SOLID ROUND TOOLS

ONE-STOP MACHINING SOLUTION

Solid Round Tools
One-Stop Machining Solution



YPP PCD® Series

Product Overview

One-Stop Service

Customized Solution

Sandvik Coromant Technical Support

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YONGPUPRECISION

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ABOUT US

SOLID ROUND TOOLS
ONE-STOP MACHINING SOLUTION

One-Stop Service

Customized Solution

Sandvik Coromant Technical Support

Suzhou Yongpu Precision Technology Co., Ltd. (“Yongpu Precision”) was founded in 2013. Headquartered in Wujiang Economic Development Zone, Suzhou, we operate two major manufacturing bases in Suzhou and Chuzhou, alongside three production and reconditioning centers in Wuhan, Chengdu and Zhuzhou.

Yongpu Precision specializes in the R&D, production and service of solid round tools. Backed by technical support from the Sandvik Group, we deliver full industrial chain customization covering rod stock, cutting tools and coatings.

We always adhere to our mission: “Solve customers’ machining challenges through technological innovation and help customers improve efficiency and reduce costs with high-quality products.”

We embed our core values — Integrity, Collaboration, Professionalism, and Enterprise — across all business operations. Yongpu Precision strives to deliver efficient, reliable one-stop solid round tool solutions for global industries, continuously empowering the metalworking sector with professional expertise.



Versatile Solution

Customized Solution



YPP PCD® Tools
INTRODUCTION

Overview & Applications

PCD is the abbreviation for Polycrystalline Diamond. It is a cutting tool material that possesses the hardness and wear resistance of natural diamond — the hardest known material on earth — making it a superior high-performance cutting material.
PCD tools are used to machine components made of non-ferrous metals and non-metallic materials, such as aluminum alloys, magnesium alloys, copper alloys, brass, engineered wood (wood-based panels), graphite, and fiberglass.

They are widely applied across industries including:

- Automotive Manufacturing
- Construction Machinery
- Precision Electronics
- Medical Devices
- Aerospace

Features & Benefits

- Excellent Wear Resistance
- Wide Cutting Speed Range
- Low Cutting Forces
- High Machining Efficiency
- Built-up Edge (BUE) free
- Stable, Consistent Material Properties

Cutting Data
RECOMMENDATION

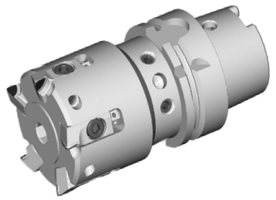
YPP PCD® Tools

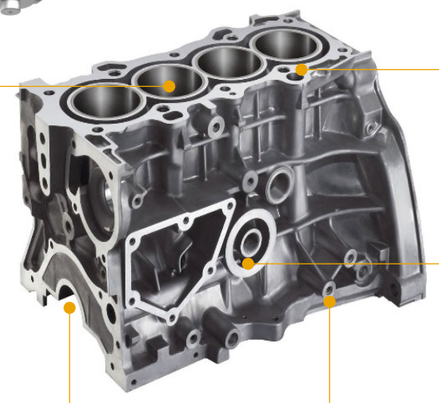
Workpiece Material	Cutting Speed (m/min)	Feed per Tooth (fz)	Depth of Cut (mm)
Aluminum Alloys (<4%Si)	300-1200	0.1-0.4	0.1-4.0
Aluminum Alloys (4-8%Si)	200-1000	0.1-0.4	0.1-4.0
Aluminum Alloys (9-13%Si)	100-800	0.08-0.2	0.1-4.0
Aluminum Alloys (>13%Si)	100-800	0.05-0.2	0.1-3.0
Magnesium Alloys	200-1000	0.1-0.4	0.1-4.0
Copper Alloys	100-500	0.05-0.2	0.1-4.0
Brass	200-1000	0.05-0.15	0.1-4.0
Engineered wood	1500-4000	0.5-6	1-100
Carbon / Graphite / Fiberglass	200 - 1000	0.01-0.25	0.1-3.0

Automotive Industry - Cylinder Block Machining

Yongpu has extensive, well-established experience in PCD tooling for cylinder blocks. We offer a full range of both standard and custom PCD tools, delivering high-efficiency solutions for aluminum alloy cylinder block machining.







Rough / Semi-Finish / Fine Boring of Cylinder Bores

Tools

·High-rigidity rough boring tools enable rapid stock removal for higher machining efficiency;
·Guide-pad semi-finish boring tools improve the cylindricity and roundness of the cylinder bore;
·Guide-pad fine boring tools ensure bore cylindricity and surface finish while delivering consistent, reliable tool life.

Face Milling

Adjustable Face Milling Cutter

The adjustable cartridge-type face mill enables surface roughing and finishing in a single pass. Its optimized insert geometry helps minimize burr formation and ensures workpiece flatness and surface finish, while delivering long tool life.

Thrust Face Milling

Integral Side-and-Face Milling Cutter

The integral side-and-face (three-edge) milling cutter performs rough and finish milling of the thrust face in one tool, ensuring dimensional stability and high surface quality with excellent machining efficiency.



Blind Hole Drilling

PCD Drill



Side Milling

PCD Face Mill



Automotive Industry - Cylinder Head Machining



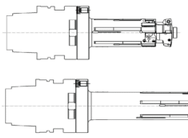
Tap Hole Drilling

PCD Drill

Camshaft Bore Boring

Guide-Pad Boring Tool

The guide-pad boring tool for camshaft bores adopts a combined pilot (guided) boring and deep-hole boring design, ensuring bore cylindricity, roundness, straightness, and surface quality. The adjustable boring cartridge guarantees the bore diameter tolerance; the guide-pad support design ensures cylindricity; and the adjustable flange design controls tool runout to within 0.003 mm.

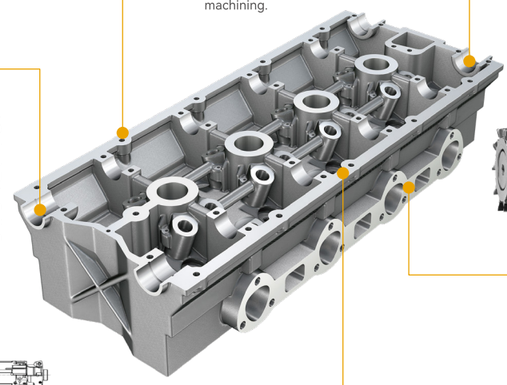


Rough Milling of Camshaft Half-Bores

Tools

Multiple PCD cutting edges are evenly and optimally arranged on the steel cutter body, forming a perfect semi-circular profile for highly efficient half-bore machining.







Side Milling

PCD Face Mill



Face Mill

Brazed PCD Face Mill

Ideal for ultra-high-efficiency face milling, with a maximum depth of cut ap_max = 5 mm, a cutter diameter range of Ø40–125 mm, and an extra-fine pitch design with 10–22 teeth.





Post-Press-Fit Guided Machining

Valve Seat & Guide Finishing Tool (JTS)

A valve seat and guide finishing tool for guided machining after press-fitting, performing superfinishing of the valve guide bores and valve seat bores in cylinder heads. The JTS short-taper quick-change interface effectively ensures the extremely high concentricity and roundness requirements between the valve guide and the seat.

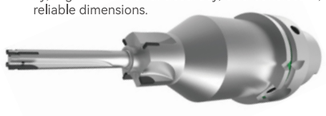
Valve Guide Finishing After Press-Fitting



Pre-Press-Fit Bore Finishing

Valve Seat & Guide Bore Finishing Tool

For valve bore machining prior to press-fitting, the seat and guide pilot bores are finished in a single pass — delivering high machining efficiency, high dimensional accuracy, and consistent, reliable dimensions.



Seat Pocket, Throat & Guide Bore Pre-Machining

Tools

Pre-machining of the valve seat pocket is completed in a single pass — delivering high machining efficiency, high dimensional accuracy, and consistent, reliable dimensions.

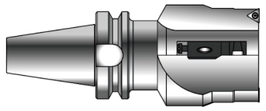


Through Hole Drilling

PCD Drill



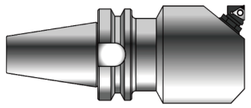
Automotive Industry
– Housing & Clutch Machining



Internal Rough Boring

Adjustable Rough Boring Tool

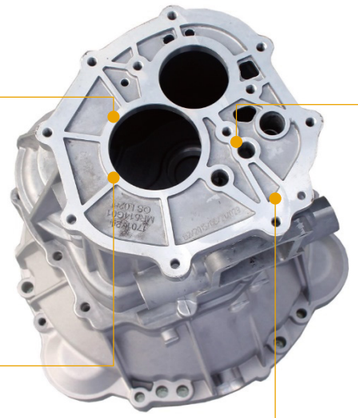
The adjustable combination rough boring tool offers flexible diameter adjustment and excellent cost-effectiveness, making it ideal for batch production.



Internal Fine Boring

Adjustable Fine Boring Tool

The adjustable fine boring tool offers high-precision diameter adjustment and high versatility, making it ideal for batch production.





Internal Reaming



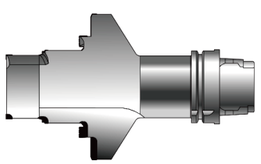
Face Mill



Drilling

PCD Drill

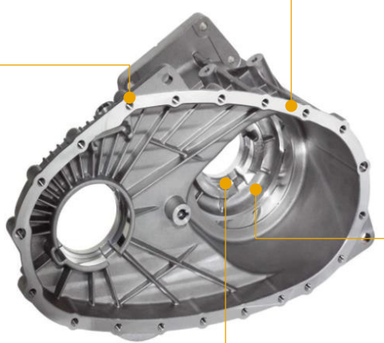
With PCD brazed at the drill tip, the PCD drill enables high-speed drilling while extending tool life.



Stepped Bore Boring

Fixed Rough Boring Tool

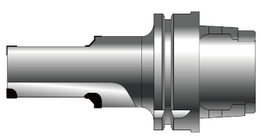
The fixed combination rough boring tool features high rigidity, high machining efficiency, and stable, consistent dimensions — ideal for high-volume production.



Internal Fine Boring

Fixed Fine Boring Tool

The fixed combination fine boring tool delivers high dimensional accuracy, stable and consistent part quality, and high efficiency — ideal for high-volume production.



