

PARTING & GROOVING

切断&切槽

Parting & Grooving Holders

Parting & Grooving Inserts Overview

Parting & Grooving Inserts (TD.)

Parting & Grooving Inserts (MGMN)

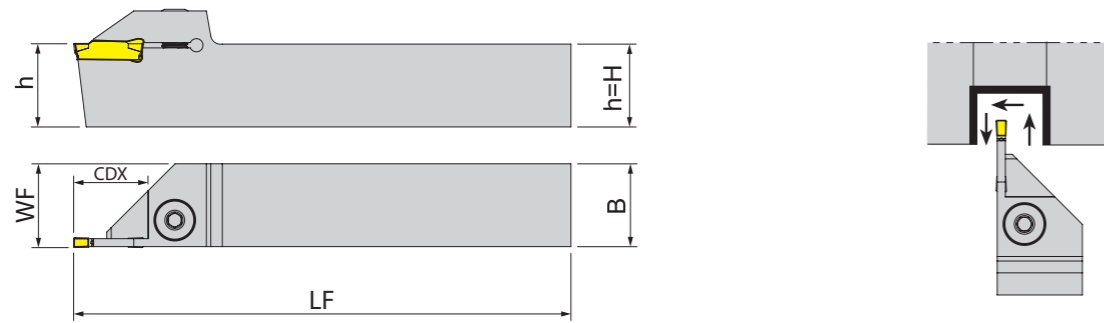
切断&切槽刀片概况

切断&切槽刀片 (TD.)

切断&切槽刀片 (MGMN)

Parting & Grooving - Holder - External
External holders for TD. insert

切断 & 切槽 - 刀柄 - 外圆
 TD.刀片可用的外圆刀柄



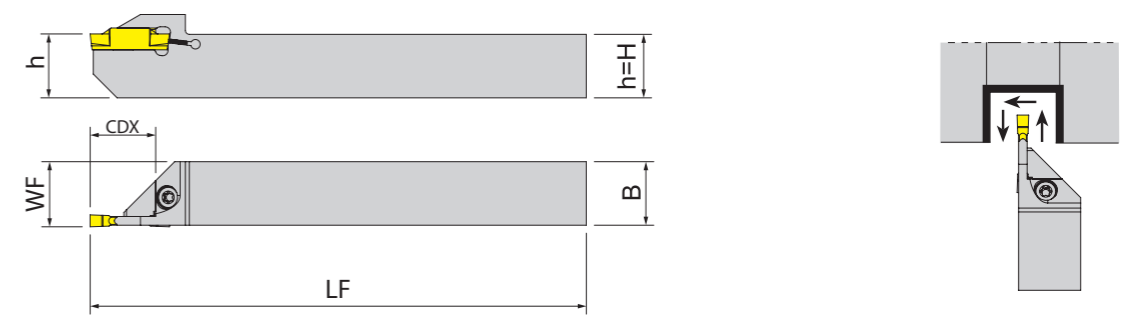
: p. 92 Unit(单位):mm

Designation	EDP 5700.. R L	CW	CDX	H	B	LF	WF	Insert
YTER/L 1212-2T15	0025 0024	2	15	12	12	100	12.3	TD.2..
YTER/L 1616-2T15	0027 0026	2	15	16	16	125	16.3	
YTER/L 2020-2T15	0030 0029	2	15	20	20	125	20.3	
YTER/L 2020-2T20	0032 0031	2	20	20	20	125	20.3	
YTER/L 2020-2T9	0028 -	2	9	20	20	125	20.3	
YTER/L 2525-2T17	0034 0033	2	17	25	25	150	25.3	TD.3..
YTER/L 1212-3T15	0036 0035	3	15	12	12	100	12.4	
YTER/L 1616-3T15	0038 0037	3	15	16	16	125	16.4	
YTER/L 2020-3T20	0040 0039	3	20	20	20	125	20.4	
YTER/L 2525-3T20	0044 0043	3	20	25	25	150	25.4	
YTER/L 2525-3T9	0042 0041	3	9	25	25	150	25.4	TD.4..
YTER/L 3232-3T20	0045 -	3	20	32	32	170	32.4	
YTER/L 2525-4T20	0047 0046	4	20	25	25	150	25.5	

