

ISO TURNING

Product Overview

Application Guide

Turning Holders Overview

Turning Holders

Turning Inserts Overview

Turning Inserts

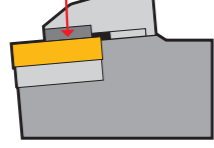
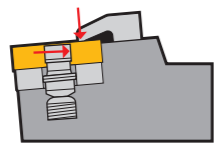
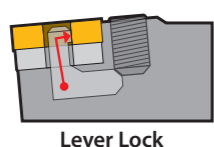
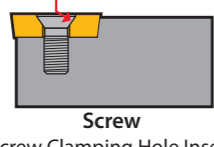
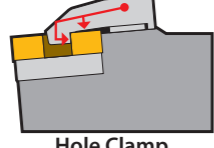
Turning - Name Code System

External Turning Holder Code (Metric)

*Metric

1	2	3	4	5	6	7	8	9	10
P	C	L	N	R	25	25	M	12	(C)
Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Shank Height (H)	Shank Width (B)	Length (LF)	Insert Size	(Optional Clamp)

1 - Clamping System

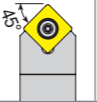

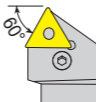
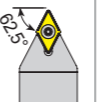

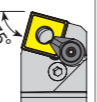
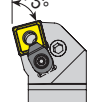
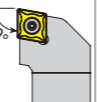
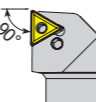

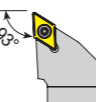
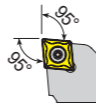
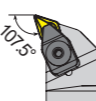
Symbol	System
C	 Top Clamp (No Clamping Hole Insert)
M	 Pin & Top Clamp (Straight Clamping Hole Insert)
P	 Lever Lock (Straight Clamping Hole Insert)
S	 Screw (Screw Clamping Hole Insert)
T (D, A)	 Hole Clamp (Straight Clamping Hole Insert)

2, 4 — Insert Compatibility *



* Related to Insert Designation to check compatibility

3 - Tool Style

Approach Angle (KAPR)	Side Direction		End Direction
	Straight Shank	Offset Shank	
45°	D 	S 	
60°		T 	
63°	N 		
72.5°	V 		
75°	B 		K 
90°	A 	G 	F 
93°		J 	U
95°		L (Both Direction) 	
107.5°		H 	

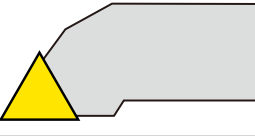
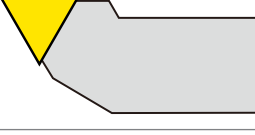
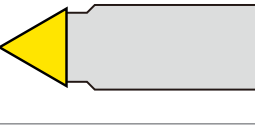
Turning - Name Code System

External Turning Holder Code (Metric)

*Metric

1	2	3	4	5	6	7	8	9
S	D	J	C	R	20	20	K	11
Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Shank Height (H)	Shank Width (B)	Length (LF)	Insert Size

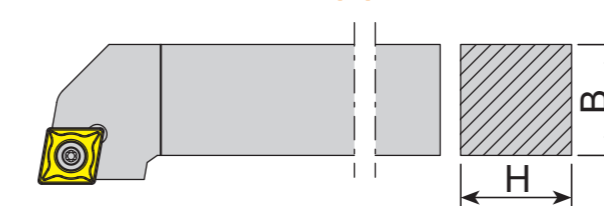
5 - Hand Direction

Symbol	Hand Direction
R	Right Hand 
L	Left Hand 
N	Neutral 

8 - Length (LF)

Symbol	Length (mm)	Symbol	Length (mm)
E	70	Q	180
F	80	R	200
H	100	S	250
K	125	T	300
M	150	U	350
P	170	V	400

**6, 7 - Shank Height (H)
Shank Width (B)**



9 - Insert Size *

Examples	is Compatible with...
PCLNR 2525M 12	CNMG 120408
SCLCR 2020K 09	CCMT 09T308
TWLNLR 2525M 08	WNMG 080408

* Related to Insert Designation to check compatibility

(10 - Optional Clamp)

Symbol	Optional Clamp
C	Included

Turning - Name Code System

Internal Turning Holder Code (Metric)

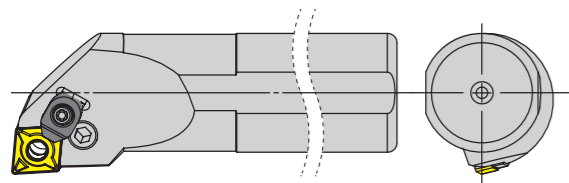
*Metric

1	2	3	-	4	5	6	7	8	9	10
A	32	S	-	P	W	L	N	R	12	(C)
Coolant & Material	Shank Diameter (DCON)	Legth (LF)		Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Insert Size	(Optional Clamp)

1 - Coolant and Tool Material

Symbol	Internal Coolant	Tool Material
A	O	Steel
S	X	
E	O	Carbide

2 - Shank Diameter (DCON)



3 - Length (LF)

Symbol	Length (mm)	Symbol	Length (mm)
E	70	Q	180
F	80	R	200
H	100	S	250
K	125	T	300
M	150	U	350
P	170	V	400

4 - Clamping System

Symbol	System
C	 Top Clamp (No Clamping Hole Insert)
M	 Pin & Top Clamp (Straight Clamping Hole Insert)
P	 Lever Lock (Straight Clamping Hole Insert)
S	 Screw (Screw Clamping Hole Insert)
T (D, A)	 Hole Clamp (Straight Clamping Hole Insert)

Turning - Name Code System

Internal Turning Holder Code (Metric)

*Metric

1	2	3	-	4	5	6	7	8	9
A	25	R	-	S	C	L	C	R	09
Coolant & Material	Shank Diameter (DCON)	Legth (LF)		Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Insert Size

6 - Tool Style

Approach Angle (KAPR)	Side Direction	End Direction
	Offset Shank	
75°		K
90°		F
93°	J	U
95°	L (Both Direction)	
107.5°		Q

8 - Hand Direction

Symbol	Hand Direction
R	Right Hand
L	Left Hand
N	Neutral

9 - Insert Size *

Examples	is Compatible with...
PCLNR 2525M 12	CNMG 120408
SCLCR 2020K 09	CCMT 09T308
TWLNR 2525M 08	WNMG 080408

* Related to Insert Designation to check compatibility

5, 7 - Insert Compatibility *



* Related to Insert Designation to check compatibility

(10 - Optional Clamp)

Symbol	Optional Clamp
C	Included

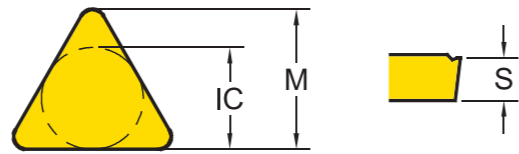
Insert ISO Code System

*Metric : According to ISO 1832

1	2	3	4	5	6	7	8	9
C	N	M	G	12	04	08	-UG	YG3020
Shape	Clearance	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

1 - Shape

Symbol	Shape	
H	Hexagonal	
O	Octagonal	
P	Pentagonal	
S	Square	
T	Triangular	
C	Rhombic 80°	
D	Rhombic 55°	
V	Rhombic 35°	
W	Trigon	
L	Rectangular	
K	Parallelogram 55°	
R	Round	



3 - Tolerance Class

Symbol	Inner Circle IC (mm)	Nose Height M (mm)	Thickness S (mm)
C	± 0.025	± 0.013	± 0.025
E	± 0.025	± 0.025	± 0.025
G	± 0.025	± 0.025	± 0.13
H	± 0.013	± 0.013	± 0.025
K*	± 0.05~0.15*	± 0.013	± 0.025
M*	± 0.05~0.15*	± 0.08~0.2*	± 0.13
U*	± 0.08~0.25*	± 0.13~0.38*	± 0.13

*Tolerance is different by insert IC size. Please see ISO 1832

4 - Clamping & Chipbreaker

Symbol	Clamping	Chipbreaker	Figure
N	No clamping hole	X	
R		One Face	
A	Cylindrical Clamping hole	X	
M		One Face	
G		Both Faces	
W	Screw Hole	X	
T		One Face	
U		Both Faces	
X		Special	

2 - Relief Angle (AN)

Symbol	Relief Angle (AN)	
N	No Relief Angle	
B	Relief 5°	
C	Relief 7°	
P	Relief 11°	
D	Relief 15°	
E	Relief 20°	
F	Relief 25°	
O	Special	

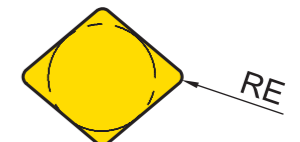
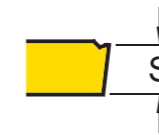
Insert ISO Code System

*Inch

1	2	3	4	5	6	7	8	9
C	N	M	G	4	3	2	-UG	YG3020
Shape	Clearance	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

5 - Insert Size

Metric							Inner Circle IC (mm)	Inch
S	T	C	D	V	W	R		
06	11	06	07	11			6.35	2
07							7.94	2.5
09	16	09	11	16	06	09 (00)	9.525	3
12	22	12	15	22	08	12 (00)	12.7	4
15		16					15.875	5
19		19					19.05	6
25		25					25.4	8
						06 (M0)	6	
						08 (M0)	8	
						10 (M0)	10	
						12 (M0)	12	
						16 (M0)	16	



6 - Insert Thickness (S)

Metric	Thickness - S (mm)	Inch
T1	1.98	1.2
02	2.38	1.5
03	3.18	2
T3	3.97	2.5
04	4.76	3
05	5.56	3.5
06	6.35	4
07	7.94	5
09	9.525	6

7 - Corner Radius (RE)

Metric	Corner Radius - RE (mm)	Inch
01	0.1	0
02	0.2	0.5
04	0.4	1
08	0.8	2
12	1.2	3
16	1.6	4
20	2.0	5
24	2.4	6

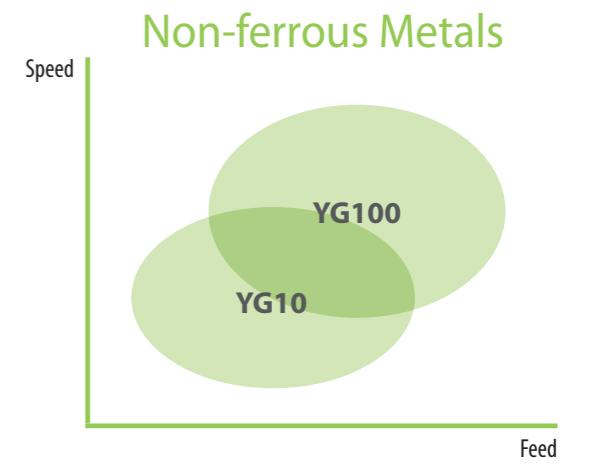
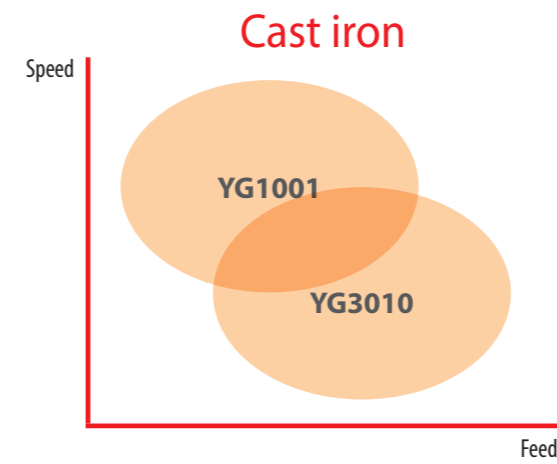
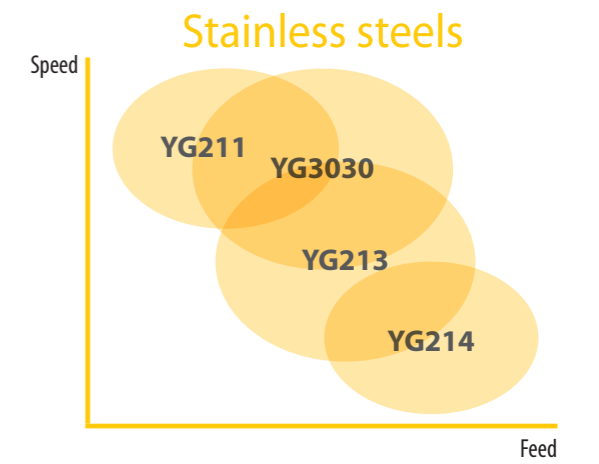
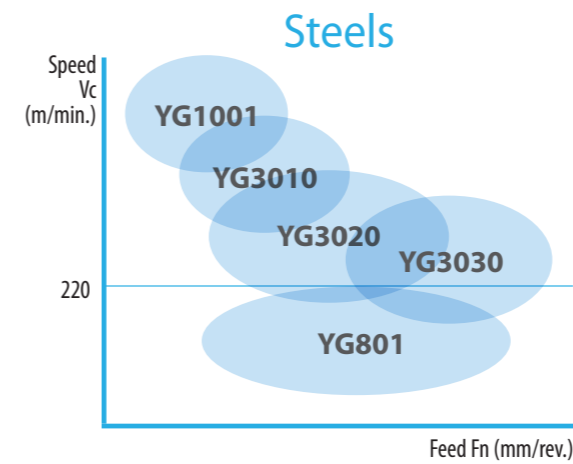
Product Overview Turning Grades

Turning Grades	P Steel				M Stainless steel			K Cast iron			N Non-ferrous		S Superalloys	
	P10	P20	P30	P40	M10	M20	M30	K10	K20	K30	N10	N20	S10	S20
CVD	YG1001	1001						1001						
	YG3010		3010					3010						
	YG3020			3020										
	YG3030				3030									
PVD	YG801	801												
	YG211					211							211	
	YG213						213							213
	YG214							214						214
DLC	YG100										100			
	YG10										10			

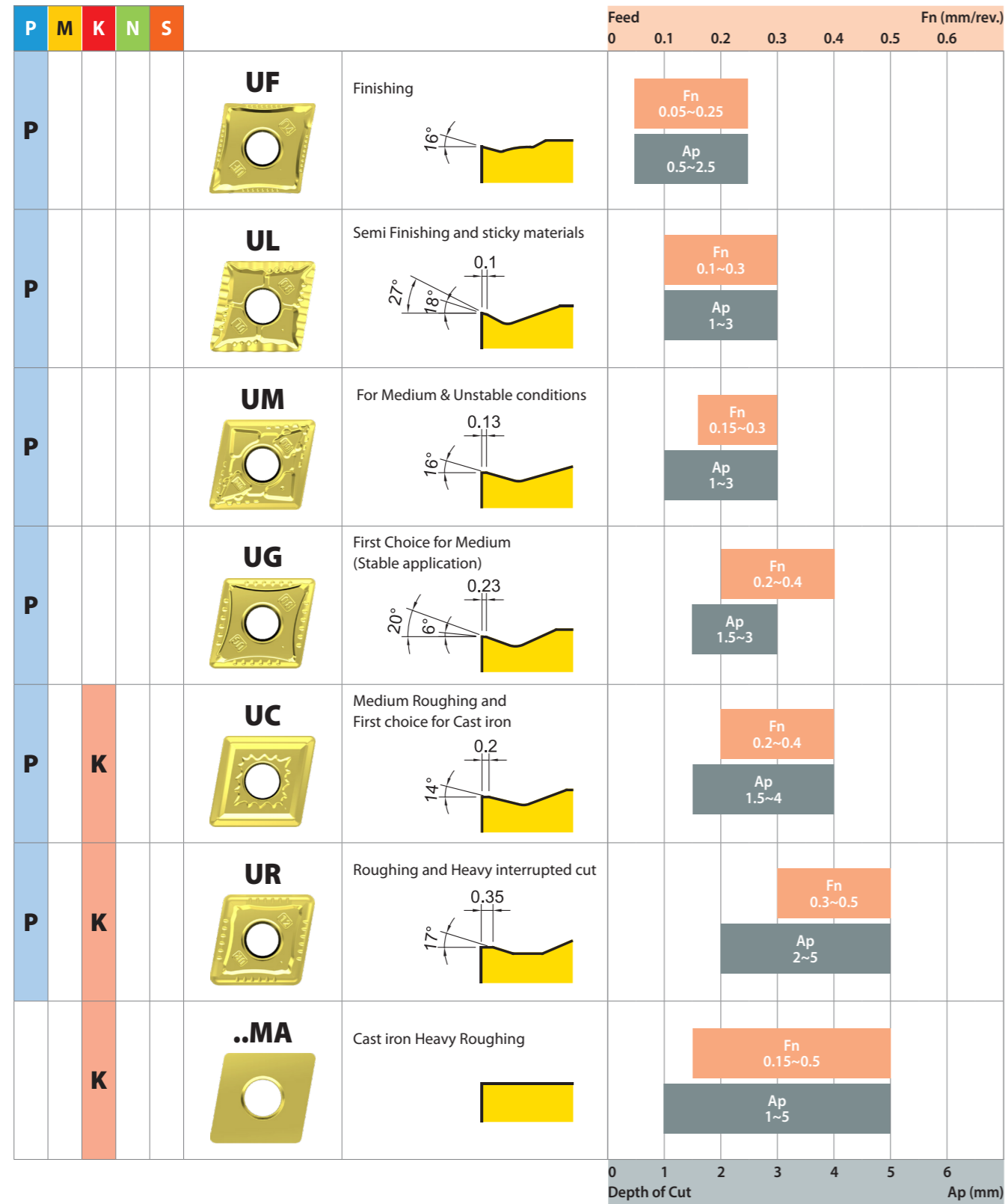
YG1001 P01 - P10 K10 - K25	<p>CVD TiCN - Al₂O₃</p>	First choice for stable machining of Cast iron <ul style="list-style-type: none"> Substrate especially designed for high wear resistance Thick Al₂O₃ layer ensures good wear resistance at high cutting speeds including dry machining
YG3010 P05 - P20 K15 - K35	<p>CVD TiCN - Al₂O₃</p>	First choice for Finishing Steels, and Ductile Cast iron <ul style="list-style-type: none"> Finishing and light machining of steel under in stable condition New Al₂O₃ coating technology and excellent surface smoothness increase wear resistance and chipping resistance
YG3020 P15 - P30	<p>CVD TiCN - Al₂O₃</p>	First Choice grade for general Steel application <ul style="list-style-type: none"> Substrate especially designed for good toughness Excellent surface smoothness increases wear resistance and reliability
YG3030 P20 - P35 M10 - M30	<p>CVD TiCN - Al₂O₃</p>	Interrupted cut of Steel and Stainless steel <ul style="list-style-type: none"> Heavy interrupted cut for Steel High cutting speed for Stainless steel
YG801 P10 - P30	<p>PVD - TiAlN</p>	for Carbon Steel with Low cutting speed <ul style="list-style-type: none"> Recommended for mild steel and boring application Substrate and special PVD coating for excellent wear resistance
YG100 N05 - N25	<p>DLC</p>	First Choice grade for aluminum with DLC coating <ul style="list-style-type: none"> Submicron carbide for high wear resistance DLC coating minimizes Built Up Edge tendency. Improve tool life in sticky non-ferrous alloy
YG10 N05 - N25	<p>Uncoated</p>	Uncoated Grade for General Aluminum <ul style="list-style-type: none"> Substrate consisted of submicron carbide for high wear resistance Shining surface to prevent built up edge

