4.0	● 1061	● 0285		● 0286	● 0287	● 0040					
		TNMG 220416 - UG	1.6	0.25 ~ 0.6	2.0 ~ 6.0	● 1209	● 0851	● 0863	● 0852	● 1263						
-UC	Cast iron and Medium roughing 铸铁，半粗加工	TNMG 160404 - UC	0.4	0.2 ~ 0.4	0.5 ~ 2.5	● 0399	● 0400		● 0401	● 0402						
		TNMG 160408 - UC	0.8	0.2 ~ 0.4	1.0 ~ 3.0	● 0075	● 0129		● 0108	● 0130						
		TNMG 160412 - UC	1.2	0.2 ~ 0.4	1.5 ~ 3.5	● 0076	● 0131		● 0109	● 0132						
-UR	Roughing 粗加工	TNMG 160408 - UR	0.8	0.30 ~ 0.50	1.0 ~ 5.0	● 0680	● 0669		● 0670	● 1054						
		TNMG 160412 - UR	1.2	0.3 ~ 0.5	1.5 ~ 3.0	● 0602	● 0404	● 0888	● 0405	● 0406	● 0038					
		TNMG 220412 - UR	1.2	0.30 ~ 0.65	1.5 ~ 4.0	● 0408	● 0409		● 0410	● 0411	● 0041					
		TNMG 220416 - UR	1.6	0.3 ~ 0.65	2.0 ~ 4.0	● 0460	● 0461		● 0696	● 0711						

Cutting Speed 切削速度

ISO	VDI	Sub Group 分组		Vc (m/min.)																	
				YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

YGTURN

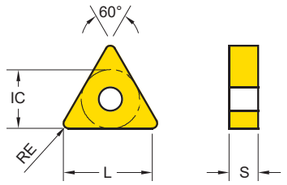
Turning Inserts - Negative

TNMG / TNMA (60° Negative)

车削刀片 - 负角型

TNMG / TNMA (60°负角型)

Series	L	IC	S
TN** 1604	15.7	9.525	4.76
TN** 2204	22	12.7	4.76



● : Stock item 常备库存
○ : Order made item 按订单生产

TNMA TNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..										
						P05 P10 K10 K20	P15	P20	P30 M20	P20	M15 M30 S10 S20	M40 S30	N20	N20		
						YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
-MF	Stainless steel Finishing 不锈钢精加工	TNMG 160404 - MF	0.4	0.07 ~ 0.3	0.2 ~ 1.5							● 0824	● 0775			
		TNMG 160408 - MF	0.8	0.07 ~ 0.3	0.15 ~ 1.5							● 0589	● 0776	● 0825		
-MM	Stainless steel Medium 不锈钢普通加工	TNMG 160404 - MM	0.4	0.2 ~ 0.35	0.5 ~ 3							● 0567	● 0568			
		TNMG 160408 - MM	0.8	0.2 ~ 0.35	1 ~ 3.5							● 0569	● 0570	● 0913		
		TNMG 160412 - MM	1.2	0.2 ~ 0.35	1.5 ~ 3.5							● 0611	● 0603			
-MR	Stainless steel Roughing 不锈钢粗加工	TNMG 160408 - MR	0.8	0.30 ~ 0.55	2.0 ~ 5.5					● 0727		● 0826	● 0985	● 0726		
		TNMG 160412 - MR	1.2	0.30 ~ 0.55	2.0 ~ 5.5					● 1062		● 0995	● 0827	● 0828		

Cutting Speed 切削速度

ISO	VDI	Sub Group 分组		Vc (m/min.)																	
				YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

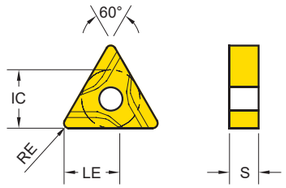
Turning Inserts - Negative

TNUX (60° Negative)

车削刀片 - 负角型

TNUX (60°负角型)

Series	LE	IC	S
TN** 1604	9.4	9.525	4.76



● : Stock item 常备库存
○ : Order made item 按订单生产

EDP 2200..

