



# Turning - Drehen

Turning Insert (Overview)  
Turning Tools (Overview)  
Recommended Grades for Turning

A4-A11  
A12-A15  
A16

Schneidplatten zum Drehen (Übersicht)  
Halter zum Drehen (Übersicht)  
Empfohlene Sorten für die  
Drehbearbeitung

Chip breaker Overview and Description  
Grade Description  
ISO indexable insert code key  
Application instruction of general turning

A22-A40  
A41-A53  
A56-A57  
A58-A59

Spanbrecher Übersicht und Beschreibung  
Sortenbeschreibung  
ISO Kennzeichnung für Schneidplatten  
Allgemeine Anwendungsempfehlung  
(Drehen)

ISO Turning Inserts  
Carbide and Cermet Inserts  
PCBN & PCD Inserts  
Ceramic Insert

A60-A160  
A60-A122  
A123-A149  
A150-A160

ISO Wendeschneidplatten zum Drehen  
Hartmetall und Cermet WSP  
PCBN & PKD Wendeschneidplatten  
Keramik Wendeschneidplatten

Turning Tool Holder  
External Turning Tools  
Internal Turning Tools  
Recommended cutting parameters

A161-A262  
A165-A232  
A233-A270  
A271-A275

Drehwerkzeuge  
Halter für **Außenbearbeitung**  
Halter für **Innenbearbeitung**  
Empfohlene Schnittdaten (Drehen)

Parting, Grooving Tools  
Parting, Grooving Tool (Overview)  
Parting, Grooving insert code key  
Parting, Grooving Inserts  
Parting, Grooving Holder  
Parting, Grooving Cutting Condition

A276-A311  
A277-A279  
A282  
A283-A291  
A292-A309  
A310-A311

Ab- und Einstech-Werkzeuge  
Ab- und Einstechen (Übersicht)  
Kennzeichnung für Stechplatten  
WSP zum Ab- und Einstechen  
Halter zum Ab- und Einstechen  
Ab- und Einstechen Schnittdatenempfehlung

Threading Tools  
Threading Tools (Overview)  
Threading inserts code key  
Threading Inserts  
ISO threading holder tools code key  
Threading Holder  
Threading Cutting Conditions

A312-A361  
A313-A318  
A320  
A321-A342  
A343  
A344-A346  
A347-A348

Gewindedreh-Werkzeuge  
Klemmhalter zum Gewindedrehen (Übersicht)  
Kennzeichnung für Gewindeplatten  
Gewindedrehplatten  
ISO Kennzeichnung für Gewindehalter  
Gewindehalter  
Gewindedrehen Schnittdatenempfehlung

Recommend Cutting datas

A349-A361

Empfohlene Schnittdaten (Gewindebearb.)

General Technical Info. for Turning

A363-370

























Allgemeine Technische Info. zum Drehen

# Turning · Drehen


## Turning Inserts Overview · WSP Übersicht

### Carbide and Cermet Inserts - Hartmetall- und Cermet-WSP






















#### Finishing · Schlichten

									Edge length · Kantenlänge Page · Seite
<b>CNMG-DF</b>	<b>CNMG-SF</b>	<b>CNMG-EF</b>	<b>CNEG-NF</b>	<b>DNMG-DF</b>	<b>DNMG-FM</b>	<b>DNMG-SF</b>	<b>DNMG-EF</b>	<b>DNEG-NF</b>	
09,12	09,12	09,12	12	11,15	15	11,15	11,15	15	
A60	A60	A60	A61	A67	A68	A67	A68	A68	
									Edge length · Kantenlänge Page · Seite
<b>SNMG-DF</b>	<b>SNMG-EF</b>	<b>SNMG-SF</b>	<b>TNMG-DF</b>	<b>TNMG-FM</b>	<b>TNMG-SF</b>	<b>TNMG-EF</b>			
09,12	09,12,15	09,12,15	16,22	16	11,16,22	11,16,22			
A73	A73	A74	A82	A83	A82	A82			
									Edge length · Kantenlänge Page · Seite
<b>VNMG-DF</b>	<b>VNMG-EF</b>	<b>VNEG-NF</b>	<b>VNMG-SF</b>	<b>WNMG-DF</b>	<b>WNMG-SF</b>	<b>WNMG-EF</b>	<b>WNEG-NF</b>		
16	16	16	16	06,08	06,08	06,08	08		
A88	A88	A88	A88	A90	A91	A91	A91		

#### Wiper

				Edge length · Kantenlänge Page · Seite
<b>CNMG-WG</b>	<b>DNMX-WG</b>	<b>TNMX-WG</b>	<b>WNMG-WG</b>	
12,16	11,15	16	06,08	
A60	A67	A82	A90	

#### Medium Cutting · Mittlere Bearbeitung

						Edge length · Kantenlänge Page · Seite			
<b>CNMG-PM</b>	<b>CNMG-DM</b>	<b>CNMG-EM</b>	<b>CNMG-TC</b>	<b>CNMG-NM</b>	<b>CNMG</b>				
09,12,16,19	09,12,16,19	12,16	12	12	12,16,19				
A61	A62	A62	A63	A63	A66				
									Edge length · Kantenlänge Page · Seite
<b>DNMG-PM</b>	<b>DNMG-DM</b>	<b>DNMG-EM</b>	<b>DNMG-NM</b>	<b>DNMG</b>	<b>KNUX</b>	<b>RCM(G)T</b>	<b>RCMX</b>	<b>RNMG</b>	
11,15	11,15	11,15	15	15,19	16	08,10,12,16,19	08,10,12,16,20,25,32	12	
A69	A69	A70	A70	A72	A95	A106	A107	A94	
									Edge length · Kantenlänge Page · Seite
<b>SNMG-PM</b>	<b>SNMG-DM</b>	<b>SNMG-EM</b>	<b>SNMG-TC</b>	<b>SNMG-NM</b>	<b>SNMG</b>				
09,12,15,19	09,12,15,19	12,15	12	12	09,12,15,19,25				
A74	A75	A75	A75	A76	A79				

Double Side Negative Inserts  
Doppelseitige Negative Platten

General Turning  
Allgemeine Drehbearbeitung

Double Side Negative Inserts  
Doppelseitige Negative Platten

### Medium Cutting · Mittlere Bearbeitung



TNMG-PM	TNMG-DM	TNMG-EM	TNMG-TC	TNMG
11,16,22	11,16,22	16,22	12	11,16,22,27,33
A83	A83	A84	A84	A86

Edge length ·  
Kantenlänge  
Page ·  
Seite



VNMG-PM	VNMG-DM	VNMG-EM	VNMG-NM	VNMG
16	16	16	16	16
A89	A89	A89	A89	A89

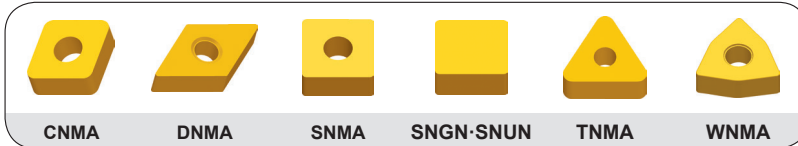
Edge length ·  
Kantenlänge  
Page ·  
Seite



WNMG-PM	WNMG-DM	WNMG-EM	WNMG-TC	WNMG-NM
06,08	06,08	06,08	08	08
A92	A92	A92	A93	A93

Edge length ·  
Kantenlänge  
Page ·  
Seite

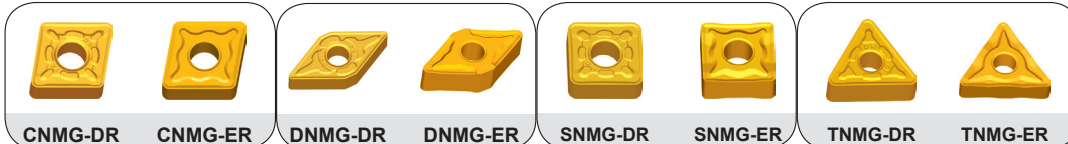
### Medium to Rough Cutting · Mittlere bis Schruppbearbeitung



CNMA	DNMA	SNMA	SNGN-SNUN	TNMA	WNMA
12,16,19	11,15	09,12,15,19	09,12,15,19,25	16,22,27	06,08
A66	A71	A80	A81	A87	A93

Edge length ·  
Kantenlänge  
Page ·  
Seite

### Roughing · Schruppen



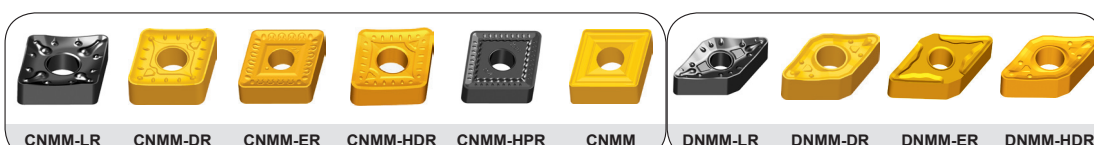
CNMG-DR	CNMG-ER	DNMG-DR	DNMG-ER	SNMG-DR	SNMG-ER	TNMG-DR	TNMG-ER
12,16,19	12,16,19	15	15	12,15,19	12,15,19	16,22,27	16,22
A63	A64	A70	A70	A76	A76	A84	A85



WNMG-DR
06,08
A93

Edge length ·  
Kantenlänge  
Page ·  
Seite

### Roughing · Schruppen



CNMM-LR	CNMM-DR	CNMM-ER	CNMM-HDR	CNMM-HPR	CNMM	DNMM-LR	DNMM-DR	DNMM-ER	DNMM-HDR
12,16,19,25	12,16,19,25	25	12,16,19	19,25	12,19	15	15	15	15
A64	A64	A64	A65	A65	A65	A72	A72	A72	A72

Edge length ·  
Kantenlänge  
Page ·  
Seite

Single Side Negative Inserts  
Einseitige Negative Platten

# Turning · Drehen

## Turning Inserts Overview · WSP Übersicht

**A**

General Turning  
Allgemeine Drehbearbeitung

Single Side Negative Inserts  
Einseitige Negative Platten

### Roughing · Schruppen

SNMM-LR	SNMM-DR	SNMM-ER	SNMM-HDR	SNMM-HPR	SNMM	TNMM-LR	TNMM-DR	TNMM-HDR	TNMM
12,15,19,25	12,15,19,25	25	12,15,19,25	09,12,19,25	09,12	16	16,22,27	16,22,27	16,22,27
A77	A77	A78	A78	A78	A79	A85	A85	A86	A86