Product Overview Turning Grade Map

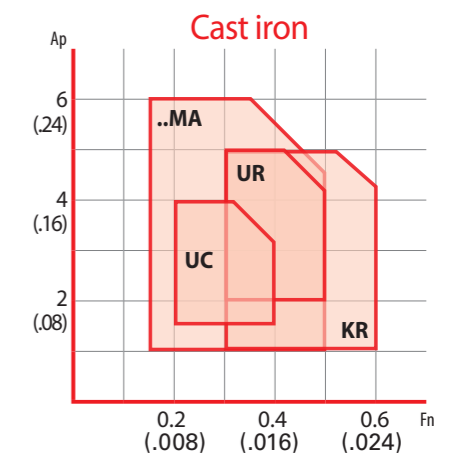
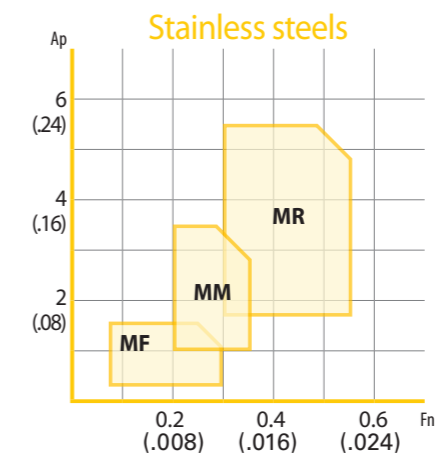
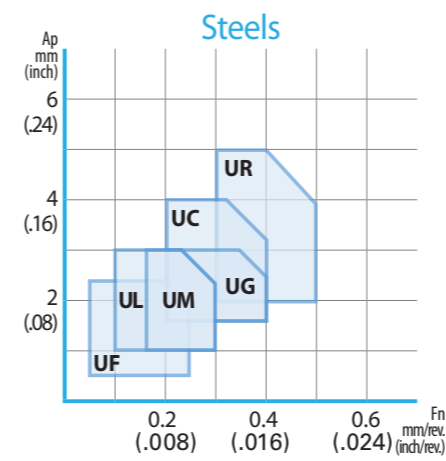
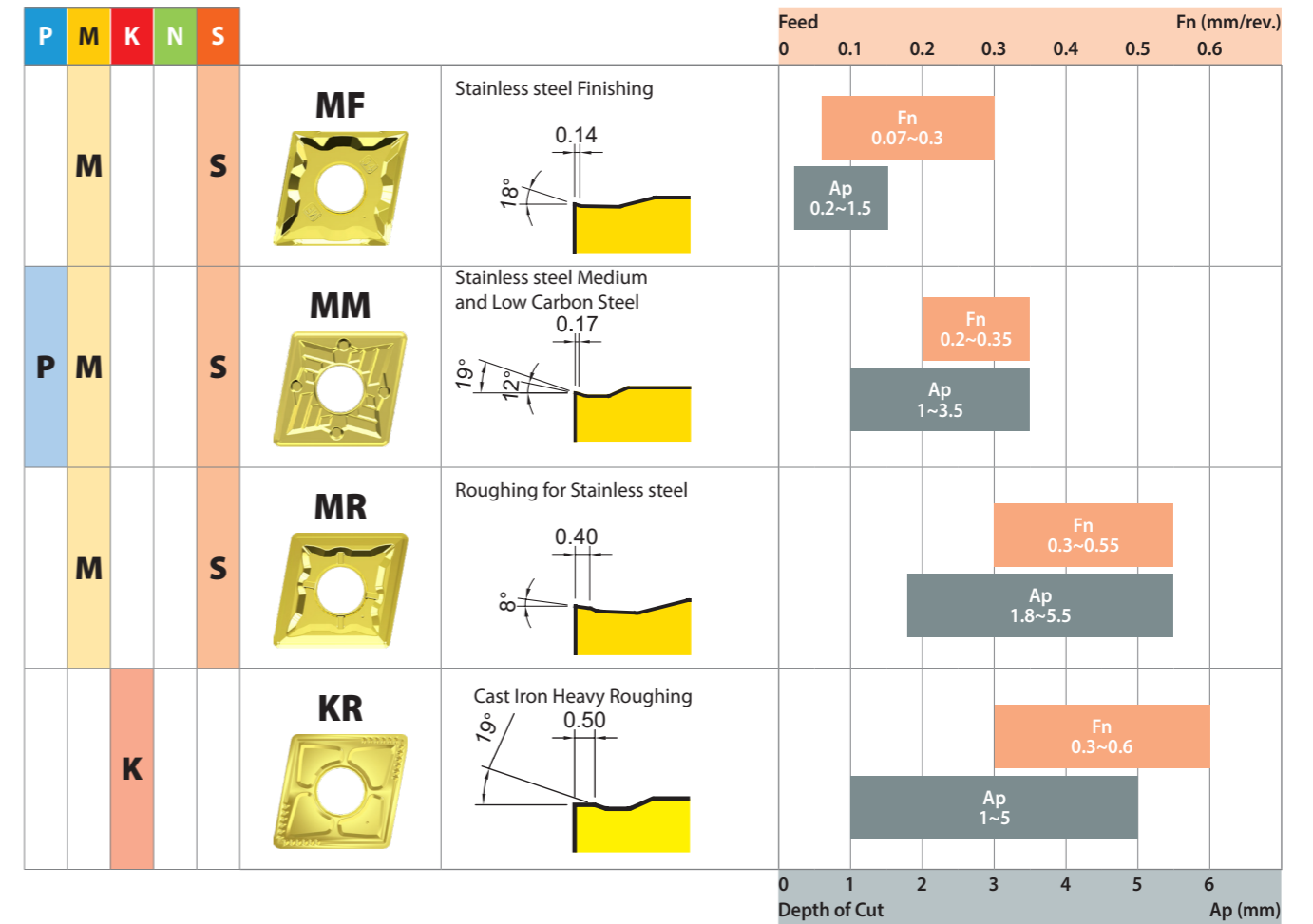
YG211 M05 - M25 S05 - S20		High wear resistance grade for Super alloys and Stainless steel <ul style="list-style-type: none"> Finishing Stainless steel Finishing Super alloys and Titanium
YG213 M20 - M35 S15 - S25		First Choice Grade on low cutting speed of Stainless steel <ul style="list-style-type: none"> First choice on Stainless steel for Low cutting speed For Medium to low cutting speed
YG214 M30 - M40 S25 - S30		Heavy Interrupted cut for Stainless steel <ul style="list-style-type: none"> For Heavy Interrupted cut on Stainless steel Minimize risk of Mechanical fracture or Chipping



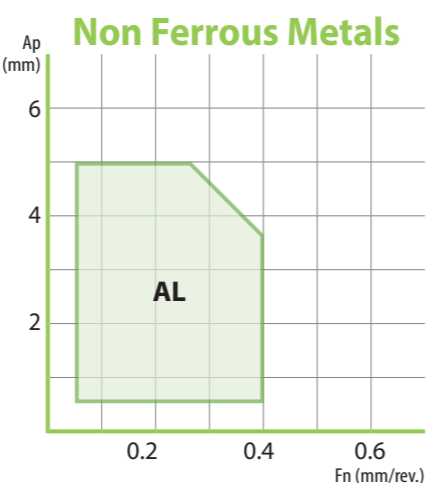
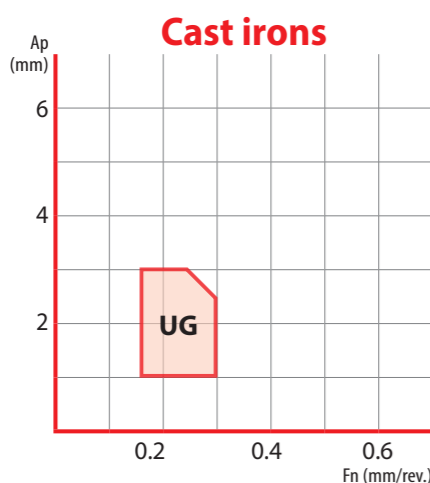
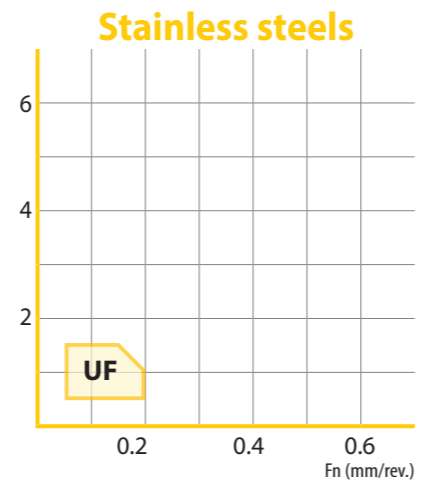
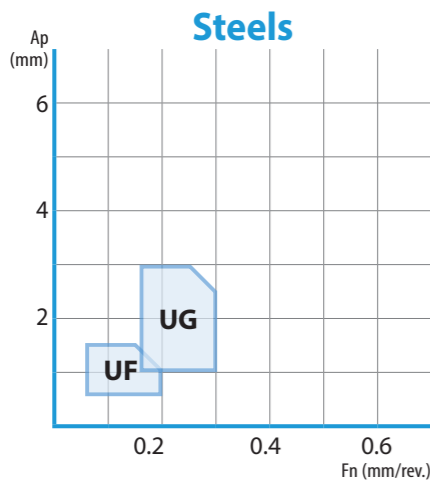
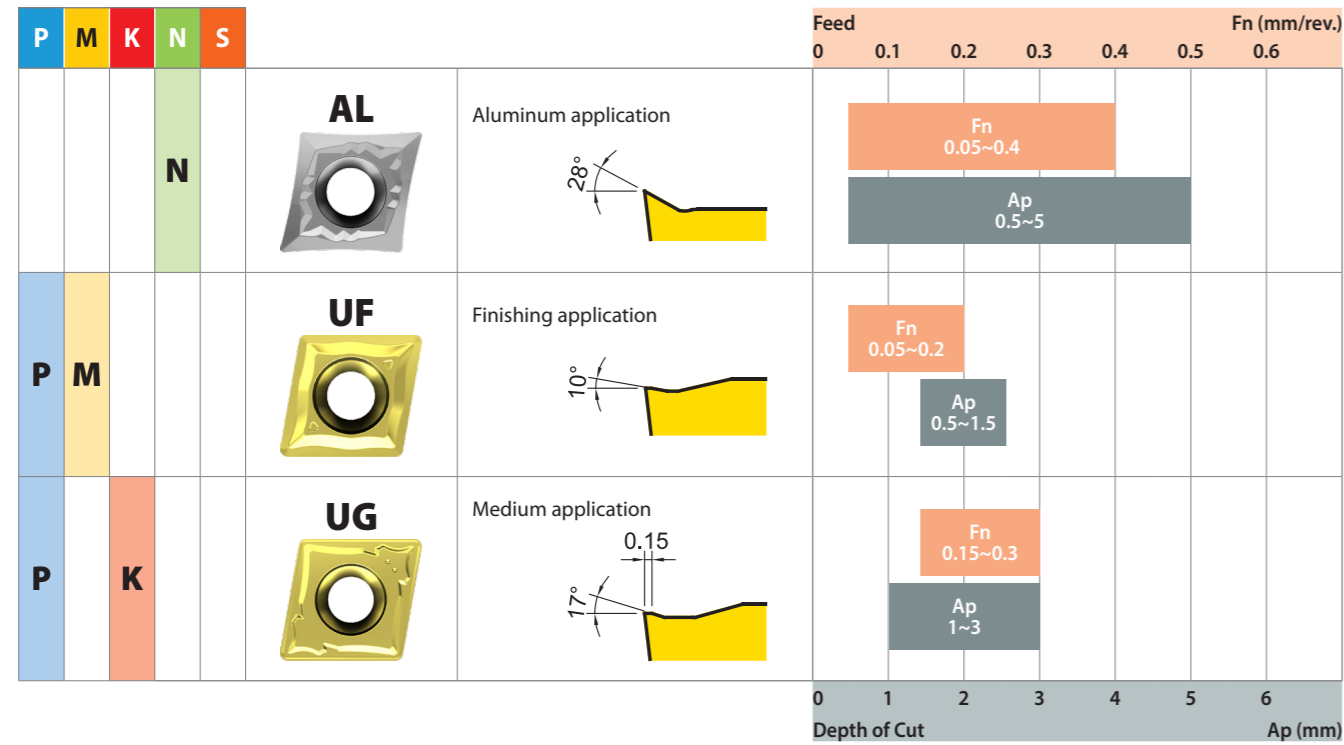
Turning Chipbreakers - Negative



Turning Chipbreakers - Negative



Product Overview
Turning Chipbreakers - Positive



Application Guide
Steel Guide

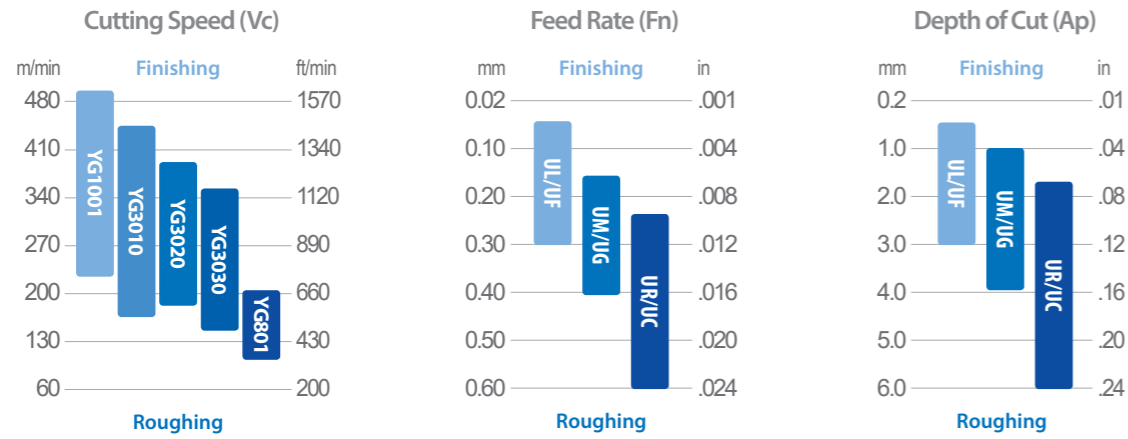
Grade Recommendation based on Workpiece Material Condition

	Pre Machined Condition No Outer Skin Uniform hardness on material Has stable machining condition	 YG3010 YG3020 YG3030
	Welded Condition Soft / No Outer Skin Weld Bead Could be of Different Hardness than Actual Part Stock on Part could even except weld Seam during Machining causing shock loads	
	Cast Condition Hard Outer Skin Could have Sand Inclusion,- if Green Sand Cast Component could have uneven Stock during machining	
	Hot Rolled Condition Soft / No Outer Skin Usually heat treated before machine to reduce Hardness Component could have uneven Stock During Machining	
	Forged Condition Soft Outer Skin Usually heat treated before machine to reduce Hardness Component could have uneven Stock during machining	

Chipbreaker, Feed Rate and Depth of Cut

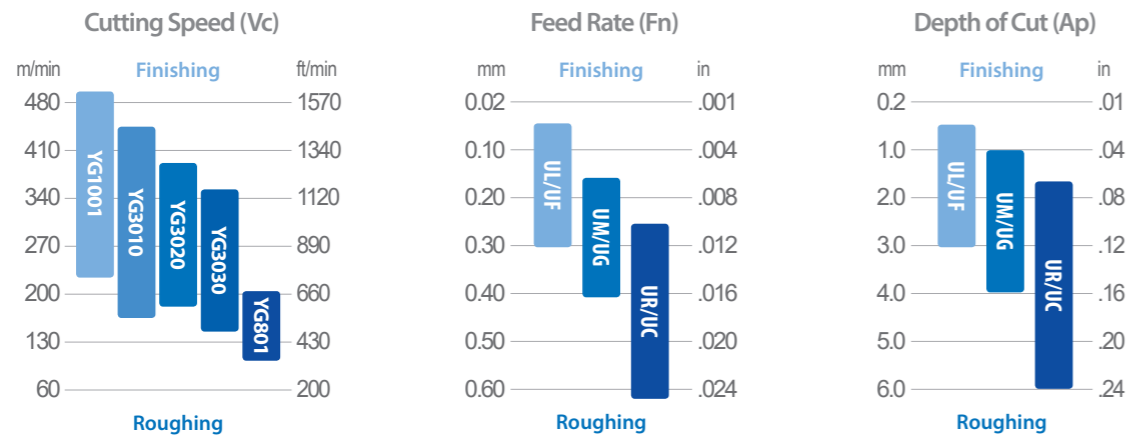
		Sharp Edge	General	Strong Edge
	Continuous	-UF	-UL	-UM
	General			-UG
	Heavy Interrupt			-UC

P	Non Alloy Steel, About 0.15% C (Low Carbon Steel)									
VDI	JIS	DIN	Mat'l No.	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST
1	S15C	CK15	1.0401	1015	1350	XC18	C15	F.1110	080M15	15



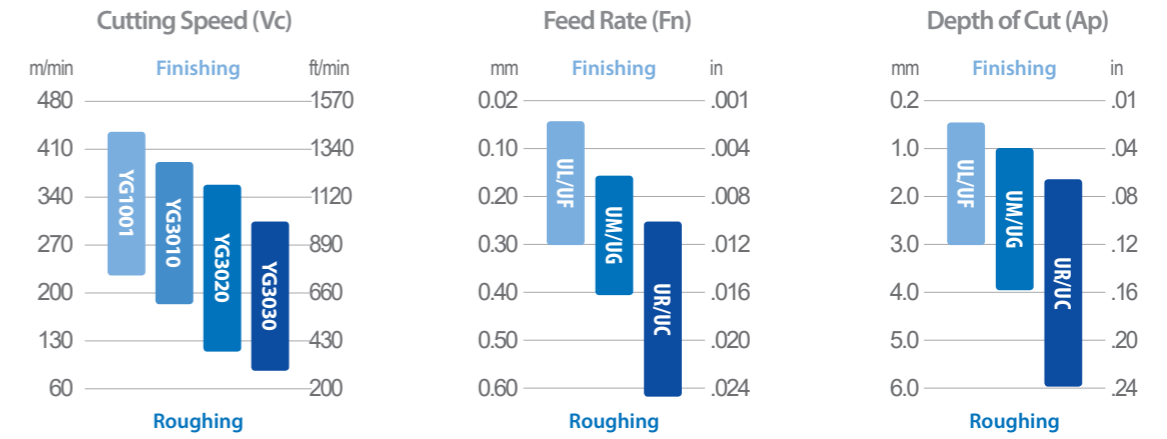
First Choice Grade and Value
 YG3010 - Vc 330m/min (1,080ft/min)
 YG801 - Vc 170m/min (560ft/min)

P	Non Alloy Steel, About 0.45% C (Medium Carbon Steel)									
VDI	JIS	DIN	Mat'l No.	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST
2-3	S45C	C45	1.0503	1045	1672	XC42H1TS	C45	F.1140	060A47	45



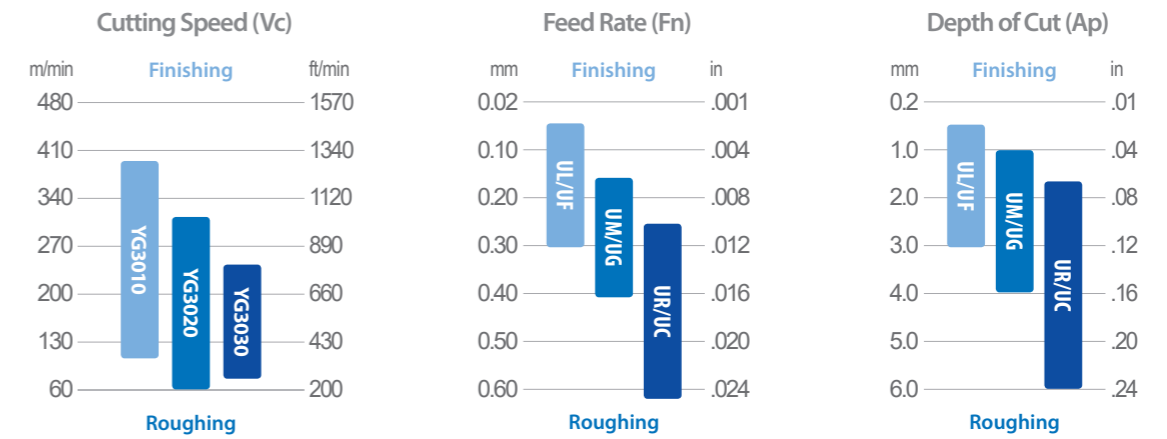
First Choice Grade and Value
 YG3010 - Vc 330m/min (1,080ft/min)
 YG801 - Vc 170m/min (560ft/min)

P	Low-alloyed Steel									
VDI	JIS	DIN	Mat'l No.	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST
6-9	SCM440	42CrMo4	1.7225	4140	2244	42 CD 4	42CrMo4	F.1252	708M40	38HM



First Choice Grade and Value
 YG3020 - Vc 240m/min (790ft/min)