TNUX	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
..UX Left	TNUX 160404 L	0.4	0.1 ~ 0.3	0.5 ~ 4		● 0412		● 0413	● 1264	● 0043					
	TNUX 160408 L	0.8	0.1 ~ 0.4	0.5 ~ 6		● 0414		● 0415	● 0675	● 0045	● 0731				
..UX Right	TNUX 160404 R	0.4	0.1 ~ 0.3	0.5 ~ 4		● 0288		● 0289	● 0290	● 0044					
	TNUX 160408 R	0.8	0.1 ~ 0.4	0.5 ~ 6		● 0291		● 0292	● 0293	● 0046					

Cutting Speed 切削速度

ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

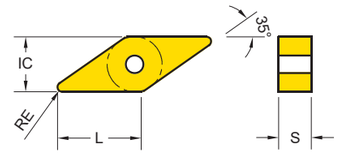
Turning Inserts - Negative

VNMG / VNMA (35° Negative)

车削刀片 - 负角型

VNMG / VNMA (35°负角型)

Series	L	IC	S
VN** 1604	15.8	9.525	4.76



● : Stock item 常备库存
○ : Order made item 按订单生产

EDP 2200..

VNMA VNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
..MA Cast iron 铸铁	VNMA 160408	0.8	0.15 ~ 0.5	1 ~ 3	● 0162	● 1275									
-UF Finishing 精加工	VNMG 160404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2		● 0306		● 0307	● 0308	● 0049					
	VNMG 160408 - UF	0.8	0.05 ~ 0.25	1 ~ 2.5		● 0309		● 0310	● 0311						
-UL Light Machining and Sticky Material 半精加工，粘性材料	VNMG 160404 -UL	0.4	0.1 ~ 0.3	0.5 ~ 3		● 0886		● 0912	● 0723						
	VNMG 160408 - UL	0.8	0.10 ~ 0.30	1 ~ 2.5		● 0428	● 0790	● 0429							
-UM Medium Machining Unstable condition 普通加工 (不稳定工况)	VNMG 160412 - UM	1.2	0.15 ~ 0.3	1.5 ~ 3	● 1230	● 0736	● 0870	● 0737	● 1214						
-UG Medium Machining at stable condition 普通加工 (稳定工况)	VNMG 160404 - UG	0.4	0.2 ~ 0.4	0.5 ~ 3		● 0993		● 0940	● 0994						
	VNMG 160408 - UG	0.8	0.2 ~ 0.4	1 ~ 3	● 0462	● 0312		● 0313	● 0314	● 0050					
	VNMG 160412 - UG	1.2	0.2 ~ 0.4	1.5 ~ 3		● 0931		● 0927	● 0917						

Cutting Speed 切削速度

ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

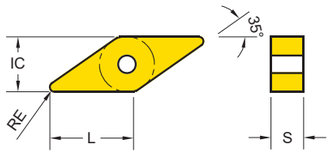
Turning Inserts - Negative

VNMG / VNMA (35° Negative)

车削刀片 - 负角型

VNMG / VNMA (35°负角型)

