2011

CUTTING TOOLS

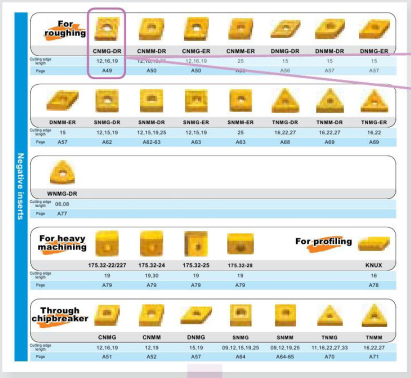
●Turning Tools ●Milling Tools ●Boring Tools

CUTTING TOOLS 2011'

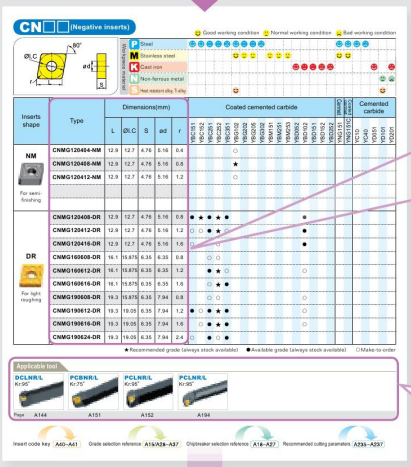
EJ Carbide Co.,Ltd

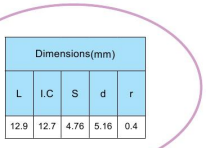
Guide to selecting general turning tools

Selection A



Step 1 : **I want to order inserts**
•Shape, •Size, •Chipbreaker

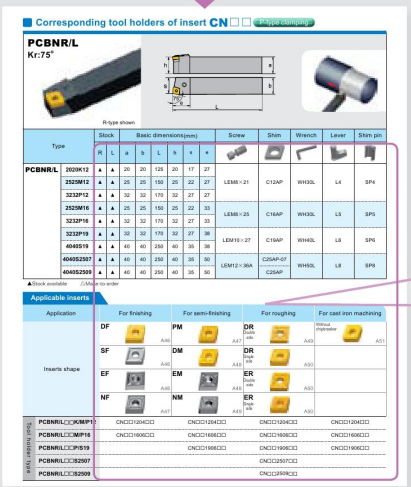




Dimensions(mm)				
L	I.C	S	d	r
12.9	12.7	4.76	5.16	0.4

Step 2 : **Details of inserts**
•Shape, •Size, •Chipbreaker, •Grade, •Stock
Applicable tool holders
•Approach angle, Page

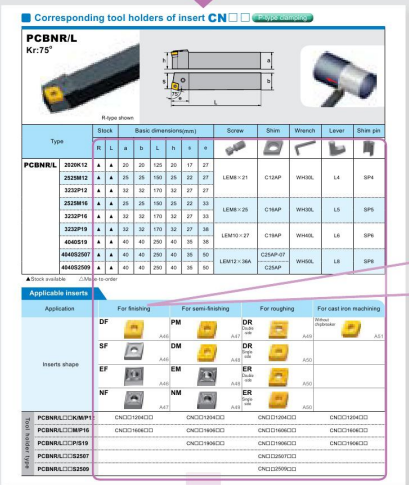
Step 3 : **Selecting tool holder**
•Tool holder type, Size, •Stock
•Operation genre, •Applicable inserts

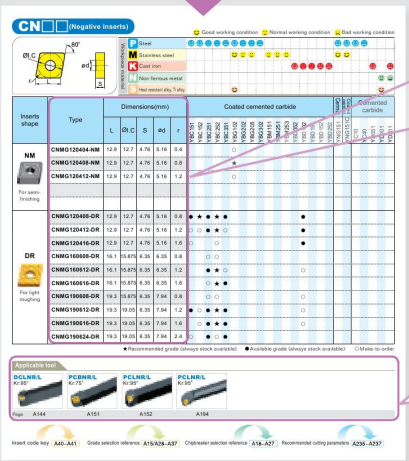


Step 4 : **Return to locate inserts**

Guide to selecting general turning tools

Selection B



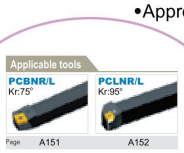


Step **1** : **I want to order tool holders**
•Approach angle, •Clamping system

Step **2** : **Details of tool holder**
•Tool holder type, Size, •Operation genre
•Applicable inserts

Dimensions(mm)				
L	I.C	S	d	r
12.9	12.7	4.76	5.16	0.4

Step **3** : **Details of insert**
•Shape, •Size, •Chipbreaker, •Grade, •Stock
Applicable tool holders
•Approach angle, •Page