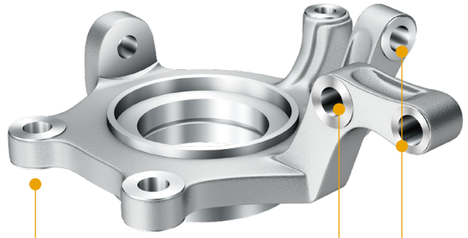
Automotive Industry
– Knuckle & Brake Pump Machining



Reaming

PCD Reamer

The PCD reamer adopts an unequally spaced tooth design for high-speed reaming, delivering bore cylindricity within 0.005 mm and a surface finish within Ra 0.8 μm.





Drilling

PCD Drill

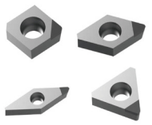
With PCD brazed at the drill tip, the PCD drill enables high-speed drilling while extending tool life.



Two-side Milling

PCD Staggered-Tooth Side-and-Face Cutter

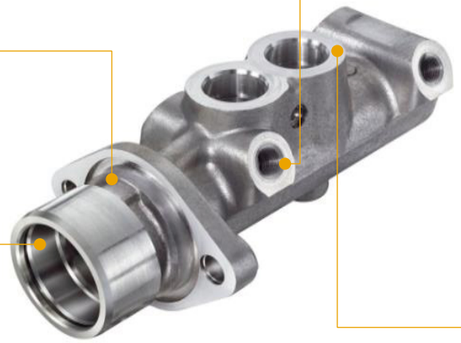
The staggered-tooth design effectively suppresses machining chatter under unstable conditions. The twin-cutter interlocked assembly machines both side faces to final size in a single pass — for high machining efficiency.



External Turning

PCD Turning Inserts

A full range of PCD turning inserts enables high-speed external turning of aluminum alloys, delivering excellent workpiece surface quality and dimensional accuracy.



Internal Boring

Multi-Flute Reamer

The integral-shank, multi-flute PCD boring tool provides a high-precision machine connection with minimal runout, delivering ultra-high bore accuracy and surface quality along with long tool life.



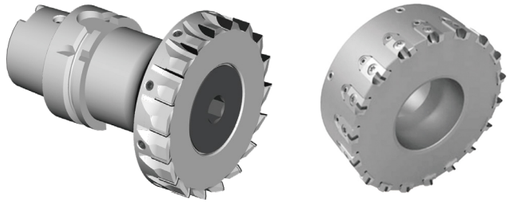


Face Mill

PCD Face Mill

刀柄一体式PCD面铣刀，和机床连接精度高，跳动小，适用于超高效率的平面铣削。

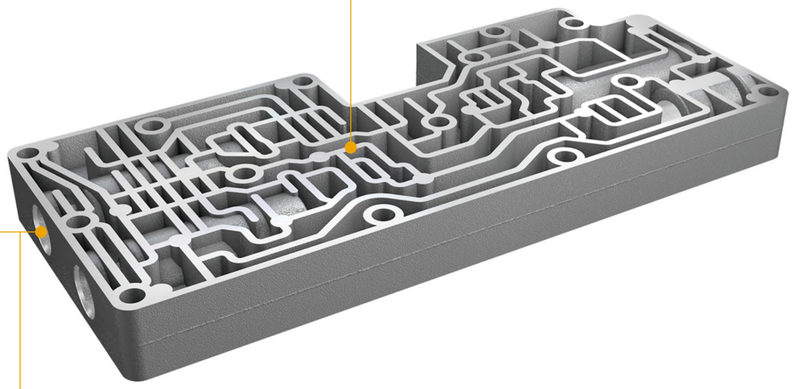
Automotive Industry
– Valve Plate Machining



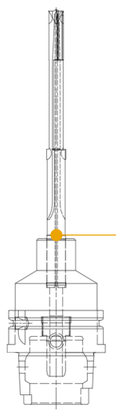
Face Mill

Extra-Fine Pitch Face Mill

Machining Requirements: Flat, burr-free surface
Vc=3,000 m/min
f=0.04~0.1 mm
Tool life: 5,000–50,000 parts per edge



Spool Bore Guided Reaming





Spool Bore Reaming

Guide-Pad Tool

The guide-pad tool for spool bore reaming adopts a combined pilot (guided) boring and deep-hole boring design, ensuring bore cylindricity, roundness, straightness, and surface quality. The adjustable boring cartridge guarantees the bore diameter tolerance; the guide-pad support design ensures cylindricity; and the adjustable flange design controls tool runout to within 0.003 mm.



Spool Bore Reaming

Brazed Fixed Multi-Flute Reamer

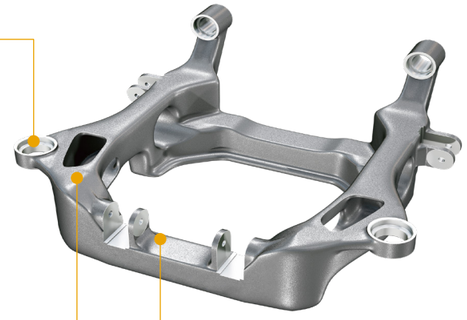
Automotive Industry
– Vehicle Frame & Battery Pack Machining



Internal Reaming

Step Reamer

The combined step (compound) reamer delivers high dimensional accuracy, stable and consistent part quality, and high efficiency — ideal for high-volume production.





Two-side Milling

Staggered-Tooth Side-and-Face Cutter

The staggered-tooth design effectively suppresses machining chatter under unstable conditions. The twin-cutter interlocked assembly machines both side faces to final size in a single pass — for high machining efficiency.

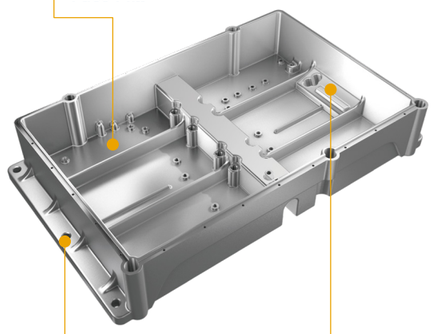
Boss Face Milling

Face Mill

Ideal for ultra-high-efficiency face milling, the high positive axial rake design delivers a light, free-cutting action. The extra-fine pitch ensures smooth, stable engagement with thin-walled parts to suppress chatter.



Face Mill





Drilling

PCD Drill

With PCD brazed at the drill tip, it enables high-speed drilling and extends tool life.

Cavity Milling

Fast-Cutting End Mill

The high positive axial rake design delivers a light, free-cutting action that prevents workpiece deformation; the large concave dish angle on the end cutting edge reduces friction with the workpiece, effectively suppressing chatter.



Automotive Industry - ABS Housing

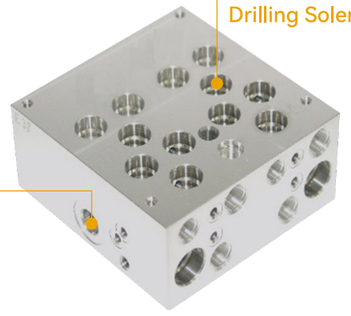
Semi-Finish Reamer

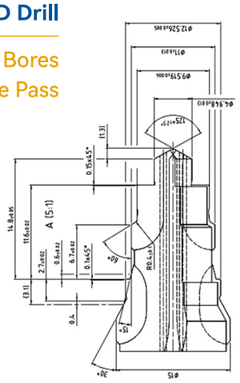
Semi-Finishing of Piston Pin Bores



PCD Drill

Drilling Solenoid Valve Bores in a Single Pass



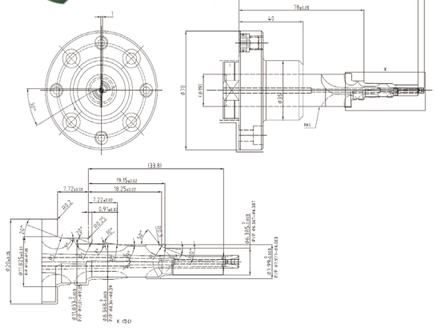


Finish Reamer

Piston Pin Bore Finishing

This one-pass, multi-step form reamer guarantees the geometric tolerance requirements of roundness, position, and runout for each stepped bore, while delivering ultra-short cycle times and superior bore surface quality.





Finish Reamer

Stepped Finish Forming of Motor Bores





Finish Reamer(Brazed, Guide-Pad, etc.)

Accumulator Bore Finish Reaming

The guide-pad reamer is ideally suited to stringent Cpk/Cmk capability requirements.



Automotive Industry - Steering Gear Housing

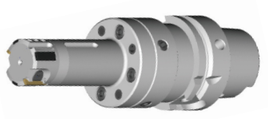


Face Mill

PCD Face Mill

Ideal for ultra-high-efficiency face milling — extra-fine pitch design, large depth of cut, high feed rate.





Internal Bore Finish Reaming

Guide-Pad Finish Reamer

The boring insert features an adjustable design, allowing flexible setting of the bore diameter; the boring bar uses a guide-pad support design to ensure bore cylindricity.

Trepanning the Outer Diameter at the Bore Opening

PCD Trepanning Cutter

Automotive Industry - Scroll Machining



Internal & External Involute Finishing (Inner Flank, Outer Flank, Floor)



Scroll Milling Cutter

The custom-designed scroll wrap milling cutter finishes the internal and external involute surfaces (inner flank, outer flank and floor), delivering perpendicularity within 0.01 mm, surface finish within Rz 6.3, flatness within 0.015 mm, and a formed profile within tolerance.





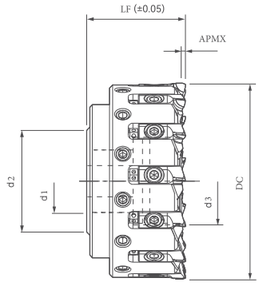
Seal Groove Turning

Custom-Designed

PCD Turning Insert

The custom-designed PCD turning insert enables high-speed finish turning of seal grooves, delivering excellent workpiece surface quality and dimensional accuracy.