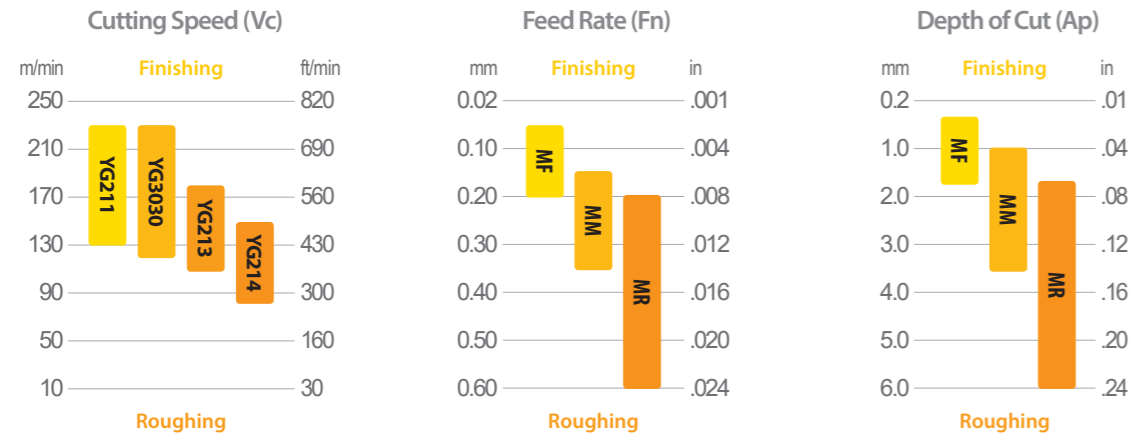
P	High Alloyed Steel, and Tool Steel									
VDI	JIS	DIN	Mat'l No.	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST
10-11	SKD11	X155CrVMo121	1.2379	D2	2310	Z160CDV12	X165CrMoW12KU	F.5318	BD2	KH12MF



First Choice Grade and Value
 YG3020 - Vc 230m/min (750ft/min)

Application Guide Stainless steel Guide

M	Ferritic / Martensitic Stainless									
VDI	JIS	DIN	Mat'l No.	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST
12-13	SUS430	X6Cr17	1.4016	430	2320	Z8C17	Z8C17	F3113	430S15	12C17



First Choice Grade and Value

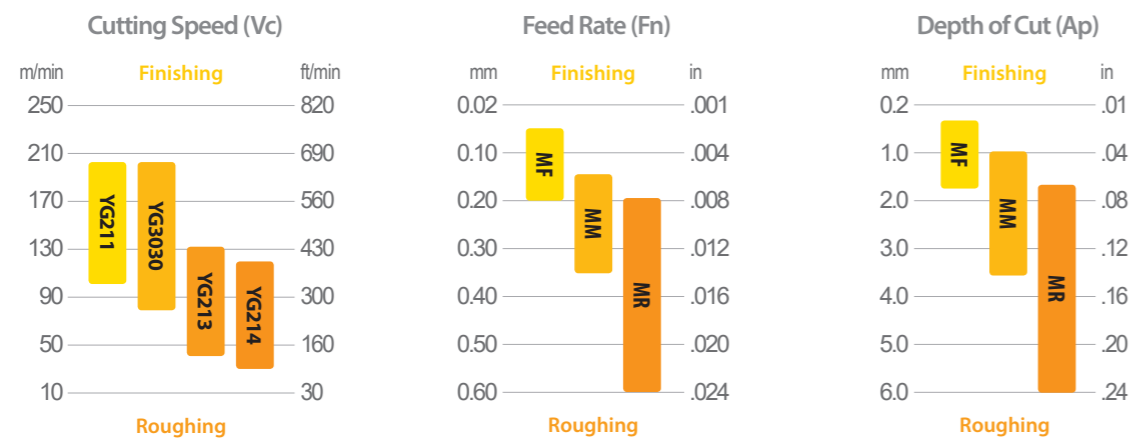
Ferritic Stainless steel

YG3030 - Vc 200m/min (660ft/min)
YG213 - Vc 160m/min (520ft/min)

Martensitic

YG3030 - Vc 160m/min (520ft/min)
YG213 - Vc 130m/min (430ft/min)

M	Austenitic Stainless steel									
VDI	JIS	DIN	Mat'l No.	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST
14	SUS304	X5CrNi18 9	1.4350	304	2332	Z6CN18 09	X5CrNi18 10	F3551	304S15	03KH18N11



First Choice Grade and Value

YG3030 - Vc 180m/min (590ft/min)
YG213 - Vc 140m/min (460ft/min)

Application Guide Cast iron Guide

K	Grey cast iron									
VDI	JIS	DIN	Mat'l No.	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST
15-16	FC250	GG25	0.6025	A48 40 B	0125	Ft 25 D	G25	FG25	Grade 260	Sc 25



First Choice Grade and Value

YG1001 - Vc 350m/min (1,150ft/min)

K	Nodular cast iron									
VDI	JIS	DIN	Mat'l No.	AISI/ASTM	SS	AFNOR	UNI	UNE	BS	GOST
17-18	FCD500	GGG50	0.7050	80-55-06	0.7050	FGS 500-7	GS 500-7	FGE50-7	SNG 500-7	Vc 50-2



First Choice Grade and Value

YG3010 - Vc 220m/min (720ft/min)

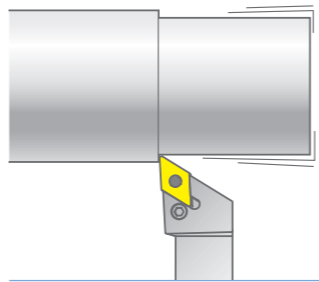
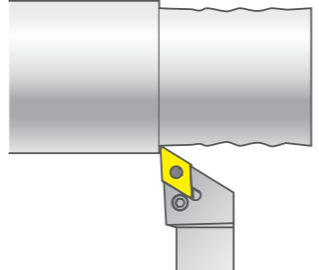
Formulas

Cutting Speed (Vc)	Metric $Vc = D \times RPM \times 0.0031$ (m/min)
	Inch $Vc = D \times RPM \times .262$ (ft/min)
	Metric Vc to Inch Vc $Inch\ Vc = Metric\ Vc \times 3.28$ (ft/min)
	Inch Vc to Metric Vc $Metric\ Vc = Inch\ Vc \times .305$ (m/min)
Spindle Speed (RPM)	Metric $RPM = Vc \times 318.3 \div D$ (rev/min)
	Inch $RPM = Vc \times 3.82 \div D$ (rev/min)
Feed Rate (Vf = Table Feed)	$Vf = Fn \times RPM$ (mm/min or in/min)
Feed per Revolution (Fn)	$Fn = Vf \div RPM$ (mm/min or in/min)
Metal Removal Rate (Q)	Metric $Q = Vc \times Fn \times Ap$ (cm ³ /min)
	Inch $Q = Vc \times Fn \times Ap \times 12$ (in ³ /min)
Cutting Time	$T = L \div Vf$ (min)

Terms

RPM (n)	Spindle Speed (Revolution per minute)
Vc	Cutting Speed
D	Work Diameter
Vf	Feed Rate (Table Feed)
Fn	Feed per Revolution
Ap	Depth of Cut
Q	Metal Removal Rate
L	Length of cut
T	Cutting Time (min)

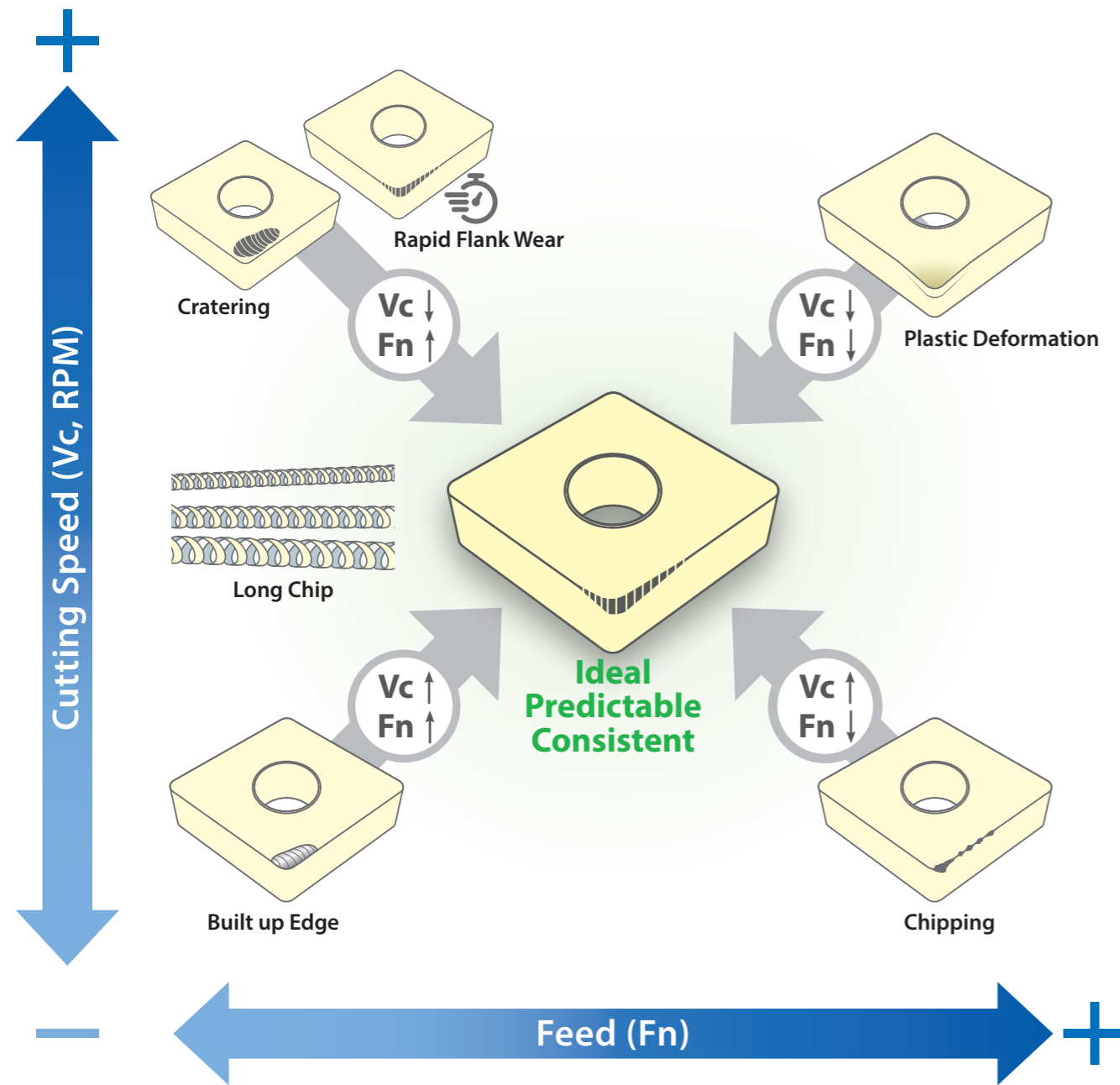
Trouble Shooting

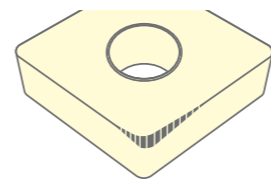
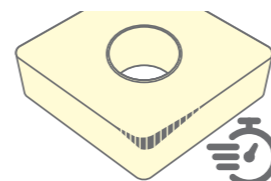
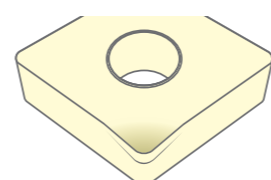
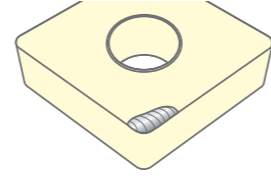
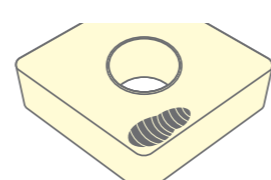
Pattern	Reasons	Solutions
Vibration 	<ul style="list-style-type: none"> - High radial or tangential force - Unstable condition 	<ul style="list-style-type: none"> - Lower depth of cut (ap) - Use sharper chipbreaker - Check stability, and position of tool and workpiece - Reduce the overhang (bigger and shorter tool)
Bad Surface 	<ul style="list-style-type: none"> - Work material is damaged by chips - Feed is too high for corner radius 	<ul style="list-style-type: none"> - Different chipbreaker - Lower depth of cut (ap) - Lower feed - Bigger corner radius

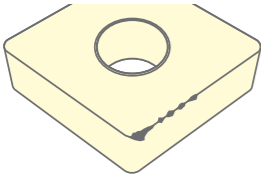
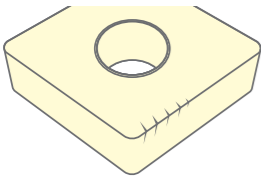
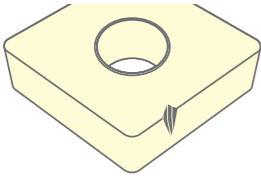
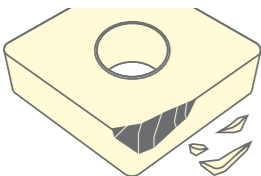
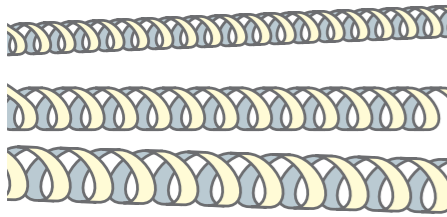
Theoretical Surface Roughness


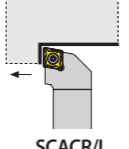
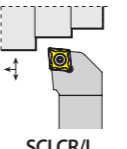

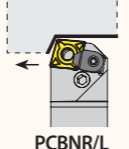
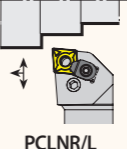
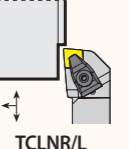

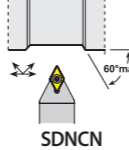
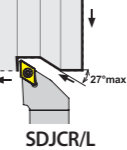

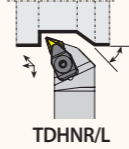
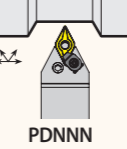
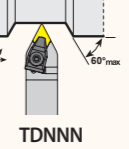
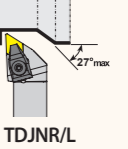
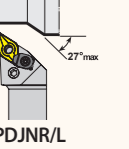

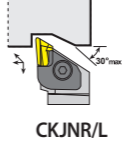

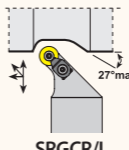
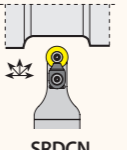

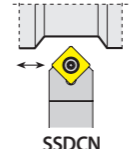

Ra / Rz μm (μ inch)	Insert Corner Radius Code ISO (ANSI)					
	02 (0)	04 (1)	08 (2)	12 (3)	16 (4)	24 (6)
	Feed Rate mm/rev (inch/rev)					
0.4 / 1.6 (16 / 64)	0.05 (.002)	0.07 (.003)	0.1 (.004)	0.12 (.005)	0.14 (.006)	0.18 (.007)
1.6 / 6.3 (64 / 256)	0.1 (.004)	0.14 (.006)	0.2 (.008)	0.25 (.010)	0.28 (.011)	0.35 (.014)
3.2 / 12.5 (128 / 512)	0.14 (.006)	0.2 (.008)	0.28 (.011)	0.35 (.014)	0.4 (.016)	0.49 (.019)
6.3 / 25 (250 / 1000)	-	0.28 (.011)	0.4 (.016)	0.49 (.019)	0.57 (.022)	0.69 (.027)
8 / 32 (320 / 1280)	-	-	0.45 (.018)	0.55 (.022)	0.64 (.025)	0.78 (.031)

Trouble Shooting Guide map



Pattern	Reasons	Solutions
<p>General Flank Wear</p>  <p>Flank face near by corner is abraded</p>	<ul style="list-style-type: none"> - The most ideal wear - Consistent and predictable - General wear behavior when machining condition is normal 	
<p>Rapid Flank Wear</p>  <p>Looks same as general flank wear, but happens quickly</p>	<p>Grade</p> <ul style="list-style-type: none"> - Not enough wear resistance - Too tough grade <p>Heat</p> <ul style="list-style-type: none"> - Cutting speed is too high - Not enough coolant 	<ul style="list-style-type: none"> - More wear resistant grade - Reduce the cutting speed (Vc, SFM, RPM or SFPM) - Optimize coolant - Increase Feed (Fn) if feed is low
<p>Plastic Deformation</p>  <p>Deformed Edge</p>	<ul style="list-style-type: none"> - Excess thermal load - Excess mechanical load 	<ul style="list-style-type: none"> - Reduce cutting temperature - More wear resistant grade - Reduce the cutting speed (Vc, SFM, RPM or SFPM) - Lower feed (Fn) - Lower depth of cut (ap) - Optimize coolant
<p>Built up Edge</p>  <p>Workpiece material is welded on the cutting edge</p>	<ul style="list-style-type: none"> - Sticky materials (low carbon steel, Stainless steel, non-ferrous metal, heat resistant super alloys) - Too low cutting speed 	<ul style="list-style-type: none"> - Increase cutting speed - Lower feed rate - Sharper chipbreaker & geometry - Use high pressure coolant - Use PVD grade - Use Positive Insert
<p>Cratering</p> 	<p>Heat</p> <ul style="list-style-type: none"> - Cutting speed is too high - Too tough grade 	<ul style="list-style-type: none"> - Reduce cutting temperature - Lower cutting speed (Vc, SFM, RPM or SFPM) - Adjust Feed (Fn) - Harder grade

Pattern	Reasons	Solutions
<p>Chipping</p> 	<ul style="list-style-type: none"> - Unstable machining condition (Vibration) - Grade is too hard / brittle - Grade is too sharp 	<ul style="list-style-type: none"> - Focus on stabilizing cutting condition - Reduce overhang (shorter and bigger tool) - Tougher grade - Tougher chipbreaker
<p>Thermal Crack</p> 	<ul style="list-style-type: none"> - Thermal stress due to rapid change of temperature 	<ul style="list-style-type: none"> - Tougher grade - Lower cutting speed (Vc, SFM, RPM or SFPM) - Lower feed (Fn) - Sharper chipbreaker - Change coolant / dry cut
<p>Notching</p> 	<ul style="list-style-type: none"> - Improved edge strength work piece has hardened skin 	<ul style="list-style-type: none"> - More wear resistant grade - Reduce the cutting speed (Vc, SFM, RPM or SFPM) - Adjust Feed (Fn) - Lower depth of cut (ap) - Optimize coolant - Go for tougher chipbreaker
<p>Breakage (Mechanical Fracture)</p> 	<ul style="list-style-type: none"> - Mechanical load is too heavy (feed or depth is too high) - Heavy interrupted cut - Grade is too hard for work material - Unstable machining(vibration) - Cutting speed is too low - Impurities in work material 	<ul style="list-style-type: none"> - Lower feed (Fn)or depth of cut (ap) - Tougher grade - Reduce overhang and check stability of tool and work material - Higher cutting speed (Vc, SFM, RPM or SFPM)
<p>Long Chip</p> 	<ul style="list-style-type: none"> - Feed is too low for chipbreaker - Depth of cut is too shallow for corner radius - Chip area (Fn x Ap) too low 	<ul style="list-style-type: none"> - Higher feed - Sharper chipbreaker - Higher depth of cut - Select a smaller corner radius

Series	Turning Holder				
 <p>CCGT CCMT</p> <p>p. 78</p>	 <p>SCACR/L</p> <p>Screw</p> <p>p. 29</p>	 <p>SCLCR/L</p> <p>Screw</p> <p>p. 29</p>			
 <p>CNMA CNMG</p> <p>p. 60</p>	 <p>PCBNR/L</p> <p>Lever</p> <p>p. 30</p>	 <p>PCLNR/L</p> <p>Lever (+Clamp)</p> <p>p. 30</p>	 <p>TCLNR/L</p> <p>Hole Clamp</p> <p>p. 30</p>		
 <p>DCGT DCMT</p> <p>p. 79</p>	 <p>SDNCN</p> <p>Screw</p> <p>p. 31</p>	 <p>SDJCR/L</p> <p>Screw</p> <p>p. 31</p>			
 <p>DNMA DNMG</p> <p>p. 63</p>	 <p>TDHNR/L</p> <p>Hole Clamp</p> <p>p. 32</p>	 <p>PDNNN</p> <p>Lever (+Clamp)</p> <p>p. 32</p>	 <p>TDNNN</p> <p>Hole Clamp</p> <p>p. 32</p>	 <p>TDJNR/L</p> <p>Hole Clamp</p> <p>p. 32</p>	 <p>PDJNR/L</p> <p>Lever (+Clamp)</p> <p>p. 32</p>
 <p>KNUX</p> <p>p. 66</p>	 <p>CKJNR/L</p> <p>Top Clamp</p> <p>p. 33</p>				
 <p>RCMT</p> <p>p. 80</p>	 <p>SRGCR/L</p> <p>Screw</p> <p>p. 34</p>	 <p>SRDCN</p> <p>Screw</p> <p>p. 34</p>			
 <p>SCMT</p> <p>p. 81</p>	 <p>SSDCN</p> <p>Screw</p> <p>p. 35</p>	 <p>SSSCR/L</p> <p>Screw</p> <p>p. 35</p>			