Step **4** : **Return to locate tool holder**

Guide to selecting parting and grooving tools

Tools for parting and grooving

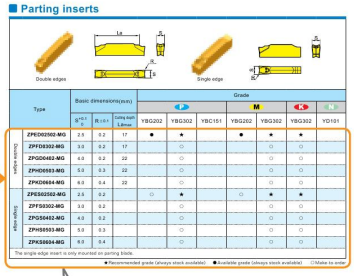
External parting, grooving and turning tools

Type		Stock R	Stock L	Basic dimensions (mm) H × B	L	S	W	ΔR max	Applicable inserts	Screw	Wrench
QEED	1616R/L10	▲	▲	16 × 16	125	15	2.5	10	ZQED025□□	GB70-85-M5 × 20	WH40L
	1616R/L17	▲	▲	16 × 16	125	15	2.5	17	ZCED025□□		
	2020R/L10	▲	▲	20 × 20	125	19	2.5	10	ZQED025□□	GB70-85-M6 × 20	WH50L
	2020R/L17	▲	▲	20 × 20	125	19	2.5	17	ZCED025□□		
	2525R/L10	▲	▲	25 × 25	150	24	2.5	10	ZQED025□□		
	2525R/L17	▲	▲	25 × 25	150	24	2.5	17	ZCED025□□		
QEFD	1616R/L10	▲	▲	16 × 16	125	14.8	3	10	ZQFD03□□	GB70-85-M5 × 20	WH40L
	1616R/L17	▲	▲	16 × 16	125	14.8	3	17	ZCFD03□□		
	2020R/L10	▲	▲	20 × 20	125	18.8	3	10	ZQFD03□□	GB70-85-M6 × 20	WH50L
	2020R/L17	▲	▲	20 × 20	125	18.8	3	17	ZCFD03□□		
	2525R/L10	▲	▲	25 × 25	150	23.8	3	10	ZQFD03□□		
	2525R/L17	▲	▲	25 × 25	150	23.8	3	17	ZCFD03□□		
QEGD	2020R/L13	▲	▲	20 × 20	140	18.5	4	13	ZCGD04□□	GB70-85-M6 × 20	WH50L
	2020R/L22	▲	▲	20 × 20	140	18.5	4	22	ZCGD04□□		
	2525R/L13	▲	▲	25 × 25	150	23.5	4	13	ZCGD04□□		
	2525R/L22	▲	▲	25 × 25	150	23.5	4	22	ZCGD04□□		
	3232R/L13	▲	▲	32 × 32	170	30.5	4	13	ZCGD04□□		
	3232R/L22	▲	▲	32 × 32	170	30.5	4	22	ZCGD04□□		
QEHD	2525R/L13	▲	▲	25 × 25	150	23	5	13	ZCHD05□□	GB70-85-M6 × 20	WH50L
	2525R/L22	▲	▲	25 × 25	150	23	5	22	ZCHD05□□		
QEHS	2525N30	▲	▲	25 × 25	150	12.5	5	30	ZCHS05□□		
QEHD	3232R/L13	▲	▲	32 × 32	170	30	5	13	ZCHD05□□		
	3232R/L22	▲	▲	32 × 32	170	30	5	22	ZCHD05□□		
QEHS	3232N30	▲	▲	32 × 32	170	16	5	30	ZCHS05□□		
QEKD	2525R/L13	▲	▲	25 × 25	150	22.6	6	13	ZCKD06□□	GB70-85-M6 × 20	WH50L
	2525R/L22	▲	▲	25 × 25	150	22.6	6	22	ZCKD06□□		
QEKS	2525N30	▲	▲	25 × 25	150	12.5	6	30	ZCKS06□□		
QEKD	3232R/L13	▲	▲	32 × 32	170	29.6	6	13	ZCKD06□□		
	3232R/L22	▲	▲	32 × 32	170	29.6	6	22	ZCKD06□□		
QEKS	3232N30	▲	▲	32 × 32	170	16	6	30	ZCKS06□□		

R-type shown

▲ Stock available ○ Made-to-order

Parting inserts



Type	Basic dimensions (mm) S (+0.1 / 0)	R (±0.1)	Cutting depth L(max)	Grade: ◀▶ YBG202	◀▶ YBG302	◀▶ YBC151	M YBG202	M YBG302	◀▶ YBG302	N YD101
Double edges: ZPED02502-MG	2.5	0.2	17	●	★		●	★	●	
ZPFD03002-MG	3.0	0.2	17		○			○	○	
ZPGD04002-MG	4.0	0.2	22		○			○	○	
ZPHD05003-MG	5.0	0.3	22		○			○	○	
ZPKD06004-MG	6.0	0.4	22		○			○	○	
Single edge: ZPES02502-MG	2.5	0.2		○	★		○	★	●	
ZPFS03002-MG	3.0	0.2			○			○	○	
ZPGS04002-MG	4.0	0.2			○			○	○	
ZPHS05003-MG	5.0	0.3			○			○	○	
ZPKS06004-MG	6.0	0.4			○			○	○	

The single edge insert is only mounted on parting blade.