Face Mill with PCD Cartridge



Cutting Diameter Tolerance (DC)	80.0-400.0
Diameter Tolerance	±0.05

Steel Body

Ordering Code	Dimension					Effective teeth	Max. Cutting Depth	Weigh with Cartridges (Kg)	Max. Spindle Speed (r/min)
	DC	d1	d2	d3	LF				
APMN-063-D22-Z08-S	63	22	43	28	48	8	5	0.8	25,000

Aluminum Body

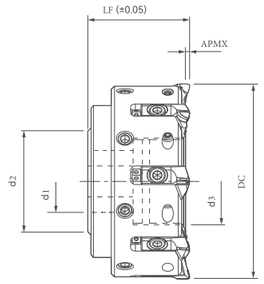
Ordering Code	Dimension					Effective teeth	Max. Cutting Depth	Weigh with Cartridges (Kg)	Max. Spindle Speed (r/min)
	DC	d1	d2	d3	LF				
APMN-080-D27-Z08-A	80	27	49	36	50	8	5	0.75	20,000
APMN-100-D32-Z10-A	100	32	59	45	50	10	5	1.20	18,000
APMN-125-D40-Z12-A	125	40	71	56	63	12	5	2.25	18,550
APMN-125-D40-Z13-A	125	40	71	56	63	13	5	2.20	16,000
APMN-160-D40-Z18-A	160	40	98	-	63	18	5	2.15	13,000
APMN-180-D40-Z20-A	180	40	104	-	63	20	5	2.60	11,500
APMN-200-D60-Z24-A	200	60	138	-	63	24	5	4.40	10,000
APMN-250-D60-Z30-A	250	60	138	-	63	30	5	7.00	8,000
APMN-315-D60-Z38-A	315	60	236	-	80	38	5	14.10	7,000
APMN-400-D60-Z50-A	400	60	236	-	80	50	5	22.10	6,100

★ The aluminum cutter body is reusable. A simple, durable cartridge adjustment design enables fast, efficient tool changes, while the precision adjustment mechanism controls the axial tool height to micron-level (μm) accuracy — resulting in excellent surface finish and minimal burrs.

★ Cartridge features: an effective depth of cut of 5 mm, and a regrindable cartridge that can be resharpened for repeated use — delivering very low overall tooling cost.

YPP PCD® TOOLS
SOLID ROUND TOOLS
ONE-STOP MACHINING SOLUTION

Face Mill with PCD Cartridge



Cutting Diameter Tolerance (DC)	80.0-400.0
Diameter Tolerance	±0.05

Steel Body

Ordering Code	Dimension					Effective teeth	Max. Cutting Depth	Weigh with Cartridges (Kg)	Max. Spindle Speed (r/min)
	DC	d1	d2	d3	LF				
APLN-50-Z04-S/HSK63A	50 一体式	-	-	-	-	-	-	-	-
APLN-050-D16-Z04-S	50	-	-	-	-	-	-	-	-
APLN-063-D22-Z03-S	63	22	43	28	48	3	5	0.85	25,000
APLN-063-D22-Z05-S	63	22	43	28	48	5	5	0.80	25,000

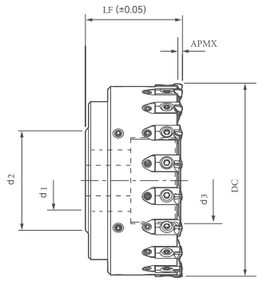
Aluminum Body

Ordering Code	Dimension					Effective teeth	Max. Cutting Depth	Weigh with Cartridges (Kg)	Max. Spindle Speed (r/min)
	DC	d1	d2	d3	LF				
APLN-080-D27-Z05-A	80	27	49	36	50	5	5	0.75	25,000
APLN-080-D27-Z06-A	80	27	49	36	50	6	5	0.75	25,000
APLN-080-D27-Z07-A	80	27	49	36	50	7	5	0.80	25,000
APLN-100-D32-Z06-A	100	32	59	45	50	6	5	1.08	21,650
APLN-100-D32-Z08-A	100	32	59	45	50	8	5	1.20	21,650
APLN-125-D40-Z08-A	125	40	71	56	63	8	5	2.20	18,550
APLN-125-D40-Z10-A	125	40	71	56	63	10	5	2.20	18,550
APLN-140-D40-Z10-A	140	40	100	56	63	10	5	2.40	18,550
APLN-160-D40-Z10-A	160	40	104	-	63	10	5	2.75	14,990
APLN-160-D40-Z12-A	160	40	98	-	63	12	5	2.80	14,990
APLN-180-D40-Z10-A	180	40	104	-	63	10	5	3.40	13,500
APLN-200-D60-Z12-A	200	60	138	-	63	12	5	4.15	12,200
APLN-250-D60-Z15-A	250	60	138	-	63	15	5	6.70	9,760
APLN-315-D60-Z18-A	315	60	236	-	80	18	5	13.35	7,750
APLN-400-D60-Z24-A	400	60	236	-	80	24	5	21.40	6,100
APLN-500-D60-Z30-A	500	60	236	-	80	30	5	34.50	4,880

★ The aluminum cutter body is reusable. A simple, durable cartridge adjustment design enables fast, efficient tool changes, while the precision adjustment mechanism controls the axial tool height to micron-level (μm) accuracy — resulting in excellent surface finish and minimal burrs.

★ Cartridge features: an effective depth of cut of 5 mm, and a regrindable cartridge that can be resharpened for repeated use — delivering very low overall tooling cost.

Face Mill with PCD Cartridge



Cutting Diameter Tolerance (DC)	80.0-400.0
Diameter Tolerance	±0.05

Steel Body

Ordering Code	Dimension					Effective teeth	Max. Cutting Depth	Weigh with Cartridges (Kg)	Max. Spindle Speed (r/min)
	DC	d1	d2	d3	LF				
ABMN-050-D22-Z06-S	50	22	49	28	40	6	3	0.44	35,000

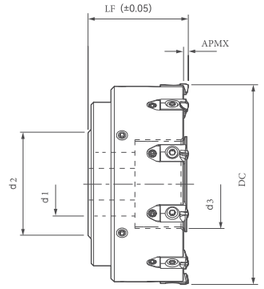
Aluminum Body

Ordering Code	Dimension					Effective teeth	Max. Cutting Depth	Weigh with Cartridges (Kg)	Max. Spindle Speed (r/min)
	DC	d1	d2	d3	LF				
ABMN-063-D22-Z08-A	63	22	49	28	48	8	3	0.42	33,000
ABMN-080-D27-Z10-A	80	27	49	38	50	10	3	0.75	33,000
ABMN-100-D32-Z14-A	100	32	59	45	50	14	3	1.20	29,500
ABMN-125-D40-Z18-A	125	40	67	56	63	18	3	2.20	25,500
ABMN-160-D40-Z24-A	160	40	96	-	63	24	3	2.80	22,200
ABMN-200-D60-Z28-A	200	60	138	-	63	28	3	4.30	18,100
ABMN-250-D60-Z36-A	250	60	136	-	63	36	3	6.80	14,500
ABMN-315-D60-Z46-A	315	60	232	-	80	46	3	13.00	11,500
ABMN-400-D60-Z58-A	400	60	236	-	80	58	3	21.60	9,000

★ The aluminum cutter body is reusable. A simple, durable cartridge adjustment design enables fast, efficient tool changes, while the precision adjustment mechanism controls the axial tool height to micron-level (μm) accuracy — resulting in excellent surface finish and minimal burrs.

★ Cartridge features: an effective depth of cut of 5 mm, and a regrindable cartridge that can be resharpened for repeated use — delivering very low overall tooling cost.

Face Mill with PCD Cartridge



Cutting Diameter Tolerance (DC)	80.0-400.0
Diameter Tolerance	±0.05

Steel Body

Ordering Code	Dimension					Effective teeth	Max. Cutting Depth	Weigh with Cartridges (Kg)	Max. Spindle Speed (r/min)
	DC	d1	d2	d3	LF				
ABLN-050-D22-Z04-S	50	22	49	28	40	4	3	0.44	35,000

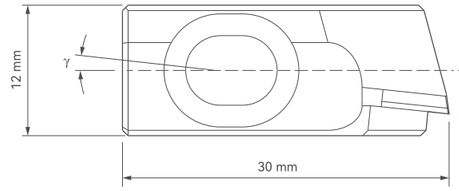
Aluminum Body

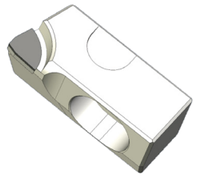
Ordering Code	Dimension					Effective teeth	Max. Cutting Depth	Weigh with Cartridges (Kg)	Max. Spindle Speed (r/min)
	DC	d1	d2	d3	LF				
ABLN-063-D22-Z05-A	63	22	49	28	48	5	3	0.40	33,000
ABLN-080-D27-Z06-A	80	27	49	36	50	6	3	0.70	33,000
ABLN-100-D32-Z08-A	100	32	59	45	50	8	3	1.10	29,500
ABLN-125-D40-Z10-A	125	40	67	56	63	10	3	2.20	25,500
ABLN-160-D40-Z12-A	160	40	98	-	63	12	3	2.80	22,200
ABLN-200-D60-Z16-A	200	60	136	-	63	16	3	4.20	18,100
ABLN-250-D60-Z20-A	250	60	136	-	63	20	3	6.70	14,500
ABLN-315-D60-Z24-A	315	60	232	-	80	24	3	12.90	11,500
ABLN-400-D60-Z28-A	400	60	236	-	80	28	3	21.30	9,000

★ The aluminum cutter body is reusable. A simple, durable cartridge adjustment design enables fast, efficient tool changes, while the precision adjustment mechanism controls the axial tool height to micron-level (μm) accuracy — resulting in excellent surface finish and minimal burrs.

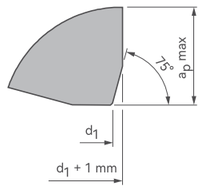
★ Cartridge features: an effective depth of cut of 5 mm, and a regrindable cartridge that can be resharpened for repeated use — delivering very low overall tooling cost.