Series	L	IC	S
VN** 1604	15.8	9.525	4.76



● : Stock item 常备库存
○ : Order made item 按订单生产

VNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..										
						P05 K10	P10 K20	P15	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20
						YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
-UC	Cast iron and Medium roughing 铸铁，半粗加工	VNMG 160404 - UC	0.4	0.2 ~ 0.4	0.5 ~ 2.5	● 0885	● 0423		● 1276	● 1277						
		VNMG 160408 - UC	0.8	0.2 ~ 0.4	1 ~ 3	● 0094	● 0424		● 0425	● 0426						
-UR	Roughing 粗加工	VNMG 160412 - UR	1.2	0.3 ~ 0.5	1.2 ~ 3	● 1231	● 0430	● 0871	● 0431	● 0432	● 0051					
-MF	Stainless steel Finishing 不锈钢精加工	VNMG 160408 - MF	0.8	0.07 ~ 0.3	0.2 ~ 1.5					● 0830		● 0829	● 0947			
-MM	Stainless steel Medium 不锈钢普通加工	VNMG 160404 - MM	0.4	0.2 ~ 0.35	0.5 ~ 3.5							● 0661	● 0662			
		VNMG 160408 - MM	0.8	0.2 ~ 0.35	0.5 ~ 3.5							● 0663	● 0664			
-MR	Stainless steel Roughing 不锈钢粗加工	VNMG 160408 -MR	0.8	0.30 ~ 0.55	2.0 ~ 5.5					● 0832		● 1020	● 0831			

Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

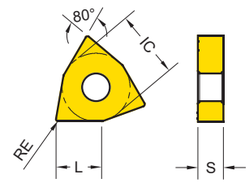
Turning Inserts - Negative

WNMG / WNMA (80° Trigonal Negative)

车削刀片 - 负角型

WNMG/WNMA (80°桃形 负角型)

Series	L	IC	S
WN** 0604	5.7	9.525	4.76
WN** 0804	7.8	12.7	4.76



● : Stock item 常备库存
○ : Order made item 按订单生产

WNMA WNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..										
						P05 K10	P10 K20	P15	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20
						YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
..MA	Cast iron 铸铁	WNMA 080404	0.4	0.15 ~ 0.5	0.5 ~ 2.5	● 0052	● 1262									
		WNMA 080408	0.8	0.15 ~ 0.5	1 ~ 3.5	● 0053	● 0433									
		WNMA 080412	1.2	0.15 ~ 0.5	1.5 ~ 5	● 0054	● 0434									
-UF	Finishing 精加工	WNMG 060404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 1.5		● 0435		● 0436	● 0437	● 0058					
		WNMG 080404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2		● 0315		● 0316	● 0317	● 0055					
		WNMG 080408 - UF	0.8	0.05 ~ 0.25	1 ~ 2.5		● 0321		● 0322	● 0323						
-UL	Light Machining and Sticky Material 半精加工，粘性材料	WNMG 060408 - UL	0.8	0.1 ~ 0.3	1 ~ 2.5		● 0439		● 0440	● 0441						
		WNMG 080408 - UL	0.8	0.1 ~ 0.3	1 ~ 3		● 0324		● 0325	● 0326						
-UM	Medium Machining Unstable condition 普通加工 (不稳定工况)	WNMG 060404 - UM	0.4	0.15 ~ 0.30	1.0 ~ 2.5	● 1259	● 0741		● 0785	● 0742						
		WNMG 060408 - UM	0.8	0.15 ~ 0.3	1 ~ 2	● 1260	● 0600		● 0601	● 1271						
		WNMG 080404 - UM	0.4	0.15 ~ 0.30	0.5 ~ 3.0		● 0786		● 0787	● 0788						
		WNMG 080408 - UM	0.8	0.15 ~ 0.3	1 ~ 3	● 0470	● 0327	● 0761	● 0328	● 0329						
		WNMG 080412 - UM	1.2	0.15 ~ 0.3	1.5 ~ 3	● 1210	● 0649	● 0762	● 0598	● 0712						
		WNMG 080416 - UM	1.6	0.15 ~ 0.3	2 ~ 3.5	● 1234	● 0593	● 0763	● 0584	● 0713						

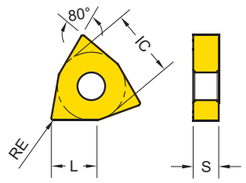
Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative

WNMG / WNMA (80° Trigonal Negative)

车削刀片 - 负角型

WNMG/WNMA (80°桃形 负角型)



Series	L	IC	S
WN** 0604	5.7	9.525	4.76
WN** 0804	7.8	12.7	4.76

EDP 2200..