Edge length ·  
Kantelänge  
Page ·  
Seite

Special Inserts  
Spezielle Drehplatten

### Roughing · Schruppen

175.32-28	175.32-22-227	175.32-24	175.32-25	TNMX	YNMX-YNUX
19	19	19,30	19	11,15	18,25
A96	A96	A96	A96	A97	A97

Edge length ·  
Kantelänge  
Page ·  
Seite

Positive Inserts  
Positive Wendschneidplatten

### Fine Finishing · Feinstbearbeitung

CCGT-USF	DCGT-USF	TCGT-USF	VCGT-USF	DPGT-USF	VPGT-USF
09	07,11	11	08,11	07,11	08,11
A98	A102	A112	A118	A105	A122

Edge length ·  
Kantelänge  
Page ·  
Seite

CCGT-SF	DCGT-SF	TCGT-SF	VCGT-SF	VBGT-SF	CPGT-SF	DPGT-SF	TPGT-SF
06,09	07,11	06,09,11	11,16	11	06,09	07,11	09,11
A98	A102	A112	A118	A120	A101	A105	A117

Edge length ·  
Kantelänge  
Page ·  
Seite

TBGH-L	TPGH-L
06	09,11
A111	A117

Edge length ·  
Kantelänge  
Page ·  
Seite

### Finishing · Schlichten









CCMT-HF	CCMT-EF	CPGT	DCMT-HF	DCMT-EF	SCMT-HF	SCMT-EF	TCMT-HF
06,09,12	06,09,12	05	07,11	07,11	09	09	06,09,11,16
A98	A99	A98	A102	A103	A108	A108	A113

Edge length ·  
Kantelänge  
Page ·  
Seite










TCMT-EF	VCGT	VCGT-HF	VCGT-NF	VBMT-HF	VBMT-EF	VBET-NF
09,11,16	13	11	16	11	11,16	16
A114	A118	A118	A118	A120	A120	A120

Edge length ·  
Kantelänge  
Page ·  
Seite






### Medium Cutting · Mittlere Bearbeitung

							
<b>CCMT-HM</b>	<b>CCMT-EM</b>	<b>CCMW</b>	<b>CPGW</b>	<b>DCMT-HM</b>	<b>DCMT-EM</b>	<b>DCMW</b>	<b>DPMW</b>
06,09,12	06,09,12	06,09,12	06	07,11	07, 11	07,11	11
A99	A99	A100	A101	A103	A103	A104	A105

Edge length ·  
Kantenlänge  
Page ·  
Seite






								
<b>SCMT-HM</b>	<b>SCMT-EM</b>	<b>SCMT</b>	<b>SCMW</b>	<b>SPMW</b>	<b>TCMT-HM</b>	<b>TCMT-EM</b>	<b>TCMT</b>	<b>TCMW</b>
09,12	09,12	09,12	06,09,12	09,12	09,11,16	09,11,16	22	11,16,22
A108	A108	A109	A109	A110	A115	A114	A115	A115

Edge length ·  
Kantenlänge  
Page ·  
Seite

				
<b>VCMT-EM/EF</b>	<b>VBMT-HM</b>	<b>VBMT-EM</b>	<b>VBMW</b>	<b>WCMX-53</b>
16	16	11	16	04,06,08
A121	A121	A121	A121	A122








Edge length ·  
Kantenlänge  
Page ·  
Seite

### Roughing · Schruppen

				
<b>CCMT-HR</b>	<b>DCMT-HR</b>	<b>SCMT-HR</b>	<b>TCMT-HR</b>	<b>VBMT-HR</b>
06,09,12	11	09,12	09,11,16,22	16
A100	A104	A109	A115	A121

Edge length ·  
Kantenlänge  
Page ·  
Seite

### Aluminium machining · Aluminiumbearbeitung

						
<b>CCGX-LC</b>	<b>CCGX-LH</b>	<b>DCGX-LC</b>	<b>DCGX-LH</b>	<b>RCGX-LH</b>	<b>SCGX-LC</b>	<b>SCGX-LH</b>
06,09,12	06,09,12	07,11	07,11	08	09,12	09,12
A100	A100	A104	A104	A106	A109	A109

Edge length ·  
Kantenlänge  
Page ·  
Seite

			
<b>TCGX-LC</b>	<b>TCGX-LH</b>	<b>VCGX-LC</b>	<b>VCGX-LH</b>
09,11,16	09,11,16	11,16,22	11,16,22
A116	A116	A119	A119

Edge length ·  
Kantenlänge  
Page ·  
Seite

# Turning · Drehen

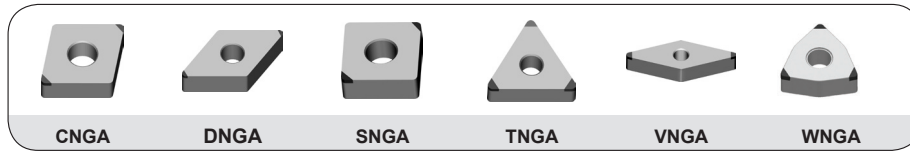
## Turning Inserts Overview · WSP Übersicht

**A**

General Turning  
Allgemeine Drehbearbeitung

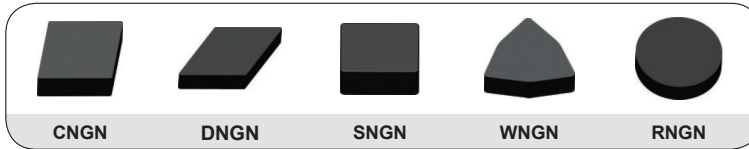
### PCBN & PCD

Negative Inserts  
Negative WSP



CNGA	DNGA	SNGA	TNGA	VNGA	WNGA
12	15	12	16	16	08 16
A129	A130	A131	A132	A133	A133

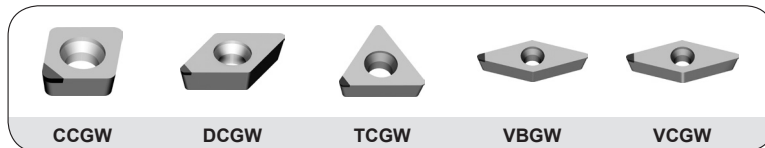
Edge length ·  
Kantelänge  
Page ·  
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CNGN	DNGN	SNGN	WNGN	RNGN
12	11	12 15	06 08	09 12 15
A138	A138	A139	A139	A140

Edge length ·  
Kantelänge  
Page ·  
Seite

Positive Inserts  
Positive WSP



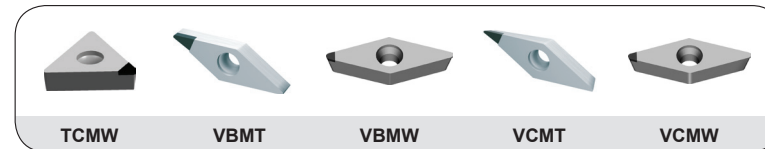
CCGW	DCGW	TCGW	VBGW	VCGW
06,09,12	07,11	11,16	16	16
A134	A135	A136	A137	A137

Edge length ·  
Kantelänge  
Page ·  
Seite



CCMT	CCMW	DCMT	DCMW	TCMT
06,09,12	06,09,12	07,11	07,11	11,16
A141	A142	A143	A144	A145

Edge length ·  
Kantelänge  
Page ·  
Seite

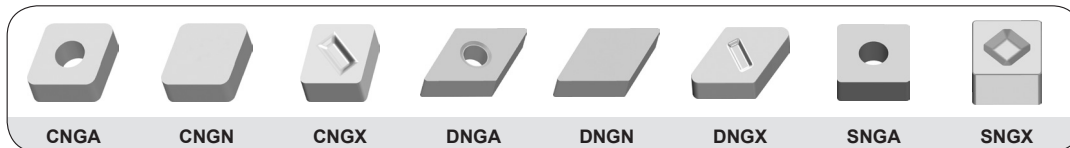


TCMW	VBMT	VBMW	VCMT	VCMW
11,16	16	16	16	16
A146	A147	A147	A148	A148

Edge length ·  
Kantelänge  
Page ·  
Seite

### Ceramic Inserts · Keramik Wendeschneidplatten

Negative Inserts  
Negative WSP



CNGA	CNGN	CNGX	DNGA	DNGN	DNGX	SNGA	SNGX
12,16	12,16	12	15	15	15	12	12
A152	A153	A154	A154	A155	A155	A156	A156

Edge length ·  
Kantelänge  
Page ·  
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SNGN	TNGA	TNGN	WNGA	RNGN
09,12,15,19,25	16,22	16,22	08	09,12,15,19,25
A157	A158	A159	A160	A160

Edge length ·  
Kantelänge  
Page ·  
Seite

### Parting and grooving · Ab- und Einstechen



**QC\*\*R/L**

0.5~4.8

A290



**QC\*\*R/L\*\*\*R**

2.0~4.0

A291

Width · Breite

Page · Seite



**ZP\*D-MG**

2.5,3,4,5,6

A283



**ZP\*D-MG-R/L**

2.5,3

A284



**ZP\*S-MG**

2.5,3,4,5,6

A283



**ZT\*D-MG**

2.5,3,4,5,6

A285



**ZTBD-MG**

2

A284



**ZT\*S-MG**

5,6

A285



**ZT\*D-EG**

1-2.4

A285

Width · Breite

Page · Seite



**ZT\*D-EG**

2.4-6.5

A285



**ZIMF-NM**

3,4,5,6

A287



**ZR\*D-MG**

2.5,3,4,5,6

A286



**ZR\*D-EG**

3,4,5,6

A286



**ZIGQ-NM**

3,4,5,6

A287



**ZR\*D-LH**

6,8

A288



**ZILD-LC**

8

A288







Width · Breite

Page · Seite







## Threading Insert · Gewindeplatten

**A**







General Turning  
Allgemeine Drehbearbeitung

ISO metric ISO metrisch		Partial-Profile 60°·55° Teil-Profil 60°·55°		Whitworth Rohrgewinde	
					