PCD Cartridge



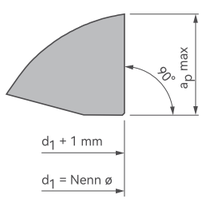


Face Mill Cartridge



Ordering Code Right Cut	Ordering Code Left Cut	Chip Flow Angle γ°	Rz Value (µm)	Max. ap
PN-711-0-D028	PN-711-1-D028	6	≤5	5
PN-712-0-D028	PN-712-1-D028	6	≤10	5
PN-713-0-D028	PN-713-1-D028	6	≤20	5
PN-714-0-D028	PN-714-1-D028	6	>20	5
PN-721-0-D028	PN-721-1-D028	3	≤5	5
PN-722-0-D028	PN-722-1-D028	3	≤10	5
PN-723-0-D028	PN-723-1-D028	3	≤20	5
PN-724-0-D028	PN-724-1-D028	3	>20	5
PN-731-0-D028	PN-731-1-D028	0	≤5	5
PN-732-0-D028	PN-732-1-D028	0	≤10	5
PN-733-0-D028	PN-733-1-D028	0	≤20	5
PN-734-0-D028	PN-734-1-D028	0	>20	5

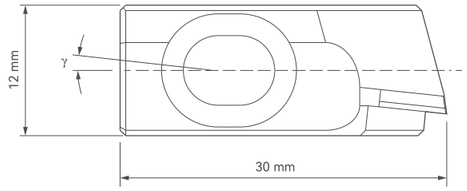
Square-shoulder Cartridge

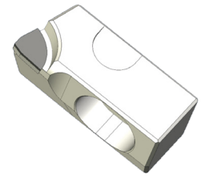


Ordering Code Right Cut	Ordering Code Left Cut	Chip Flow Angle γ°	Rz Value (µm)	Max. ap
PN-611-0-D028	PN-611-1-D028	6	≤5	5
PN-612-0-D028	PN-612-1-D028	6	≤10	5
PN-613-0-D028	PN-613-1-D028	6	≤20	5
PN-614-0-D028	PN-614-1-D028	6	>20	5
PN-621-0-D028	PN-621-1-D028	3	≤5	5
PN-622-0-D028	PN-622-1-D028	3	≤10	5
PN-623-0-D028	PN-623-1-D028	3	≤20	5
PN-624-0-D028	PN-624-1-D028	3	>20	5
PN-631-0-D028	PN-631-1-D028	0	≤5	5
PN-632-0-D028	PN-632-1-D028	0	≤10	5
PN-633-0-D028	PN-633-1-D028	0	≤20	5
PN-634-0-D028	PN-634-1-D028	0	>20	5

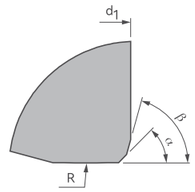
YPP PCD® TOOLS
SOLID ROUND TOOLS
ONE-STOP MACHINING SOLUTION

PCD Cartridge



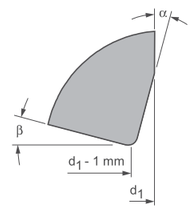


Wiper Cartridge



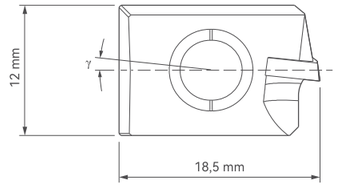
Ordering Code Right Cut	Ordering Code Left Cut	Chip Flow Angle γ°	Rz Value (µm)	Max. ap
PN-811-0-D028	PN-811-1-D028	6	<5	5

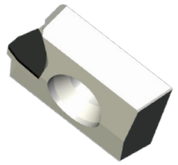
PT Cartridge



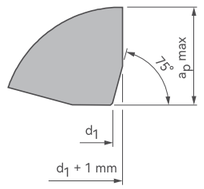
Ordering Code Right Cut	Ordering Code Left Cut	Chip Flow Angle γ°	Rz Value (µm)	Max. ap
PN-931-0-D028		0	<5	5

PCD cartridge



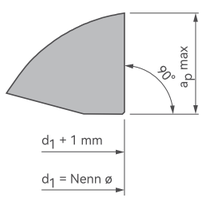


Face Mill Cartridge



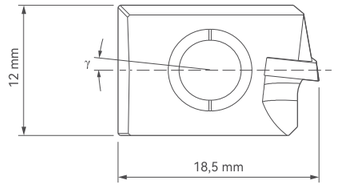
Ordering Code	Chip Flow Angle γ°	Rz Value (μm)	Max. ap
BN-711-0-D028	6	≤5	3
BN-712-0-D028	6	≤10	3
BN-713-0-D028	6	≤20	3
BN-714-0-D028	6	>20	3
BN-721-0-D028	3	≤5	3
BN-722-0-D028	3	≤10	3
BN-723-0-D028	3	≤20	3
BN-724-0-D028	3	>20	3
BN-731-0-D028	0	≤5	3
BN-732-0-D028	0	≤10	3
BN-733-0-D028	0	≤20	3
BN-734-0-D028	0	>20	3

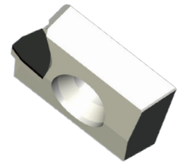
Square-shoulder Cartridge



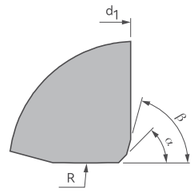
Ordering Code	Chip Flow Angle γ°	Rz Value (μm)	Max. ap
BN-611-0-D028	6	≤5	3
BN-612-0-D028	6	≤10	3
BN-613-0-D028	6	≤20	3
BN-614-0-D028	6	>20	3
BN-621-0-D028	3	≤5	3
BN-622-0-D028	3	≤10	3
BN-623-0-D028	3	≤20	3
BN-624-0-D028	3	>20	3
BN-631-0-D028	0	≤5	3
BN-632-0-D028	0	≤10	3
BN-633-0-D028	0	≤20	3
BN-634-0-D028	0	>20	3

PCD cartridge



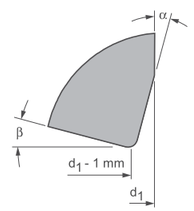


Wiper Cartridge



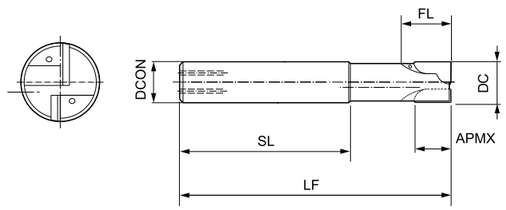
订货号	Chip Flow Angle γ°	Rz Value (μm)	Max. ap
BN-811-0-D028	6	<5	3
BN-831-0-D028	0	<3	3

PT Cartridge



订货号	Chip Flow Angle γ°	Rz Value (μm)	Max. ap
BN-931-0-D028	0	<5	3

Brazed YPP PCD® HPM Mill



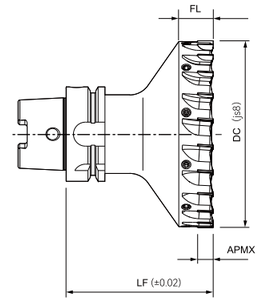
Shank Diameter Tolerance DCON	h6
Cutting Diameter Tolerance	h10
Tool Diameter	3.0-16.0
Point Geometry	0.1x45°
Maximum Ramping Angle	5°

Ordering Code	Dimension							
	DC	APMX	LF	SL	DCON	Axial Rake Angle *	Number of Teeth, Z	Shank Type
P390-03A6-2	3	2.5	60	36	6	+2°	2	Cylindrical Shank
P390-04A6-2	4	2.5	60	36	6	+2°	2	Cylindrical Shank
P390-05A6-2	5	3	60	36	6	+2°	2	Cylindrical Shank
P390-06A6-2-1	6	10	60	36	6	+2°	2	Cylindrical Shank
P390-06A6-2-2	6	15	60	36	6	+2°	2	Cylindrical Shank
P390-06A6-2-3	6	20	80	36	6	+2°	2	Cylindrical Shank
P390-08A6-2-1	8	10	80	36	8	+2°	2	Cylindrical Shank
P390-08A6-2-2	8	15	80	36	8	+2°	2	Cylindrical Shank
P390-08A6-2-3	8	20	80	36	8	+2°	2	Cylindrical Shank
P390-10A6-2-1	10	10	80	40	10	+2°	2	Cylindrical Shank
P390-10A6-2-2	10	15	80	40	10	+2°	2	Cylindrical Shank
P390-10A6-2-3	10	20	90	40	10	+2°	2	Cylindrical Shank
P390-12A6-2-1	12	10	100	45	12	+2°	2	Cylindrical Shank
P390-12A6-2-2	12	15	100	45	12	+2°	2	Cylindrical Shank
P390-12A6-2-3	12	20	100	45	12	+2°	2	Cylindrical Shank
P390-16A6-2	16	20	125	48	16	+2°	2	Cylindrical Shank

★ Application: For machining aluminum structural components and thin-walled parts.

* Axial rake angles are available as custom options in 0°, −2°, +4°, and −4°. Please contact your YPP sales representative to place a custom (non-standard) order.

Brazed YPP PCD® HPM Mill

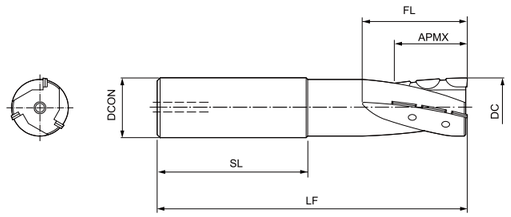


Cutting diameter tolerance	js8
Axial Rake Angle	4°
Tool Diameter	40.0-125.0

Ordering Code	Dimension							
	DC	APMX	LF	Number of Teeth, Z	Point Geometry			Shank Type
P490-40HSKA63-10	40	8	100	10	0.2X45°	R0.2	R0.4	HSK-A63
P490-50HSKA63-12	50	8	100	12	0.2X45°	R0.2	R0.4	HSK-A63
P490-63HSKA63-14	63	8	100	14	0.2X45°	R0.2	R0.4	HSK-A63
P490-80HSKA63-16	80	8	100	16	0.2X45°	R0.2	R0.4	HSK-A63
P490-100HSKA63-18	100	8	100	18	0.2X45°	R0.2	R0.4	HSK-A63
P490-125HSKA63-22	125	8	100	22	0.2X45°	R0.2	R0.4	HSK-A63
P490-80HSKA63-16	80	8	100	16	0.2X45°	R0.2	R0.4	HSK-A100
P490-100HSKA63-18	100	8	100	18	0.2X45°	R0.2	R0.4	HSK-A100
P490-125HSKA63-22	125	8	100	22	0.2X45°	R0.2	R0.4	HSK-A100
P490-40SK40-10	40	8	100	10	0.2X45°	R0.2	R0.4	SK 40
P490-50SK40-12	50	8	100	12	0.2X45°	R0.2	R0.4	SK 40
P490-63SK40-14	63	8	100	14	0.2X45°	R0.2	R0.4	SK 40
P490-80SK40-16	80	8	100	16	0.2X45°	R0.2	R0.4	SK 40
P490-100SK40-18	100	8	100	18	0.2X45°	R0.2	R0.4	SK 40
P490-125SK40-22	125	8	100	22	0.2X45°	R0.2	R0.4	SK 40
P490-40BT40-10	40	8	100	10	0.2X45°	R0.2	R0.4	BT 40
P490-50BT40-12	50	8	100	12	0.2X45°	R0.2	R0.4	BT 40
P490-63BT40-14	63	8	100	14	0.2X45°	R0.2	R0.4	BT 40
P490-80BT40-16	80	8	100	16	0.2X45°	R0.2	R0.4	BT 40
P490-100BT40-18	100	8	100	18	0.2X45°	R0.2	R0.4	BT 40
P490-125BT40-22	125	8	100	22	0.2X45°	R0.2	R0.4	BT 40

★ Application: Dedicated to heavy-stock face milling, with an effective depth of cut of 8 mm.