● : Stock item 常备库存
○ : Order made item 按订单生产

WNMA WNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-UG	Medium Machining at stable condition 普通加工 (稳定工况)	WNMG 060408 - UG	0.8	0.2 ~ 0.4	1 ~ 2.5	● 0697	● 1047		● 0438	● 0874	● 0059					
		WNMG 080404 - UG	0.4	0.2 ~ 0.4	1.5 ~ 2.5	● 1232	● 0318		● 0319	● 0320						
		WNMG 080408 - UG	0.8	0.2 ~ 0.4	1 ~ 3.5	● 0463	● 0147	● 0582	● 0148	● 0149	● 0056					
		WNMG 080412 - UG	1.2	0.2 ~ 0.4	1.5 ~ 3.5	● 0466	● 0503	● 0648	● 0490	● 0941						
		WNMG 080416 - UG	1.6	0.2 ~ 0.4	2 ~ 4	● 1233	● 1056	● 0764	● 0583	● 1238						
-UC	Cast iron and Medium roughing 铸铁，半粗加工	WNMG 060408 - UC	0.8	0.2 ~ 0.4	1 ~ 3	● 0095	● 0875		● 0876	● 0724						
		WNMG 080404 - UC	0.4	0.25 ~ 0.4	0.5 ~ 3.5	● 0097	● 0133		● 0110	● 0134						
		WNMG 080408 - UC	0.8	0.2 ~ 0.4	1 ~ 4	● 0077	● 0135	● 0733	● 0111	● 0136						
		WNMG 080412 - UC	1.2	0.2 ~ 0.4	1.5 ~ 4.5	● 0078	● 0137	● 0630	● 0112	● 0138						
		WNMG 080416 - UC	1.6	0.2 ~ 0.4	2 ~ 4	● 1055	● 1235		● 1236	● 0743						
-UR	Roughing 粗加工	WNMG 060412 - UR	1.2	0.3 ~ 0.5	1.5 ~ 3	● 1066	● 1057		● 1058	● 1060						
		WNMG 080408 - UR	0.8	0.3 ~ 0.5	1.2 ~ 5	● 0464	● 0465		● 0471	● 0472						
		WNMG 080412 - UR	1.2	0.3 ~ 0.5	1.5 ~ 5	● 0467	● 0442	● 0631	● 0443	● 0444	● 0057					
		WNMG 080416 - UR	1.6	0.3 ~ 0.5	2 ~ 5	● 0468	● 0469	● 0889	● 0725	● 0714						

Cutting Speed 切削速度

Vc (m/min.)

ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

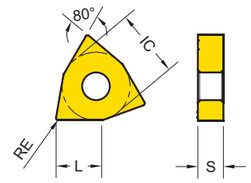
YG TURN

Turning Inserts - Negative

WNMG / WNMA (80° Trigonal Negative)

车削刀片 - 负角型

WNMG/WNMA (80°桃形 负角型)



Series	L	IC	S
WN** 0604	5.7	9.525	4.76
WN** 0804	7.8	12.7	4.76

EDP 2200..