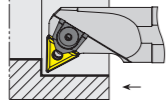
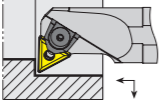
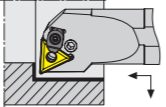
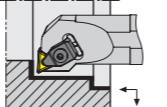

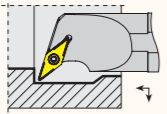
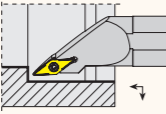
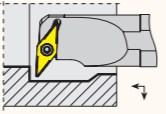

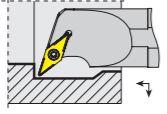
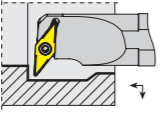

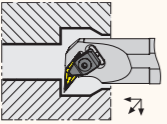

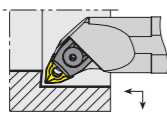
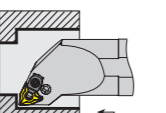
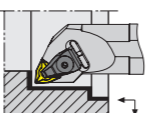
Turning - Holder - External External Holders Overview

Series	Turning Holder			
SNMA SNMG	PSDNN Lever (+Clamp)	TSDNN Hole Clamp	PSSNR/L Lever (+Clamp)	TSSNR/L Hole Clamp
p. 67	p. 36	p. 36	p. 36	p. 36
TCGT TCMT	STFCR/L Screw	STGCR/L Screw	STJCR/L Screw	STUCR/L Screw
p. 82	p. 37	p. 37	p. 37	p. 37
TNMA TNMG TNUX	PTTNR/L Lever (+Clamp)	PTFNR/L Lever (+Clamp)	PTGCR/L Lever (+Clamp)	TTGCR/L Hole Clamp
p. 69	p. 38	p. 38	p. 38	p. 39
VBMT	SVHBR/L Screw	SVVBN Screw	SVJBR/L Screw	
p. 83	p. 40	p. 40	p. 40	
VCGT VCMT	SVHCR/L Screw	SVVCN Screw	SVJCR/L Screw	
p. 84	p. 41	p. 41	p. 41	
VNMA VNMG	TVVNN Hole Clamp	TVJNR/L Hole Clamp		
p. 73	p. 42	p. 42		
WNMA WNMG	MWLNR/L Pin + Clamp	PWLNR/L Lever (+Clamp)	TWLNR/L Hole Clamp	
p. 75	p. 43	p. 43	p. 43	

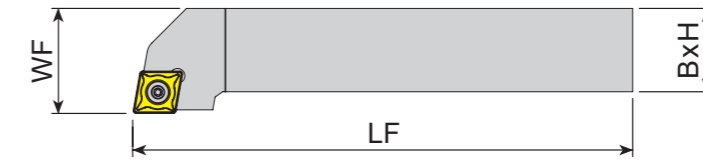
Turning - Holder - Internal Internal Holders Overview

Series	Turning Holder		
CCGT CCMT	..SCFCR/L Screw	..SCLCR/L Screw	E..SCLCR/L Screw
p. 78	p. 44	p. 45	p. 45
CNMA CNMG	..PCLNR/L Lever (+Clamp)	..TCLNR/L Hole Clamp	
p. 60	p. 46	p. 46	
DCGT DCMT	..SDQCR/L Screw	..SDUCR/L Screw	E..SDUCR/L Screw
p. 79	p. 47	p. 48	p. 48
DNMA DNMG	..PDQNR/L Lever (+Clamp)	..TDQNR/L Hole Clamp	..PDUNR/L Lever (+Clamp)
p. 63	p. 49	p. 49	p. 49
SNMA SNMG	..PSKNR/L Lever (+Clamp)		
p. 67	p. 50		
TCGT TCMT	..STFCR/L Screw	..STUCR/L Screw	
p. 82	p. 51	p. 51	

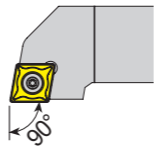
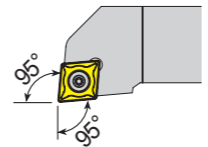
Turning - Holder - Internal
Internal Holders Overview

Series	Turning Holder			
 <p>TNMA TNMG TNUX</p>	 <p>..MTFNR/L Pin + Clamp</p>	 <p>..MTUNR/L Pin + Clamp</p>	 <p>..PTUNR/L Lever (+Clamp)</p>	 <p>..TTUNR/L Hole Clamp</p>
p. 69	p. 52	p. 52	p. 53	p. 53
 <p>VBMT</p>	 <p>..SVQBR/L Screw</p>	 <p>..SVJBR/L Screw</p>	 <p>..SVUBR/L Screw</p>	
p. 83	p. 54	p. 54	p. 54	
 <p>VCGT VCMT</p>	 <p>..SVQCR/L Screw</p>	 <p>..SVUCR/L Screw</p>		
p. 84	p. 55	p. 55		
 <p>VNMA VNMG</p>	 <p>..TVUNR/L Hole Clamp</p>			
p. 73	p. 56			
 <p>WNMA WNMG</p>	 <p>..MWLNR/L Pin + Clamp</p>	 <p>..PWLNR/L Lever (+Clamp)</p>	 <p>..TWLNR/L Hole Clamp</p>	
p. 75	p. 57	p. 57	p. 58	

Turning - Holder - External
External Holders for CC Insert**

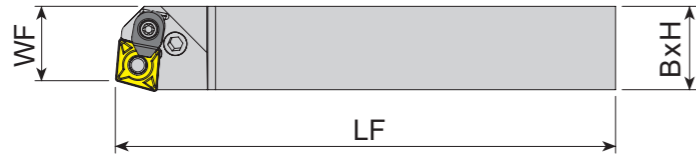


□: p. 78 unit:mm

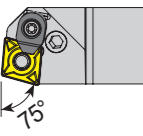
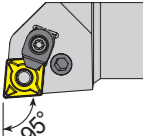
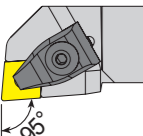
Series	Designation	EDP 2700..		H	B	WF	LF	Insert
		R	L					
 <p>SCACR/L (Screw Type 90°)</p>	SCACR/L 0808E 06	0675	0676	08	08	10	70	CC0602
	SCLCR/L 0808E 06	0689	0690	08	08	10	70	CC0602
	SCLCR/L 1010E 06	0691	-	10	10	12	70	
 <p>SCLCR/L (Screw Type 95°)</p>	SCLCR/L 1010E 09	0692	0693	10	10	12	70	CC09T3
	SCLCR/L 1212F 09	0089	0090	12	12	16	80	
	SCLCR/L 1616H 09	0091	0092	16	16	20	100	
	SCLCR/L 2020K 09	0093	0094	20	20	25	125	CC1204
	SCLCR/L 2525M 09	0694	0695	25	25	32	150	
	SCLCR/L 1616H 12	0696	-	16	16	20	100	
	SCLCR/L 2020K 12	0095	0096	20	20	25	125	
SCLCR/L 2525M 12	0097	0098	25	25	32	150		

Series	Size	Screw	Shim	Shim Screw	Torx Key
SCACR/L	.06	Y4008-M2.5x6	-	-	Y80-T08
	.06	Y4008-M2.5x6	-	-	Y80-T08
	.1010..09	Y4015-M3x9	-	-	Y80-T15
SCLCR/L	.1212..09	Y4015-M3.5x11	-	-	Y80-T15
	.1616~2525..09	Y4015-M3.5x14	YAACN-2-0001	YAAV-06-M3.5x11	Y80-T15
	.1616..12	Y1020-M5x11	-	-	Y80-T20
	.2020~2525..12	Y1020-M4.5x16	YAACN-2-0003	YAAV-07-M4.5x13	Y80-T20

Turning - Holder - External
External Holders for CN Insert**

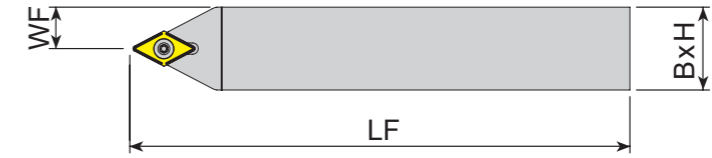


* 'C' Letter at Last : Optional Clamp Included □: p.60 unit:mm

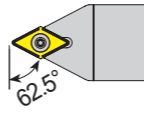
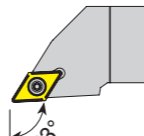
Series	Designation	EDP 2700..		H	B	WF	LF	Insert
		R	L					
 PCBNR/L (Lever Type 75°)	PCBNR/L 2525M 16C	0444	0445	25	25	22	150	CN1606
	PCBNR/L 3232P 16C	0446	0447	32	32	27	170	
	PCBNR/L 3232P 19C	0448	0449	32	32	37	170	CN1906
	PCBNR/L 4040S 19C	0450	0451	40	40	37	250	
 PCLNR/L (Lever Type 95°)	PCLNR/L 1616H 12	0464	0465	16	16	20	100	CN1204
	PCLNR/L 2020K 12C	0466	0467	20	20	25	125	
	PCLNR/L 2525M 12C	0468	0469	25	25	32	150	
	PCLNR/L 3232P 12C	0470	0471	32	32	40	170	
	CN1606	PCLNR/L 2525M 16C	0472	0473	25	25	32	150
		PCLNR/L 3232P 16C	0474	0475	32	32	40	170
		PCLNR/L 2525M 19C	0476	0477	25	25	32	150
		PCLNR/L 3232P 19C	0478	0479	32	32	40	170
PCLNR/L 4040S 19C		0480	0481	40	40	50	250	
 TCLNR/L (Hole Clamp Type 95°)	TCLNR/L 2020K 12	0482	0483	20	20	25	125	CN1204
	TCLNR/L 2525M 12	0484	0485	25	25	32	150	
	TCLNR/L 3232P 12	0486	0487	32	32	40	170	CN1606
	TCLNR/L 2525M 16	0492	0493	25	25	32	150	
	TCLNR/L 3232P 16	0494	-	32	32	40	170	

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
PCBNR/L	..16C	YAPL-04	YALV-04-M8x22	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0002	-	YAAV-03	YAAL-03-3
	..19C	YAPL-05	YALV-05-M10x27	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0003	-	YAAV-04	YAAL-05-4
PCLNR/L	..12	YAPL-02	YALV-03-M8x19	-	-	-	-	YAACN-3-0001	-	YAAV-02	YAAL-03-3
	..2020~3232..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAACN-3-0001	-	YAAV-02	YAAL-03-3
	..16C	YAPL-04	YALV-04-M8x22	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0002	-	YAAV-03	YAAL-03-3
	..19C	YAPL-05	YALV-05-M10x27	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0003	-	YAAV-04	YAAL-05-4
TCLNR/L	..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAACN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
	..16	-	-	YATK-04	YAKV-19-M7x25	YABPL-02	-	YAACN-3-0002	YAAV-05-M6x15	-	YAAL-05-4

Turning - Holder - External
External Holders for DC Insert**

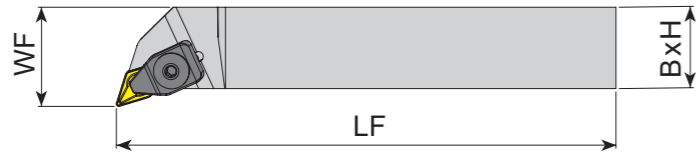


□: p.79 unit:mm

Series	Designation	EDP 2700..		H	B	WF	LF	Insert
		R	L					
 SDNCN (Screw Type 62.5°)	SDNCN 0808E 07	0723		08	08	4	70	DC0702
	SDNCN 1010E 07	0724		10	10	5	70	
	SDNCN 1212F 07	0123		12	12	6	80	DC11T3
	SDNCN 1616H 07	0725		16	16	8	100	
	SDNCN 1616H 11	0124		16	16	8	100	DC11T3
	SDNCN 2020K 11	0125		20	20	10	125	
	SDNCN 2525M 11	0126		25	25	12.5	150	
	SDNCN 3232P 11	0726		32	32	16	170	
 SDJCR/L (Screw Type 93°)	SDJCR/L 0808E 07	0713	0714	08	08	10	70	DC0702
	SDJCR/L 1010E 07	0715	0716	10	10	12	70	
	SDJCR/L 1212F 07	0113	0114	12	12	16	80	
	SDJCR/L 1616H 07	0717	0718	16	16	20	100	DC11T3
	SDJCR/L 1616H 11	0117	0118	16	16	20	100	
	SDJCR/L 2020K 11	0119	0120	20	20	25	125	
	SDJCR/L 2525M 11	0719	0720	25	25	32	150	DC11T3
	SDJCR/L 3232P 11	0721	0722	32	32	40	170	

Series	Size	Screw	Shim	Shim Screw	Torx Key
SDNCN	..07	Y4008-M2.5x6	-	-	Y80-T08
	..11	Y4015-M3.5x14	YAADN-2-0001	YAAV-06-M3.5x11	Y80-T15
SDJCR/L	..07	Y4008-M2.5x6	-	-	Y80-T08
	..11	Y4015-M3.5x14	YAADN-2-0001	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - External
External Holders for DN Insert**



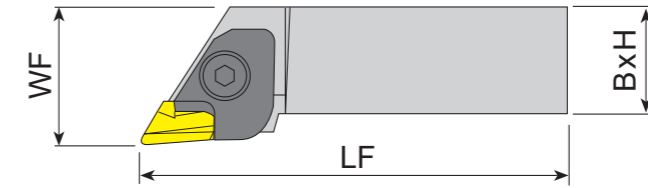
* 'C' Letter at Last : Optional Clamp Included

☐: p.63 unit:mm

Series	Designation	EDP 2700..		H	B	WF	LF	Insert
		R	L					
 TDHNR/L (Hole Clamp Type 107.5°)	TDHNR/L 2020K 15	0495	0496	20	20	25	125	DN1506
	TDHNR/L 2525M 15	0497	0498	25	25	32	150	
 PDNNN (Lever Type 62.5°)	PDNNN 2020K 15C	0515		20	20	10	125	DN1506
	PDNNN 2525M 15C	0516		25	25	12.5	150	
	PDNNN 3232P 15C	0517		32	32	16	170	
 TDNNN (Hole Clamp Type 62.5°)	TDNNN 2020K 15	0518		20	20	10	125	DN1506
	TDNNN 2525M 15	0519		25	25	12.5	150	
	TDNNN 3232P 15	0520		32	32	16	170	
 PDJNR/L (Lever Type 93°)	PDJNR/L 2020K 15C	0500	0501	20	20	25	125	DN1506
	PDJNR/L 2525M 15C	0502	0503	25	25	32	150	
	PDJNR/L 3232P 15C	0504	0505	32	32	40	170	
	PDJNR/L 4040S 15C	-	0506	40	40	50	250	
 TDJNR/L (Hole Clamp Type 93°)	TDJNR/L 2020K 15	0507	0508	20	20	25	125	DN1506
	TDJNR/L 2525M 15	0509	0510	25	25	32	150	
	TDJNR/L 3232P 15	0511	0512	32	32	40	170	
	TDJNR/L 4040S 15	0513	0514	40	40	50	250	

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
TDHNR/L	..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
PDNNN	..15C	YAPL-03	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAADN-3-0001	-	YAAV-02	YAAL-03-3
TDNNN	..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
PDJNR/L	..15C	YAPL-03	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAADN-3-0001	-	YAAV-02	YAAL-03-3
TDJNR/L	..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - External
External Holders for KN Insert**

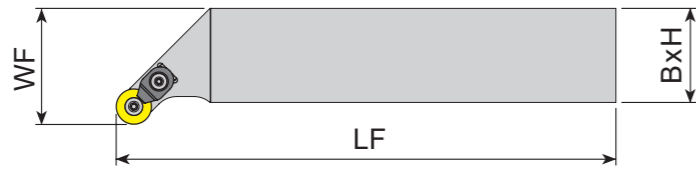


☐: p.66 unit:mm

Series	Designation	EDP 2700..		H	B	WF	LF	Insert
		R	L					
 CKJNR/L (Top Clamp Type 93°)	CKJNR/L 2525M 16	0152	0153	25	25	31.5	150	KNUX1604
	CKJNR/L 3232P 16	0154	0155	32	32	40	170	

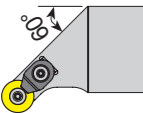
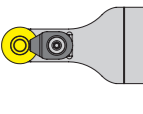
Series	Size	Clamp	Clamp Screw	Spring	Upper Ring	Shim	Shim Screw	Allen Key
CKJNR	..16	YACK-01-R	YAKV-06-M6x20	YAKY-02	YABPL-01	YAKS-16-R	YAAV-01-M3x10	YAAL-05-4
CKJNL	..16	YACK-01-L	YAKV-06-M6x20	YAKY-02	YABPL-01	YAKS-16-L	YAAV-01-M3x10	YAAL-05-4

Turning - Holder - External
External Holders for RC Insert**



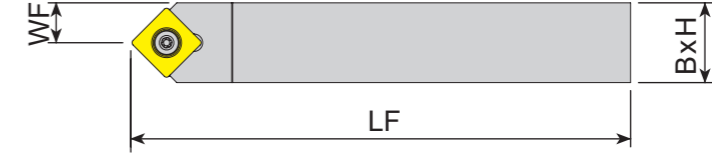
* 'C' Letter at Last : Optional Clamp Included

□: p.80 unit:mm

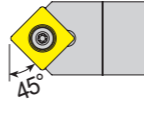
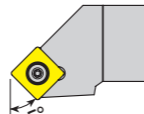
Series	Designation	EDP 2700.. R L	H	B	WF	LF	Insert
 SRGCR/L (Screw Type 90°)	SRGCR/L 1616H 06	0739 0740	16	16	20	100	RC0602
	SRGCR/L 2020K 06	0741 0742	20	20	25	125	
	SRGCR/L 1616H 08C	0743 0744	16	16	32	100	RC0803
	SRGCR/L 2020K 08C	0745 0746	20	20	25	125	
	SRGCR/L 2525M 08C	0747 0748	25	25	32	150	RC10T3
	SRGCR/L 1616H 10C	0749 0750	16	16	20	100	
	SRGCR/L 2020K 10C	0751 0752	20	20	25	125	
	SRGCR/L 2525M 10C	0753 0754	25	25	32	150	RC1204
	SRGCR/L 3232P 10C	0755 0756	32	32	40	170	
	SRGCR/L 2020K 12C	0757 0758	20	20	25	125	RC1204
SRGCR/L 2525M 12C	0759 0760	25	25	32	150		
SRGCR/L 3232P 12C	0761 0762	32	32	40	170		
 SRDCN (Screw Type 90°)	SRDCN 1616H 06	0162	16	16	8	100	RC0602
	SRDCN 2020K 06	0163	20	20	10	125	
	SRDCN 2525M 06	0164	25	25	12.5	150	
	SRDCN 1616H 08C	0727	16	16	8	100	RC0803
	SRDCN 2020K 08C	0728	20	20	10	125	
	SRDCN 2525M 08C	0729	25	25	12.5	150	
	SRDCN 1616H 10C	0730	16	16	8	100	RC10T3
	SRDCN 2020K 10C	0731	20	20	10	125	
	SRDCN 2525M 10C	0732	25	25	12.5	150	
	SRDCN 3232P 10C	0733	32	32	16	170	RC1204
	SRDCN 2020K 12C	0734	20	20	10	125	
	SRDCN 2525M 12C	0735	25	25	12.5	150	
SRDCN 3232P 12C	0736	32	32	16	170		

Series	Size	Clamp	Clamp Screw	Screw	Torx Key
SRGCR/L	..06	-	-	Y3008-M2.5x6	Y80-T08
	..1616..08C	YACK-15	Y4015-M3.5x11	Y3008-M3x8	Y80-T08
	..10C	YACK-15	Y4015-M3.5x11	Y3008-M3x8	Y80-T15
	..12C	YACK-05	Y4015-M4x11	Y4015-M3.5x11	Y80-T15
SRDCN	..06	-	-	Y3008-M2.5x6	Y80-T08
	..08C	YACK-15	Y4015-M3.5x11	Y3008-M3x8	Y80-T08
	..10C	YACK-15	Y4015-M3.5x11	Y4015-M3.5x11	Y80-T15
	..12C	YACK-05	Y4015-M4x11	Y4015-M3.5x11	Y80-T15