PCD Corn Mill with Helix Flute (Cylindrical Shank)

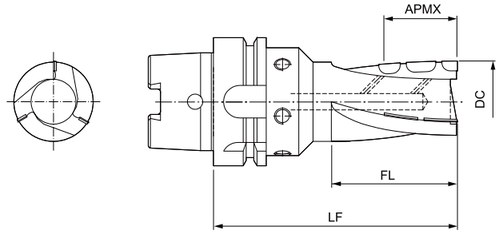


Shank Diameter Tolerance DCON	h6
Cutting Diameter Tolerance	h10
Tool Diameter	0.15x45
Point Geometry	16.0-25.0

Ordering Code	Dimension							
	DC	APMX	LF	DCON	FL	SL	Number of Teeth, Z	Shank Type
P190-016A16-3	16	30	100	16	50	48	3	Cylindrical Shank
P190-020A20-3	20	30	100	20	50	50	3	Cylindrical Shank
P190-025A25-3	25	30	115	25	50	56	3	Cylindrical Shank

★ Application: With its helical insert arrangement, this cutter is ideally suited for high metal-removal-rate milling — for example, monolithic structural components.

PCD Corn Mill with Helix Flute (HSK/SK/BT Shank)

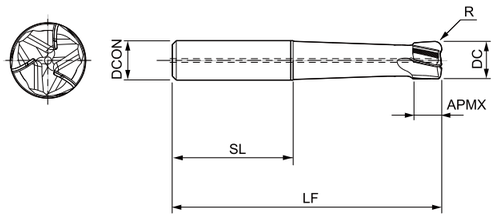


Helix Angle	15°
Cutting Diameter Tolerance	h10
Tool Diameter	32.0-63.0

Ordering Code	Dimension							
	DC	APMX	LF	FL	Helix Angle	Point Geometry	Number of Teeth, Z	Shank Type
P190-032HSKA63-3	32	50	100	40	15°	0.1X45°	3	HSK-A63
P190-040HSKA63-3	40	60	100	43	15°	0.1X45°	3	HSK-A63
P190-050HSKA63-4	50	60	110	46	15°	0.1X45°	4	HSK-A63
P190-063HSKA63-4	63	60	110	63	15°	0.1X45°	4	HSK-A63
P190-032SK40-3	32	50	100	47	15°	0.1X45°	3	SK40
P190-040SK40-3	40	60	100	50	15°	0.1X45°	3	SK40
P190-050SK40-4	50	60	110	70	15°	0.1X45°	4	SK40
P190-063SK40-4	63	60	110	70	15°	0.1X45°	4	SK40
P190-032BT40-3	32	50	100	56	15°	0.1X45°	3	BT40
P190-040BT40-3	40	60	100	57	15°	0.1X45°	3	BT40
P190-050BT40-4	50	60	110	62	15°	0.1X45°	4	BT40
P190-063BT40-4	63	60	110	62	15°	0.1X45°	4	BT40

★ Application: With its helical insert arrangement, this cutter is ideally suited for high metal-removal-rate milling — for example, monolithic structural components.

Brazed PCD Heavey Duty Mill

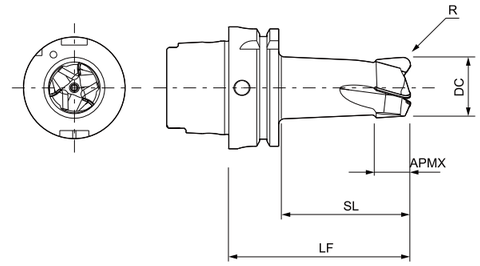


Shank Diameter Tolerance	h6
Cutting Diameter Tolerance	h10
Tool Diameter	6.0-32.0
Maximum Ramping Angle	5°

Ordering Code	Dimension							
	DC	APMX	LF	SL	Axial Rake Angle	刃尖R	Number of Teeth, Z	Shank Type
P290-06A6-3	6	6	60	36	9°	1	3	Cylindrical Shank
P290-08A8-3	8	7	70	36	9°	1	3	Cylindrical Shank
P290-10A10-3	10	7.5	80	40	9°	2	3	Cylindrical Shank
P290-12A12-3	12	8.5	90	45	9°	2	3	Cylindrical Shank
P290-14A14-3	14	10	100	45	12°	3	3	Cylindrical Shank
P290-15A16-3	15	10.6	100	48	12°	3	3	Cylindrical Shank
P290-16A16-3	16	11.4	105	48	12°	3	3	Cylindrical Shank
P290-18A20-3	18	12.8	115	48	12°	3	3	Cylindrical Shank
P290-20A20-3	20	14.2	120	50	12°	3	3	Cylindrical Shank
P290-25A25-3	25	17.8	145	56	12°	4	3	Cylindrical Shank
P290-30A32-3	30	18.5	150	60	12°	4	3	Cylindrical Shank
P290-32A32-3	32	20	150	60	12°	4	3	Cylindrical Shank

★ Application: For machining aluminum structural components.

Brazed PCD Heavey Duty Mill



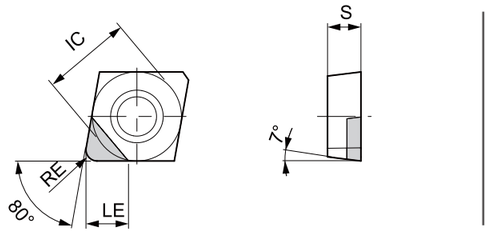
Cutting Diameter Tolerance	h10
Tool Diameter	6.0-32.0
Maximum Ramping Angle	5°

Ordering Code	Dimension							
	DC	APMX	LF	SL	Axial Rake Angle	刃尖R	Number of Teeth, Z	Shank Type
P290-32HSKA63-3	32	18	85	56	12°	3	3	HSK-A63
P290-40HSKA63-3	40	18	100	72	12°	4	4	HSK-A63
P290-50HSKA63-3	50	20	110	81	12°	4	4	HSK-A63

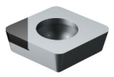
★ Application: For machining aluminum structural components.

★ Application: For machining aluminum structural components.

CCGW PCD Insert (Rhombic 80°)

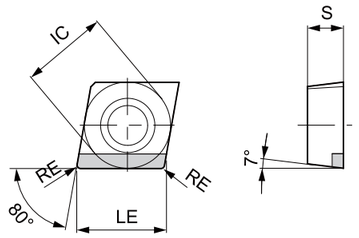


Insert Size			
Size	IC	S	LE
06	6.35	2.38	2.9
09	9.525	3.97	3.4
12	12.7	4.76	4.6

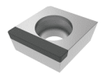
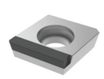
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		CCGW060204F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		CCGW060208F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		CCGW09T304F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	3.0							★					
		CCGW09T308F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	3.0							★					
		CCGW120404F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	4.0							★					
		CCGW120408F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	4.0							★					

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

CCGW PCD Insert (Rhombic 80°)

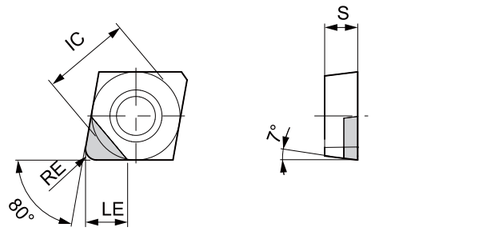


Insert Size			
Size	IC	S	LE
06	6.35	2.38	6.1/5.6
09	9.525	3.97	9.3/8.8
12	12.7	4.76	12.5/12

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning	 Full-Edge Insert	CCGW060204F0L-P0E	0.4	0.1	0.05	0.2	0.5	0.1	6.0							★					
		CCGW060208F0L-P0E	0.8	0.1	0.05	0.2	0.5	0.1	6.0							★					
		CCGW09T304F0L-P0E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CCGW09T308F0L-P0E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CCGW120404F0L-P0E	0.4	0.1	0.05	0.2	0.5	0.1	12.0							★					
		CCGW120408F0L-P0E	0.8	0.1	0.05	0.2	0.5	0.1	12.0							★					
		CCGW060204F0R-P0E	0.4	0.1	0.05	0.2	0.5	0.1	6.0							★					
		CCGW060208F0R-P0E	0.8	0.1	0.05	0.2	0.5	0.1	6.0							★					
		CCGW09T304F0R-P0E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CCGW09T308F0R-P0E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CCGW120404F0R-P0E	0.4	0.1	0.05	0.2	0.5	0.1	12.0							★					
		CCGW120408F0R-P0E	0.8	0.1	0.05	0.2	0.5	0.1	12.0							★					
	 Short Insert	CCGW060204F0SL-P0E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CCGW060208F0SL-P0E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CCGW09T304F0SL-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CCGW09T308F0SL-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CCGW20404F0SL-P0E	0.4	0.1	0.05	0.2	0.5	0.1	11.0							★					
		CCGW20408F0SL-P0E	0.8	0.1	0.05	0.2	0.5	0.1	11.0							★					
		CCGW060204F0SR-P0E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CCGW060208F0SR-P0E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CCGW09T304F0SR-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CCGW09T308F0SR-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CCGW120404F0SR-P0E	0.4	0.1	0.05	0.2	0.5	0.1	11.0							★					
		CCGW120408F0SR-P0E	0.8	0.1	0.05	0.2	0.5	0.1	11.0							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