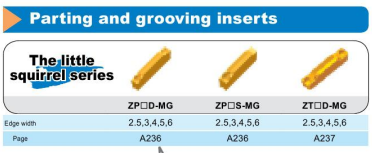
●Recommended grade (always stock available) ●Available grade (always stock available) □Make to order

1 Selection of tool holder type

2 Tool holder type, Size and applicable inserts

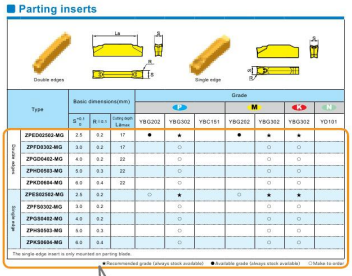
3 Insert type, Chip-breaker, Size and grade

Parting and grooving inserts



	ZP□D-MG	ZP□S-MG	ZT□D-MG
Edge width	2.5,3,4,5,6	2.5,3,4,5,6	2.5,3,4,5,6
Page	A236	A236	A237

Parting inserts



Type	Basic dimensions (mm) S (+0.1 / 0)	R (±0.1)	Cutting depth L(max)	Grade: ◀▶ YBG202	◀▶ YBG302	◀▶ YBC151	M YBG202	M YBG302	◀▶ YBG302	N YD101
Double edges: ZPED02502-MG	2.5	0.2	17	●	★		●	★	●	
ZPFD03002-MG	3.0	0.2	17		○			○	○	
ZPGD04002-MG	4.0	0.2	22		○			○	○	
ZPHD05003-MG	5.0	0.3	22		○			○	○	
ZPKD06004-MG	6.0	0.4	22		○			○	○	
Single edge: ZPES02502-MG	2.5	0.2		○	★		○	★	●	
ZPFS03002-MG	3.0	0.2			○			○	○	
ZPGS04002-MG	4.0	0.2			○			○	○	
ZPHS05003-MG	5.0	0.3			○			○	○	
ZPKS06004-MG	6.0	0.4			○			○	○	

The single edge insert is only mounted on parting blade.

●Recommended grade (always stock available) ●Available grade (always stock available) □Make to order

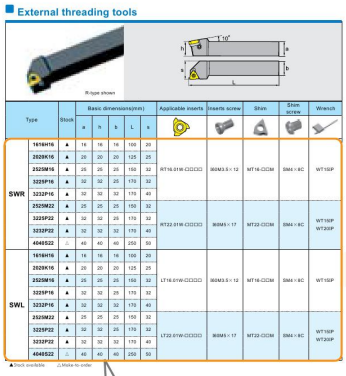
1 Selecting insert type

2 Insert type, Chip-breaker, Size and grade

Guide of selecting threading tools

Threading tools

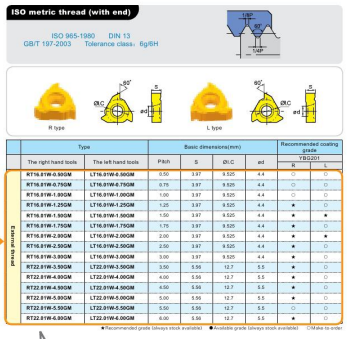
External threading tools



Type		Stock	Basic dimensions(mm) a	h	b	L	s	Applicable inserts	Inserts screw	Shim	Shim screw	Wrench
SWR	1616H16	▲	16	16	16	100	20	RT16.01W-□□□□	IM3/M3.5×12	MT16-□□M	SM4×8C	WT10IP
	2020K16	▲	20	20	20	125	25					
	2525M16	▲	25	25	25	150	32					
	3225P16	▲	32	32	25	170	32					
	3232P16	▲	32	32	32	170	40					
	2525M22	▲	25	25	25	150	32	RT22.01W-□□□□	IM3/M5×17	MT22-□□M	SM4×8C	WT10IP WT20IP
	3225P22	▲	32	32	25	170	32					
	3232P22	▲	32	32	32	170	40					
	4040S22	△	40	40	40	200	50					
SWL	1616H16	▲	16	16	16	100	20	LT16.01W-□□□□	IM3/M3.5×12	MT16-□□M	SM4×8C	WT10IP
	2020K16	▲	20	20	20	125	25					
	2525M16	▲	25	25	25	150	32					
	3225P16	▲	32	32	25	170	32					
	3232P16	▲	32	32	32	170	40					
	2525M22	▲	25	25	25	150	32	LT22.01W-□□□□	IM3/M5×17	MT22-□□M	SM4×8C	WT10IP WT20IP
	3225P22	▲	32	32	25	170	32					
	3232P22	▲	32	32	32	170	40					
	4040S22	△	40	40	40	200	50					