Series	Size	Screw	Ring	Wrench
YTER/L	..2..	YAKV-02-M6x22	YABPL-01	YAAL-03-3
	..3.. / ..4..	Y2004-M8x1x20	-	YAAL-05-4

Parting & Grooving - Holder - External
External holders (Swiss Lathe) for TD. insert

切断 & 切槽 - 刀柄 - 外圆
 TD.刀片可用的外圆刀柄



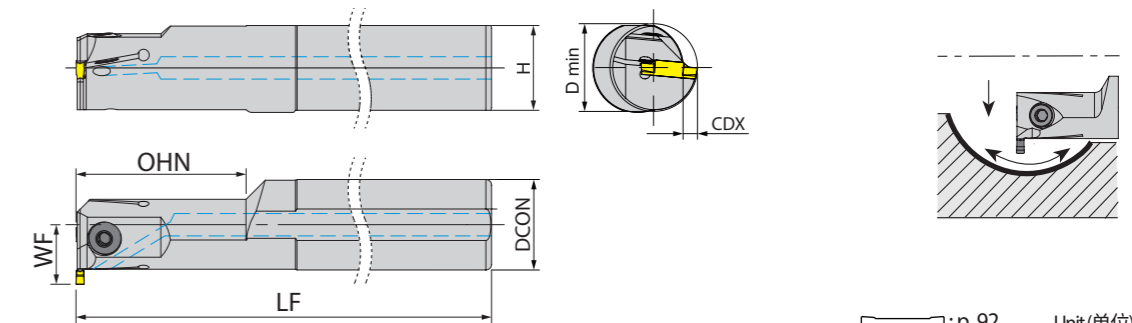
: p. 92 Unit(单位):mm

Designation	EDP 5700.. R L	CW	CDX	H	B	LF	WF	Insert
YTER/L 1212-2T12-S	0048 -	2	12	12	12	125	12.2	TD.2..
YTER/L 1616-2T16-S	0049 -	2	16	16	16	125	16.2	
YTER/L 1212-3T12-S	0051 0050	3	12	12	12	125	12.3	TD.3..
YTER/L 1616-3T16-S	0053 0052	3	16	16	16	125	16.3	