Turning - Holder - External
External Holders for SC Insert**

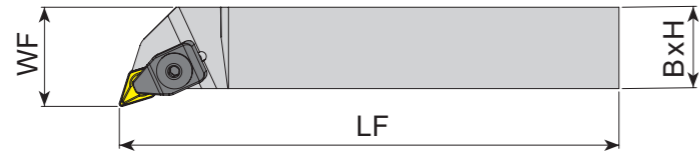


□: p.81 unit:mm

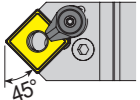
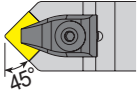
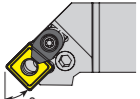
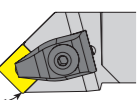
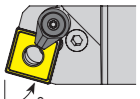
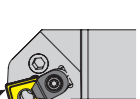
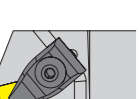
Series	Designation	EDP 2700.. R L	H	B	WF	LF	Insert
 SSDCN (Screw Type 45°)	SSDCN 1212F 09	0148	12	12	6	80	SC09T3
	SSDCN 1616H 09	0149	16	16	8	100	
	SSDCN 2020K 09	0770	20	20	10	125	
	SSDCN 1616H 12	0771	16	16	8	100	SC1204
	SSDCN 2020K 12	0150	20	20	10	125	
	SSDCN 2525M 12	0151	25	25	12.5	150	
 SSSCR/L (Screw Type 45°)	SSSCR/L 1212F 09	0772 0773	12	12	16	80	SC09T3
	SSSCR/L 1616H 09	0774 0775	16	16	20	100	
	SSSCR/L 2020K 09	0776 0777	20	20	25	125	
	SSSCR/L 1616H 12	0778 0779	16	16	20	100	SC1204
	SSSCR/L 2020K 12	0780 0781	20	20	25	125	
	SSSCR/L 2525M 12	0782 0783	25	25	32	150	

Series	Size	Screw	Shim	Shim Screw	Torx Key
SSDCN	..1212..09	Y4015-M3.5x11	-	-	Y80-T15
	..1616~2020..09	Y4015-M3.5x14	YAASN-2-0001	YAAV-06-M3.5x11	Y80-T15
	..1616..12	Y4020-M4.5x12	YAASN-2-0004	YAAV-10-M4.5x8	Y80-T20
	..2020~2525..12	Y1020-M4.5x16	YAASN-2-0004	YAAV-07-M4.5x13	Y80-T20
SSSCR/L	..1212..09	Y4015-M3.5x11	-	-	Y80-T15
	..1616~2020..09	Y4015-M3.5x14	YAASN-2-0001	YAAV-06-M3.5x11	Y80-T15
	..1616..12	Y4020-M4.5x12	YAASN-2-0004	YAAV-10-M4.5x8	Y80-T20
	..2020~2525..12	Y1020-M4.5x16	YAASN-2-0004	YAAV-07-M4.5x13	Y80-T20

Turning - Holder - External
External Holders for SN Insert**

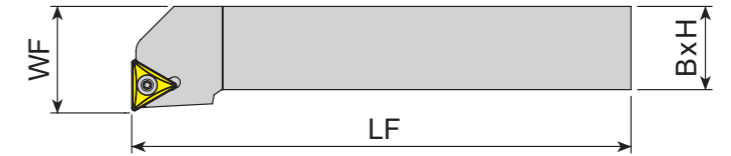


* 'C' Letter at Last : Optional Clamp Included □: p.67 unit:mm

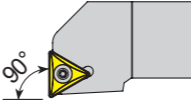
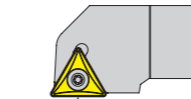
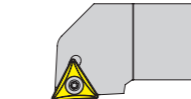
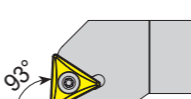
Series	Designation	EDP 2700.. R L	H	B	WF	LF	Insert
 PSDNN (Lever Type 45°)	PSDNN 2020K 12C	0530	20	20	10	125	SN1204
	PSDNN 2525M 12C	0531	25	25	12.5	150	
	PSDNN 3232P 12C	0532	32	32	16	170	
 TSDNN (Hole Clamp Type 45°)	TSDNN 1616H 12	0533	16	16	8	100	SN1204
	TSDNN 2020K 12	0534	20	20	10	125	
	TSDNN 2525M 12	0535	25	25	12.5	150	
 PSSNR/L (Lever Type 45°)	PSSNR/L 2020K 12C	0548 0549	20	20	25	125	SN1204
	PSSNR/L 2525M 12C	0550 0551	25	25	32	150	
	PSSNR/L 3232P 12C	0552 0553	32	32	40	170	
 TSSNR/L (Hole Clamp Type 45°)	TSSNR/L 2020K 12	0554 0555	20	20	25	125	SN1204
	TSSNR/L 2525M 12	0556 0557	25	25	32	150	
	TSSNR/L 3232P 12	0558 0559	32	32	40	170	
 PSBNR/L (Lever Type 75°)	PSBNR/L 2020K 12	0430 0525	20	20	17	125	SN1204
	PSBNR/L 2525M 12C	0526 0527	25	25	22	150	
 PSKNR/L (Lever Type 75°)	PSKNR/L 2020K 12C	0537	20	20	25	125	SN1204
	PSKNR/L 2525M 12C	0538 0539	25	25	32	150	
	PSKNR/L 3232P 12C	0540 0541	32	32	40	170	
 TSKNR/L (Hole Clamp Type 75°)	TSKNR/L 2020K 12	0542 0543	20	20	25	125	SN1204
	TSKNR/L 2525M 12	0544 0545	25	25	32	150	
	TSKNR/L 3232P 12	0546 0547	32	32	40	170	

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
PSDNN	..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
TSDNN	..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAASN-3-0004	YAAV-02-M5x12	-	YAAL-03-3
PSSNR/L	..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
TSSNR/L	..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAASN-3-0004	YAAV-02-M5x12	-	YAAL-03-3
PSBNR/L	..12	YAPL-02	YALV-03-M8x19	-	-	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
PSKNR/L	..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
PSKNR/L	..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAASN-3-0004	-	YAAY-02	YAAL-03-3
TSKNR/L	..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAASN-3-0004	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - External
External Holders for TC Insert**

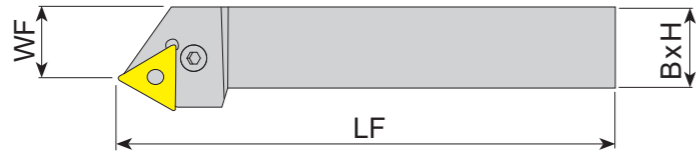


□: p.82 unit:mm

Series	Designation	EDP 2700.. R L	H	B	WF	LF	Insert
 STFCR/L (Screw Type 90°)	STFCR/L 1212F 11	0099 0100	12	12	16	80	TC1102
	STFCR/L 1616H 11	0101 0102	16	16	20	100	
	STFCR/L 1616H 16	0105 0106	16	16	20	100	TC16T3
	STFCR/L 2020K 16	0107 0108	20	20	25	125	
	STFCR/L 2525M 16	0109 0110	25	25	32	150	
 STGCR/L (Screw Type 90°)	STGCR/L 1212F 11	0786 0787	12	12	16	80	TC1102
	STGCR/L 1616H 11	0433 0788	16	16	20	100	
	STGCR/L 1616H 16	0789 0790	16	16	20	100	TC16T3
	STGCR/L 2020K 16	0434 0791	20	20	25	125	
	STGCR/L 2525M 16	0792 0793	25	25	32	150	
 STJCR/L (Screw Type 93°)	STJCR/L 1212F 11	0796 0797	12	12	16	80	TC1102
	STJCR/L 1616H 11	0798 0799	16	16	20	100	
	STJCR/L 1616H 16	0800 0801	16	16	20	100	TC16T3
	STJCR/L 2020K 16	0802 0803	20	20	25	125	
	STJCR/L 2525M 16	0804 0805	25	25	32	150	
 STUCR/L (Screw Type 93°)	STUCR/L 1212F 11	0808 0809	12	12	16	80	TC1102
	STUCR/L 1616H 11	0810 0811	16	16	20	100	
	STUCR/L 2020K 16	0812 0813	20	20	25	125	TC16T3
	STUCR/L 2525M 16	0814 0815	25	25	32	150	
	STUCR/L 3232P 16	0816 0817	32	32	40	170	

Series	Size	Screw	Shim	Shim Screw	Torx Key
STFCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15
STGCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15
STJCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15
STUCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - External
External Holders for TN Insert**



* 'C' Letter at Last : Optional Clamp Included

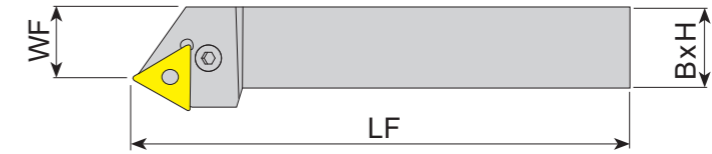
□: p. 69 unit:mm

Series	Designation	EDP 2700.. R L	H	B	WF	LF	Insert
 PTTNR/L (Lever Type 60°)	PTTNR/L 2020K 16	0429 0621	20	20	17	125	TN1604
	PTTNR/L 2525M 16	0622 0623	25	25	21.5	150	
	PTTNR/L 2525M 22C	0626 0627	25	25	20.5	150	TN2204
	PTTNR/L 3232P 22C	0628 0629	32	32	29	170	
 PTFNR/L (Lever Type 90°)	PTFNR/L 1616H 16	0560 0561	16	16	20	100	TN1604
	PTFNR/L 2020K 16	0049 0050	20	20	25	125	
	PTFNR/L 2525M 16	0051 0052	25	25	32	150	TN2204
	PTFNR/L 3232P 16	0562 0563	32	32	40	170	
 PTGNR/L (Lever Type 90°)	PTGNR/L 1616H 16	0568 0569	16	16	20	100	TN1604
	PTGNR/L 2020K 16	0055 0056	20	20	25	125	
	PTGNR/L 2525M 16	0057 0058	25	25	32	150	TN2204
	PTGNR/L 2525M 22C	0570 0571	25	25	32	150	
 TTGNR/L (Hole Clamp Type 90°)	TTGNR/L 3232P 22C	0572 0573	32	32	40	170	TN2204
	TTGNR/L 2020K 16	0574 0575	20	20	25	125	
	TTGNR/L 2525M 16	0576 0577	25	25	32	150	TN1604
	TTGNR/L 3232P 16	0578 0579	32	32	40	170	
 TTGNR/L (Hole Clamp Type 90°)	TTGNR/L 2525M 22	0580 0581	25	25	32	150	TN2204
	TTGNR/L 3232P 22	0582 0583	32	32	40	170	
	TTGNR/L 4040S 22	0584 -	40	40	50	250	TN1604
	TTGNR/L 3232P 22	0582 0583	32	32	40	170	

▶ NEXT PAGE

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
PTTNR/L	..16	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-03-3
PTFNR/L	..16	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-03-3
PTGNR/L	..16	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-02-2.5
TTGNR/L	..16	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAATN-2-0002	YAAV-03-M5x12	-	YAAL-03-3
	..22	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAATN-3-0015	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - External
External Holders for TN Insert**



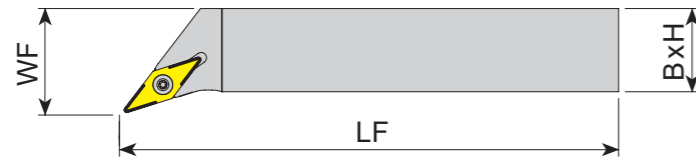
* 'C' Letter at Last : Optional Clamp Included

□: p. 69 unit:mm

Series	Designation	EDP 2700.. R L	H	B	WF	LF	Insert
 MTJNR/L (Pin + Top Clamp Type 93°)	MTJNR/L 2020K 16	0585 0586	20	20	25	125	TN1604
	MTJNR/L 2525M 16	0587 0588	25	25	32	150	
	MTJNR/L 3232P 16	0589 0590	32	32	40	170	TN2204
	MTJNR/L 2525M 22	0591 0592	25	25	32	150	
	MTJNR/L 3232P 22	0593 0594	32	32	40	170	TN2204
	MTJNR/L 4040S 22	0595 0596	40	40	50	250	
 PTJNR/L (Lever Type 93°)	PTJNR/L 1616H 16	0597 0598	16	16	20	100	TN1604
	PTJNR/L 2020K 16	0599 0600	20	20	25	125	
	PTJNR/L 2525M 16	0601 0602	25	25	32	150	TN2204
	PTJNR/L 3232P 16	0603 0604	32	32	40	170	
	PTJNR/L 2525M 22C	0605 0606	25	25	32	150	TN2204
	PTJNR/L 3232P 22C	0607 0608	32	32	40	170	
 TTJNR/L (Hole Clamp Type 93°)	TTJNR/L 2020K 16	0609 0610	20	20	25	125	TN1604
	TTJNR/L 2525M 16	0611 0612	25	25	32	150	
	TTJNR/L 3232P 16	0613 0614	32	32	40	170	TN2204
	TTJNR/L 2525M 22	0615 0616	25	25	32	150	
	TTJNR/L 3232P 22	0617 0618	32	32	40	170	TN2204
	TTJNR/L 3232P 22	0617 0618	32	32	40	170	

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
MTJNR/L	..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-01	YAATN-2-0002	-	-	YAAL-03-3
	..22	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-02	YAATN-3-0015	-	-	YAAL-03-3
PTJNR/L	..16	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-03-3
TTJNR/L	..16	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAATN-2-0002	YAAV-03-M5x12	-	YAAL-03-3
	..22	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAATN-3-0015	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - External External Holders for VB** Insert

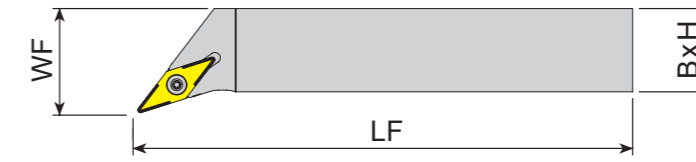


: p. 83 unit:mm

Series	Designation	EDP 2700..		H	B	WF	LF	Insert
		R	L					
 SVHBR/L (Screw Type 107.5°)	SVHBR/L 2020K 16	0818	0819	20	20	25	125	VB1604
	SVHBR/L 2525M 16	0820	0821	25	25	32	150	
	SVHBR/L 3232P 16	0822	0823	32	32	40	170	
 SVVBN (Screw Type 72.5°)	SVVBN 2020K 16	0131		20	20	10	125	VB1604
	SVVBN 2525M 16	0132		25	25	12.5	150	
	SVVBN 3232P 16	0827		32	32	16	170	
 SVJBR/L (Screw Type 93°)	SVJBR/L 1616H 16	0824	0825	16	16	20	100	VB1604
	SVJBR/L 2020K 16	0127	0128	20	20	25	125	
	SVJBR/L 2525M 16	0129	0130	25	25	32	150	
	SVJBR/L 3232P 16	0436	0826	32	32	40	170	

Series	Size	Screw	Shim	Shim Screw	Torx Key
SVHBR/L	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
SVVBN	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
SVJBR/L	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - External External Holders for VC** Insert

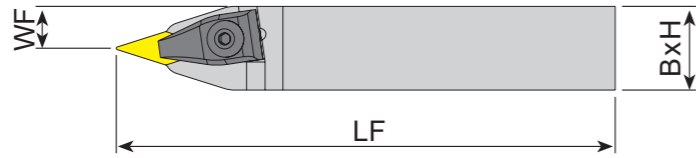


: p. 84 unit:mm

Series	Designation	EDP 2700..		H	B	WF	LF	Insert
		R	L					
 SVHCR/L (Screw Type 107.5°)	SVHCR/L 2020K 16	0828	0829	20	20	25	125	VC1604
	SVHCR/L 2525M 16	0830	0831	25	25	32	150	
	SVHCR/L 3232P 16	0832	0833	32	32	40	170	
 SVVCN (Screw Type 72.5°)	SVVCN 2525M 16	0147		25	25	12.5	150	VC1604
	SVVCN 3232P 16	0838		32	32	16	170	
 SVJCR/L (Screw Type 93°)	SVJCR/L 1212F 16	0834	0835	12	12	16	80	VC1604
	SVJCR/L 2020K 16	0139	0140	20	20	25	125	
	SVJCR/L 2525M 16	0141	0142	25	25	32	150	
	SVJCR/L 3232P 16	0836	0837	32	32	40	170	

Series	Size	Screw	Shim	Shim Screw	Torx Key
SVHCR/L	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
SVVCN	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
SVJCR/L	..1212..16	Y4015-M3.5x11	-	-	Y80-T15
	..2020~3232..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - External
External Holders for VN Insert**

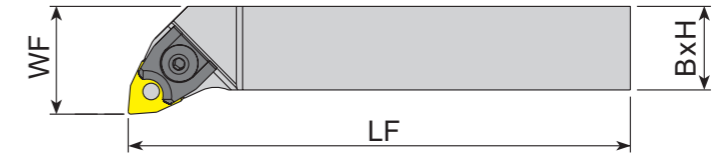


: p. 73 unit:mm

Series	Designation	EDP 2700.. R L	H	B	WF	LF	Insert
 TVVNN (Hole Clamp Type 72.5°)	TVVNN 2020K 16	0642	20	20	10	125	VN1604
	TVVNN 2525M 16	0643	25	25	12.5	150	
	TVVNN 3232P 16	0644	32	32	16	170	
 TVJNR/L (Hole Clamp Type 93°)	TVJNR/L 2020K 16	0636 0637	20	20	25	125	VN1604
	TVJNR/L 2525M 16	0638 0639	25	25	32	150	
	TVJNR/L 3232P 16	0640 0641	32	32	40	170	

Series	Size	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Allen Key
TVVNN	..16	YATK-03	YAKV-30-M6x22	YABPL-01	YAS-01	YAAVN-2-0002	YAAV-04-M5x12	YAAL-03-3
TVJNR/L	..16	YATK-03	YAKV-30-M6x22	YABPL-01	YAS-01	YAAVN-2-0002	YAAV-04-M5x12	YAAL-03-3

Turning - Holder - External
External Holders for WN Insert**



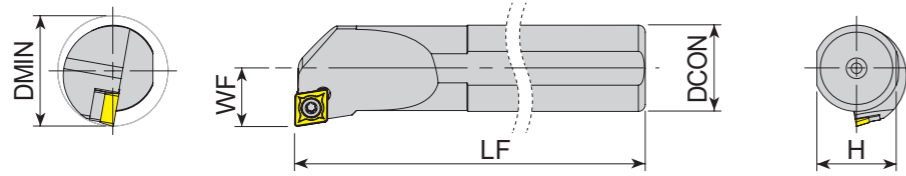
: p. 75 unit:mm

* 'C' Letter at Last : Optional Clamp Included

Series	Designation	EDP 2700.. R L	H	B	WF	LF	Insert	
 MWLNR/L (Pin + Top Clamp Type 95°)	MWLNR/L 1616H 06	0645 0646	16	16	20	100	WN0604	
	MWLNR/L 2020K 06	0021 0022	20	20	25	125		
	MWLNR/L 2525M 06	0023 0024	25	25	32	150		
	 PWLNR/L (Lever Type 95°)	MWLNR/L 2020K 08	0025 0026	20	20	25	125	WN0804
		MWLNR/L 2525M 08	0027 0028	25	25	32	150	
		MWLNR/L 3232P 08	0029 0030	32	32	40	170	
PWLNR/L 1616H 06		0647 0648	16	16	20	100	WN0604	
PWLNR/L 2020K 06	0649 0650	20	20	25	125			
PWLNR/L 2525M 06	0651 0652	25	25	32	150			
 TWLNR/L (Hole Clamp Type 95°)	PWLNR/L 1616H 08	0653 0654	16	16	20	100	WN0804	
	PWLNR/L 2020K 08C	0655 0656	20	20	25	125		
	PWLNR/L 2525M 08C	0657 0658	25	25	32	150		
	PWLNR/L 3232P 08C	0659 0660	32	32	40	170	WN0804	
	TWLNR/L 1616H 06	0661 0662	16	16	20	100		
	TWLNR/L 2020K 06	0663 0664	20	20	25	125		
	TWLNR/L 2525M 06	0665 0666	25	25	32	150		
	TWLNR/L 2020K 08	0667 0668	20	20	25	125		
TWLNR/L 2525M 08	0669 0670	25	25	32	150			
TWLNR/L 3232P 08	0671 0672	32	32	40	170			
TWLNR/L 4040S 08	0673 0674	40	40	50	250			

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
MWLNR/L	..06	-	-	YAMK-01	YAKV-04-M5x17	-	-	YAPM-08	-	-	-	YAAL-03-3
	..08	-	-	YAMK-05	YAKV-03-M6x22	YABPL-01	YAS-01	YAPM-02	YAAWN-3-0001	-	-	YAAL-03-3
PWLNR/L	..06	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAAWN-SW317	-	YAAY-01	YAAL-02-2.5
	..08	YAPL-02	YALV-03-M8x19	-	-	-	-	-	YAAWN-3-0001	-	YAAY-02	YAAL-03-3
	..08C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAAWN-3-0001	-	YAAY-02	YAAL-03-3
TWLNR/L	..06	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAAWN-SW317	YAAV-01-M3x10	-	YAAL-03-3
	..08	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAAWN-3-0001	YAAV-02-M5x12	-	YAAL-03-3