External thread Außengewinde	Internal thread Innengewinde	External thread Außengewinde	Internal thread Innengewinde	External thread Außengewinde	Internal thread Innengewinde
1~6	1~6	0.5~5	0.5~5	8~16	8~16
A321	A322	A323	A323	A324	A324
Pitch · Steigung					
Page · Seite					







  

UN Unified Conventional Thread Gewindeform UN 60°amerikanisch		BSPT Britain Standard Taper Pipe Thread Rohrgewinde für Dampf-, Gas-, & Wasserleitungen		NPT American Standard Amerikanisches kegeliges Rohrgewinde	
					
External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde
8~20	8~20	11~28	11~28	8~27	8~27
A325	A325	A326	A326	A327	A327
Pitch · Steigung					
Page · Seite					

NPTF60°		Round screw 30°		MJ (Metric)	UNJ (American)
					
External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	External Threads Außengewinde
8~27	8~27	6~10	6~10	1.5~2.0	8~32
A328	A328	A329	A329	A330	A330
Pitch · Steigung					
Page · Seite					

Tr (ISO trapezoid thread 30°)		ACME		STUB-ACME	
					
External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde
1.5~3.0	1.5~3.0	8~16	8~16	8~16	8~16
A331	A331	A332	A332	A333	A333
Pitch · Steigung					
Page · Seite					



















API (60°)		API (round)		API (inclined trapezoid screw)	
					
External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde
4~5	4~5	8~10	8~10	5	5
A334	A334	A335	A335	A336	A336
Pitch · Steigung					
Page · Seite					

Illustration shows the right hand type · Die Illustration zeigt die Rechtsausführung.

## Threading Insert (thin type) · Gewindeplatten (dünne Type)

ISO metric (full profile) ISO metrisch (voll Profil)		Partial-Profile 60°-55° Teil-Profil 60°-55°		Whitworth Rohrgewinde		
						
External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde	
0.5~3.0	0.5~3.0	0.5~5.0(5~48)	0.5~5.0(5~48)	0.5~5.0(5~48)	0.5~5.0(5~48)	Pitch · Steigung
A337	A337	A338	A338	A339	A339	Page · Seite

UN Unified Conventional Thread Gewindeform UN 60°amerikanisch		BSPT Britain Standard Taper Pipe Thread Rohrgewinde für Dampf-, Gas-, & Wasserleitungen		NPT American Standard Amerikanisches kegeliges Rohrgewinde		
						
External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde	External Threads Außengewinde	Internal Threads Innengewinde	
8~20	8~20	11~28	11~28	8~27	8~27	Pitch · Steigung
A340	A340	A341	A341	A342	A342	Page · Seite

# Turning · Drehen

## Turning Toolholder Overview · Halter zum Drehen Übersicht

### External Turning Holder · Halter zur Außenbearbeitung

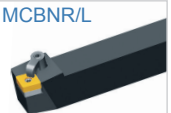
















#### D-type Clamping (lever) · D Halter (Doppelpratze)

						
Angle-Winkel 95°	93°	75°	91°	72°30'	93°	95°
Page-Seite A173	A174	A175	A176	A177	A178	A179






#### P-type Clamping (lever) · P Halter (Kniehebel)

						
Angle-Winkel 75°	95°	93°	63°	75°	45°	75°
Page-Seite A180	A181	A182	A183	A184	A185	A186
						
Angle-Winkel 45°	90°	60°	90°	95°		
Page-Seite A187	A188	A189	A190	A191		

#### M-type Clamping (clamping finger) · M Halter (Pratze)

						
Angle-Winkel 75°	95°	93°	62°30'	75°	75°	75°
Page-Seite A192	A193	A194	A195	A196	A197	A198
						
Angle-Winkel 45°	90°	93°	93°	90°	72°30'	93°
Page-Seite A199	A200	A201	A202	A203	A204	A205
						
Angle-Winkel 95°						
Page-Seite A206	A207	A207				

#### S-type Clamping (screw) · S Halter (Schraube)

						
Angle-Winkel 90°	95°	90°	93°	62°30'	93°	90°
Page-Seite A208	A209	A210	A211	A212	A213	A214

A

General Turning  
Allgemeine Drehbearbeitung

### S-type Clamping (screw) · S Halter (Schraube)



Angle-Winkel	<b>72°30'</b>	<b>72°30'</b>	<b>93°</b>	<b>75°</b>	<b>45°</b>	<b>75°</b>	<b>45°</b>
Page-Seite	A215	A216	A217	A218	A218	A219	A219



Angle-Winkel	<b>90°</b>	<b>91°</b>	<b>91°</b>	<b>60°</b>	<b>90°</b>		
Page-Seite	A220	A220	A221	A222	A223	A224	A225

### C-type Clamping (clamping finger) · C Halter (Pratze)



Angle-Winkel	<b>93°</b>	<b>63°</b>
Page-Seite	A226	A226

### Tool holder for ceramic inserts · Halter für Keramikplatten



Angle-Winkel	<b>95°</b>	<b>93°</b>	<b>93°</b>	<b>93°</b>	<b>75°</b>	<b>75°</b>	<b>45°</b>
Page-Seite	A227	A227	A228	A228	A229	A229	A230



Angle-Winkel	<b>45°</b>	<b>95°</b>	<b>93°</b>	<b>45°</b>
Page-Seite	A230	A231	A231	A232

# Turning · Drehen

## Turning Tools Overview · Halter zum Drehen Übersicht

### Tool holder for Internal Machining · Halter zur Innenbearbeitung

#### P-type Clamping (lever) · P Halter (Kniehebel)

PCLNR/L	PDSNR/L	PDUNR/L	PSKNR/L	PTFNR/L	PWLNR/L
					
Angle-Winkel 95°	62°30'	93°	75°	90°	95°
Page-Seite A238	A240	A241	A243	A244	A245

#### S-type Clamping (screw) · S Halter (Schraube)

SCLCR/L	SDQCR/L	SDUCR/L	SDZCR/L	SSKCR/L	STFCR/L	SVQCR/L
						
Angle-Winkel 95°	107°30'	93°	85°	75°	90°	107°30'
Page-Seite A246	A248	A249	A250	A251	A252	A253

SVUCR/L	SVQBR/L	SVUBR/L	SCLPR/L	SDQPR/L	SDUPR/L	STUPR/L
						
Angle-Winkel 93°	107°30'	93°	95°	107°30'	93°	93°
Page-Seite A254	A255	A256	A257	A258	A259	A260

SCFCR	SCLCR
	
Angle-Winkel 90°	95°
Page-Seite A261	A262

#### Carbide boring bars · Hartmetallbohrstangen

SCLPR/L	SDQPR/L	SDUPR/L	STUPR/L	STFCR/L STFPR/L	SVQCR/L	SVUCR/L
						
Angle-Winkel 95°	107°30'	93°	93°	95°	107°30'	93°
Page-Seite A264	A265	A266	A267	A268	A269	A270

A

General Turning  
Allgemeine Drehbearbeitung

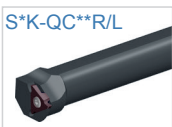
### Tool Holder for Parting off & Grooving · Halter zum Ab- und Einstechen



Page: A295      A294      A296      A296      A297      A298      A298  
Seite

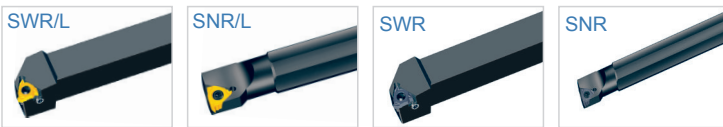


Page: A299-300      A301-304      A305-306      A307      A294      A307      A309  
Seite



Page: A309  
Seite

### Tool Holder for Threading · Halter für Gewindebearbeitung



Page: A344      A345      A346      A346  
Seite

# A

General Turning  
Allgemeine Drehbearbeitung

# Turning · Drehen

## Recommended Grade Overview (Inserts) · Empfohlene Sorten Übersicht (WSP)

**A**

General Turning  
Allgemeine Drehbearbeitung

ISO	General Turning · Allgemeine Drehbearbeitung										Threading Gewinde	Parting and Grooving Ab- und Einstechen		
	Code	Coating · beschichtet				Cermet unbeschichtet	Cermet beschichtet	Ceramic Keramik	cemented carbide Hartmetall	PCBN	PCD	Coated beschichtet		cemented carbide Hartmetall
		CVD	PVD	PVD	CVD							PVD		
<b>P</b> Steel · Stahl	01													
	10		YBC152									YBG205		
	20		YBC251									YBG201		
	30		YBC252									YBG202		
	40		YBC351									YBC251		YBG202
<b>M</b> Stainless Steel · Rostfreier Stahl	01													
	10	YBM153										YBG205		
	20	YBM253										YBG201		
	30	YBM251										YBG202		
	40													YBG202
<b>K</b> Cast iron · Gusseisen	01													
	10	YBD052						CN1000						
	20	YBD102						CA1000						
	30	YBD152						CN2000						
	40	YBD152C						CA1000						
<b>N</b> Non-ferrous materials NE Metalle	01													
	10													
	20				YBG102									
	30													
	40													
<b>S</b> Heat-resistant steel Superlegierungen	01													
	10				YBG102									
	20				YBG105									
	30				YBG202									
	40				YBG205									
<b>H</b> super Hard Material Gehärtete Werkstoffe	01													
	10													
	20													
	30													
	40													