● : Stock item 常备库存
○ : Order made item 按订单生产

WNMA WNMG		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-MF	Stainless steel Finishing 不锈钢精加工	WNMG 060404 -MF	0.4	0.07 ~ 0.3	0.2 ~ 1.5		○ 0833			● 0996		● 1215	● 1217			
		WNMG 060408 -MF	0.8	0.07 ~ 0.3	0.5 ~ 2.0							● 1216	● 1218			
		WNMG 080404 - MF	0.4	0.07 ~ 0.3	0.15 ~ 1.5					● 0834		● 0667	● 0668	● 0970		
		WNMG 080408 - MF	0.8	0.07 ~ 0.3	0.2 ~ 1.5							● 0617	● 0618			
-MM	Stainless steel Medium 不锈钢普通加工	WNMG 080404 - MM	0.4	0.2 ~ 0.35	0.5 ~ 3.5							● 0571	● 0572			
		WNMG 080408 - MM	0.8	0.2 ~ 0.35	1 ~ 3.5					● 0491		● 0497	● 0498			
		WNMG 080412 - MM	1.2	0.2 ~ 0.35	1.5 ~ 3.5							● 0612	● 0615			
-MR	Stainless steel Roughing 不锈钢粗加工	WNMG 060412 - MR	1.2	0.2 ~ 0.5	1.2 ~ 4							● 0616				
		WNMG 080408 - MR	0.8	0.30 ~ 0.55	2.0 ~ 5.5							● 0619	● 0620	● 0835		
		WNMG 080412 - MR	1.2	0.30 ~ 0.55	2.0 ~ 5.5					● 0837		● 0665	● 0666	● 0836		
-KR	Cast Iron Heavy Roughing 铸铁重切削	WNMG 080408 - KR	0.8	0.30 ~ 0.60	1.0 ~ 5.0	● 0720	● 1038									
		WNMG 080412 - KR	1.2	0.30 ~ 0.60	1.5 ~ 5.0	● 0522	● 0542									

Cutting Speed 切削速度

Vc (m/min.)

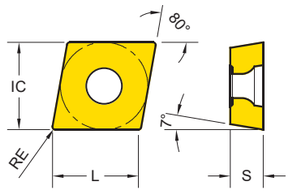
ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Positive

CCMT / CCGT (80° Positive)

车削刀片 - 正角型

CCMT/CCGT (80°正角型)



Series	L	IC	S
CC** 0602	6.2	6.35	2.38
CC** 09T3	9.2	9.525	3.97
CC** 1204	12.4	12.7	4.76

● : Stock item 常备库存
○ : Order made item 按订单生产

EDP 2200..

CCGT CCMT		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-AL	Aluminum 铝	CCGT 09T302 - AL	0.2	0.02 ~ 0.08	0.5 ~ 1										● 0340	● 0339
		CCGT 09T304 - AL	0.4	0.05 ~ 0.25	0.5 ~ 2										● 0330	● 0081
		CCGT 09T308 - AL	0.8	0.1 ~ 0.35	1 ~ 3										● 0331	● 0082
		CCGT 120402 - AL	0.2	0.04 ~ 0.15	0.1 ~ 1										● 0474	● 0473
		CCGT 120404 - AL	0.4	0.04 ~ 0.2	0.3 ~ 1.5										● 0476	● 0475
		CCGT 120408 - AL	0.8	0.04 ~ 0.2	0.6 ~ 2.5										● 0478	● 0477
-UF	Finishing 精加工	CCMT 060204 - UF	0.4	0.05 ~ 0.2	0.5 ~ 1.5		● 0163	● 0866	● 0164	● 0165						
		CCMT 09T304 - UF	0.4	0.05 ~ 0.2	0.5 ~ 2		● 0169		● 0170	● 0171						
		CCMT 09T308 - UF	0.8	0.05 ~ 0.25	1 ~ 2		● 0964		● 0951	● 0953						
-UG	General 普通加工	CCMT 060204 - UG	0.4	0.1 ~ 0.25	0.5 ~ 2		● 0166		● 0167	● 0168	● 0006					
		CCMT 060208 - UG	0.8	0.1 ~ 0.25	0.8 ~ 2		● 0479		● 0683	● 0684	● 0009					
		CCMT 09T304 - UG	0.4	0.15 ~ 0.3	0.5 ~ 2		● 0172		● 0173	● 0174	● 0007					
		CCMT 09T308 - UG	0.8	0.15 ~ 0.3	0.8 ~ 2.5	● 0445	● 0150		● 0151	● 0152	● 0008					
		CCMT 120404 - UG	0.4	0.15 ~ 0.35	0.5 ~ 2.5		● 0175		● 0176	● 0177						
		CCMT 120408 - UG	0.8	0.15 ~ 0.35	0.8 ~ 3.5		● 0153	● 0867	● 0154	● 0155	● 0005					
		CCMT 120412 - UG	1.2	0.15 ~ 0.35	1.2 ~ 3.5		● 0483		● 0915	● 0135						

Cutting Speed 切削速度

Vc (m/min.)