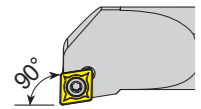
Turning - Holder - Internal
Internal Holders for CC Insert**



□: p. 78 unit:mm

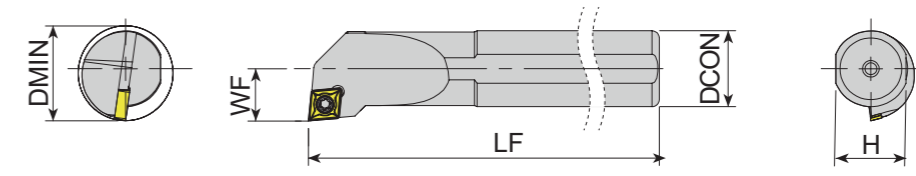
Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
	S08H - SCFCR/L 06	1102 1103	11	08	7.3	6	100	CC0602
X	S10K - SCFCR/L 06	1104 1105	13	10	9	7	125	
	S12K - SCFCR/L 06	1106 1107	16	12	11	9	125	
	S12K - SCFCR/L 09	1108 1109	16	12	11	9	125	CC09T3
X	S16P - SCFCR/L 09	1110 1111	20	16	14.8	11	170	
	S20R - SCFCR/L 09	1112 1113	25	20	18.3	13	200	
	S25S - SCFCR/L 09	1114 1115	32	25	23	17	250	CC1204
X	S25S - SCFCR/L 12	1116 -	32	25	23	17	250	

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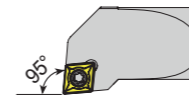
..-SCFCR/L
(Screw Type 90°)

Turning - Holder - Internal
Internal Holders for CC Insert**

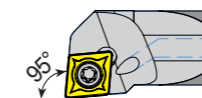


□: p. 78 unit:mm

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
	A08H - SCLCR/L 06	1117 1118	11	08	7.3	6	100	CC0602
●	A10H - SCLCR/L 06	1119 1120	13	10	9	7	100	
	A12H - SCLCR/L 06	1121 1122	16	12	11	9	100	
	S08H - SCLCR/L 06	1133 1134	11	08	7.3	6	100	CC0602
X	S10K - SCLCR/L 06	1135 1136	13	10	9	7	125	
	S12K - SCLCR/L 06	1137 1138	16	12	11	9	125	
	S16P - SCLCR/L 06	1139 1140	20	16	14.8	11	170	CC09T3
	A16M - SCLCR/L 09	1123 1124	20	16	14.8	11	150	
●	A20P - SCLCR/L 09	1125 1126	25	20	18.3	13	170	
	A25R - SCLCR/L 09	1127 1128	32	25	23	17	200	CC09T3
	A32S - SCLCR/L 09	1129 1130	40	32	30	22	250	
	S12K - SCLCR/L 09	1141 1142	16	12	11	9	125	
	S16P - SCLCR/L 09	- 1143	20	16	14.8	11	170	CC1204
X	S20R - SCLCR/L 09	1144 1145	25	20	18.3	13	200	
	S25S - SCLCR/L 09	1146 1147	32	25	23	17	250	
	S32T - SCLCR/L 09	1148 1149	40	32	30	22	300	CC1204
●	A25R - SCLCR/L 12	1131 1132	32	25	23	17	200	
	S25S - SCLCR/L 12	1150 1151	32	25	23	17	250	
X	S32T - SCLCR/L 12	1152 1153	40	32	30	22	300	CC1204
	S40U - SCLCR/L 12	1154 1155	50	40	37.5	27	350	
●	E08K - SCLCR/L 06	0325 1156	11	08	7.3	6	125	
	E12Q - SCLCR/L 06	1157 1158	16	12	11	9	180	CC09T3
●	E16R - SCLCR/L 09	0329 1159	20	16	14.8	11	200	
●	E20S - SCLCR/L 09	1160 1161	24	20	18.3	13	250	



..-SCLCR/L
(Screw Type 95°)

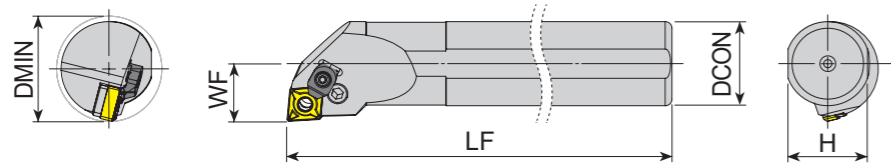


E..-SCLCR/L
(Screw Type 95° Carbide)

Series	Size	Screw	Shim	Shim Screw	Torx Key
..SCFCR/L	..06	Y4008-M2.5x6	-	-	Y80-T08
	..12..09	Y4015-M3.5x8	-	-	Y80-T15
	..16~20..09	Y4015-M3.5x9	-	-	Y80-T15
	..25..09	Y4015-M3.5x12	YAACN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..12	Y4020-M4.5x12	YAACN-2-0003	YAAV-10-M4.5x8	Y80-T20

Series	Size	Screw	Shim	Shim Screw	Torx Key
..SCLCR/L	..06	Y4008-M2.5x6	-	-	Y80-T08
	..12..09	Y4015-M3.5x8	-	-	Y80-T15
	..16~20..09	Y4015-M3.5x9	-	-	Y80-T15
	..25~32..09	Y4015-M3.5x12	YAACN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..25~32..12	Y4020-M4.5x12	YAACN-2-0003	YAAV-10-M4.5x8	Y80-T20
	..40..12	Y1020-M4.5x16	YAACN-2-0003	YAAV-07-M4.5x13	Y80-T20
E..SCLCR/L	..06	Y4008-M2.5x6	-	-	Y80-T08
	..09	Y4015-M3.5x9	-	-	Y80-T15

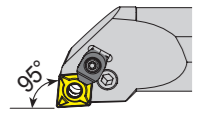
Turning - Holder - Internal
Internal Holders for CN Insert**



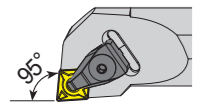
* 'C' Letter at Last : Optional Clamp Included

□ : p. 60 unit:mm

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert		
●	A25R - PCLNR/L 12C	0839 0840	32	25	23	17	200	CN1204		
	A32S - PCLNR/L 12C	0841 0842	40	32	30	22	250			
	A40T - PCLNR/L 12C	0843 0844	50	40	37.5	27	300			
	A50U - PCLNR/L 12C	0845 0846	63	50	47	35	350			
	S25S - PCLNR/L 12C	0863 0864	32	25	23	17	250			
	X S32T - PCLNR/L 12C	0865 0866	40	32	30	22	300			
	X S40U - PCLNR/L 12C	0867 0868	50	40	37.5	27	350			
	X S50V - PCLNR/L 12C	0869 0870	63	50	47	35	400			
	●	A32S - PCLNR/L 16C	0847 0848	40	32	30	22		250	CN1606
		A40T - PCLNR/L 16C	0849 0850	50	40	37.5	27		300	
A50U - PCLNR/L 16C		0851 0852	63	50	47	35	350			
X S32T - PCLNR/L 16C		0871 0872	40	32	30	22	300			
X S40U - PCLNR/L 16C		0873 0874	50	40	37.5	27	350			
●	X S50V - PCLNR/L 16C	0875 0876	63	50	47	35	400	CN1906		
	A40T - PCLNR/L 19C	0853 0854	50	40	37.5	27	300			
	A50U - PCLNR/L 19C	0855 0856	63	50	47	35	350			
	X S40U - PCLNR/L 19C	0877 0878	50	40	37.5	27	350			
●	X S50V - PCLNR/L 19C	0879 0880	63	50	47	35	400	CN1204		
	S25S - TCLNR/L 12	0881 0882	32	25	23	17	250			
	X S32T - TCLNR/L 12	0883 0884	40	32	30	22	300			
	X S40U - TCLNR/L 12	0885 0886	50	40	37.5	27	350			
●	X S50V - TCLNR/L 12	0887 0888	63	50	47	35	400	CN1606		
	S32T - TCLNR/L 16	0889 0890	40	32	30	22	300			
	X S40U - TCLNR/L 16	0891 0892	50	40	37.5	27	350			
●	X S50V - TCLNR/L 16	0893 0894	63	50	47	35	400			



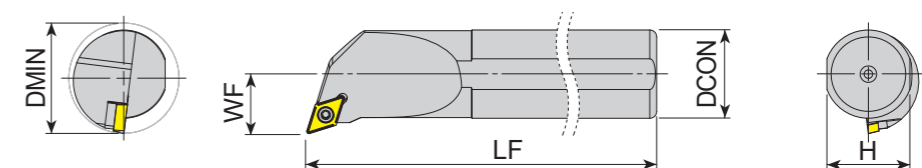
● **..PCLNR/L**
(Lever Type 95°)



● **..TCLNR/L**
(Hole Clamp Type 95°)

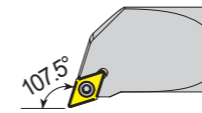
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
..PCLNR/L	..25..12C	YAPL-02	YALV-08-M8x16	YACK-05	Y4015-M4x11	-	-	YAACN-3-0001	-	YAAY-02	YAAL-03-3
	..32~50..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	YAACN-3-0001	-	YAAY-02	YAAL-03-3
	..16C	YAPL-04	YALV-04-M8x22	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0002	-	YAAY-03	YAAL-03-3
	..19C	YAPL-05	YALV-05-M10x27	YACK-09	YAAV-05-M6x15	-	-	YAACN-3-0003	-	YAAY-04	YAAL-05-4
..TCLNR/L	..25..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAACN-3-0001	YAAV-13-M5x8	-	YAAL-03-3
	..32~50..12	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAACN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
	..16	-	-	YATK-04	YAKV-19-M7x25	YABPL-02	-	YAACN-3-0002	YAAV-05-M6x15	-	YAAL-05-4

Turning - Holder - Internal
Internal Holders for DC Insert**



□ : p. 79 unit:mm

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert		
●	A10H - SDQCR/L 07	1172 1173	13	10	9	7	100	DC0702		
	A12H - SDQCR/L 07	1174 1175	16	12	11	9	100			
	A16M - SDQCR/L 07	1176 1177	20	16	14.8	11	150			
	A20P - SDQCR/L 07	1178 1179	25	20	18.3	13	170			
	S10K - SDQCR/L 07	1188 1189	13	10	9	7	125			
	X S12K - SDQCR/L 07	1190 1191	16	12	11	9	125			
	X S16P - SDQCR/L 07	1192 1193	20	16	14.8	11	170			
	X S20R - SDQCR/L 07	1194 1195	25	20	18.3	13	200			
	●	A16M - SDQCR/L 11	1180 1181	20	16	14.8	11		150	DC11T3
		A20P - SDQCR/L 11	1182 1183	25	20	18.3	13		170	
A25R - SDQCR/L 11		1184 1185	32	25	23	17	200			
A32S - SDQCR/L 11		1186 1187	40	32	30	22	250			
S16P - SDQCR/L 11		1196 1197	20	16	14.8	11	170			
●	X S20R - SDQCR/L 11	1198 1199	25	20	18.3	13	200	DC11T3		
	X S25S - SDQCR/L 11	1200 1201	32	25	23	17	250			
	S32T - SDQCR/L 11	1202 1203	40	32	30	22	300			
	S40U - SDQCR/L 11	1204 1205	50	40	37.5	27	350			

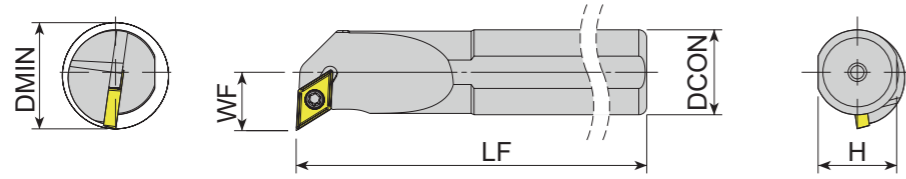


● **..SDQCR/L**
(Screw Type 107.5°)

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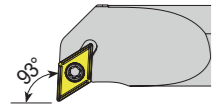
Series	Size	Screw	Shim	Shim Screw	Torx Key
..SDQCR/L	..07	Y4008-M2.5x6	-	-	Y80-T08
	..16..11	Y4015-M3.5x9	-	-	Y80-T15
	..20..11	Y4015-M3.5x11	-	-	Y80-T15
	..25..11	Y4015-M3.5x12	YAADN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..32..11	Y4015-M3.5x14	YAADN-2-0001	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - Internal
Internal Holders for DC Insert**

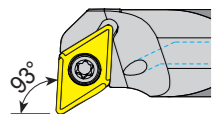


: p. 79 unit:mm

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert		
●	A10H - SDUCR/L 07	1206 1207	13	10	9	8	100	DC0702		
	A12H - SDUCR/L 07	1208 1209	16	12	11	9	100			
	A16M - SDUCR/L 07	1210 1211	20	16	14.8	11	150			
	A20P - SDUCR/L 07	1212 1213	25	20	18.3	13	170			
	S10K - SDUCR/L 07	1222 1223	13	10	9	8	125			
	X S12K - SDUCR/L 07	1224 1225	16	12	11	9	125			
	X S16P - SDUCR/L 07	1226 1227	20	16	14.8	11	170			
	X S20R - SDUCR/L 07	1228 1229	25	20	18.3	13	200			
	●	A16M - SDUCR/L 11	1214 1215	20	16	14.8	11		150	DC11T3
		A20P - SDUCR/L 11	1216 1217	25	20	18.3	13		170	
A25R - SDUCR/L 11		1218 1219	32	25	23	17	200			
A32S - SDUCR/L 11		1220 1221	40	32	30	22	250			
X S16P - SDUCR/L 11		1230 1231	20	16	14.8	11	170			
X S20R - SDUCR/L 11		1232 1233	25	20	18.3	13	200			
X S25S - SDUCR/L 11		1234 1235	32	25	23	17	250			
X S32T - SDUCR/L 11		1236 1237	40	32	30	22	300			
X S40U - SDUCR/L 11		1238 1239	50	40	37.5	27	350			
X S50V - SDUCR/L 11		- 1240	63	50	47	35	400			
●	E10M - SDUCR/L 07	1241 1242	13	10	9	8	150	DC0702		
	E12Q - SDUCR/L 07	1243 1244	16	12	11	9	180	DC0702		
	E16R - SDUCR/L 11	0339 1245	20	16	14.8	11	200	DC11T3		
	E20S - SDUCR/L 11	1246 1247	23	20	18.3	12	250	DC11T3		



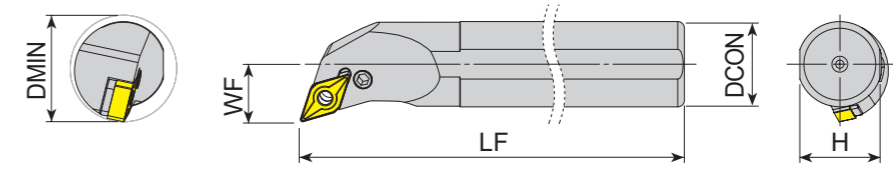
..SDUCR/L
(Screw Type 93°)



E..SDUCR/L
(Screw Type 93° Carbide)

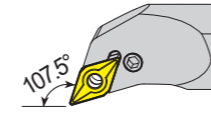
Series	Size	Screw	Shim	Shim Screw	Torx Key
..SDUCR/L	..07	Y4008-M2.5x6	-	-	Y80-T08
	..16..11	Y4015-M3.5x9	-	-	Y80-T15
	..20..11	Y4015-M3.5x11	-	-	Y80-T15
	..25..11	Y4015-M3.5x12	YAADN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..32..11	Y4015-M3.5x14	YAADN-2-0001	YAAV-06-M3.5x11	Y80-T15
E..SDUCR/L	..07	Y4008-M2.5x6	-	-	Y80-T08
	..11	Y4015-M3.5x9	-	-	Y80-T15

Turning - Holder - Internal
Internal Holders for DN Insert**

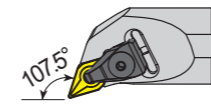


: p. 63 unit:mm

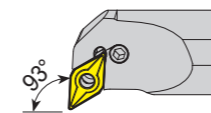
Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
●	A32S - PDQNR/L 1504	0895 -	40	32	30	22	250	DN1504
	A40T - PDQNR/L 1504	0896 -	50	40	37.5	27	300	
	S32T - PDQNR/L 1504	0903 -	40	32	30	22	300	
	X S40U - PDQNR/L 1504	0904 -	50	40	37.5	27	350	
	S50V - PDQNR/L 1504	0905 -	63	50	47	35	400	
●	A32S - PDQNR/L 15	0897 0898	40	32	30	22	250	DN1506
	A40T - PDQNR/L 15	0899 0900	50	40	37.5	27	300	
	A50U - PDQNR/L 15	0901 0902	63	50	47	35	350	
	X S32T - PDQNR/L 15	0906 0907	40	32	30	22	300	
	X S40U - PDQNR/L 15	0908 0909	50	40	37.5	27	350	
●	S50V - PDQNR/L 15	0910 0911	63	50	47	35	400	DN1506
	S25S - TDQNR/L 15	0912 0913	32	25	23	17	250	
	X S32T - TDQNR/L 15	0914 0915	40	32	30	22	300	
	X S40U - TDQNR/L 15	0916 0917	50	40	37.5	27	350	
	S50V - TDQNR/L 15	0918 0919	63	50	47	35	400	
●	A32S - PDUNR/L 15	0920 0921	40	32	30	22	250	DN1506
	A40T - PDUNR/L 15	0922 0923	50	40	37.5	27	300	
	A50U - PDUNR/L 15	0924 0925	63	50	47	35	350	
	X S25S - PDUNR/L 15	0934 0935	32	25	23	19	250	
	X S32T - PDUNR/L 15	0936 0937	40	32	30	22	300	
●	S40U - PDUNR/L 15	0938 0939	50	40	37.5	27	350	DN1506
	S50V - PDUNR/L 15	0940 0941	63	50	47	35	400	
	S25S - TDUNR/L 15	0942 0943	34	25	23	17	250	
	X S32T - TDUNR/L 15	0944 0945	40	32	30	22	300	
	X S40U - TDUNR/L 15	0946 0947	50	40	37.5	27	350	
●	S50V - TDUNR/L 15	0948 0949	63	50	47	35	400	DN1506



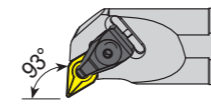
..PDQNR/L
(Lever Type 107.5°)



..TDQNR/L
(Hole Clamp Type 107.5°)



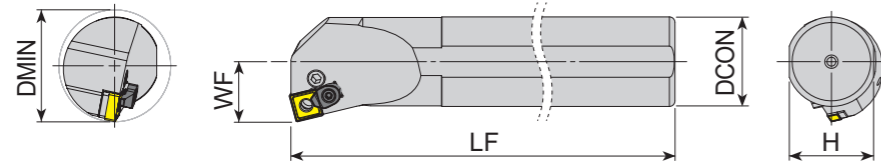
..PDUNR/L
(Lever Type 93°)



..TDUNR/L
(Hole Clamp Type 93°)

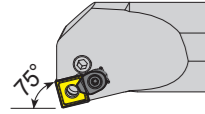
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Shim	Shim Screw	Shim Pin	Allen Key
..PDQNR/L	..15	YAPL-03	YALV-03-M8x19	-	-	-	-	YAADN-3-0001	-	YAAV-02	YAAL-03-3
	..1504	YAPL-03	YALV-03-M8x19	-	-	-	-	YAADN-2-0003	-	YAAV-02	YAAL-03-3
..TDQNR/L	..25..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	-	YAADN-3-0001	YAAV-13-M5x8	-	YAAL-03-3
	..32~50..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3
..PDUNR/L	..25..15	YAPL-03	YALV-08-M8x16	-	-	-	-	YAADN-3-0001	-	YAAV-02	YAAL-03-3
	..32~50..15	YAPL-03	YALV-03-M8x19	-	-	-	-	YAADN-3-0001	-	YAAV-02	YAAL-03-3
..TDUNR/L	..25..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-13-M5x8	-	YAAL-03-3
	..32~50..15	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	YAADN-3-0001	YAAV-02-M5x12	-	YAAL-03-3

Turning - Holder - Internal
Internal Holders for SN Insert**



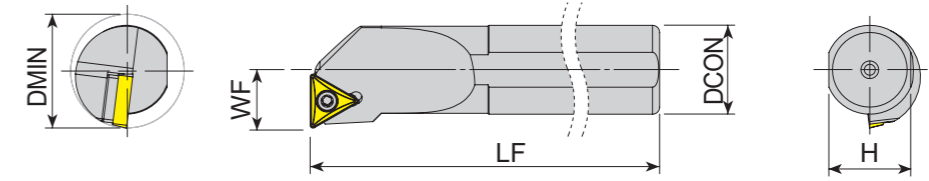
* 'C' Letter at Last : Optional Clamp Included