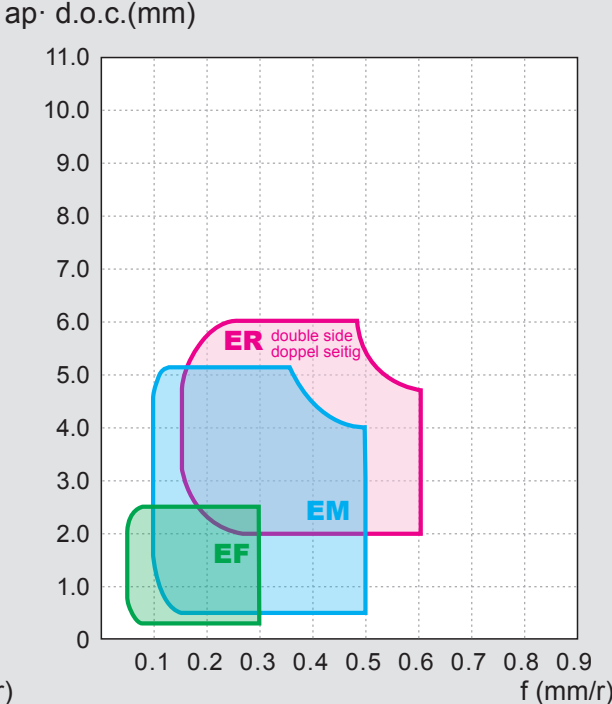
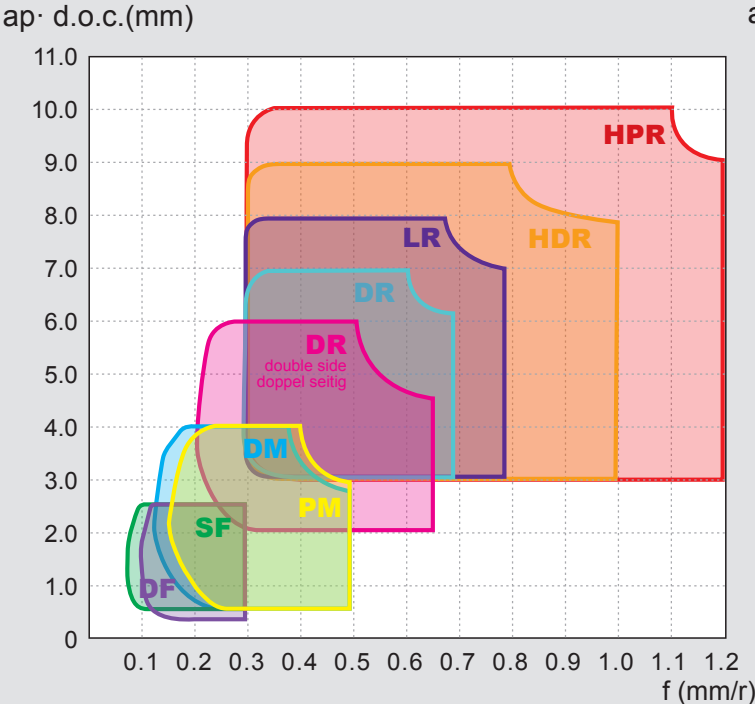
<b>P</b>	Steel / Stahl
<b>M</b>	Stainless Steel / Rostfreier Stahl
<b>K</b>	Cast iron / Gusseisen

<b>N</b>	Non Ferrous materials · Ne Metalle
<b>S</b>	Heat-resistant steel · Warmfester Stahl
<b>H</b>	Hardened material · Gehärtete Werkstoffe

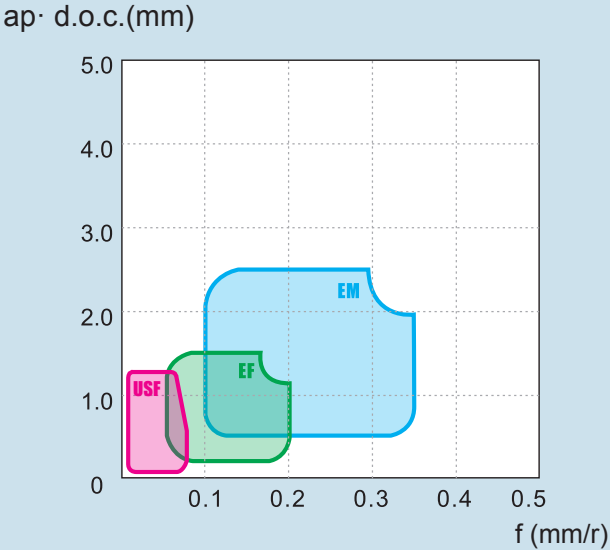
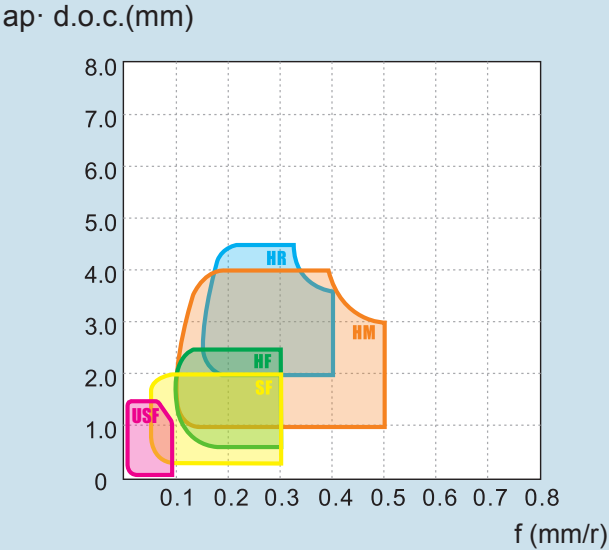
Recommended Grade Overview (Inserts) · Empfohlene Sorten Übersicht (WSP)

Main Chip breaker for general Turning ·  
Hauptspanbrecher für allgemeine Drehbearbeitung

### Negative Inserts · Negative Wendeschneidplatten



### Positive Inserts · Positive Wendeschneidplatten



















# Turning · Drehen

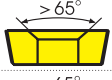
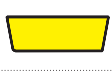
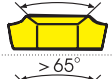

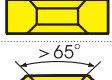

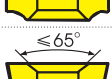

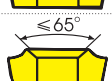
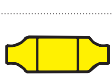
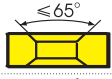
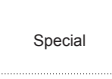
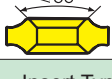
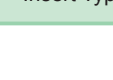
## Turning Inserts Code Key · WSP ISO Kennzeichnung

**A**










General Turning  
Allgemeine Drehbearbeitung

Turning Inserts Code Key  
WSP ISO Kennzeichnung

Insert Shape / Schneidplattenform		
 A	 B	 C
 D	 E	 H
 K	 L	 M
 O	 P	 R
 S	 T	 T
 V	 W	Others Z

Metric / Metrisch							
Code	Hole / Bohrung	Insert Section / Spanleitstufe	Insert Section / Plattenform	Code	Hole / Bohrung	Insert Section / Spanleitstufe	Insert Section / Plattenform
B	✓	---		N	---	---	
H	✓	Single side / einseitig		R	---	Single side / einseitig	
C	✓	---		F	---	Double side / doppelseitig	
J	✓	Double side / doppelseitig		A	✓	---	
W	✓	---		M	✓	Single side / einseitig	
T	✓	Single side / einseitig		G	✓	Double side / doppelseitig	
Q	✓	---		X	---	---	Special
U	✓	Double side / doppelseitig					



Clearance angle of main cutting edge Freiwinkel der Hauptschneide			
Code	angle / Winkel	Code	angle / Winkel
A	 3°	B	 5°
C	 7°	D	 15°
E	 20°	F	 25°
G	 30°	N	 0°
P	 11°	O	Others

Tolerances / Toleranzklasse											
Code	Tolerance	Incirle Tolerance ØI.C	Tolerance S	(Reference) M class precision (according to shape and size) (mm) (Bezug) M-Toleranz (entsprechend Form und Größe)							
				Incirle	regular triangle	square	80° rhomboid	55° rhomboid	35° rhomboid	round runde	
A	±0.005	±0.025	±0.025								
F	±0.005	±0.013	±0.025	6.35	±0.08	±0.08	±0.08	±0.11	±0.16	---	
C	±0.013	±0.025	±0.025	9.525	±0.08	±0.08	±0.08	±0.11	±0.16	---	
H	±0.013	±0.013	±0.025	12.7	±0.13	±0.13	±0.13	±0.15	---	---	
E	±0.025	±0.025	±0.025	15.875	±0.15	±0.15	±0.15	±0.18	---	---	
G	±0.025	±0.025	±0.13	19.05	±0.15	±0.15	±0.15	±0.18	---	---	
J	±0.005	±0.05±0.13	±0.025	25.4	---	±0.18	---	---	---	---	
K	±0.013	±0.05±0.13	±0.025	ØI.C (mm) Incirle tolerance Eingeschriebener Kreis Toleranz							
L	±0.025	±0.05±0.13	±0.025	Incirle	regular triangle	square	80° rhomboid	55° rhomboid	35° rhomboid	round runde	
M	±0.08±0.18	±0.05±0.13	±0.13	6.35	±0.05	±0.05	±0.05	±0.05	±0.05	---	
N	±0.08±0.18	±0.05±0.13	±0.025	9.525	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05	
U	±0.13±0.38	±0.08±0.25	±0.13	12.7	±0.08	±0.08	±0.08	±0.08	---	±0.08	
				15.875	±0.10	±0.10	±0.10	±0.10	---	±0.10	
				19.05	±0.10	±0.10	±0.10	±0.10	---	±0.10	
				25.4	---	±0.13	---	---	---	±0.13	

# Turning · Drehen

## Turning Inserts Code Key · WSP ISO Kennzeichnung

**A**

General Turning  
Allgemeine Drehbearbeitung

Turning Inserts Code Key  
WSP ISO Kennzeichnung

Ø of IC (mm)	Cutting edge length / Schneidenlänge (mm)							
	Insert Shape / Plattenform							
	C	D	R	S	T	V	W	K
3.97					06			
5.0			05					
5.56					09			
6.0			06					
6.35	06	07			11	11		
8.0			08					
9.525	09	11	09	09	16	16	06	16
10.0			10					
12.0			12					
12.7	12	15	12	12	22	22	08	
15.875	16		15	15	27			
16.0		19	16					
19.05	19		19	19	33			
20.0			20					
25.0	25	25	25					
25.4			25	25				
31.75			31					
32			32					

Insert Thickness / Dicke (mm)	
Thickness / Dicke	
Code	Insert Thickness (mm)
00	0.79
T0	0.99
01	1.59
T1	1.98
02	2.38
T2	2.58
03	3.18
T3	3.97
04	4.76
T4	4.96
05	<b>5.56</b>
T5	5.95
06	6.35
T6	6.75
07	7.94
09	9.52
T9	9.72
11	11.11
12	12.70

**22 04 08 - DM (ISO)**

**4 3 2 (inch)**

Incircle Innenkreis	
Code	Diameter (mm)
2	6.35
3	9.525
4	12.7
5	15.875
6	19.05
8	25.4