CCGT PCD Insert (Rhombic 80°)

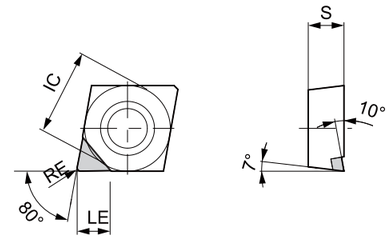


Insert Size			
Size	IC	S	LE
06	6.35	2.38	2.9
09	9.525	3.97	3.4

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning		CCGT060202F0N-P0A-CB1	0.2	0.1	0.05	0.2	0.5	0.1	2.3								★				
		CCGT060204F0N-P0A-CB1	0.4	0.1	0.05	0.2	0.5	0.1	2.3								★				
		CCGT09T304F0N-P0A-CB1	0.4	0.1	0.05	0.2	0.5	0.1	3.4								★				
		CCGT09T308F0N-P0A-CB1	0.8	0.1	0.05	0.2	0.5	0.1	3.4								★				
		CCGT060202F0N-P0A-CB2	0.2	0.1	0.05	0.2	0.5	0.1	2.3								★				
		CCGT060204F0N-P0A-CB2	0.4	0.1	0.05	0.2	0.5	0.1	2.3								★				
		CCGT09T304F0N-P0A-CB2	0.4	0.1	0.05	0.2	0.5	0.1	3.4								★				
		CCGT09T308F0N-P0A-CB2	0.8	0.1	0.05	0.2	0.5	0.1	3.4								★				

★ Designed for non-ferrous materials, this chip-breaker geometry positively and effectively forms short, curled chips and suits facing, external (OD) turning and profile turning.

CCGT PCD Insert (Rhombic 80°)

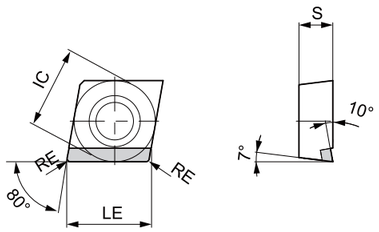


Insert Size			
Size	IC	S	LE
06	6.35	2.38	2.9
09	9.525	3.97	3.4
12	12.7	4.76	4.6

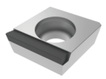
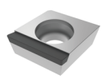
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning		CCGT060204F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	2.3								★				
		CCGT060208F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	2.3								★				
		CCGT09T304F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	3.4								★				
		CCGT09T308F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	3.4								★				
		CCGT120404F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	4.0								★				
		CCGT120408F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	4.0								★				

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

CCGT PCD Insert (Rhombic 80°)

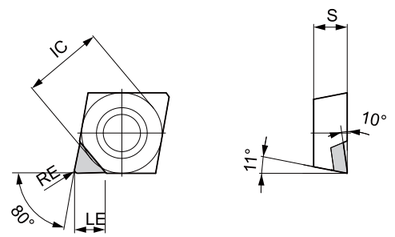


Insert Size			
Size	IC	S	LE
06	6.35	2.38	6.1/5.6
09	9.525	3.97	9.3/8.8
12	12.7	4.76	12.5/12

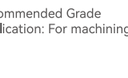
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		CCGT060204F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CCGT060208F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CCGT09T304F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CCGT09T308F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CCGT120404F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	11.0							★					
		CCGT120408F01SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	11.0							★					
	 Short Insert	CCGT060204F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CCGT060208F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CCGT09T304F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CCGT09T308F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CCGT120404F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	11.0							★					
		CCGT120408F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	11.0							★					
		CCGT060204F0R-P2E	0.4	0.1	0.05	0.2	0.5	0.1	6.0							★					
		CCGT060204F0R-P2E	0.8	0.1	0.05	0.2	0.5	0.1	6.0							★					
		CCGT09T304F0R-P2E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CCGT09T308F0R-P2E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CCGT120404F0R-P2E	0.4	0.1	0.05	0.2	0.5	0.1	12.0							★					
	 Full-Edge Insert	CCGT120408F0R-P2E	0.8	0.1	0.05	0.2	0.5	0.1	12.0							★					
		CCGT060204F0L-P2E	0.4	0.1	0.05	0.2	0.5	0.1	6.0							★					
		CCGT060208F0L-P2E	0.8	0.1	0.05	0.2	0.5	0.1	6.0							★					
		CCGT09T304F0L-P2E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CCGT09T308F0L-P2E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CCGT120404F0L-P2E	0.4	0.1	0.05	0.2	0.5	0.1	12.0							★					
		CCGT120408F0L-P2E	0.8	0.1	0.05	0.2	0.5	0.1	12.0							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

CPGT PCD Insert (Rhombic 80°)

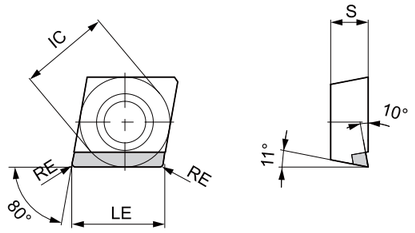


Insert Size			
Size	IC	S	LE
06	6.35	2.38	2.9
09	9.525	3.97	3.4

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		CPGT060204F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		CPGT060208F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		CPGT09T304F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	3.4							★					
		CPGT09T308F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	3.4							★					

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

CPGT PCD Insert (Rhombic 80°)

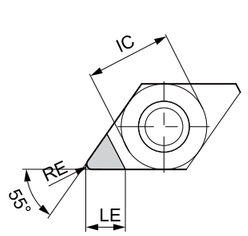


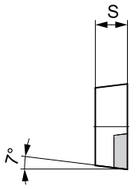
Insert Size			
Size	IC	S	LE
06	6.35	2.38	6.1/5.6
09	9.525	3.97	9.3/8.8

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning	Short Insert	CPGT060204F01SL-P2A	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CPGT060208F01SL-P2A	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CPGT09T304F01SL-P2A	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CPGT09T308F01SL-P2A	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CPGT060204F01SR-P2A	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CPGT060208F01SR-P2A	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		CPGT09T304F01SR-P2A	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		CPGT09T308F01SR-P2A	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
	Full-Edge Insert	CPGT060204F0L-P2E	0.4	0.1	0.05	0.2	0.5	0.1	5.8							★					
		CPGT060208F0L-P2E	0.8	0.1	0.05	0.2	0.5	0.1	5.8							★					
		CPGT09T304F0L-P2E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CPGT09T308F0L-P2E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CPGT060204F0R-P2E	0.4	0.1	0.05	0.2	0.5	0.1	5.8							★					
		CPGT060208F0R-P2E	0.8	0.1	0.05	0.2	0.5	0.1	5.8							★					
		CPGT09T304F0R-P2E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		CPGT09T308F0R-P2E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

DCGW / DCGT PCD Insert (Rhombic 55°)



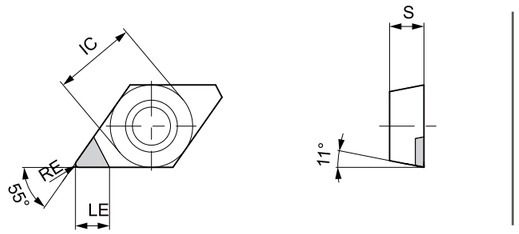


Insert Size			
Size	IC	S	LE
07	6.35	2.38	3
11	9.525	3.97	3.5

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		DCGW070202F0N-P0A	0.2	0.1	0.05	0.2	0.5	0.1	2.3							★					
		DCGW070204F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		DCGW070208F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		DCGW11T304F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	3							★					
		DCGW11T308F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	3							★					
		DCGT070202F0N-P0A CB1	0.2	0.1	0.05	0.2	0.5	0.1	2.3								★				
		DCGT070204F0N-P0A CB1	0.4	0.1	0.05	0.2	0.5	0.1	2.3								★				
		DCGT11T302F0N-P01 CB1	0.2	0.1	0.05	0.2	0.5	0.1	3								★				
		DCGT11T304F0N-P0A CB1	0.4	0.1	0.05	0.2	0.5	0.1	3								★				
		DCGT11T308F0N-P01 CB1	0.8	0.1	0.05	0.2	0.5	0.1	3								★				
		DCGT070202F0N-P0A CB2	0.2	0.1	0.05	0.2	0.5	0.1	2.3								★				
		DCGT070204F0N-P0A CB2	0.4	0.1	0.05	0.2	0.5	0.1	2.3								★				
		DCGT11T302F0-NP0A CB2	0.2	0.1	0.05	0.2	0.5	0.1	3								★				
		DCGT11T304F0N-P0A CB2	0.4	0.1	0.05	0.2	0.5	0.1	3								★				
		DCGT11T308F0N-P0A CB2	0.8	0.1	0.05	0.2	0.5	0.1	3								★				

★ Designed for non-ferrous materials, this chip-breaker geometry positively and effectively forms short, curled chips and suits facing, external (OD) turning and profile turning.