: p.67 unit:mm

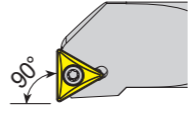
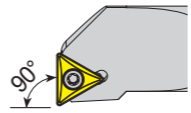
Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
 ..-PSKNR/L (Lever Type 75°)	X S25S - PSKNR/L 12C	0958 0959	32	25	23	17	250	SN1204
	S32T - PSKNR/L 12C	0960 0961	40	32	30	22	300	

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Shim	Shim Pin	Allen Key
..-PSKNR/L	..25..12C	YAPL-02	YALV-08-M8x16	YACK-05	Y4015-M4x11	YAASN-3-0004	YAAY-02	YAAL-03-3
	..32..12C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	YAASN-3-0004	YAAY-02	YAAL-03-3

Turning - Holder - Internal
Internal Holders for TC Insert**

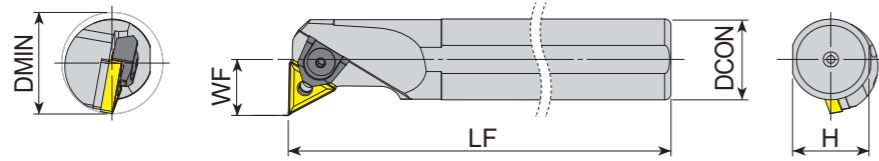


: p.82 unit:mm

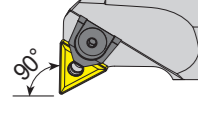
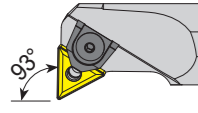
Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert	
 ..-STFCR/L (Screw Type 90°)	S12K - STFCR/L 11	1264 1265	17	12	11	9	125	TC1102	
	X S16P - STFCR/L 11	1266 1267	20	16	14.8	11	170		
	S20R - STFCR/L 11	1268 1269	25	20	18.3	13	200		
	X	S16P - STFCR/L 16	1270 1271	20	16	14.8	11	170	TC16T3
		S20R - STFCR/L 16	1272 1273	25	20	18.3	13	200	
		S25S - STFCR/L 16	1274 1275	32	25	23	17	250	
	S32T - STFCR/L 16	1276 1277	40	32	30	22	300		
	S40U - STFCR/L 16	1278 -	50	40	37.5	27	350		
 ..-STUCR/L (Screw Type 93°)	S12K - STUCR/L 11	1279 1280	17	12	11	9	125	TC1102	
	X S16P - STUCR/L 11	1281 1282	20	16	14.8	11	170		
	S20R - STUCR/L 11	1283 1284	25	20	18.3	13	200		
	X	S16P - STUCR/L 16	1285 1286	20	16	14.8	11	170	TC16T3
		S20R - STUCR/L 16	1287 1288	25	20	18.3	13	200	
		S25S - STUCR/L 16	1289 1290	32	25	23	17	250	
	S32T - STUCR/L 16	1291 1292	40	32	30	22	300		
	S40U - STUCR/L 16	1293 1294	50	40	37.5	27	350		

Series	Size	Screw	Shim	Shim Screw	Torx Key
..-STFCR/L	..12~20..11	Y4008-M2.5x6	-	-	Y80-T08
	..16..16	Y4015-M3.5x9	-	-	Y80-T15
	..20..16	Y4015-M3.5x11	-	-	Y80-T15
	..25..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..32~40..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15
..-STUCR/L	..11	Y4008-M2.5x6	-	-	Y80-T08
	..16..16	Y4015-M3.5x9	-	-	Y80-T15
	..20..16	Y4015-M3.5x11	-	-	Y80-T15
	..25..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-08-M3.5x8	Y80-T15
	..32~40..16	Y4015-M3.5x14	YAATN-2-0001	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - Internal
Internal Holders for TN Insert**



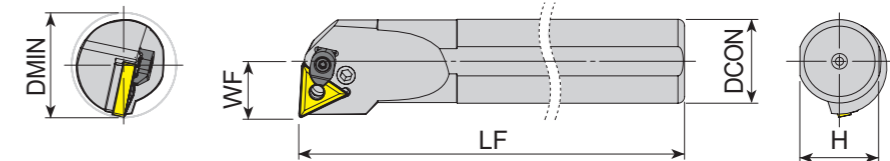
□: p. 69 unit:mm

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
 ..-MTFNR/L (Pin + Top Clamp Type 90°)	X S20R - MTFNR/L 16	0972 -	25	20	18.3	14	200	TN1604
	S25S - MTFNR/L 16	0973 0974	32	25	23	17	250	
	S32T - MTFNR/L 16	0975 0976	40	32	30	22	300	
	S40U - MTFNR/L 16	0977 0978	50	40	37.5	27	350	
	S32T - MTFNR/L 22	0979 0980	40	32	30	22	300	
X S40U - MTFNR/L 22	0981 0982	50	40	37.5	27	350	TN2204	
S50V - MTFNR/L 22	0983 -	63	50	47	35	400		
 ..-MTUNR/L (Pin + Top Clamp Type 93°)	X S20R - MTUNR/L 16	0998 0999	25	20	18.3	13	200	TN1604
	S25S - MTUNR/L 16	1000 1001	32	25	23	17	250	
	S32T - MTUNR/L 16	1002 1003	40	32	30	22	300	
	S40U - MTUNR/L 16	1004 1005	50	40	37.5	27	350	
	S50V - MTUNR/L 16	1006 1007	63	50	47	35	400	

▶ NEXT PAGE

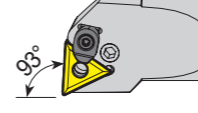
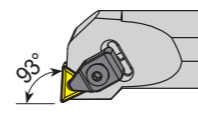
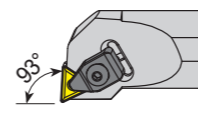
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
..-MTFNR/L	..20..16	-	-	YAMK-02	YAKV-17-M5x15	-	-	YAPM-03	-	-	-	YAAL-03-3
	..25..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-14	YAATN-2-0002	-	-	YAAL-03-3
	..32~40..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-01	YAATN-2-0002	-	-	YAAL-03-3
	..22	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-02	YAATN-3-0015	-	-	YAAL-03-3
..-MTUNR/L	..20..16	-	-	YAMK-02	YAKV-17-M5x15	-	-	YAPM-03	-	-	-	YAAL-03-3
	..25..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-14	YAATN-2-0002	-	-	YAAL-03-3
	..32~50..16	-	-	YAMK-04	YAKV-30-M6x22	YABPL-01	YAS-01	YAPM-01	YAATN-2-0002	-	-	YAAL-03-3

Turning - Holder - Internal
Internal Holders for TN Insert**



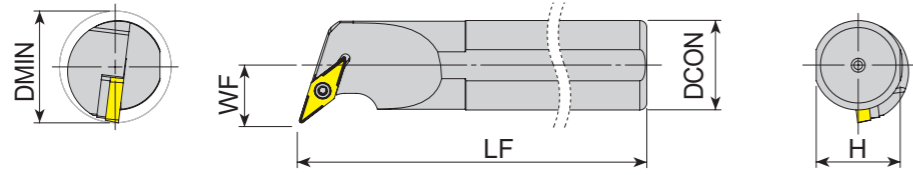
□: p. 69 unit:mm

* 'C' Letter at Last : Optional Clamp Included

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
 ..-PTUNR/L (Lever Type 93°)	S16P - PTUNR/L 16	1014 1015	20	16	14.8	11	170	TN1604
	S20R - PTUNR/L 16	1016 1017	25	20	18.3	13	200	
	X S25S - PTUNR/L 16C	1018 1019	32	25	23	17	250	
	S32T - PTUNR/L 16C	1020 1021	40	32	30	22	300	
	S40U - PTUNR/L 16C	1022 1023	50	40	37.5	27	350	
 ..-TTUNR/L (Hole Clamp Type 93°)	X S32T - PTUNR/L 22C	1024 1025	40	32	30	22	300	TN2204
	X S40U - PTUNR/L 22C	1026 1027	50	40	37.5	27	350	
	S50V - PTUNR/L 22C	1028 1029	63	50	47	35	400	
 ..-TTUNR/L (Hole Clamp Type 93°)	X S25S - TTUNR/L 16	1030 1031	32	25	23	17	250	TN1604
	S32T - TTUNR/L 16	1032 1033	40	32	30	22	300	
	S25S - TTUNR/L 22	1034 1035	32	25	23	17	250	
	X S32T - TTUNR/L 22	1036 1037	40	32	30	22	300	
	S40U - TTUNR/L 22	1038 1039	50	40	37.5	27	350	
S50V - TTUNR/L 22	1040 1041	63	50	47	35	400	TN2204	

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
..-PTUNR/L	..16..16	YAPL-08	YALV-07-M6x13	-	-	-	-	-	-	-	YAAY-07	YAAL-02-2.5
	..20..16	YAPL-01	YALV-01-M6x14	-	-	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..16C	YAPL-01	YALV-02-M6x17	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0025	-	YAAY-01	YAAL-02-2.5
	..22C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAATN-3-0015	-	YAAY-02	YAAL-03-3
	..16	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAATN-2-0002	YAAV-03-M5x12	-	YAAL-03-3
..22	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAATN-3-0015	YAAV-02-M5x12	-	YAAL-03-3	

Turning - Holder - Internal
Internal Holders for VB Insert**

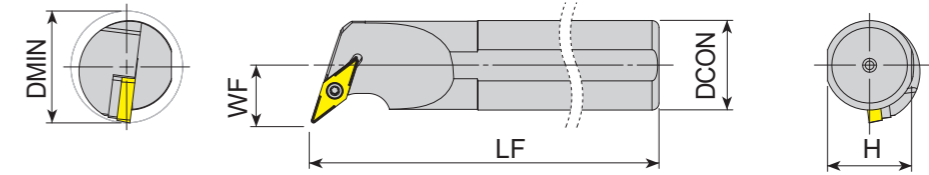


: p.83 unit:mm

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
 ..-SVQBR/L (Screw Type 107.5°)	A20Q - SVQBR/L 16	1299 1300	30	20	18.3	20	180	VB1604
	● A25S - SVQBR/L 16	1301 1302	32	25	23	17	250	
	A32S - SVQBR/L 16	1303 1304	40	32	30	22	250	
	S25S - SVQBR/L 16	1305 1306	32	25	23	17	250	
	X S32T - SVQBR/L 16	1307 1308	40	32	30	22	300	
	S40U - SVQBR/L 16	1309 1310	50	40	37.5	27	350	
 ..-SVJBR/L (Screw Type 93°)	S25S - SVJBR/L 16	1295 1296	32	25	23	17	250	VB1604
	X S32T - SVJBR/L 16	1297 1298	40	32	30	22	300	
 ..-SVUBR/L (Screw Type 93°)	● A20Q - SVUBR/L 16	1311 -	30	20	18.3	20	180	VB1604
	A32S - SVUBR/L 16	1312 1313	40	32	30	22	250	
	S25S - SVUBR/L 16	1314 1315	32	25	23	19	250	
	X S32T - SVUBR/L 16	1316 1317	40	32	30	22	300	
	S40U - SVUBR/L 16	1318 1319	50	40	37.5	27	350	

Series	Size	Screw	Shim	Shim Screw	Torx Key
..-SVQBR/L	..20..16	Y4015-M3.5x11	-	-	Y80-T15
	..25..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
	..25..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-08-M3.5x8	Y80-T15
	..32~40..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
..-SVJBR/L	..16	Y4015-M3.5x12	YAAVN-2-0002	YAAV-08-M3.5x8	Y80-T15
..-SVUBR/L	..20..16	Y4015-M3.5x11	-	-	Y80-T15
	..25~40..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - Internal
Internal Holders for VC Insert**

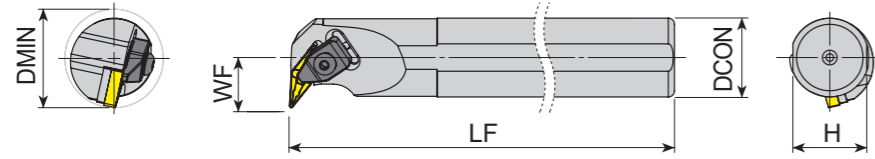


: p.84 unit:mm

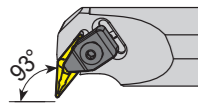
Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
 ..-SVQCR/L (Screw Type 107.5°)	S25S - SVQCR/L 16	1320 1321	32	25	23	17	250	VC1604
	X S32T - SVQCR/L 16	1322 1323	40	32	30	22	300	
	S40U - SVQCR/L 16	1324 1325	50	40	37.5	27	350	
 ..-SVUCR/L (Screw Type 93°)	● A25R - SVUCR/L 16	1326 -	32	25	23	19	200	VC1604
	S25S - SVUCR/L 16	1327 1328	32	25	23	19	250	
	X S32T - SVUCR/L 16	1329 1330	40	32	30	22	300	
	S40U - SVUCR/L 16	1331 1332	50	40	37.5	27	350	

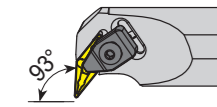
Series	Size	Screw	Shim	Shim Screw	Torx Key
..-SVQCR/L	..25..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-08-M3.5x8	Y80-T15
	..32~40..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15
..-SVUCR/L	..16	Y4015-M3.5x14	YAAVN-2-0002	YAAV-06-M3.5x11	Y80-T15

Turning - Holder - Internal
Internal Holders for VN Insert**



: p. 73 unit:mm

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert
 ..TVUNR/L (Hole Clamp Type 93°)	S25S - TVUNR/L 16	1042 1043	36	25	23	20	250	VN1604
	S32T - TVUNR/L 16	1044 1045	40	32	30	22	300	
	S40U - TVUNR/L 16	1046 1047	50	40	37.5	27	350	

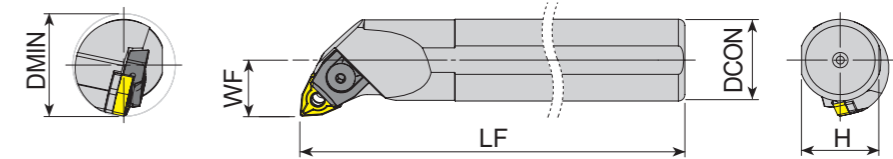


..TVUNR/L
(Hole Clamp Type 93°)

X

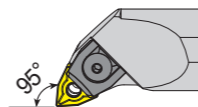
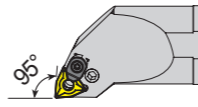
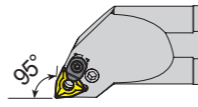
VN1604

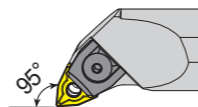
Turning - Holder - Internal
Internal Holders for WN Insert**



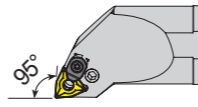
: p. 75 unit:mm

* 'C' Letter at Last : Optional Clamp Included

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert	
 ..MWLNR/L (Pin + Top Clamp Type 95°)	S16P - MWLNR/L 06	1064 1065	20	16	14.8	11	170	WN0604	
	X S20R - MWLNR/L 06	1066 1067	25	20	18.3	13	200		
	S25S - MWLNR/L 06	1068 1069	32	25	23	17	250		
	S25S - MWLNR/L 08	1070 1071	32	25	23	17	250		
 ..PWLNR/L (Lever Type 95°)	X S32T - MWLNR/L 08	1072 1073	40	32	30	22	300	WN0804	
	S40U - MWLNR/L 08	1074 1075	50	40	37.5	27	350		
	A20P - PWLNR/L 06	1048 1049	25	20	18.3	13	170		WN0604
	● A25R - PWLNR/L 06	1050 1051	32	25	23	17	200		
A32S - PWLNR/L 06	1052 1053	40	32	30	22	250			
S20R - PWLNR/L 06	1076 1077	25	20	18.3	13	200			
 ..PWLNR/L (Lever Type 95°)	X S25S - PWLNR/L 06	1078 1079	32	25	23	17	250	WN0804	
	S32T - PWLNR/L 06	1080 1081	40	32	30	22	300		
	● A25R - PWLNR/L 08C	1054 1055	32	25	23	17	200		
	● A32S - PWLNR/L 08C	1056 1057	40	32	30	22	250		
	● A40T - PWLNR/L 08C	1058 1059	50	40	37.5	27	300		
	A50U - PWLNR/L 08C	1060 1061	63	50	47	35	350		
	S25S - PWLNR/L 08C	1082 1083	32	25	23	17	250		
	X S32T - PWLNR/L 08C	1084 1085	40	32	30	22	300		
X S40U - PWLNR/L 08C	1086 1087	50	40	37.5	27	350			
S50V - PWLNR/L 08C	1088 1089	63	50	47	35	400			



..MWLNR/L
(Pin + Top Clamp Type 95°)

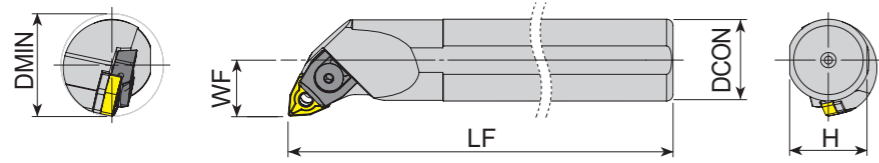


..PWLNR/L
(Lever Type 95°)

Series	Size	Clamp	Clamp Screw	Upper Ring	Shim	Shim Screw	Allen Key
..TVUNR/L	..16	YATK-01	YAKV-01-M5x22	YABPL-01	YAAVN-2-0002	YAAV-04-M5x12	YAAL-03-3

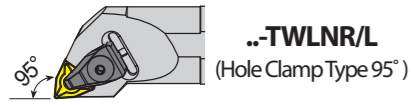
Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
..MWLNR/L	..16..06	-	-	YAMK-01	YAKV-17-M5x15	-	-	YAPM-09	-	-	-	-
	..20..06	-	-	YAMK-01	YAKV-04-M5x17	-	-	YAPM-10	-	-	-	-
	..25..06	-	-	YAMK-01	YAKV-04-M5x17	-	-	YAPM-08	-	-	-	-
	..25..08	-	-	YAMK-05	YAKV-27-M6x20	YABPL-01	YAS-01	YAPM-04	YAAWN-3-0001	-	-	YAAL-03-3
..PWLNR/L	..32~40..08	-	-	YAMK-05	YAKV-03-M6x22	YABPL-01	YAS-01	YAPM-02	YAAWN-3-0001	-	-	YAAL-03-3
	..20..06	YAPL-01	YALV-01-M6x14	-	-	-	-	-	YAAWN-SW317	-	YAAY-01	YAAL-02-2.5
..PWLNR/L	..25~32..06	YAPL-01	YALV-02-M6x17	-	-	-	-	-	YAAWN-SW317	-	YAAY-01	YAAL-02-2.5
	..08C	YAPL-02	YALV-03-M8x19	YACK-05	Y4015-M4x11	-	-	-	YAAWN-3-0001	-	YAAY-02	YAAL-03-3

Turning - Holder - Internal
Internal Holders for WN Insert**



□: p. 75 unit:mm

Series	Designation	EDP 2700.. R L	DMIN	DCON	H	WF	LF	Insert	
X	S25S - TWLNR/L 06	1090 1091	32	25	23	17	250	WN0604	
	S32T - TWLNR/L 06	1092 1093	40	32	30	22	300		
	A40T - TWLNR/L 08	1062 -	50	40	37.5	27	300		
●	A50U - TWLNR/L 08	1063 -	63	50	47	35	350	WN0804	
	S25S - TWLNR/L 08	1094 1095	32	25	23	17	250		
	X	S32T - TWLNR/L 08	1096 1097	40	32	30	22		300
	S40U - TWLNR/L 08	1098 1099	50	40	37.5	27	350		
	S50V - TWLNR/L 08	1100 1101	63	50	47	35	400		



..-TWLNR/L
 (Hole Clamp Type 95°)

Series	Size	Lever	Lever Screw	Clamp	Clamp Screw	Upper Ring	Lower Ring	Pin	Shim	Shim Screw	Shim Pin	Allen Key
..TWLNR/L	..06	-	-	YATK-01	YAKV-01-M5x22	YABPL-01	-	-	YAAWN-SW317	YAAV-01-M3x10	-	YAAL-03-3
	..25..08	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAAWN-3-0001	YAAV-13-M5x8	-	YAAL-03-3
	..32~50..08	-	-	YATK-02	YAKV-30-M6x22	YABPL-01	YAS-01	-	YAAWN-3-0001	YAAV-02-M5x12	-	YAAL-03-3