Thickness Dicke	
Code	Thickness (mm)
2	3.18
3	4.76
4	6.35
5	7.94
6	9.52

Nose radius Eckenradius	
Code	Nose radius (mm)
0	0.2
1	0.4
2	0.8
3	1.2
4	1.6
5	2.0
6	2.4

Nose radius Eckenradius	
Code	Radius (mm)
00	No Radius
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
32	3.2
X	Others
MO	Round Inserts Andere Runde Platten

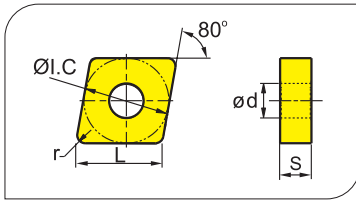
Code Chipbreakers Spanleitstufen		
DF	DM	DR / HDR

# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## CN\*\* Negative Insert · Negative WSP





● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
⊗ Normal Machining Condition / Normale Bearbeitungsbedingungen  
⊗ Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrous material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

**A**

General Turning / Allgemeine Drehbearbeitung

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet Beschicht. / Cermet.	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
<b>DF</b>  Finishing / Schlichten	CNMG090304-DF	9.7	9.525	3.18	3.81	0.4	○	●	○	●				○															
	CNMG090308-DF	9.7	9.525	3.18	3.81	0.8	○	●	○	●																			
	CNMG120404-DF	12.9	12.7	4.76	5.16	0.4	○	●	●	●				○		○													
	CNMG120408-DF	12.9	12.7	4.76	5.16	0.8	○	●	●	●	○																		
	CNMG120412-DF	12.9	12.7	4.76	5.16	1.2	○	●	●	●																			
<b>WG</b>  Wiper	CNMG120404-WG	12.9	12.7	4.76	5.16	0.4	●																						
	CNMG120408-WG	12.9	12.7	4.76	5.16	0.8	●	●	○	●					○			●		●									
	CNMG120412-WG	12.9	12.7	4.76	5.16	1.2	●	●	○																				
	CNMG160608-WG	16.1	15.875	6.35	6.35	0.8		○																					
	CNMG160612-WG	16.1	15.875	6.35	6.35	1.2		○																					
<b>SF</b>  Finishing / Schlichten	CNMG090304-SF	9.7	9.525	3.18	3.81	0.4																			●				
	CNMG090308-SF	9.7	9.525	3.18	3.81	0.8																				●			
	CNMG120404-SF	12.9	12.7	4.76	5.16	0.4																				●			
	CNMG120408-SF	12.9	12.7	4.76	5.16	0.8																				●			
	CNMG120412-SF	12.9	12.7	4.76	5.16	1.2																							
<b>EF</b>  Finishing / Schlichten	CNMG090304-EF	9.7	9.525	3.18	3.81	0.4									●	○													
	CNMG090308-EF	9.7	9.525	3.18	3.81	0.8								○	●	○													
	CNMG120404-EF	12.9	12.7	4.76	5.16	0.4		○		○	○	●	○	●	●														
	CNMG120408-EF	12.9	12.7	4.76	5.16	0.8		○		●	●	●	○	●	○														
	CNMG120412-EF	12.9	12.7	4.76	5.16	1.2								○	○		○												

### Tool holder / Klemmhalter



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● Ex Stock / ab Lager    ○ On demand / auf Anfrage    YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

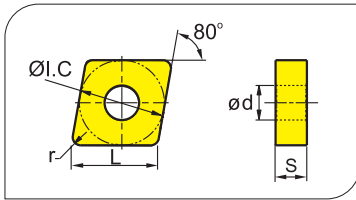


# Turning · Drehen



Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## CN\*\* Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / Beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
DM  Medium Cut / Mittl. Bearb.	CNMG090304-DM	9.7	9.525	3.18	3.81	0.4	○	●	●	●																		
	CNMG090308-DM	9.7	9.525	3.18	3.81	0.8		●	●	●																		
	CNMG090312-DM	9.7	9.525	3.18	3.81	1.2				○																		
	CNMG120404-DM	12.9	12.7	4.76	5.16	0.4	○	●	●	●	●						○	○										
	CNMG120408-DM	12.9	12.7	4.76	5.16	0.8	●	●	●	●	●					●	●											
	CNMG120412-DM	12.9	12.7	4.76	5.16	1.2	●	●	●	●	●					○	○	●										
	CNMG120416-DM	12.9	12.7	4.76	5.16	1.6		●	○	●								○										
	CNMG160608-DM	16.1	15.875	6.35	6.35	0.8	○	●	○	●	●							○										
	CNMG160612-DM	16.1	15.875	6.35	6.35	1.2	○	●	●	●	○							○										
	CNMG160616-DM	16.1	15.875	6.35	6.35	1.6	○	●	●	●	●																	
	CNMG190608-DM	19.3	19.05	6.35	7.94	0.8		●	●	●								○										
	CNMG190612-DM	19.3	19.05	6.35	7.94	1.2		●	●	●	●							○										
CNMG190616-DM	19.3	19.05	6.35	7.94	1.6		●	●	●	●							○											
EM  Medium Cut / Mittl. Bearb.	CNMG120404-EM	12.9	12.7	4.76	5.16	0.4							●	●	●	○	●											
	CNMG120408-EM	12.9	12.7	4.76	5.16	0.8							●	●	○	●	○	●										
	CNMG120412-EM	12.9	12.7	4.76	5.16	1.2							○	●	●	○	●											
	CNMG160608-EM	16.1	15.875	6.35	6.35	0.8								●	●	●	●											
	CNMG160612-EM	16.1	15.875	6.35	6.35	1.2							○	●	●	○	●											
CNMG160616-EM	16.1	15.875	6.35	6.35	1.6									○														

Tool holder / Klemmhalter



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● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

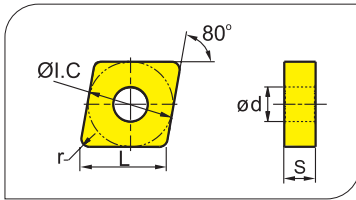


# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## CN\*\* Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●

**A**

General Turning / Allgemeine Drehbearbeitung

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C.	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
<b>LR</b>  Roughing / Schruppen	CNMM120408-LR	12.9	12.7	4.76	5.16	0.8	●	●										●										
	CNMM120412-LR	12.9	12.7	4.76	5.16	1.2	●	●										●										
	CNMM120416-LR	12.9	12.7	4.76	5.16	1.6	●	●										○										
	CNMM160608-LR	16.1	15.875	6.35	6.35	0.8	●	●											●									
	CNMM160612-LR	16.1	15.875	6.35	6.35	1.2	●	●											●									
	CNMM160616-LR	16.1	15.875	6.35	6.35	1.6	●	●											○									
	CNMM160624-LR	16.1	15.875	6.35	6.35	2.4	○	○																				
	CNMM190612-LR	19.3	19.05	6.35	7.94	1.2	●	●											●									
	CNMM190616-LR	19.3	19.05	6.35	7.94	1.6	●	●											○									
	CNMM190624-LR	19.3	19.05	6.35	7.94	2.4	●	●																				
CNMM250924-LR	25.79	25.4	9.525	9.12	2.4	○	●																					
<b>DR</b>  Roughing / Schruppen	CNMM120412-DR	12.9	12.7	4.76	5.16	1.2	●	○	●																			
	CNMM160612-DR	16.1	15.875	6.35	6.35	1.2	●	●	●									●										
	CNMM160616-DR	16.1	15.875	6.35	6.35	1.6	●	●	●	●																		
	CNMM190612-DR	19.3	19.05	6.35	7.94	1.2	○	●	●	●	●								●									
	CNMM190616-DR	19.3	19.05	6.35	7.94	1.6	○	●	●	●	●																	
	CNMM190624-DR	19.3	19.05	6.35	7.94	2.4	○	●	●	●	○																	
CNMM250924-DR	25.79	25.4	9.525	9.12	2.4	○	●	●	●	○																		
<b>ER</b>  Roughing / Schruppen	CNMG120408-ER	12.9	12.7	4.76	5.16	0.8												○	●									
	CNMG120412-ER	12.9	12.7	4.76	5.16	1.2												○	●									
	CNMG160612-ER	16.1	15.875	6.35	6.35	1.2												○	●									
	CNMG160616-ER	16.1	15.875	6.35	6.35	1.6												○	●									
	CNMG190612-ER	19.3	19.05	6.35	7.94	1.2				○				○	○				●									
CNMG190616-ER	19.3	19.05	6.35	7.94	1.6				○				○	○				●										
<b>ER</b>  Roughing / Schruppen	CNMM250724-ER	25.79	25.4	7.94	9.12	2.4			●						○	○												
	CNMM250732-ER	25.79	25.4	7.94	9.12	3.2			●						○	○												
	CNMM250924-ER	25.79	25.4	9.525	9.12	2.4			●						○	○			●									
	CNMM250932-ER	25.79	25.4	9.525	9.12	3.2			●						○	○												

### Tool holder / Klemmhalter



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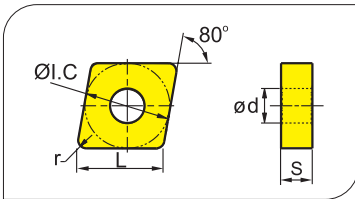
● Ex Stock / ab Lager    ○ On demand / auf Anfrage    YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## CN\*\* Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
● Normal Machining Condition / Normale Bearbeitungsbedingungen  
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