DPGW PCD Insert (Rhombic 55°)

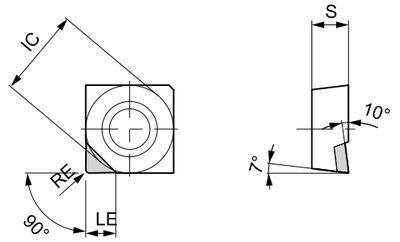


Insert Size			
Size	IC	S	LE
07	6.35	2.38	3
11	9.525	3.97	3.5

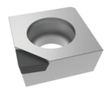
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		DPGW070202F0N-P0A	0.2	0.1	0.05	0.2	0.5	0.1	2.3							★					
		DPGW070204F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		DPGW070208F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		DPGW11T304F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	3							★					
		DPGW11T308F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	3							★					

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

SCGT PCD Insert (Square 90°)

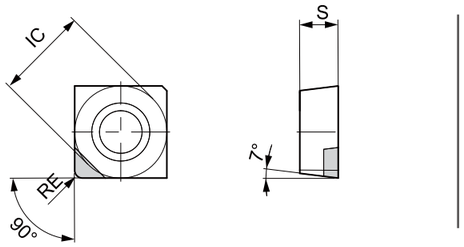


Insert Size			
SIZE	IC	S	LE
06	6.35	2.38	2.8
09	9.525	3.97	3.1
12	12.7	4.76	4.5

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		SCGT060204F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		SCGT060208F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		SCGT09T304F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	3.0							★					
		SCGT09T308F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	3.0							★					
		SCGT120404F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	4.0							★					
		SCGT120408F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	4.0							★					

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

SCGT PCD Insert (Square 90°)

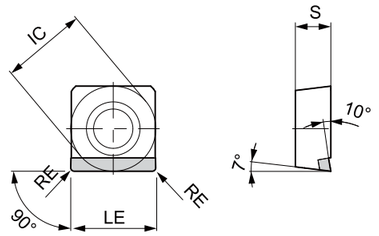


Insert Size			
SIZE	IC	S	LE
09	9.525	3.97	3.1
12	12.7	4.76	4.5

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		SCGT09T304F0N-P0A CB1	0.4	0.1	0.05	0.2	0.5	0.1	3.0								★				
		SCGT09T308F0N-P0A CB1	0.8	0.1	0.05	0.2	0.5	0.1	3.0								★				
		SCGT120404F01N-P0A CB1	0.4	0.1	0.05	0.2	0.5	0.1	4.0								★				
		SCGT120408F0N-P0A CB1	0.8	0.1	0.05	0.2	0.5	0.1	4.0								★				
		SCGT09T304F0N-P0A CB2	0.4	0.1	0.05	0.2	0.5	0.1	3.0								★				
		SCGT09T304F0N-P0A CB2	0.8	0.1	0.05	0.2	0.5	0.1	3.0								★				
		SCGT120404F0N-P0A CB2	0.4	0.1	0.05	0.2	0.5	0.1	4.0								★				
		SCGT120408F0N-P0A CB2	0.8	0.1	0.05	0.2	0.5	0.1	4.0								★				

★ Designed for non-ferrous materials, this chip-breaker geometry positively and effectively forms short, curled chips and suits facing, external (OD) turning and profile turning.

SCGT PCD Insert (Square 90°)

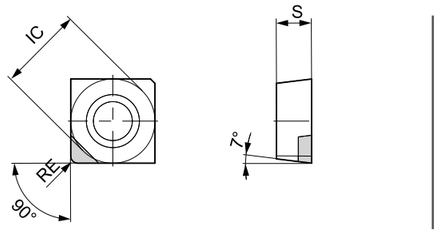


Insert Size			
SIZE	IC	S	LE
06	6.35	2.38	6.2/5.7
09	9.525	3.97	9.3/8.8
12	12.7	4.76	12.4/11.9

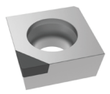
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning	Short Insert	SCGT060204F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SCGT060208F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SCGT09T304F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SCGT09T308F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SCGT120404F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	11.0							★					
		SCGT120408F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	11.0							★					
		SCGT060204F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SCGT060208F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SCGT09T304F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SCGT09T308F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SCGT120404F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	11.0							★					
		SCGT120408F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	11.0							★					
	Full-Edge Insert	SCGT060204F0-P2E	0.4	0.1	0.05	0.2	0.5	0.1	6.0							★					
		SCGT060208F0-P2E	0.8	0.1	0.05	0.2	0.5	0.1	6.0							★					
		SCGT09T304F0-P2E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		SCGT09T308F0-P2E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		SCGT120404F0-P2E	0.4	0.1	0.05	0.2	0.5	0.1	12.0							★					
		SCGT120408F0-P2E	0.8	0.1	0.05	0.2	0.5	0.1	12.0							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

SCGW PCD Insert (Square 90°)

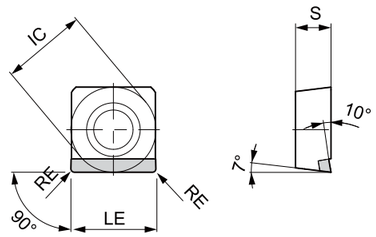


Insert Size			
SIZE	IC	S	LE
06	6.35	2.38	2.8
09	9.525	3.97	3.1
12	12.7	4.76	4.5

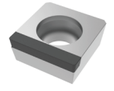
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning		SCGW060204F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		SCGW060208F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		SCGW09T304F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	3.0							★					
		SCGW09T308F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	3.0							★					
		SCGW120404F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	4.0							★					
		SCGW120408F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	4.0							★					

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

SCGW PCD Insert (Square 90°)

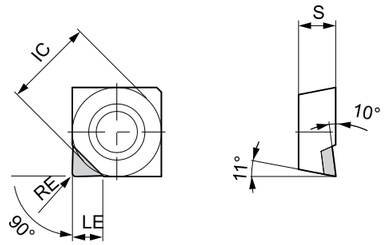


Insert Size			
SIZE	IC	S	LE
06	6.35	2.38	6.2/5.7
09	9.525	3.97	9.3/8.8
12	12.7	4.76	12.4/11.9

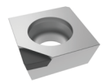
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning	Short Insert	SCGW060204F0SL-P0E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SCGW060208F0SL-P0E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SCGW09T304F0SL-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SCGW09T308F0SL-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SCGW120404F0SL-P0E	0.4	0.1	0.05	0.2	0.5	0.1	11.0							★					
		SCGW120408F0SL-P0E	0.8	0.1	0.05	0.2	0.5	0.1	11.0							★					
		SCGW060204F0SR-P0E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SCGW060208F0SR-P0E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SCGW09T304F0SR-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SCGW09T308F0SR-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SCGW120404F0SR-P0E	0.4	0.1	0.05	0.2	0.5	0.1	11.0							★					
		SCGW120408F0SR-P0E	0.8	0.1	0.05	0.2	0.5	0.1	11.0							★					
	 Full-Edge Insert	SCGW060204F0-P0E	0.4	0.1	0.05	0.2	0.5	0.1	6.0							★					
		SCGW060208F0-P0E	0.8	0.1	0.05	0.2	0.5	0.1	6.0							★					
		SCGW09T308F0-P0E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		SCGW09T308F0-P0E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		SCGW120404F0-P0E	0.4	0.1	0.05	0.2	0.5	0.1	12.0							★					
		SCGW120408F0-P0E	0.8	0.1	0.05	0.2	0.5	0.1	12.0							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

SPGT PCD Insert (Square 90°)

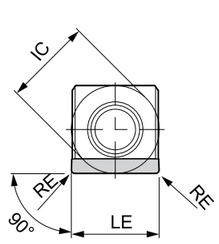


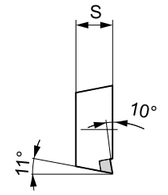
Insert Size			
SIZE	IC	S	LE
06	6.35	2.38	2.8
09	9.525	3.97	3.1

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning		SPGT060304F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		SPGT060308F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		SPGT09T304F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	3.0							★					
		SPGT09T308F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	3.0							★					

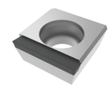
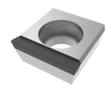
★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

SPGT PCD Insert (Square 90°)



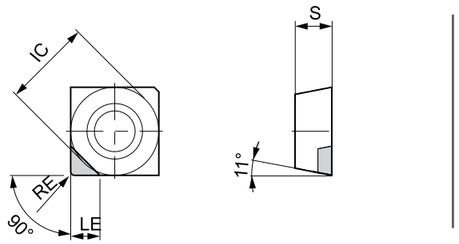


Insert Size			
SIZE	IC	S	LE
06	6.35	2.38	6.2/5.6
09	9.525	3.97	9.3/8.7

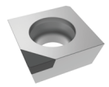
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning	 Short Insert	SPGT060304F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SPGT060308F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SPGT09T304F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SPGT09T308F0SL -P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SPGT060304F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SPGT060308F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SPGT09T304F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SPGT09T308F0SR -P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
	 Full-Edge Insert	SPGT060304F0-P2E	0.4	0.1	0.05	0.2	0.5	0.1	6.0							★					
		SPGT060304F0-P2E	0.8	0.1	0.05	0.2	0.5	0.1	6.0							★					
		SPGT09T304F0-P2E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		SPGT09T308F0-P2E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

SPGW PCD Insert (Square 90°)

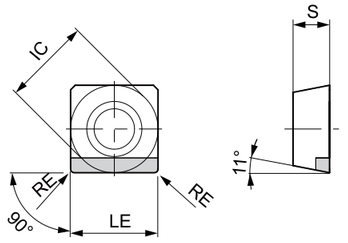


Insert Size			
SIZE	IC	S	LE
06	6.35	2.38	2.8
09	9.525	3.97	3.1

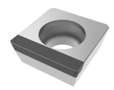
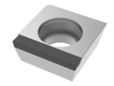
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		SPGW060304F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		SPGW060308F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		SPGW09T304F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	3.0							★					
		SPGW09T308F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	3.0							★					

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

SPGW PCD Insert (Square 90°)

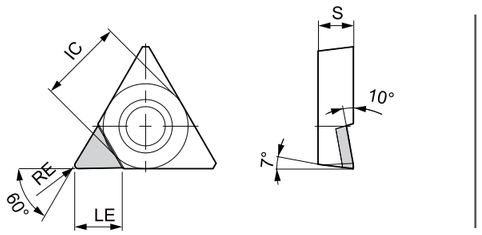


Insert Size			
SIZE	IC	S	LE
06	6.35	2.38	6.2/5.6
09	9.525	3.97	9.3/8.7

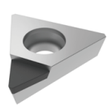
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning	 Full-Edge Insert	SPGW060304F0SL-P0E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SPGW060308F0SL-P0E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SPGW09T304F0SL-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SPGW09T308F0SL-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SPGW060304F0SR-P0E	0.4	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SPGW060308F0SR-P0E	0.8	0.1	0.05	0.2	0.5	0.1	5.0							★					
		SPGW09T304F0SR-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		SPGW09T308F0SR-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
	 Short Insert	SPGW060304F0-P0E	0.4	0.1	0.05	0.2	0.5	0.1	6.0							★					
		SPGW060304F0-P0E	0.8	0.1	0.05	0.2	0.5	0.1	6.0							★					
		SPGW09T304F0-P0E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		SPGW09T308F0-P0E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