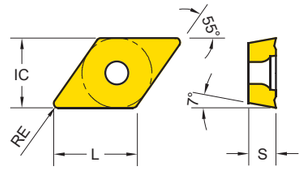
ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Positive

DCMT / DCGT (55° Positive)

车削刀片 - 正角型

DCMT/DCGT (55°正角型)



Series	L	IC	S
DC** 0702	7.5	6.35	2.38
DC** 11T3	11.2	9.525	3.97

● : Stock item 常备库存
○ : Order made item 按订单生产

EDP 2200..

DCGT DCMT		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-AL	Aluminum 铝	DCGT 11T302 - AL	0.2	0.02 ~ 0.08	0.5 ~ 1										● 0342	● 0341
		DCGT 11T304 - AL	0.4	0.05 ~ 0.25	0.5 ~ 2										● 0332	● 0083
		DCGT 11T308 - AL	0.8	0.1 ~ 0.3	1 ~ 2.5										● 0333	● 0084
-UF	Finishing 精加工	DCMT 070204 - UF	0.4	0.05 ~ 0.2	0.5 ~ 1.5		● 0207		● 0208	● 0209						
		DCMT 11T304 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2		● 0213		● 0214	● 0215						
		DCMT 11T308 - UF	0.8	0.05 ~ 0.25	1 ~ 2.5		● 0219		● 0220	● 0221						
-UG	General 普通加工	DCMT 070204 - UG	0.4	0.1 ~ 0.25	0.5 ~ 1.5		● 0210		● 0211	● 0212	● 0013					
		DCMT 070208 - UG	0.8	0.1 ~ 0.25	0.8 ~ 1.5		● 0484		● 0717	● 1136						
		DCMT 11T304 - UG	0.4	0.15 ~ 0.3	0.5 ~ 2	● 0677	● 0216		● 0217	● 0218	● 0014					
		DCMT 11T308 - UG	0.8	0.15 ~ 0.3	0.8 ~ 2.5	● 0678	● 0222		● 0223	● 0224	● 0015					

Cutting Speed 切削速度

Vc (m/min.)

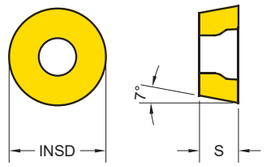
ISO	VDI	Sub Group 分组		YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Positive

RCMT (Round Positive)

车削刀片 - 正角型

RCMT (圆形)



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

● : Stock item 常备库存
○ : Order made item 按订单生产

EDP 2200..

RCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 M15 K10 S10 YG1001	P10 M30 K20 S20 YG3010	P15 YG3015	P20 P30 M20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
 General 普通加工	RCMT 0602M0	3	0.05 ~ 0.25	0.2 ~ 1.2	● 0374	● 0375		● 0376	● 1151	● 0023					
	RCMT 0803M0	4	0.05 ~ 0.3	0.5 ~ 1.5	● 0377	● 0378		● 0379	● 1152	● 0024					
	RCMT 10T3M0	5	0.1 ~ 0.35	0.5 ~ 2.5	● 0380	● 0381		● 0382	● 1153	● 0021					
	RCMT 1204M0	6	0.15 ~ 0.45	0.5 ~ 3	● 0383	● 0384		● 0385	● 1170	● 0022					

Cutting Speed 切削速度

Vc (m/min.)

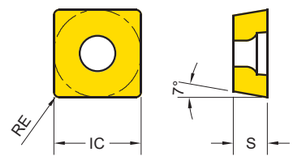
ISO	VDI	Sub Group 分组	YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel 非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel 低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel 高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic 铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel 奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron 灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron 球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al) 非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium 超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials 高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Positive

SCMT (Square Positive)

车削刀片 - 正角型

SCMT (正方形)



Series	IC	S
SC** 09T3	9.525	3.97
SC** 1204	12.7	4.76

● : Stock item 常备库存
○ : Order made item 按订单生产

EDP 2200..

SCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 M15 K10 S10 YG1001	P10 M30 K20 S20 YG3010	P15 YG3015	P20 P30 M20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-UF  Finishing 精加工	SCMT 09T304 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2		● 0386		● 0387	● 0783						
	SCMT 09T308 - UF	0.8	0.05 ~ 0.25	1 ~ 2		● 1021		● 1022	● 0997						
-UG  General 普通加工	SCMT 09T304 - UG	0.4	0.15 ~ 0.3	1 ~ 2.5	● 0455	● 0482		● 0916	● 1171	● 0025					
	SCMT 09T308 - UG	0.8	0.15 ~ 0.3	1 ~ 2.5	● 0456	● 0159		● 0160	● 0161	● 0026					
	SCMT 120408 - UG	0.8	0.15 ~ 0.35	1 ~ 3.5	● 0674	● 0255		● 0256	● 0257						

Cutting Speed 切削速度

Vc (m/min.)

ISO	VDI	Sub Group 分组	YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel 非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel 低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel 高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic 铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel 奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron 灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron 球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al) 非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium 超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials 高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

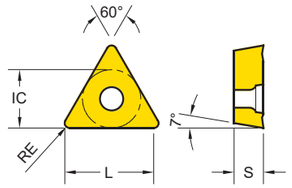
Turning Inserts - Positive

TCMT / TCGT (Triangle Positive)

车削刀片 - 正角型

TCMT/TCGT (三角形 正角型)

Series	L	IC	S
TC** 1102	10.3	6.35	2.38
TC** 16T3	15.6	9.525	3.97



EDP 2200..

●: Stock item 常备库存
○: Order made item 按订单生产

TCGT TCMT		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-AL	Aluminum 铝	TCGT 16T302 - AL	0.2	0.02 ~ 0.05	0.5 ~ 1										● 0344	● 0343
		TCGT 16T304 - AL	0.4	0.05 ~ 0.25	0.5 ~ 2										● 0334	● 0085
		TCGT 16T308 - AL	0.8	0.1 ~ 0.35	1 ~ 3										● 0335	● 0086
-UF	Finishing 精加工	TCMT 110204 - UF	0.4	0.05 ~ 0.2	0.5 ~ 2		● 0395		● 0396	● 1196						
		TCMT 16T304 - UF	0.4	0.05 ~ 0.25	0.5 ~ 3		● 0397		● 0398	● 1046	● 0033					
		TCMT 16T308 - UF	0.8	0.05 ~ 0.25	0.8 ~ 3		● 0624		● 0625	● 1045						
-UG	General 普通加工	TCMT 110204 - UG	0.4	0.15 ~ 0.25	0.5 ~ 1.5	● 0728	● 0264		● 0265	● 0266	● 0032					
		TCMT 110208 - UG	0.8	0.15 ~ 0.25	0.8 ~ 2		● 0485		● 0715	● 1204						
		TCMT 16T304 - UG	0.4	0.15 ~ 0.3	0.5 ~ 2	● 0679	● 0267		● 0268							
		TCMT 16T308 - UG	0.8	0.15 ~ 0.3	0.8 ~ 3	● 0457	● 0156		● 0157	● 0158	● 0034					

Cutting Speed 切削速度

Vc (m/min.)

ISO	VDI	Sub Group 分组	YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel 非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel 低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel 高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic 铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel 奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron 灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron 球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al) 非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium 超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials 高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

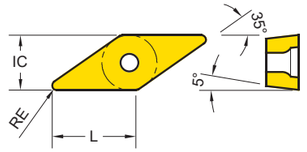
Turning Inserts - Positive

VBMT (35° Positive)

车削刀片 - 正角型

VBMT (35°正角型)

Series	L	IC	S
VB** 1604	15.8	9.525	4.76



EDP 2200..