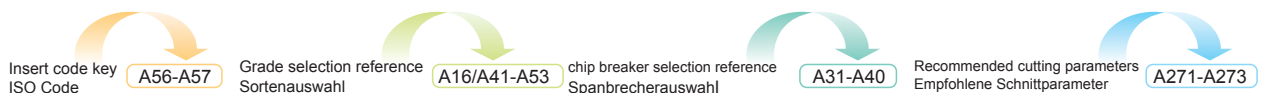
Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
<b>HDR</b>  Roughing / Schruppen	CNMM120408-HDR	12.9	12.7	4.76	5.16	0.8	○	●	●	●	●																		
	CNMM120412-HDR	12.9	12.7	4.76	5.16	1.2	○	●	●	●																			
	CNMM120416-HDR	12.9	12.7	4.76	5.16	1.6	○	○	●	●	○																		
	CNMM160612-HDR	16.1	15.875	6.35	6.35	1.2	○	●	●	●	○																		
	CNMM160616-HDR	16.1	15.875	6.35	6.35	1.6	○	○	●	●	○																		
	CNMM160624-HDR	16.1	15.875	6.35	6.35	2.4	○	○	●	●	○																		
	CNMM190608-HDR	19.3	19.05	6.35	7.94	0.8			○	●																			
	CNMM190612-HDR	19.3	19.05	6.35	7.94	1.2			○	●	○																		
	CNMM190616-HDR	19.3	19.05	6.35	7.94	1.6	○	●	●	●	●											○							
	CNMM190624-HDR	19.3	19.05	6.35	7.94	2.4	○	●	●	●																			
	CNMM250924-HDR	25.79	25.4	9.525	9.12	2.4		●		●																			
<b>HPR</b>  Roughing / Schruppen	CNMM190616-HPR	19.3	19.05	6.35	7.94	1.6				●																			
	CNMM250924-HPR	25.79	25.4	9.525	9.12	2.4				●																			
<b>Basic</b> 	CNMM120404	12.9	12.7	4.76	5.16	0.4	○	○																					
	CNMM120408	12.9	12.7	4.76	5.16	0.8		○																					
	CNMM120412	12.9	12.7	4.76	5.16	1.2		○																					
	CNMM190608	19.3	19.05	6.35	7.94	0.8		○																					
	CNMM190612	19.3	19.05	6.35	7.94	1.2		○		●	○																		
	CNMM190616	19.3	19.05	6.35	7.94	1.6		○																					
	CNMM190624	19.3	19.05	6.35	7.94	2.4		○																					

### Tool holder / Klemmhalter



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**A**

General Turning / Allgemeine Drehbearbeitung

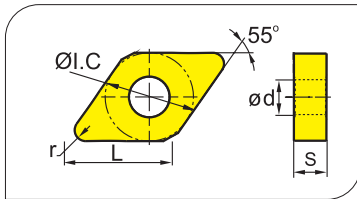


# Turning · Drehen



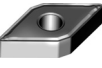
Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## DN\*\* Negative Insert-Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

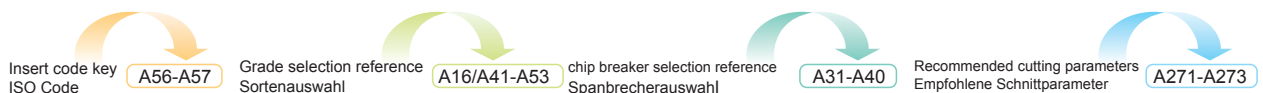


Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrous material / Ne Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet Coated / Beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall						
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
DF  Finishing / Schlichten	DNMG110404-DF	11.6	9.525	4.76	3.81	0.4	○	●	○	●																		
	DNMG110408-DF	11.6	9.525	4.76	3.81	0.8	○	●	○	●																		
	DNMG110412-DF	11.6	9.525	4.76	3.81	1.2		●	○	○																		
	DNMG150404-DF	15.5	12.7	4.76	5.16	0.4	○	●	○	○																		
	DNMG150408-DF	15.5	12.7	4.76	5.16	0.8	○	●	○	●																		
	DNMG150412-DF	15.5	12.7	4.76	5.16	1.2		○	○	○																		
	DNMG150604-DF	15.5	12.7	6.35	5.16	0.4	○	●	●	●																		
	DNMG150608-DF	15.5	12.7	6.35	5.16	0.8	○	●	●	●																		
	DNMG150612-DF	15.5	12.7	6.35	5.16	1.2		●	○	○																		
WG  Wiper	DNMX110404-WG	11.6	9.525	4.76	3.81	0.4	●	○																				
	DNMX110408-WG	11.6	9.525	4.76	3.81	0.8	○	●	○	●																		
	DNMX150408-WG	15.5	12.7	4.76	5.16	0.8	○	○																				
	DNMX150412-WG	15.5	12.7	4.76	5.16	1.2		○																				
	DNMX150608-WG	15.5	12.7	6.35	5.16	0.8	○	●	○	●																		
SF  Finishing / Schlichten	DNMG110404-SF	11.6	9.525	4.76	3.81	0.4																		●				
	DNMG150404-SF	15.5	12.7	4.76	5.16	0.4																		●				
	DNMG150408-SF	15.5	12.7	4.76	5.16	0.8																		●				
	DNMG150604-SF	15.5	12.7	6.35	5.16	0.4																		●				
	DNMG150608-SF	15.5	12.7	6.35	5.16	0.8																		●				

### Tool holder / Klemmhalter

 DDJNR/L Kr:93°	 PDJNR/L Kr:93°	 PDNRR/L Kr:63°	 MDJNR/L Kr:93°	 MDPNN Kr:62°30'	 PDSNR/L Kr:62°30'	 PDUNR/L Kr:93°
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A

General Turning / Allgemeine Drehbearbeitung





# Turning · Drehen

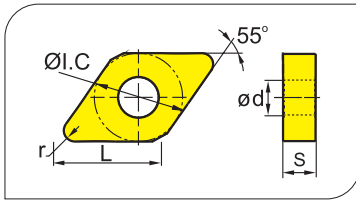
Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## DN\*\* Negative Insert/Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

**A**

General Turning  
Allgemeine Drehbearbeitung



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall						
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
<b>EM</b>  Medium Cut / Mittl. Bearb.	<b>DNMG110404-EM</b>	11.6	9.525	4.76	3.81	0.4									○	●	●											
	<b>DNMG110408-EM</b>	11.6	9.525	4.76	3.81	0.8									○	●	●	○										
	<b>DNMG110412-EM</b>	11.6	9.525	4.76	3.81	1.2									○													
	<b>DNMG150404-EM</b>	15.5	12.7	4.76	5.16	0.4										●	●											
	<b>DNMG150408-EM</b>	15.5	12.7	4.76	5.16	0.8										●	●											
	<b>DNMG150412-EM</b>	15.5	12.7	4.76	5.16	1.2										○	○											
	<b>DNMG150604-EM</b>	15.5	12.7	6.35	5.16	0.4									○	●	●	○	●									
	<b>DNMG150608-EM</b>	15.5	12.7	6.35	5.16	0.8									○	●	○	●	○	●								
<b>DNMG150612-EM</b>	15.5	12.7	6.35	5.16	1.2										●	●	○	●										
<b>NM</b>  Medium Cut / Mittl. Bearb.	<b>DNMG150608-NM</b>	15.5	12.7	6.35	5.16	1.2										●												
	<b>DNMG150612-NM</b>	15.5	12.7	6.35	5.16	1.2									○	●										○		
<b>DR</b>  Roughing / Schruppen	<b>DNMG150608-DR</b>	15.5	12.7	6.35	5.16	0.8	○	●	●	●	○									○	●	●						
	<b>DNMG150612-DR</b>	15.5	12.7	6.35	5.16	1.2	○	●	●	●	○										●	●						
	<b>DNMG150616-DR</b>	15.5	12.7	6.35	5.16	1.6		●	○	●	○										●	○						
<b>ER</b>  Roughing / Schruppen	<b>DNMG150608-ER</b>	15.5	12.7	6.35	5.16	0.8									○		●											
	<b>DNMG150612-ER</b>	15.5	12.7	6.35	5.16	1.2									○		●											

### Tool holder / Klemmhalter



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● Ex Stock / ab Lager    ○ On demand / auf Anfrage    YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.



# Turning · Drehen

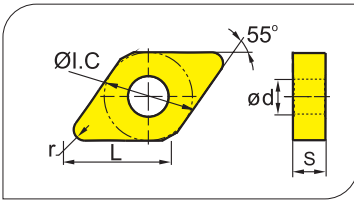
Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## DN\*\* Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

**A**

General Turning  
Allgemeine Drehbearbeitung



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrous material / Ne Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C.	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
<b>LR</b> Roughing / Schruppen	DNMM150608-LR	15.5	12.7	6.35	5.16	0.8	●	●										●										
	DNMM150612-LR	15.5	12.7	6.35	5.16	1.2	●	●										●										
	DNMM150616-LR	15.5	12.7	6.35	5.16	1.6	●	●										●										
<b>DR</b> Roughing / Schruppen	DNMM150608-DR	15.5	12.7	6.35	5.16	0.8	○	●	○	●	○							○										
	DNMM150612-DR	15.5	12.7	6.35	5.16	1.2	○	●	○	●																		
	DNMM150616-DR	15.5	12.7	6.35	5.16	1.6	●	○	●	○																		
<b>ER</b> Roughing / Schruppen	DNMM150608-ER	15.5	12.7	6.35	5.16	0.8												○	●									
	DNMM150612-ER	15.5	12.7	6.35	5.16	1.2												○	●									
<b>HDR</b> Roughing / Schruppen	DNMM150608-HDR	15.5	12.7	6.35	5.16	0.8	●	○	○	○																		
	DNMM150612-HDR	15.5	12.7	6.35	5.16	1.2	○	○	○																			
	DNMM150616-HDR	15.5	12.7	6.35	5.16	1.6	●	○	●	○																		
<b>Basic</b>	DNMG150604	15.5	12.7	6.35	5.16	0.4				○																		
	DNMG150608	15.5	12.7	6.35	5.16	0.8				○																		
	DNMG150612	15.5	12.7	6.35	5.16	1.2																						
	DNMG150616	15.5	12.7	6.35	5.16	1.6																						
	DNMG190608	19.3	15.875	6.35	7.94	0.8				○																		
	DNMG190612	19.3	15.875	6.35	7.94	1.2				○																		

### Tool holder / Klemmhalter



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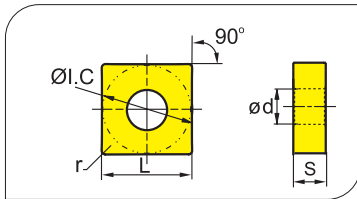
● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

# Turning · Drehen



Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## SN\*\* Negative Insert · Negative WSP





● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
● Normal Machining Condition / Normale Bearbeitungsbedingungen  
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