Series	Size	Screw	Wrench
YTER/L	..S	Y4015-M4x11	Y80-T15

Parting & Grooving - Holder - Internal
Internal holders for TD. insert

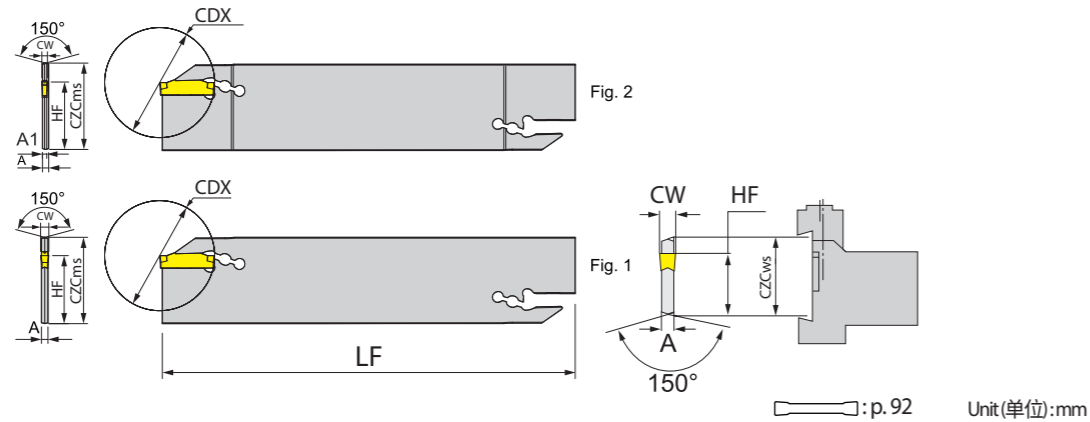
切断 & 切槽 - 刀柄 - 内圆
 TD.刀片可用的内圆刀柄



: p. 92 Unit(单位):mm

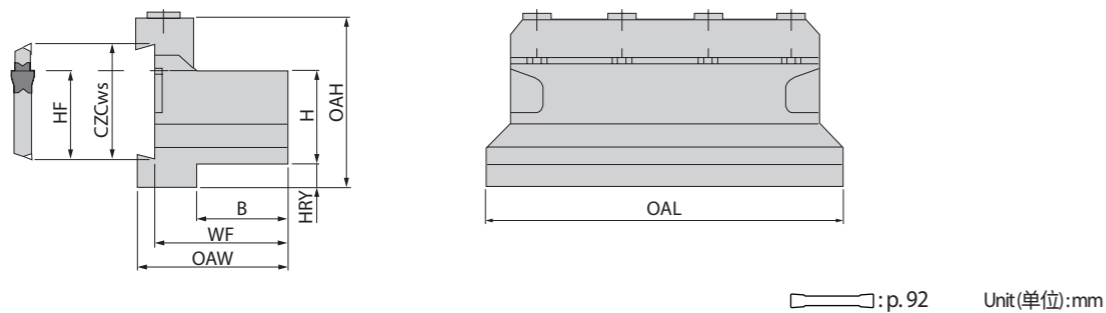
Designation	EDP 5700.. R L	CW	DMIN	CDX	DCON	H	OHN	LF	WF	Insert
YTIR/L 16-2C-T8.5	● 0054 -	2	25	8.5	16	14.8	28	150	16.5	TD.2..
YTIR/L 20-3C-T6	● 0055 -	3	25	6	20	18.3	40	170	16	
YTIR/L 25-3C-T6	● 0056 -	3	25	6	25	23	40	200	18.5	TD.3..
YTIR/L 32-3C-T5	● 0057 -	3	31	5	32	30	60	250	21	

Series	Size	Screw	Wrench
YTIR/L	16-2C..	Y2503-M4x10	YAAL-03-3
	20~25-3C..	Y2504-M5x12	YAAL-05-4
	32-3C..	Y2004-M8x1x20	YAAL-05-4



Designation	EDP 5700..	CZCms	CW	CDX	HF	LF	W	Insert
YGB 32-2	0058	32	2	20	25	150	2.4	TD2..
YGB 32-3	0059	32	3	20	25	150	2.4	TD3..

Series	Wrench
YGB..	YALA-01



Designation	EDP 5700..	CZCws	H	B	HF	WF	HRY	OAL	OAH	OAW
YGBU 20-32	0060	32	20	19	25	32.7	13	100	50	38
YGBU 25-32	0061	32	25	23	25	36.7	8	110	50	42
YGBU 32-32	0062	32	32	29	25	42.7	5	110	54	48

Series	Size	Clamp	Screw	Wrench
YGBU	20-32	YABK-03	Y2505-M6x30	YAAL-07-5
	25~32-32	YABK-04	Y2505-M6x30	YAAL-07-5

Parting & Groove Turn Grades 切断&切槽材质

Parting and Grooving Grades	P Steel				M Stainless steel			K Cast iron			N Non Ferrous		S Super Alloy	
	P10	P20	P30	P40	M10	M20	M30	K10	K20	K30	N10	N20	S10	S20
PVD YG602G (YG602)		602G				602G			602G					602G

YG602G (YG602)

PVD - TiAlN

Universal grade for Parting & Groove Turn

- Ultra Dense PVD Coating with optimal thermal resistance & strength
- Sub-Micron substrate designed for demanding application
- YG602G : First Choice for Low Cutting Speed, Soft and Sticky Material with Low Hardness
- YG602 : First Choice for General Application

切断&切槽的通用型材质

- 超高密度PVD涂层提高耐热性和强度
- 亚微米级层设计可适应多种工况
- YG602G: 低硬度软粘性材料低速切削的首选
- YG602: 普通加工的首选

Parting & Grooving Inserts 切断&切槽刀片

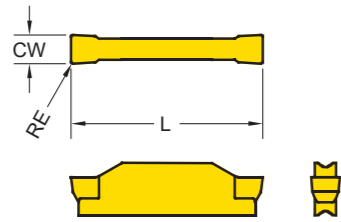
	TD. Series	Inserts	2, 3, 4
	MGMN Series		

Parting & Grooving Chipbreakers 切断&切槽断屑槽

-P TDP MGMN			<ul style="list-style-type: none"> Parting & Grooving (Positive) 切断&切槽(正角型)
-N TDN MGMN			<ul style="list-style-type: none"> Parting & Grooving (General) 切断&切槽(普通型)
-Y TDY			<ul style="list-style-type: none"> Turning, Parting & Grooving 车槽

