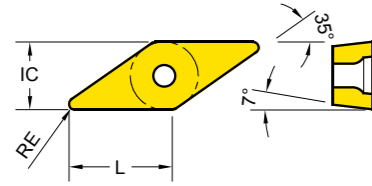


Turning - Inserts - Positive  
**VCMT / VCGT (35° Positive)**



Series	L	IC	S
VCMT 1604	15.8	9.53	4.76

●: Stock item ○: Order made item

VCMT / VCGT	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG100	YG10
<b>-AL</b> Aluminum	VCMT 160402 - AL	0.2	0.02~0.05	0.5~1							●	●
	VCMT 160404 - AL	0.4	0.05~0.25	0.5~2							●	●
	VCMT 160408 - AL	0.8	0.1~0.35	1~3							●	●
<b>-UF</b> Finishing	VCMT 160404 - UF	0.4	0.05~0.25	0.5~3			●					
<b>-UG</b> General	VCMT 160404 - UG	0.4	0.15~0.25	0.5~2.5					●			
	VCMT 160408 - UG	0.8	0.2~0.4	1~3			●		●			

Cutting Speed			Vc (m/min.)															
ISO	VDI	Sub Group	YG1001		YG3010		YG3020		YG3030		YG801		YG211		YG100		YG10	
			Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
P	1~5	Non Alloy Steel	220	480	170	450	180	380	150	350	120	250	-	-	-	-	-	-
	6~9	Low Alloy Steel	220	420	180	380	110	350	90	300	70	230	-	-	-	-	-	-
	10~11	High Alloy Steel	-	-	100	330	60	300	70	250	70	180	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	220	60	180	100	200	-	-	-	-
	14	Austenitic Stainless Steel	-	-	-	-	-	-	50	180	60	150	70	160	-	-	-	-
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	60	160	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	60	120	-	-	-	-	-	-
N	21~30	Aluminum	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800	-
S	31~37	Heat Resistant Super Alloy	-	-	-	-	-	-	35	80	35	60	30	90	-	-	-	-
H	38~41	Hardened Material	-	-	-	-	-	-	-	-	40	80	-	-	-	-	-	-



**PARTING & GROOVE TURN**

## Parting & Groove Turn Overview

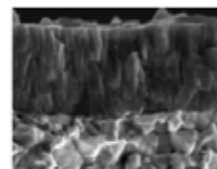
### Parting & Groove Turn Grades

Parting and Grooving Grades		P Steel				M Stainless Steel				K Cast Iron				S Super Alloy			
		P05	P15	P25	P35	M05	M15	M25	M35	K05	K15	K25	K35	S05	S15	S25	S35
PVD	YG602				602				602				602				602

### YG602

P20 - P35 M20 - M40  
K20 - K40 S15 - S25

PVD - TiAIN



**Universal grade for Parting & Groove Turn**

- Ultra Dense PVD Coating with optimal thermal resistance & strength
- Sub-Micron substrate designed for demanding application

### Parting & Groove Turn Inserts

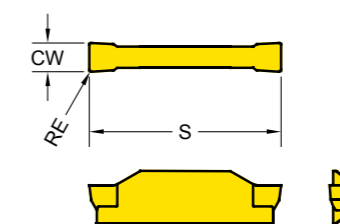
	TD. Series	Inserts	2, 3, 4
		TDN TDP TDY	

### Parting & Groove Turn Chipbreakers

<b>-P</b> TDP			• Parting & Grooving (Positive)
<b>-N</b> TDN			• Parting & Grooving (General)
<b>-Y</b> TDY			• Groove Turn

## Parting & Groove Turn - Inserts

### Parting & Groove Turn Inserts (TD.)



Series	S	CW
TD□2	20	2
TD□3	20	3
TD□4	20	4

● : Stock item ○ : Order made item

TD.	Designation	RE	Parting & Grooving		Groove Turn		YG602
			Fn (mm/rev.)	Tmax (mm)	Fn (mm/rev.)	Ap (mm)	
<b>TDP</b> Parting & Grooving (Positive)	TDP 2002	0.2	0.04~0.12	19	-	-	●
	TDP 3002	0.2	0.05~0.16	19	-	-	●
	TDP 4003	0.3	0.06~0.18	19	-	-	●
<b>TDN</b> Parting & Grooving (General)	TDN 2002	0.2	0.06~0.18	19	-	-	●
	TDN 3002	0.2	0.07~0.22	19	-	-	●
	TDN 4003	0.3	0.08~0.25	19	-	-	●
<b>TDY</b> Groove Turn	TDY 3 E - 0.4	0.4	0.10~0.20	19	0.10~0.38	0.5~2.2	●
	TDY 4 E - 0.4	0.4	0.15~0.26	19	0.10~0.40	0.5~2.8	●

Cutting Speed			Vc (m/min.)	
ISO	VDI	Sub Group	YG602	
			Min.	Max.
P	1~5	Non Alloy Steel	90	180
	6~9	Low Alloy Steel	80	120
	10~11	High Alloy Steel	80	110
M	12~13	Ferritic & Martensitic	70	160
	14	Austenitic Stainless Steel	55	140
K	15~16	Grey Cast Iron	110	185
	17~18	Nodular Cast Iron	110	140
N	21~30	Aluminum	250	440
S	31~37	Heat Resistant Super Alloy	25	45
H	38~41	Hardened Material	25	50