▲Stock available △Made-to-order

ISO metric thread (with end)



ISO 965-1980 DIN 13
GB/T 197-2003 Tolerance class: 6g/6H

External thread	Type: The right hand tools	Type: The left hand tools	Basic dimensions(mm): Pitch	S	ØLC	ad	Recommended coating grade YBG201: R	L
	RT16.01W-0.50GM	LT16.01W-0.50GM	0.50	3.97	9.525	4.4	○	○
	RT16.01W-0.75GM	LT16.01W-0.75GM	0.75	3.97	9.525	4.4	○	○
	RT16.01W-1.00GM	LT16.01W-1.00GM	1.00	3.97	9.525	4.4	○	○
	RT16.01W-1.25GM	LT16.01W-1.25GM	1.25	3.97	9.525	4.4	★	○
	RT16.01W-1.50GM	LT16.01W-1.50GM	1.50	3.97	9.525	4.4	★	★
	RT16.01W-1.75GM	LT16.01W-1.75GM	1.75	3.97	9.525	4.4	★	○
	RT16.01W-2.00GM	LT16.01W-2.00GM	2.00	3.97	9.525	4.4	★	★
	RT16.01W-2.50GM	LT16.01W-2.50GM	2.50	3.97	9.525	4.4	★	○
	RT16.01W-3.00GM	LT16.01W-3.00GM	3.00	3.97	9.525	4.4	★	○
	RT22.01W-3.50GM	LT22.01W-3.50GM	3.50	5.56	12.7	5.5	★	○
	RT22.01W-4.00GM	LT22.01W-4.00GM	4.00	5.56	12.7	5.5	★	○
	RT22.01W-4.50GM	LT22.01W-4.50GM	4.50	5.56	12.7	5.5	★	○
	RT22.01W-5.00GM	LT22.01W-5.00GM	5.00	5.56	12.7	5.5	★	○
	RT22.01W-5.50GM	LT22.01W-5.50GM	5.50	5.56	12.7	5.5	○	○
	RT22.01W-6.00GM	LT22.01W-6.00GM	6.00	5.56	12.7	5.5	★	○

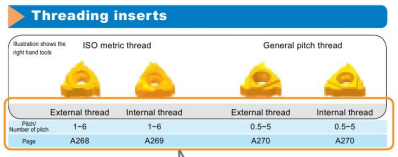
★Recommended grade (always stock available) ●Available grade (always stock available) ○Made-to-order

1 Selection of tool holder type

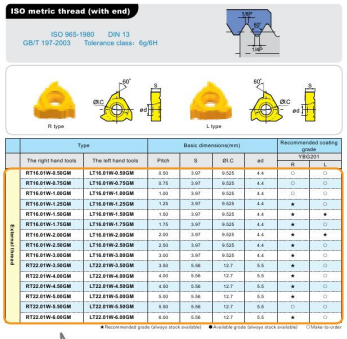
2 Tool holder type, Size and applicable inserts

3 Insert type, Chip-breaker, Size and grade

Threading inserts



ISO metric thread (with end)