Parting & Grooving - Inserts
Parting & Grooving Inserts

切断 & 切槽
切断&切槽刀片



Series	L	CW
TD* 2	20	2
TD* 3	20	3
TD* 4	20	4

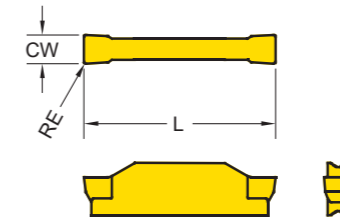
* CDX : Cutting Depth Maximum
* CDX: 最大切深

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

TD.	Designation	RE	Parting & Grooving		Turning		EDP 5200..	
			Fn (mm/rev.)	CDX (mm)	Fn (mm/rev.)	Ap (mm)	YG602	YG602G
-P Parting & Grooving (Positive) 切断&切槽(正角型)	TDP2002	0.2	0.04~0.12	19			● 0012	○ 0036
	TDP3002	0.2	0.05~0.16	19			● 0029	○ 0030
	TDP4003	0.3	0.06~0.18	19			● 0023	○ 0038
-N Parting & Grooving (General) 切断&切槽(普通型)	TDN2002	0.2	0.06~0.18	19			● 0010	○ 0035
	TDN3002	0.2	0.07~0.22	19			● 0024	○ 0025
	TDN4003	0.3	0.08~0.25	19			● 0022	○ 0037
-Y Groove Turn 车槽	TDY3E - 0.4	0.4	0.10~0.20	19	0.10~0.38	0.50~2.20		● 0027
	TDY4E - 0.4	0.4	0.15~0.26	19	0.10~0.40	0.50~2.80		● 0020

Parting & Grooving - Inserts
Parting & Grooving Inserts (MGMN)

切断 & 切槽
切断&切槽刀片(MGMN)



Series	L	CW
MGMN 2	16	2
MGMN 3	21	3
MGMN 4	21	4

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

MGMN	Designation	RE	Parting & Grooving		Turning		EDP 5200..	
			Fn (mm/rev.)	CDX (mm)	Fn (mm/rev.)	Ap (mm)	YG602	YG602G
-P Parting & Grooving (Positive)	MGMN 2002 - P	0.2	0.04~0.12	14	-	-	○ 0003	
	MGMN 3002 - P	0.2	0.05~0.16	18	-	-	○ 0005	
	MGMN 4002 - P	0.2	0.06~0.18	18	-	-	○ 0007	
-N Parting & Grooving (General)	MGMN 2002 - N	0.2	0.06~0.18	14	-	-	○ 0002	
	MGMN 3004 - N	0.4	0.07~0.22	18	-	-	○ 0004	
	MGMN 4002 - N	0.2	0.08~0.25	18	-	-	○ 0006	

Cutting Speed 切削速度				Vc (m/min.)	
ISO	VDI	Sub Group 分组		YG602G (YG602)	
				Min.	Max.
P	1~5	Non-Alloyed Steel	非合金钢	90	180
	6~9	Low-Alloyed Steel	低合金钢	80	120
	10~11	High-Alloyed Steel	高合金钢	80	110
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	70	160
	14	Austenitic Stainless Steel	奥氏体不锈钢	55	140
K	15~16	Grey Cast Iron	灰铸铁	110	185
	17~18	Nodular Cast Iron	球墨铸铁	110	140
N	21~30	Non-Ferrous Metals (Al)	非铁金属	250	440
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45
H	38~41	Hard Materials	高硬材料	25	50

Cutting Speed 切削速度				Vc (m/min.)	
ISO	VDI	Sub Group 分组		YG602G (YG602)	
				Min.	Max.
P	1~5	Non-Alloyed Steel	非合金钢	90	180
	6~9	Low-Alloyed Steel	低合金钢	80	120
	10~11	High-Alloyed Steel	高合金钢	80	110
M	12~13	Ferritic & Martensitic	铁素体&马氏体不锈钢	70	160
	14	Austenitic Stainless Steel	奥氏体不锈钢	55	140
K	15~16	Grey Cast Iron	灰铸铁	110	185
	17~18	Nodular Cast Iron	球墨铸铁	110	140
N	21~30	Non-Ferrous Metals (Al)	非铁金属	250	440
S	31~37	Superalloys & Titanium	超耐热合金&钛合金	25	45
H	38~41	Hard Materials	高硬材料	25	50