TCGT PCD Insert (Triangle 60°)

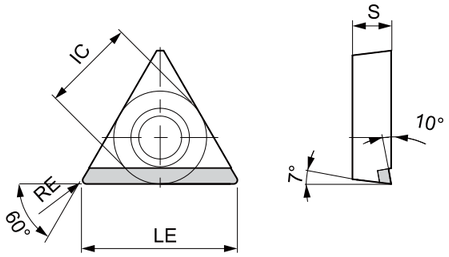


Insert Size			
SIZE	IC	S	LE
09	5.56	2.38	3.1
11	6.35	2.38	3.5
16	9.52	3.97	5.1

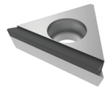
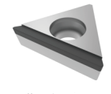
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning		TCGT090204 F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	2.3							★					
		TCGT090208 F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	2.3							★					
		TCGT110204 F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	3.0							★					
		TCGT110208 F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	3.0							★					
		TCGT16T304 F0N-P2A	0.4	0.1	0.05	0.2	0.5	0.1	4.0							★					
		TCGT16T308 F0N-P2A	0.8	0.1	0.05	0.2	0.5	0.1	4.0							★					

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

TCGT PCD Insert (Triangle 60°)

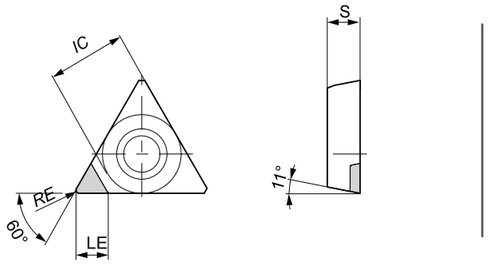


Insert Size			
SIZE	IC	S	LE
09	5.56	2.38	8.3/7.8
11	6.35	2.38	9.5/9
16	9.52	3.97	15/14.5

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)														
				Rec.	Min.	Max.	Rec.	Min.	Max.							D028	D003				
General Turning	 Short Insert	TCGT090204 F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	7.5							★					
		TCGT090208 F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	7.5							★					
		TCGT110204 F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.5							★					
		TCGT110208 F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.5							★					
		TCGT16T304 F0SL-P2E	0.4	0.1	0.05	0.2	0.5	0.1	14.0							★					
		TCGT16T308 F0SL-P2E	0.8	0.1	0.05	0.2	0.5	0.1	14.0							★					
		TCGT090204 F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	7.5							★					
		TCGT090208 F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	7.5							★					
		TCGT110204 F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.5							★					
		TCGT110208 F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.5							★					
		TCGT16T304 F0SR-P2E	0.4	0.1	0.05	0.2	0.5	0.1	14.0							★					
		TCGT16T308 F0SR-P2E	0.8	0.1	0.05	0.2	0.5	0.1	14.0							★					
	 Full-Edge Insert	TCGT090204 F0-P2E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		TCGT090208 F0-P2E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		TCGT110204 F0-P2E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		TCGT110208 F0-P2E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		TCGT16T304 F0-P2E	0.4	0.1	0.05	0.2	0.5	0.1	14.8							★					
		TCGT16T308 F0-P2E	0.8	0.1	0.05	0.2	0.5	0.1	14.8							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

TCGT PCD Insert (Triangle 60°)

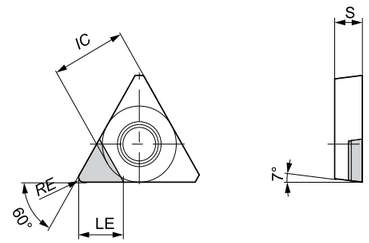


Insert Size			
SIZE	IC	S	LE
11	6.35	2.38	3.5

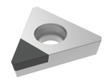
Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning		TCGT110202 F0 N-CB1	0.4	0.1	0.05	0.2	0.5	0.1	3.0								★				
		TCGT110204 F01N-CB1	0.8	0.1	0.05	0.2	0.5	0.1	3.0								★				
		TCGT110202 F0N-CB2	0.4	0.1	0.05	0.2	0.5	0.1	3.0								★				
		TCGT110204 F0N-CB2	0.8	0.1	0.05	0.2	0.5	0.1	3.0								★				

★ Designed for non-ferrous materials, this chip-breaker geometry positively and effectively forms short, curled chips and suits facing, external (OD) turning and profile turning.

TCGW PCD Insert (Triangle 60°)

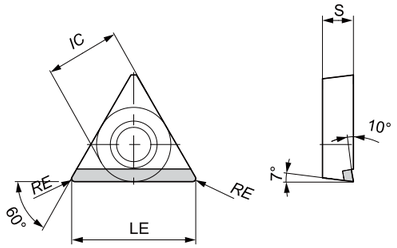


Insert Size			
SIZE	IC	S	LE
09	5.56	2.38	3.1
11	6.35	2.38	3.5
16	9.52	3.97	5.1

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning		TCGW 090204 F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	2.3								★				
		TCGW 090208 F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	2.3								★				
		TCGW 110204 F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	3.0								★				
		TCGW 110208 F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	3.0								★				
		TCGW 16T304 F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	4.0								★				
		TCGW 16T308 F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	4.0								★				

★ Recommended Grade
Application: For machining non-ferrous materials (ISO N) — facing, external (OD) turning, and profile turning.

TCGW PCD Insert (Triangle 60°)

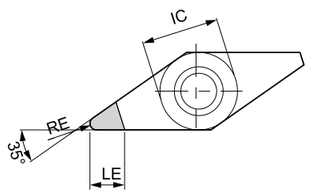


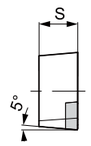
Insert Size			
SIZE	IC	S	LE
09	5.56	2.38	8.3/7.8
11	6.35	2.38	9.5/9
16	9.52	3.97	15/14.5

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning	Short Insert	TCGW 090204 F0L-P0E	0.4	0.1	0.05	0.2	0.5	0.1	7.5							★					
		TCGW 090208 F0L-P0E	0.8	0.1	0.05	0.2	0.5	0.1	7.5							★					
		TCGW 110204 F0L-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.5							★					
		TCGW 110208 F0L-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.5							★					
		TCGW 16T304 F0L-P0E	0.4	0.1	0.05	0.2	0.5	0.1	14.0							★					
		TCGW 16T308 F0L-P0E	0.8	0.1	0.05	0.2	0.5	0.1	14.0							★					
		TCGW 090204 F0R-P0E	0.4	0.1	0.05	0.2	0.5	0.1	7.5							★					
		TCGW 090208 F0R-P0E	0.8	0.1	0.05	0.2	0.5	0.1	7.5							★					
		TCGW 110204 F0R-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.5							★					
		TCGW 110208 F0R-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.5							★					
		TCGW 16T304 F0R-P0E	0.4	0.1	0.05	0.2	0.5	0.1	14.0							★					
		TCGW 16T308 F0R-P0E	0.8	0.1	0.05	0.2	0.5	0.1	14.0							★					
	Full-Edge Insert	TCGW 090204 F0-P0E	0.4	0.1	0.05	0.2	0.5	0.1	8.0							★					
		TCGW 090208 F0-P0E	0.8	0.1	0.05	0.2	0.5	0.1	8.0							★					
		TCGW 110204 F0-P0E	0.4	0.1	0.05	0.2	0.5	0.1	9.0							★					
		TCGW 110208 F0-P0E	0.8	0.1	0.05	0.2	0.5	0.1	9.0							★					
		TCGW 16T304 F0-P0E	0.4	0.1	0.05	0.2	0.5	0.1	14.8							★					
		TCGW 16T308 F0-P0E	0.8	0.1	0.05	0.2	0.5	0.1	14.8							★					

★ Recommended Grade
Application: Especially suited for machining non-ferrous materials (ISO N) at large depths of cut — facing, external (OD) turning, and profile turning.

VBGW PCD Insert (Rhombic 35°)



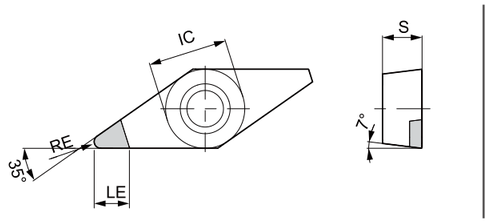


Insert Size			
Size	IC	S	LE
16	9.525	4.76	5

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning		VBGW 160404 F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	1.5							★					
		VBGW 160408 F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	1.5							★					
		VBGT 160404 F0N CB1	0.4	0.1	0.05	0.2	0.5	0.1	1.5								★				
		VBGT 160408 F0N CB1	0.8	0.1	0.05	0.2	0.5	0.1	1.5								★				

★ Designed for non-ferrous materials, this chip-breaker geometry positively and effectively forms short, curled chips and suits facing, external (OD) turning and profile turning.

VCGW PCD Insert (Rhombic 35°)



Insert Size			
Size	IC	S	LE
11	6.35	3.18	3.9
16	9.525	4.76	5

Application	Insert Shape	Ordering Code	Corner Radius, RE	Recommended Cutting Data						Insert Grade											
				Feed (mm/r)			Depth of Cut (mm)									D028	D003				
				Rec.	Min.	Max.	Rec.	Min.	Max.												
General Turning		VCGW 160404 F0N-P0A	0.4	0.1	0.05	0.2	0.5	0.1	1.0							★					
		VCGW 160408 F0N-P0A	0.8	0.1	0.05	0.2	0.5	0.1	1.0							★					
		VCGT 110302 F0N-CB1	0.2	0.1	0.05	0.2	0.5	0.1	1.0								★				
		VCGT 110304 F0N-CB1	0.4	0.1	0.05	0.2	0.5	0.1	1.0								★				
		VCGT 160404 F0N-CB1	0.4	0.1	0.05	0.2	0.5	0.1	1.0								★				
		VCGT 160408 F0N-CB1	0.8	0.1	0.05	0.2	0.5	0.1	1.0								★				

★ Designed for non-ferrous materials, this chip-breaker geometry positively and effectively forms short, curled chips and suits facing, external (OD) turning and profile turning.

MEMO