ISO 965-1980 DIN 13
GB/T 197-2003 Tolerance class: 6g/6H

External thread	Type: The right hand tools	Type: The left hand tools	Basic dimensions(mm): Pitch	S	ØLC	ad	Recommended coating grade YBG201: R	L
	RT16.01W-0.50GM	LT16.01W-0.50GM	0.50	3.97	9.525	4.4	○	○
	RT16.01W-0.75GM	LT16.01W-0.75GM	0.75	3.97	9.525	4.4	○	○
	RT16.01W-1.00GM	LT16.01W-1.00GM	1.00	3.97	9.525	4.4	○	○
	RT16.01W-1.25GM	LT16.01W-1.25GM	1.25	3.97	9.525	4.4	★	○
	RT16.01W-1.50GM	LT16.01W-1.50GM	1.50	3.97	9.525	4.4	★	★
	RT16.01W-1.75GM	LT16.01W-1.75GM	1.75	3.97	9.525	4.4	★	○
	RT16.01W-2.00GM	LT16.01W-2.00GM	2.00	3.97	9.525	4.4	★	★
	RT16.01W-2.50GM	LT16.01W-2.50GM	2.50	3.97	9.525	4.4	★	○
	RT16.01W-3.00GM	LT16.01W-3.00GM	3.00	3.97	9.525	4.4	★	○
	RT22.01W-3.50GM	LT22.01W-3.50GM	3.50	5.56	12.7	5.5	★	○
	RT22.01W-4.00GM	LT22.01W-4.00GM	4.00	5.56	12.7	5.5	★	○
	RT22.01W-4.50GM	LT22.01W-4.50GM	4.50	5.56	12.7	5.5	★	○
	RT22.01W-5.00GM	LT22.01W-5.00GM	5.00	5.56	12.7	5.5	★	○
	RT22.01W-5.50GM	LT22.01W-5.50GM	5.50	5.56	12.7	5.5	○	○
	RT22.01W-6.00GM	LT22.01W-6.00GM	6.00	5.56	12.7	5.5	★	○

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

1 Selecting insert category

2 Insert type, Chip-breaker, Size and grade

TURNING Turning Inserts Overview

Cemented carbide and cermet inserts

Negative inserts

For finishing

	CNMG-DF	CNMG-SF	CNMG-EF	CNEG-NF	DNMG-DF	DNMG-SF	DNMG-EF
	09,12	09,12	09,12	12	11,15	11,15	11,15
	A46	A46	A46	A47	A53	A53	A54

	DNEG-NF	SNMG-DF	SNMG-EF	SNMG-SF	TNMG-DF	TNMG-SF	TNMG-EF	VNMG-DF
Cutting edge length	15	09,12	09,12,15	09,12,15	16,22	11,16,22	11,16,22	16
Page	A54	A59	A59	A60	A66	A66	A66	A72

	VNMG-EF	VNEG-NF	VNMG-SF	WNMG-DF	WNMG-SF	WNMG-EF	WNEG-NF
Cutting edge length	16	16	16	06,08	06,08	06,08	08
Page	A72	A72	A72	A74	A75	A75	A75

Wiper

	CNMG-WG	DNMX-WG	TNMX-WG	WNMG-WG
Cutting edge length	12,16	11,15	16	06,08
Page	A46	A53	A66	A74

For semi-finishing

	CNMG-PM	CNMG-DM	CNMG-EM	CNMG-NM	DNMG-PM	DNMG-DM	DNMG-EM
Cutting edge length	09,12,16,19	09,12,16,19	12,16	12	11,15	11,15	11,15
Page	A47	A48	A48	A49	A54-55	A55	A56

	DNMG-NM	SNMG-PM	SNMG-DM	SNMG-EM	SNMG-NM	TNMG-PM	TNMG-DM	TNMG-EM
Cutting edge length	15	09,12,15,19	09,12,15,19	12,15	12	11,16,22	11,16,22	16,22
Page	A56	A60	A61	A61	A62	A67	A67	A68

	VNMG-PM	VNMG-DM	VNMG-EM	VNMG-NM	WNMG-PM	WNMG-DM	WNMG-EM	WNMG-NM
Cutting edge length	16	16	16	16	06,08	06,08	06,08	08
Page	A73	A73	A73	A73	A76	A76	A76	A77

Negative inserts

For roughing

	CNMG-DR	CNMM-DR	CNMG-ER	CNMM-ER	DNMG-DR	DNMM-DR	DNMG-ER
Cutting edge length	12,16,19	12,16,19,25	12,16,19	25	15	15	15
Page	A49	A50	A50	A50	A56	A57	A57

	DNMM-ER	SNMG-DR	SNMM-DR	SNMG-ER	SNMM-ER	TNMG-DR	TNMM-DR	TNMG-ER
Cutting edge length	15	12,15,19	12,15,19,25	12,15,19	25	16,22,27	16,22,27	16,22
Page	A57	A62	A62-63	A63	A63	A68	A69	A69

	WNMG-DR
Cutting edge length	06,08
Page	A77

For heavy machining

For profiling

	175.32-22/227	175.32-24	175.32-25	175.32-28	KNUX
Cutting edge length	19	19,30	19	19	16
Page	A79	A79	A79	A79	A78

Through chipbreaker

	CNMG	CNMM	DNMG	SNMG	SNMM	TNMG	TNMM
Cutting edge length	12,16,19	12,19	15,19	09,12,15,19,25	09,12,19,25	11,16,22,27,33	16,22,27
Page	A51	A52	A57	A64	A64-65	A70	A71