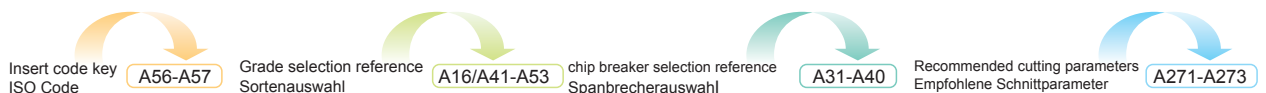


Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall											
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201			
<b>DF</b>  Finishing / Schlichten	<b>SNMG090304-DF</b>	9.525	9.525	3.18	3.81	0.4	○																									
	<b>SNMG090308-DF</b>	9.525	9.525	3.18	3.81	0.8	○																									
	<b>SNMG120404-DF</b>	12.7	12.7	4.76	5.16	0.4	○																									
	<b>SNMG120408-DF</b>	12.7	12.7	4.76	5.16	0.8	○ ● ○ ●																									
	<b>SNMG120412-DF</b>	12.7	12.7	4.76	5.16	1.2	○ ● ○ ●																									
<b>EF</b>  Finishing / Schlichten	<b>SNMG090304-EF</b>	9.525	9.525	3.18	3.81	0.4							○ ●	●																		
	<b>SNMG090308-EF</b>	9.525	9.525	3.18	3.81	0.8							○ ●	●																		
	<b>SNMG090312-EF</b>	9.525	9.525	3.18	3.81	1.2							○ ○	○																		
	<b>SNMG120404-EF</b>	12.7	12.7	4.76	5.16	0.4							○ ●	●																		
	<b>SNMG120408-EF</b>	12.7	12.7	4.76	5.16	0.8							○ ● ○ ●																			
	<b>SNMG120412-EF</b>	12.7	12.7	4.76	5.16	1.2							○ ●	○																		
	<b>SNMG150608-EF</b>	15.875	15.875	6.35	6.35	0.8							○ ○	○																		
<b>SNMG150612-EF</b>	15.875	15.875	6.35	6.35	1.2							○ ○	○																			

### Tool holder / Klemmhalter

<b>DSBNR/L</b> Kr:75°  Page/Seite A175	<b>PSBNR/L</b> Kr:75°  A184	<b>PSDNN</b> Kr:45°  A185	<b>PSKNR/L</b> Kr:75°  A186	<b>PSSNR/L</b> Kr:45°  A187	<b>MSBNR/L</b> Kr:75°  A196	<b>MSRNR/L</b> Kr:75°  A197
<b>MSKNR/L</b> Kr:75°  Page/Seite A198	<b>MSDNN</b> Kr:45°  A199	<b>PSKNR/L</b> Kr:75°  A243				



**A**

General Turning / Allgemeine Drehbearbeitung







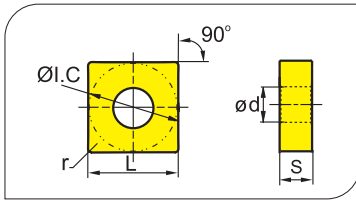


# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## SN\*\* Negative Insert-Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
⊗ Normal Machining Condition / Normale Bearbeitungsbedingungen  
⊗ Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrous material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall																	
		L	I.C.	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201									
<b>ER</b>  Roughing / Schruppen	SNMM250724-ER	25.4	25.4	7.94	9.12	2.4			●						○																							
	SNMM250732-ER	25.4	25.4	7.94	9.12	3.2			●																													
	SNMM250924-ER	25.4	25.4	9.525	9.12	2.4			●							○			●																			
	SNMM250932-ER	25.4	25.4	9.525	9.12	3.2			●												○																	
<b>HDR</b>  Roughing / Schruppen	SNMM120408-HDR	12.7	12.7	4.76	5.16	0.8			●	○	○																											
	SNMM120412-HDR	12.7	12.7	4.76	5.16	1.2			●	○	●																											
	SNMM120416-HDR	12.7	12.7	4.76	5.16	1.6				○	○																											
	SNMM150608-HDR	15.875	15.875	6.35	6.35	0.8			○	●	○																											
	SNMM150612-HDR	15.875	15.875	6.35	6.35	1.2	○		●	●	●																											
	SNMM150616-HDR	15.875	15.875	6.35	6.35	1.6			●	○	○																											
	SNMM150624-HDR	15.875	15.875	6.35	6.35	2.4				○																												
	SNMM190608-HDR	19.05	19.05	6.35	7.94	0.8				○																												
	SNMM190612-HDR	19.05	19.05	6.35	7.94	1.2				●	○																											
	SNMM190616-HDR	19.05	19.05	6.35	7.94	1.6	○	●	●	●										●																		
SNMM190624-HDR	19.05	19.05	6.35	7.94	2.4		●		●																													
SNMM250724-HDR	25.4	25.4	7.94	9.12	2.4			○	●	●																												
SNMM250924-HDR	25.4	25.4	9.525	9.12	2.4		○		●																													
<b>HPR</b>  Roughing / Schruppen	SNMM190616-HPR	19.05	19.05	6.35	7.94	1.6			●																													
	SNMM250924-HPR	25.4	25.4	9.525	9.12	2.4			●																													

### Tool holder / Klemmhalter

<b>DSBNN/L</b> Kr:75° 	<b>PSBNN/L</b> Kr:75° 	<b>PSDNN</b> Kr:45° 	<b>PSKNR/L</b> Kr:75° 	<b>PSSNR/L</b> Kr:45° 	<b>MSBNN/L</b> Kr:75° 	<b>MSRNR/L</b> Kr:75° 
Page/Seite A175	A184	A185	A186	A187	A196	A197
<b>MSKNR/L</b> Kr:75° 	<b>MSDNN</b> Kr:45° 	<b>PSKNR/L</b> Kr:75° 				
Page/Seite A198	A199	A243				

● Ex Stock / ab Lager    ○ On demand / auf Anfrage    YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.



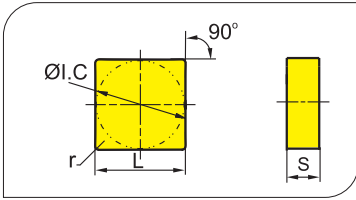


# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## SN\*\* Negative Insert-Negative WSP

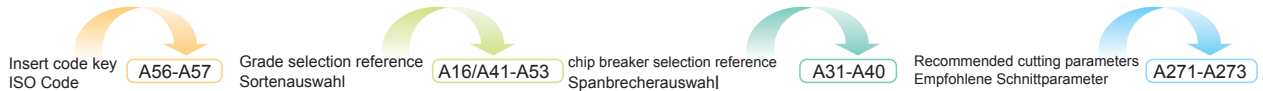
● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
● Normal Machining Condition / Normale Bearbeitungsbedingungen  
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●				
Stainless Steel / Rostfreier Stahl		●●●●●●●●●●			
Cast iron / Gusseisen			●●●●●●●●●●		
Non-ferrous material / Ne Metalle				●●	
Heat-resistant steel / Warmfester Stahl					●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / Beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBG153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
 Flat Glatt	SNUN090304	9.525	9.525	3.18	-	0.4																							
	SNUN090308	9.525	9.525	3.18	-	0.8																					○		
	SNUN120408	12.7	12.7	4.76	-	0.8															●								
	SNUN120412	12.7	12.7	4.76	-	1.2	○	●	○												○	○						○	
	SNUN150408	15.875	15.875	4.76	-	0.8																							
	SNUN150412	15.875	15.875	4.76	-	1.2																							
	SNUN190408	19.05	19.05	4.76	-	0.8																							
	SNUN190412	19.05	19.05	4.76	-	1.2			○																			○	○
	SNUN190424	19.05	19.05	4.76	-	2.4																							
	SNUN250724	25.4	25.4	7.94	-	2.4					○																		
	SNUN250924	25.4	25.4	9.525	-	2.4																							

**A**  
 General Turning / Allgemeine Drehbearbeitung

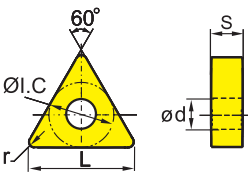


# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP





## TN\*\* Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
⊗ Normal Machining Condition / Normale Bearbeitungsbedingungen  
⊗ Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrous material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

General Turning / Allgemeine Drehbearbeitung

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
 Finishing / Schlichten	TNMG160404-DF	16.5	9.525	4.76	3.81	0.4	○	●	○	●																		
	TNMG160408-DF	16.5	9.525	4.76	3.81	0.8	○	●	●	●																		
	TNMG160412-DF	16.5	9.525	4.76	3.81	1.2	○	●	●	●																		
	TNMG220408-DF	22	12.7	4.76	5.16	0.8	○	●	○	●																		
	TNMG220412-DF	22	12.7	4.76	5.16	0.8	○	●	●	○																		
 Wiper	TNMX160404-WG	16.5	9.525	4.76	3.81	0.4	○	○	○																			
	TNMX160408-WG	16.5	9.525	4.76	3.81	0.8		●																				
	TNMX160412-WG	16.5	9.525	4.76	3.81	1.2	○	○	○											○								
 Finishing / Schlichten	TNMG110304-SF	11	6.35	3.18	2.26	0.4																○	○					
	TNMG160404-SF	16.5	9.525	4.76	3.81	0.4																○	○					
	TNMG160408-SF	16.5	9.525	4.76	3.81	0.8																○	○					
	TNMG220408-SF	22	12.7	4.76	5.16	0.8																○	○					
 Finishing / Schlichten	TNMG110304-EF	11	6.35	3.18	2.26	0.4																						
	TNMG110308-EF	11	6.35	3.18	2.26	0.8																						
	TNMG160404-EF	16.5	9.525	4.76	3.81	0.4																						
	TNMG160408-EF	16.5	9.525	4.76	3.81	0.8																						
	TNMG160412-EF	16.5	9.525	4.76	3.81	1.2																						
	TNMG220404-EF	22	12.7	4.76	5.16	0.4																						
	TNMG220408-EF	22	12.7	4.76	5.16	0.8																						
	TNMG220412-EF	22	12.7	4.76	5.16	1.2																						

### Tool holder / Klemmhalter



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Page/Seite A244

● Ex Stock / ab Lager    ○ On demand / auf Anfrage    YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.