●: Stock item 常备库存
○: Order made item 按订单生产

VBMT		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-UF	Finishing 精加工	VBMT 160404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2		● 0294		● 0295	● 0296						
		VBMT 160408 - UF	0.8	0.05 ~ 0.25	0.5 ~ 3		● 0300		● 0301	● 0302						
-UG	General 普通加工	VBMT 160404 - UG	0.4	0.15 ~ 0.30	0.5 ~ 2.5	● 0682	● 0297		● 0298	● 0299	● 0047					
		VBMT 160408 - UG	0.8	0.15 ~ 0.3	1 ~ 3	● 0681	● 0303		● 0304	● 0305	● 0048					

Cutting Speed 切削速度

Vc (m/min.)

ISO	VDI	Sub Group 分组	YG1001 Min	YG1001 Max	YG3010 Min	YG3010 Max	YG3015 Min	YG3015 Max	YG3020 Min	YG3020 Max	YG3030 Min	YG3030 Max	YG801 Min	YG801 Max	YG211 Min	YG211 Max	YG213 Min	YG213 Max	YG214 Min	YG214 Max	YG100 Min	YG100 Max	YG10 Min	YG10 Max
P	1~5	Non-Alloyed Steel 非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel 低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel 高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic 铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel 奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron 灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron 球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al) 非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium 超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials 高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

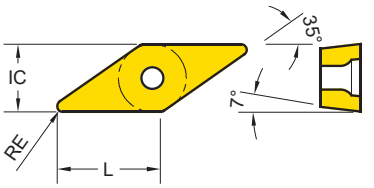
Turning Inserts - Positive

VCMT / VCGT (35° Positive)

车削刀片 - 正角型

VCMT/VCGT (35°正角型)

Series	L	IC	S
VC** 1604	15.8	9.525	4.76



●: Stock item 常备库存
○: Order made item 按订单生产

EDP 2200..

VCGT VCMT		Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10 YG1001	P10 K20 YG3010	P15 YG3015	P20 YG3020	P30 M20 YG3030	P20 YG801	M15 S10 YG211	M30 S20 YG213	M40 S30 YG214	N20 YG100	N20 YG10
-AL	 Aluminum 铝	VCGT 160402 - AL	0.2	0.02 ~ 0.05	0.5 ~ 1.0										● 0418	● 0417
		VCGT 160404 - AL	0.4	0.05 ~ 0.25	0.5 ~ 2.0										● 0336	● 0087
		VCGT 160408 - AL	0.8	0.1 ~ 0.35	1.0 ~ 30.										● 0420	● 0419
-UF	 Finishing 精加工	VCMT 160404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 3		● 0716		● 0421	● 0955						
		VCMT 160408 -UF	0.8	0.05 ~ 0.25	0.5 ~3.0		● 0557		● 0558							
-UG	 General 普通加工	VCMT 160404 - UG	0.4	0.15 ~ 0.30	0.5 ~ 2.5						● 0060					
		VCMT 160408 - UG	0.8	0.15 ~ 0.30	1 .0~ 3		● 0946		● 0422	● 0956	● 0061					

Cutting Speed 切削速度				Vc (m/min.)																	
ISO	VDI	Sub Group 分组		YG1001		YG3010		YG3015		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
				Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	非合金钢	220	480	170	450	170	410	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
P	6~9	Low-Alloyed Steel	低合金钢	220	420	180	380	130	360	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
P	10~11	High-Alloyed Steel	高合金钢	-	-	100	330	80	310	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	-	-	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
M	14	Austenitic Stainless Steel	奥氏体不锈钢	-	-	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	灰铸铁	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
K	17~18	Nodular Cast Iron	球墨铸铁	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	非铁金属	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	-	-	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	高硬材料	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

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