	VNMG
Cutting edge length	16
Page	A73

Without chipbreaker

	CNMA	DNMA	SNMA	TNMA	WNMA
Cutting edge length	12,16,19	11,15	09,12,15,19	16,22,27	06,08
Page	A51	A58	A65	A71	A77

TURNING Turning Inserts Overview

Positive inserts

For extra finishing

	CCGT-SF	DCGT-SF	TCGT-SF	VCGT-SF	VBGT-SF	CPGT-SF	DPGT-SF
Cutting edge length	06,09	07,11	06,09,11	11	11	06,09	07,11
Page	A80	A84	A91	A95	A98	A100	A101

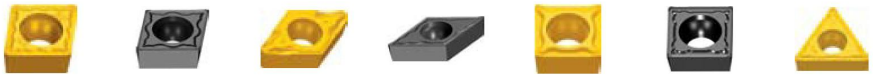
	TBGH-L	TPGT-SF	TPGH-L
Cutting edge length	06	09,11	09,11
Page	A103	A104	A104

For finishing

	CCMT-HF	CCMT-EF	DCMT-HF	DCMT-EF	SCMT-HF	SCMT-EF	TCMT-HF
Cutting edge length	06,09,12	06,09,12	07,11	07,11	09	09	06,09,11,16
Page	A80	A81	A84	A85	A89	A89	A91

	TCMT-EF	VCGT-HF	VCGT-NF	VBMT-HF	VBMT-EF	VBET-NF
Cutting edge length	09,11,16	11	16	11	11,16	16
Page	A92	A95	A95	A98	A98	A98

For semi-finishing



	CCMT-HM	CCMT-EM	DCMT-HM	DCMT-EM	SCMT-HM	SCMT-EM	TCMT-HM
Cutting edge length	06,09,12	06,09,12	07,11	07, 11	09,12	09,12	09,11,16
Page	A81	A81	A85	A85	A89	A89	A93

	TCMT-EM	VBMT-HM	VBMT-EM
Cutting edge length	09,11,16	16	11
Page	A92	A99	A99

For roughing

	CCMT-HR	DCMT-HR	SCMT-HR	TCMT-HR	VBMT-HR
Cutting edge length	06,09,12	11	09,12	09,11,16,22	16
Page	A82	A86	A90	A93	A99

Positive inserts

For Al machining

	CCGX-LC	CCGX-LH	DCGX-LC	DCGX-LH	RCGX-LH	SCGX-LC	SCGX-LH
Cutting edge length	06,09,12	06,09,12	07,11	07,11	08	09,12	09,12
Page	A82	A82-83	A86	A86	A87	A90	A90

	TCGX-LC	TCGX-LH	VCGX-LC	VCGX-LH
Cutting edge length	09,11,16	09,11,16	11,16,22	11,16,22
Page	A93	A94	A96	A96

Through chipbreaker

	RCM(G)T	RCMX	SCMT	TCMT	WCMX-53
Cutting edge length	08,10,12,16,19	08,10,12,16,20,25,32	09,12	22	04,06,08
Page	A87	A88	A90	A94	A97

Without chipbreaker

	CCMW	DCMW	SCMW	TCMW	SPMW
Cutting edge length	06,09,12	07,11	06,09,12	11,16,22	09,12
Page	A83	A86	A90	A94	A102

PCBN&PCD inserts

Negative inserts

	CNGA	DNGA	SNGA	TNGA	VNGA
Cutting edge length	12	15	12	16	16
Page	A110	A111	A112	A113	A114

Positive inserts

	CCGW	DCGW	TCGW	VBGW	VCGW
Cutting edge length	06,09,12	07,11	09,11,16	16	16
Page	A115	A116	A117	A118	A118

Ceramic inserts

	CNGA	CNGN	CNGX	DNGA	DNGN	DNGX	SNGA	SNGX
Cutting edge length	12,16	12,16	12	15	15	15	12	12
Page	A122	A123	A124	A124	A125	A125	A126	A126

	SNGN	TNGA	TNGN	WNGA	RNGN
Cutting edge length	09,12,15,19,25	16,22	16,22	08	09,12,15,19,25
Page	A127	A128	A129	A130	A130

Parting and grooving inserts

Little squirrel series

	ZP□D-MG	ZP□S-MG	ZT□D-MG	ZT□S-MG	ZT□D-EG	ZT□D-EG
Cutting edge width	2.5,3,4,5,6	2.5,3,4,5,6	2.5,3,4,5,6	5,6	1-2.4(tailor-made)	2.4-6.5(tailor-made)
Page	A236	A236	A237	A237	A237	A237