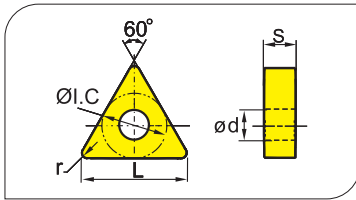


# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## TN\*\* Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrous material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
<b>HDR</b>  Heavy Turning / Schwer zerspannung	TNMM160408-HDR	16.5	9.525	4.76	3.81	0.8																							
	TNMM160412-HDR	16.5	9.525	4.76	3.81	1.2																							
	TNMM220408-HDR	22	12.7	4.76	5.16	0.8																							
	TNMM220412-HDR	22	12.7	4.76	5.16	1.2																							
	TNMM220416-HDR	22	12.7	4.76	5.16	1.6																							
	TNMM270612-HDR	27.5	15.875	6.35	6.35	1.2																							
	TNMM270616-HDR	27.5	15.875	6.35	6.35	1.6																							
	TNMM270624-HDR	27.5	15.875	6.35	6.35	2.4																							
<b>Basic</b> 	TNMG110308	11	6.35	3.18	2.26	0.8	○																						
	TNMG160404	16.5	9.525	4.76	3.81	0.4		●	○																				
	TNMG160408	16.5	9.525	4.76	3.81	0.8		●	●	○																			
	TNMG160412	16.5	9.525	4.76	3.81	1.2		●	●	●																			
	TNMG220404	22	12.7	4.76	5.16	0.4			○	○																			
	TNMG220408	22	12.7	4.76	5.16	0.8			●	○																			
	TNMG220412	22	12.7	4.76	5.16	1.2			○	○	○																		
	TNMG220416	22	12.7	4.76	5.16	1.6			○	○																			
	TNMG270612	27.5	15.875	6.35	6.35	1.2			○	○	●																		
	TNMG270616	27.5	15.875	6.35	6.35	1.6			○	○	●																		
	TNMG330916	33	19.05	9.525	7.94	1.6			○	○	○																		
	TNMG330924	33	19.05	9.525	7.94	2.4			○	○	○																		

### Tool holder / Klemmhalter

<b>DTGNR/L</b> Kr:91°  Page/Seite A176	<b>PTFNR/L</b> Kr:90°  A188	<b>PTTNR/L</b> Kr:60°  A189	<b>PTGNR/L</b> Kr:90°  A190	<b>MTGNR/L</b> Kr:90°  A200	<b>MTJNR/L</b> Kr:93°  A201	<b>MTFNR/L</b> Kr:90°  A203
<b>PTFNR/L</b> Kr:90°  Page/Seite A244						

● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.





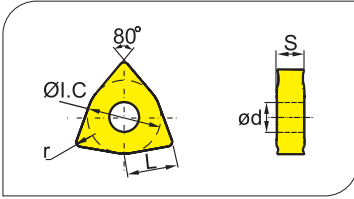


# Turning · Drehen



Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## WN\*\* Negative Insert · Negative WSP

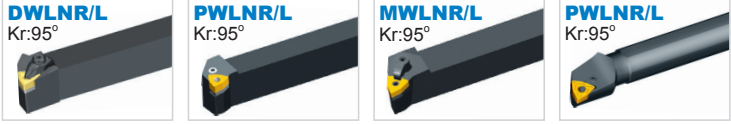
● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrous material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall						
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
 Finishing / Schlichten	WNUMG06T304-DF	6.5	9.525	3.97	3.81	0.4																						
	WNUMG06T308-DF	6.5	9.525	3.97	3.81	0.8																						
	WNUMG06T312-DF	6.5	9.525	3.97	3.81	1.2																						
	WNUMG060404-DF	6.5	9.525	4.76	3.81	0.4	○	●	●	●																		
	WNUMG060408-DF	6.5	9.525	4.76	3.81	0.8	○	●	●	●																		
	WNUMG060412-DF	6.5	9.525	4.76	3.81	1.2	○	●	○	○																		
	WNUMG080404-DF	8.7	12.7	4.76	5.16	0.4	○	●	●	●																		
	WNUMG080408-DF	8.7	12.7	4.76t	5.16	0.8	○	●	●	○																		
	WNUMG080412-DF	8.7	12.7	4.76	5.16	1.2	○	●	●	●																		
 Wiper	WNUMG060404-WG	6.5	9.525	4.76	3.81	0.4																						
	WNUMG060408-WG	6.5	9.525	4.76	3.81	0.8																						
	WNUMG060412-WG	6.5	9.525	4.76	3.81	1.2																						
	WNUMG080404-WG	8.7	12.7	4.76	5.16	0.4																						
	WNUMG080408-WG	8.7	12.7	4.76	5.16	0.8	●	●	●	●		○			○													
	WNUMG080412-WG	8.7	12.7	4.76	5.16	1.2	●	●	●	●																		

### Tool holder / Klemmhalter



Page/Seite A179      A191      A206      A245

● Ex Stock / ab Lager    ○ On demand / auf Anfrage    YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

**A**  
 General Turning / Allgemeine Drehbearbeitung

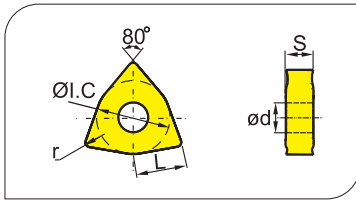


# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## WN\*\* Negative Insert · Negative WSP



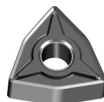
● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

**A**

General Turning  
Allgemeine Drehbearbeitung

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall															Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall													
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253	YBD052	YBD102			YBD152	YBD152C	YNG151	YNG151C	YD101	YD201								
 Medium Cut / Mittl. Bearb.	WNUMG060408-PM	6.5	9.525	4.76	3.81	0.8	○	●	●	●	○																										
	WNUMG060412-PM	6.5	9.525	4.76	3.81	1.2	○	●	●	●	○																										
	WNUMG080404-PM	8.7	12.7	4.76	5.16	0.4	○	●	●	●	○																										
	WNUMG080408-PM	8.7	12.7	4.76	5.16	0.8	○	●	●	●	●																										
	WNUMG080412-PM	8.7	12.7	4.76	5.16	1.2	○	●	●	●	●																										
	WNUMG080416-PM	8.7	12.7	4.76	5.16	1.6						○	○																								
 Medium Cut / Mittl. Bearb.	WNUMG06T304-DM	6.5	9.525	3.97	3.81	0.4																															
	WNUMG06T308-DM	6.5	9.525	3.97	3.81	0.8					●	○																									
	WNUMG06T312-DM	6.5	9.525	3.97	3.81	1.2																															
	WNUMG060408-DM	6.5	9.525	4.76	3.81	0.8	○	●	●	●	●					○	○	○																			
	WNUMG060412-DM	6.5	9.525	4.76	3.81	1.2	○	●	●	●	○					○	○																				
	WNUMG080404-DM	8.7	12.7	4.76	5.16	0.4	○	●	●	●	●																										
	WNUMG080408-DM	8.7	12.7	4.76	5.16	0.8	○	●	●	●	●			○		○	○	○																			
	WNUMG080412-DM	8.7	12.7	4.76	5.16	1.2	○	●	●	●	●					○	○	○																			
 Medium Cut / Mittl. Bearb.	WNUMG06T304-EM	6.5	9.525	3.97	3.81	0.4																															
	WNUMG06T308-EM	6.5	9.525	3.97	3.81	0.8																															
	WNUMG06T312-EM	6.5	9.525	3.97	3.81	1.2																															
	WNUMG060404-EM	6.5	9.525	4.76	3.81	0.4								○	●	●	●	●																			
	WNUMG060408-EM	6.5	9.525	4.76	3.81	0.8								○	●	●	●	○	●																		
	WNUMG080404-EM	8.7	12.7	4.76	5.16	0.4								○	●	○	●	○	●																		
	WNUMG080408-EM	8.7	12.7	4.76	5.16	0.8								○	●	○	●	○	●																		
	WNUMG080412-EM	8.7	12.7	4.76	5.16	1.2								○	●	●	●	●																			

### Tool holder / Klemmhalter



Page/Seite A179      A191      A206      A245

● Ex Stock / ab Lager    ○ On demand / auf Anfrage    YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.





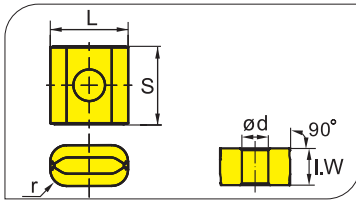


# Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

## Railway Wheel Machining/ Radsatz Bearbeitung

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall														Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall					
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253	YBD052			YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
	175.32-191940-22	19.05	10	19.05	6.35	4.0	○	●																				
	175.32-191940-227	19.05	10	19.05	7.2	4.0		○																				
	175.32-191940-24	19.05	10	19.05	6.35	4.0	○	●																				
	175.32-301940-24	30	10	19.05	6.35	4.0	○	○	●	○																		
	175.32-191940-25	19.05	10	19.05	6.35	4.0			○																			
	175.32-191940-28	19.05	10	19.05	6.35	4.0	○	●	●	●																		
	175.32-30194031	30	10	19.05	6.35	4.0			○	○																		

● Ex Stock / ab Lager    ○ On demand / auf Anfrage    YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

A  
General Turning  
Allgemeine Drehbearbeitung

# Turning · Drehen

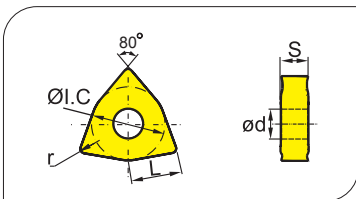
Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

**A**

General Turning  
Allgemeine Drehbearbeitung

## TN\*\* Negative Insert/ Negative WSP

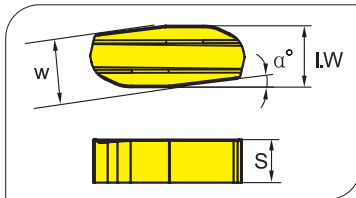
● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrous material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
	TNMX1106-2	11.3	15.875	6.35	6.35	1.6	●	○																				
	TNMX1509-2	15.9	22.225	9.52	7.94	1.6		○																				
	TNMX15T916-2	15.9	22.225	9.72	7.94	1.6		○																				

● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrous material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
	YNMX1812L	18	22	12	20°			○																				
	YNMX2518173L	25	25	18	7°			○																				
	YNUX1812150L	18	18	12	15°			○																				