	ZIMF-NM	ZR□D-MG	ZR□D-EG	ZIGQ-NM	ZR□D-LH	ZILD-LC
Cutting edge width	3,4,5,6	2.5,3,4,5,6	3,4,5,6	3,4,5,6	6,8	8
Page	A238	A238	A239	A239	A240	A240

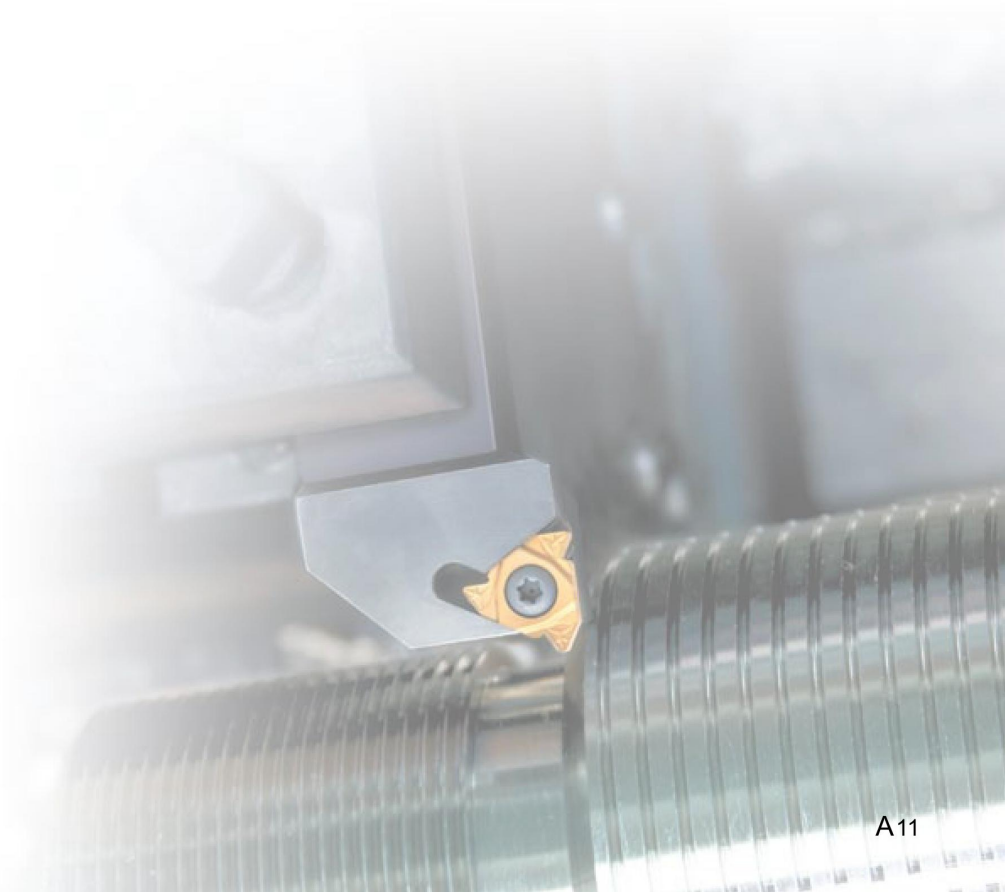
Supplemental series

	ZQMX-1E
Cutting edge width	3.125,4.125,5.125,6.4,7.05
Page	A241

Threading inserts

Right hand type shown	ISO metric thread		General pitch thread		Whitworth thread	
	External thread	Internal thread	External thread	Internal thread	External thread	Internal thread
Pitch/ Number of pitch	1~6	1~6	0.5~5	0.5~5	8~16	8~16
Page	A268	A269	A270	A270	A271	A271

Right hand type shown	Unified thread		British Standard pipe thread		American standard pipe thread	
	External thread	Internal thread	External thread	Internal thread	External thread	Internal thread
Pitch/ Number of pitch	8~20	8~20	11~28	11~28	8~27	8~27
Page	A272	A272	A273	A273	A274	A274



Tool holders for external turning

D-type clamping system

	DCLNR/L	DDJNR/L	DSBNR/L	DTGNR/L	DVVNN	DVJNR/L	DWLNR/L
Approach angle	95°	93°	75°	91°	72°30'	93°	95°
Page	A144	A145	A146	A147	A148	A149	A150

P-type clamping system

	PCBNR/L	PCLNR/L	PDJNR/L	PDNNR/L	PSBNR/L	PSDNN	PSKNR/L
Approach angle	75°	95°	93°	63°	75°	45°	75°
Page	A151	A152	A153	A154	A155	A156	A157

	PSSNR/L	PTFNR/L	PTTNR/L	PTGNR/L	PWLNR/L
Approach angle	45°	90°	60°	90°	95°
Page	A158	A159	A160	A161	A162

S-type clamping system

	SCACR/L	SCLCR/L	SDACR/L	SDJCR/L	SDNCN	SVJBR/L	SVABR/L
Approach angle	90°	95°	90°	93°	62°30'	93°	90°
Page	A163	A164	A165	A166	A167	A168	A169

	SVVBN	SVVCN	SVJCR/L	SSBCR/L	SSDCN	SSKCR/L	SSSCR/L
Approach angle	72°30'	72°30'	93°	75°	45°	75°	45°
Page	A170	A171	A172	A173	A173	A174	A174

	STACR/L	STFCR/L	STGCR/L	STTCR/L	SWACR/L	SRDCN	SRGCR/L
Approach angle	90°	91°	91°	60°	90°		
Page	A175	A175	A176	A177	A178	A179	A180

C-type clamping system

	CKJNR/L	CKNNR/L
Approach angle	93°	63°
Page	A181	A181

Turning tool holders for ceramic inserts

	CCLNR/L	CTJNR/L	CTUNR/L	CDJNR/L	CSRNR/L	CSKNR/L	CSDNN
Approach angle	95°	93°	93°	93°	75°	75°	45°
Page	A182	A182	A183	A183	A184	A184	A185

	CRDNN	JCLNR/L	JDJNR/L	JSDNN
Approach angle		95°	93°	45°
Page	A185	A186	A186	A187

Turning tool holders for internal machining

P-type clamping system

	PCLNR/L	PDSNR/L	PDUNR/L	PSKNR/L	PTFNR/L	PWLNR/L
Approach angle	95°	62°30'	93°	75°	90°	95°
Page	A194	A196	A197	A198	A199	A200

S-type clamping system

	SCLCR/L	SDQCR/L	SDUCR/L	SDZCR/L	SSKCR/L	STFCR/L	SVQCR/L
Approach angle	95°	107°30'	93°	95°	75°	91°	107°30'
Page	A201	A202	A203	A204	A205	A206	A207

TURNING Turning Tools Overview

	SVUCR/L	SVQBR/L	SVUBR/L	SCLPR/L	SDQPR/L	SDUPR/L	STUPR/L
Approach angle	93°	107°30'	93°	95°	107°30'	93°	93°
Page	A208	A209	A210	A211	A212	A213	A214

	SCFCR	SCLCR
Approach angle	90°	95°
Page	A215	A216

Damping tool holders

	SCLPR/L	SDQPR/L	SDUPR/L	STUPR/L	SVQCR/L	SVUCR/L
Approach angle	95°	107°30'	93°	93°	107°30'	93°
Page	A218	A219	A220	A221	A222	A222

Parting and grooving tools

	QE□□R/L	QECDR/L	QX□DR/L	QE□SR/L	QE□S□□N	QZS□	QF□□R/L
Page	A244	A245	A245	A246	A247	A247	A248-249

	QF□□RR/LL	QF□DR/L	C□□□-Q□DR/L	C40X-Q□DR/L	QZQ□□R/L
Page	A250-253	A254-255	A256	A257	A259

Threading tools

	SWR/L	SNR/L
Page	A276	A277

Recommended Grade Overview for Turning Inserts

TURNING

ISO		General turning								Thread-ing	Parting and grooving		
Code		Coating								Coating	Coating		
		CVD	PVD	Cermet	Coated cermet	Ceramic	Cemented carbide	PCBN	PCD	PVD	CVD	PVD	Cemented carbide
P Steel	01												
	10	YBC151	YBG102	YNG151	YNG151C		YC10			YBG201	YBC251		
	20	YBC251 YBC152	YBG202			CN2000 CA1000						YBG302	
	30	YBC252					YC40						
	40	YBC351											
M Stainless steel	01												
	10	YBM151	YBG202	YNG151	YNG151C					YBG201			
	20	YBM251	YBG205									YBG302	
	30	YBM253											
	40												
K Cast iron	01												
	10	YBD052		YNG151	YNG151C	CN1000	YD051	YCB011		YBG201			YD201
	20	YBD102 YBD152					YD201					YBG302	
	30	YBD151 YBD252				CN2000							
N Non ferrous metal	01												
	10						YD101		YCD011	YBG201			YD201
	20												
	30												
S Heat resistant alloy & Ti alloy	01												
	10		YBG102				YD101			YBG201		YBG102	YD201
	20		YBG202									YBG302	
	30												
H Super hard material	01												
	10							YCB012					
	20												
	30												