Turning Inserts Overview

Negative Inserts

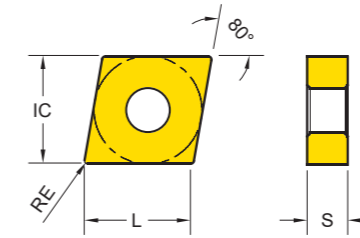
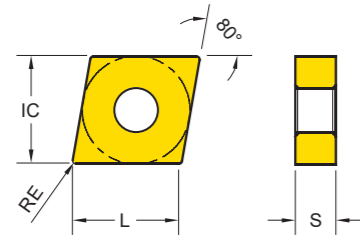
Shape	Series	Size				Page
C	CNMA	12	16	19	60	
	CNMG	12	16	19		
D	DNMA	1504	1506		63	
	DNMG	1504	1506			
K	KNUX	16			66	
S	SNMA	12	15		67	
	SNMG	12				
T	TNMA	16			69	
	TNMG	16	22			
	TNUX	16				
V	VNMA	16			73	
	VNMG	16				
W	WNMA		08		75	
	WNMG	06	08			

Positive Inserts

Shape	Series	Size				Page
C	CCGT		09	12	78	
	CCMT	06	09	12		
D	DCGT		11		79	
	DCMT	07	11			
R	RCMT	06	08	10	12	80
S	SCMT	09	12			81
T	TCGT		16		82	
	TCMT	11	16			
V	VBMT	16			83	
	VCGT / VCMT	16			84	

Turning Inserts - Negative
CNMG / CNMA (80° Negative)

Turning Inserts - Negative
CNMG / CNMA (80° Negative)



Series	L	IC	S
CN** 1204	12	12.7	4.76
CN** 1606	16	15.875	6.35
CN** 1906	19	19.05	6.35

Series	L	IC	S
CN** 1204	12	12.7	4.76
CN** 1606	16	15.875	6.35
CN** 1906	19	19.05	6.35

EDP 2200.. ●: Stock item ○: Order made item

EDP 2200.. ●: Stock item ○: Order made item

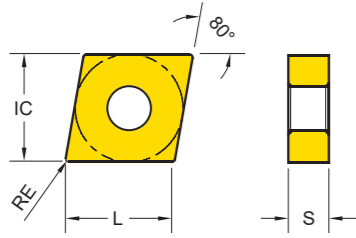
CNMA CNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10						
..MA Cast iron	CNMA 120404	0.4	0.15~0.5	0.5~2.5	●0089	●0354														
	CNMA 120408	0.8	0.15~0.5	1~3.5	●0010	●0355														
	CNMA 120412	1.2	0.15~0.5	1.5~5	●0011	●0356														
	CNMA 160612	1.2	0.15~0.5	1.5~5	●0012	●0357														
	CNMA 160616	1.6	0.15~0.5	2~5	●0446	●0447														
	CNMA 190616	1.6	0.15~1	3~10	●0448	●0449														
-UF Finishing	CNMG 120404 - UF	0.4	0.05~0.25	0.5~1.5	●0178	●0179	●0180	●0003												
	CNMG 120408 - UF	0.8	0.05~0.25	1~2.5	●0189	●0190	●0191													
-UL Light Machining and Sticky Material	CNMG 120404 - UL	0.4	0.1~0.3	0.5~2	●0358	●0359	●0524													
	CNMG 120408 - UL	0.8	0.1~0.3	1~3	●0192	●0193	●0194													
	CNMG 120412 - UL	1.2	0.1~0.3	1.5~3.5	●0201	●0202	●0203													
-UM Medium Machining Unstable condition	CNMG 120404 - UM	0.4	0.15~0.3	0.5~1.5	●0184	●0185	●0186													
	CNMG 120408 - UM	0.8	0.15~0.3	0.5~2	●0338	●0114	●0100	●0140												
	CNMG 120412 - UM	1.2	0.15~0.3	1.5~3.0	●0525	●0486	●0526													

CNMA CNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10						
-UG Medium Machining at stable condition	CNMG 120404 - UG	0.4	0.2~0.4	0.5~2		●0181	●0182	●0183												
	CNMG 120408 - UG	0.8	0.2~0.4	1~3	●0337	●0113	●0099	●0139	●0001											
	CNMG 120412 - UG	1.2	0.2~0.4	1.5~4	●0685	●0198	●0199	●0200												
	CNMG 160608 - UG	0.8	0.20~0.40	1.5~5.0				●0749												
	CNMG 160612 - UG	1.2	0.2~0.4	1.5~5		●0530	●0508	●0531												
	CNMG 160616 - UG	1.6	0.2~0.4	1.8~5		●0534	●0510	●0535												
-UC Cast iron and Medium roughing	CNMG 120404 - UC	0.4	0.2~0.4	0.5~2.5	●0096	●0115	●0101	●0116												
	CNMG 120408 - UC	0.8	0.2~0.4	1~4	●0062	●0117	●0102	●0118												
	CNMG 120412 - UC	1.2	0.2~0.4	1.5~4.5	●0088	●0119	●0103	●0120												
-UR Roughing	CNMG 120408 - UR	0.8	0.3~0.5	1~4		●0195	●0196	●0197												
	CNMG 120412 - UR	1.2	0.3~0.5	1.5~5		●0204	●0205	●0206	●0004											
	CNMG 120416 - UR	1.6	0.3~0.5	2~5		●0707	●0623													
	CNMG 160612 - UR	1.2	0.3~0.5	1.5~5		●0532	●0509	●0533												
	CNMG 160616 - UR	1.6	0.3~0.5	2~5	●0676	●0536	●0511	●0537												
	CNMG 190608 - UR	0.8	0.3~0.8	3.0~9.0		●0804	●0805	●0806												
-UR	CNMG 190612 - UR	1.2	0.3~0.8	3~9	●0450	●0451	●0698	●0699												
	CNMG 190616 - UR	1.6	0.3~0.8	3.0~9.0	●0480	●0481	●0734	●0735												

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	350 1200 250 800
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	350 1200 250 800
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative
CNMG / CNMA (80° Negative)



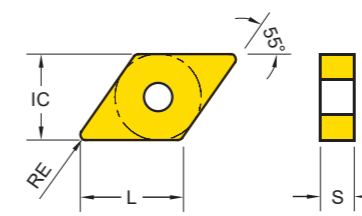
Series	L	IC	S
CN** 1204	12	12.7	4.76
CN** 1606	16	15.875	6.35
CN** 1906	19	19.05	6.35

EDP 2200.. ● : Stock item ○ : Order made item

CNMA CNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..																	
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10								
-MF Stainless steel Finishing	CNMG 120404 - MF	0.4	0.07~0.3	0.2~1.5																		
	CNMG 120408 - MF	0.8	0.07~0.3	0.2~1.5																		
-MM Stainless steel Medium	CNMG 120404 - MM	0.4	0.2~0.35	0.5~3																		
	CNMG 120408 - MM	0.8	0.2~0.35	1~3.5																		
	CNMG 120412 - MM	1.2	0.2~0.35	1.5~3.5																		
-MR Stainless steel Roughing	CNMG 120408 - MR	0.8	0.3~0.55	1.2~5.5																		
	CNMG 120412 - MR	1.2	0.3~0.55	1.5~5.5																		
-KR Cast Iron Heavy Roughing	CNMG 120408 - KR	0.8	0.30~0.60	1.0~5.0																		
	CNMG 120412 - KR	1.2	0.30~0.60	1.5~5.0																		

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	30	90	20
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	250

Turning Inserts - Negative
DNMG / DNMA (55° Negative)



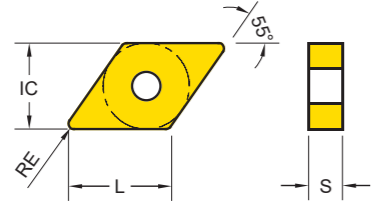
Series	L	IC	S
DN** 1504	14	12.7	4.76
DN** 1506	14	12.7	6.35

EDP 2200.. ● : Stock item ○ : Order made item

DNMA DNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..																	
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10								
..MA Cast iron	DNMA 150408	0.8	0.15~0.5	1~3																		
	DNMA 150412	1.2	0.15~0.5	1.5~4																		
	DNMA 150608	0.8	0.15~0.5	1~3																		
	DNMA 150612	1.2	0.15~0.5	1.5~4																		
-UF Finishing	DNMG 150404 - UF	0.4	0.05~0.25	0.5~1.5																		
	DNMG 150604 - UF	0.4	0.05~0.25	1~2																		
	DNMG 150608 - UF	0.8	0.05~0.25	1.5~3.5																		
-UL Light Machining and Sticky Material	DNMG 150404 - UL	0.4	0.10~0.3	0.5~3.0																		
	DNMG 150408 - UL	0.8	0.10~0.3	1.0~3.0																		
	DNMG 150412 - UL	1.2	0.10~0.3	1.5~3.0																		
	DNMG 150604 - UL	0.4	0.1~0.3	0.5~2																		
	DNMG 150608 - UL	0.8	0.1~0.3	1.5~3																		
-UM Medium Machining Unstable condition	DNMG 150612 - UL	1.2	0.10~0.3	1.5~3.0																		
	DNMG 150408 - UM	0.8	0.15~0.3	1.0~3.0																		
	DNMG 150412 - UM	1.2	0.15~0.3	1.5~4																		
	DNMG 150608 - UM	0.8	0.15~0.3	0.5~2																		
DNMG 150612 - UM	1.2	0.15~0.3	1.5~3.0																			

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	30	90	20
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	250

Turning Inserts - Negative
DNMG / DNMA (55° Negative)

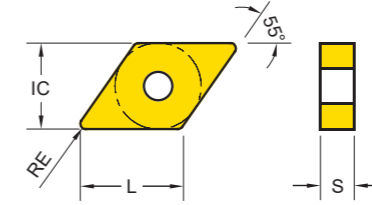


Series	L	IC	S
DN** 1504	14	12.7	4.76
DN** 1506	14	12.7	6.35

EDP 2200.. ●: Stock item ○: Order made item

DNMA DNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05		P10		P20		P30		M15		M30		M40		N20		N20		
					K10	K20	P20	M20	P20	S10	S20	S30	N20	N20									
-UG Medium Machining at stable condition	DNMG 150404 - UG	0.4	0.2~0.4	0.5~3.0																			
	DNMG 150408 - UG	0.8	0.2~0.4	1~2.5	●	●	●	●	●	●													
	DNMG 150412 - UG	1.2	0.2~0.4	1.5~3	●																		
	DNMG 150604 - UG	0.4	0.2~0.4	0.5~2																			
	DNMG 150608 - UG	0.8	0.2~0.4	1~3	●	●	●	●	●	●													
	DNMG 150612 - UG	1.2	0.2~0.4	1.5~3.5	●	●	●	●	●	●													
-UC Cast iron and Medium roughing	DNMG 150408 - UC	0.8	0.2~0.4	1~3	●	●																	
	DNMG 150412 - UC	1.2	0.2~0.4	1.5~3.5	●	●																	
	DNMG 150608 - UC	0.8	0.2~0.4	1~3	●	●	●	●	●	●													
	DNMG 150612 - UC	1.2	0.2~0.4	1.5~3.5	●	●	●	●	●	●													
-UR Roughing	DNMG 150408 - UR	0.8	0.3~0.5	1~3.5		●																	
	DNMG 150412 - UR	1.2	0.3~0.5	1.5~4		●																	
	DNMG 150608 - UR	0.8	0.3~0.5	1.0~5.0	●	●	●																
	DNMG 150612 - UR	1.2	0.3~0.5	1.5~4	●	●	●	●	●	●													

Turning Inserts - Negative
DNMG / DNMA (55° Negative)



Series	L	IC	S
DN** 1504	14	12.7	4.76
DN** 1506	14	12.7	6.35

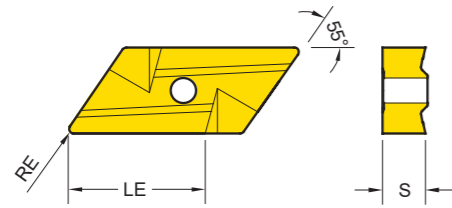
EDP 2200.. ●: Stock item ○: Order made item

DNMA DNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05		P10		P20		P30		M15		M30		M40		N20		N20	
					K10	K20	P20	M20	P20	S10	S20	S30	N20	N20								
-MF Stainless steel Finishing	DNMG 150404 - MF	0.4	0.07~0.3	0.2~1.5																		
	DNMG 150408 - MF	0.8	0.07~0.3	0.2~1.5																		
	DNMG 150604 - MF	0.4	0.07~0.3	0.2~1.5																		
	DNMG 150608 - MF	0.8	0.07~0.3	0.2~1.5																		
-MM Stainless steel Medium	DNMG 150404 - MM	0.4	0.2~0.35	0.5~3																		
	DNMG 150408 - MM	0.8	0.2~0.35	1~3.5																		
	DNMG 150412 - MM	1.2	0.2~.35	1.5~3.5																		
	DNMG 150604 - MM	0.4	0.2~0.35	0.5~3																		
	DNMG 150608 - MM	0.8	0.2~0.35	1~3.5																		
	DNMG 150612 - MM	1.2	0.2~0.35	1.5~3.5																		
-MR Stainless steel Roughing	DNMG 150408 - MR	0.8	0.3~0.55	2.0~5.5																		
	DNMG 150412 - MR	1.2	0.3~0.55	2.0~5.5																		
	DNMG 150608 - MR	0.8	0.3~0.55	2.0~5.5																		
	DNMG 150612 - MR	1.2	0.3~0.55	2.0~5.5																		

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative
KNUX (55° - 2 Corners Single Side)

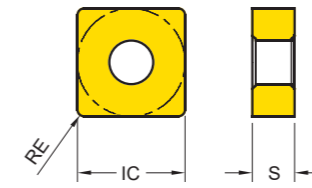


Series	LE	S
KN** 1604	15	4.76

EDP 2200.. ●: Stock item ○: Order made item

KNUX	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10						
..UX Left	KNUX 160405 L	0.5	0.1~0.4	0.5~6	●	●	●	●	●											
..UX Right	KNUX 160405 R	0.5	0.1~0.4	0.5~6	○	○	○	○	○											

Turning Inserts - Negative
SNMG / SNMA (90° Negative)



Series	IC	S
SN** 1204	12.7	4.76
SN** 1506	15.875	6.35

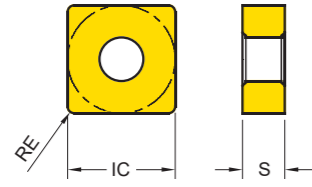
EDP 2200.. ●: Stock item ○: Order made item

SNMA SNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10						
..MA Cast iron	SNMA 120408	0.8	0.15~0.5	1~3.5	●															
	SNMA 120412	1.2	0.15~0.5	1.5~5	●															
	SNMA 150612	1.2	0.15~0.5	1.5~5	●															
-UF Finishing	SNMG 120404 - UF	0.4	0.05~0.25	0.5~1.5					●											
-UL Light Machining and sticky material	SNMG 120404 - UL	0.4	0.10~0.30	0.5~3.0				●												
	SNMG 120408 - UL	0.8	0.1~0.3	1~3	●	●	●													
-UM For Medium & Unstable conditions	SNMG 120408 - UM	0.8	0.15~0.30	1.0~3.0	●	●	●													
-UG Medium Machining at stable condition	SNMG 120408 - UG	0.8	0.2~0.4	1~3	●	●	●	●												
	SNMG 120412 - UG	1.2	0.2~0.4	1.5~4	●	●	●													
	SNMG 120416 - UG	1.6	0.2~0.40	2.0~3.0	●															
-UC Cast iron and Medium roughing	SNMG 120408 - UC	0.8	0.2~0.4	1~4	●	●	●	●												
	SNMG 120412 - UC	1.2	0.2~0.4	1.5~4.5	●	●	●	●												

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative
SNMG / SNMA (90° Negative)



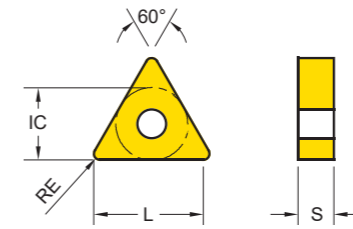
Series	IC	S
SN** 1204	12.7	4.76

EDP 2200.. ●: Stock item ○: Order made item

SNMA SNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10						
-UR Roughing	SNMG 120408 - UR	0.8	0.3~0.5	1~4.5	●	●	●													
	SNMG 120412 - UR	1.2	0.3~0.5	1.5~5		●	●	●		●										
-MF Stainless steel Finishing	SNMG 120408 - MF	0.8	0.07~0.3	0.2~1.5				●	●	●	●									
	SNMG 120412 - MF	1.2	0.07~0.3	0.2~1.5				●	●	●	●									
-MM Stainless steel Medium	SNMG 120408 - MM	0.8	0.2~0.35	1~3.5					●	●										
	SNMG 120412 - MM	1.2	0.2~0.35	1.5~3.5					●	●										
-MR Stainless steel Roughing	SNMG 120408 - MR	0.8	0.3~0.55	0.15~5.5					●	●	●									
	SNMG 120412 - MR	1.2	0.3~0.55	0.15~5.5				●	●	●	●									
-KR Cast Iron Heavy Roughing	SNMG 120416 - KR	1.6	0.30~0.60	2.0~5.0	●															

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative
TNMG / TNMA (60° Negative)



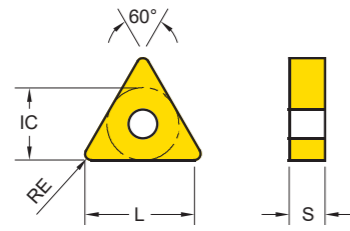
Series	L	IC	S
TN** 1604	15.7	9.525	4.76
TN** 2204	22	12.7	4.76

EDP 2200.. ●: Stock item ○: Order made item

TNMA TNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10						
..MA Cast iron	TNMA 160408	0.8	0.15~0.5	1~3	●															
	TNMA 160412	1.2	0.15~0.5	1.5~4	●															
-UF Finishing	TNMG 160404 - UF	0.4	0.05~0.25	1~2		●	●	●	●											
	TNMG 160408 - UF	0.8	0.05~0.25	1.5~3.5		●	●	●	●											
	TNMG 160412 - UF	1.2	0.05~0.25	1.5~3.5		●	●	●	●											
-UL Light Machining and sticky material	TNMG 220404 - UF	0.4	0.1~0.35	1~4		●					●									
	TNMG 160408 - UL	0.8	0.1~0.3	1~3		●	●	●												
-UM Medium Machining Unstable condition	TNMG 160408 - UM	0.8	0.15~0.3	0.5~2		●	●	●												
	TNMG 160412 - UM	1.2	0.15~0.3	1.5~3		●	●	●												

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative
TNMG / TNMA (60° Negative)

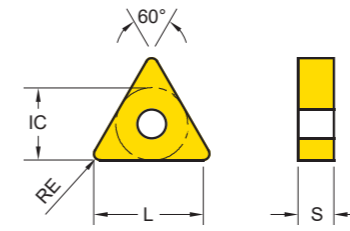


Series	L	IC	S
TN** 1604	15.7	9.525	4.76
TN** 2204	22	12.7	4.76

EDP 2200.. ●: Stock item ○: Order made item

TNMA TNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					P05 K10	P10 K20	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20						
-UG Medium Machining at Stable condition	TNMG 160404 - UG	0.4	0.2~0.4	0.5~2	●	●	●	●												
	TNMG 160408 - UG	0.8	0.2~0.4	1~3	●	●	●	●	●											
	TNMG 160412 - UG	1.2	0.2~0.4	1.5~3	●	●	●	●												
	TNMG 220408 - UG	0.8	0.25~0.6	1~4		●	●	●	●	●										
-UC Cast iron and Medium roughing	TNMG 160404 - UC	0.4	0.2~0.4	0.5~2.5	●	●	●	●												
	TNMG 160408 - UC	0.8	0.2~0.4	1~3	●	●	●	●												
	TNMG 160412 - UC	1.2	0.2~0.4	1.5~3.5	●			●												
-UR Roughing	TNMG 160408 - UR	0.8	0.30~0.50	1.0~5.0	●	●	●													
	TNMG 160412 - UR	1.2	0.3~0.5	1.5~3	●	●	●	●	●											
	TNMG 220412 - UR	1.2	0.30~0.65	1.5~4	●	●	●	●	●											
	TNMG 220416 - UR	1.6	0.3~0.65	2~4	●	●	●	●												

Turning Inserts - Negative
TNMG / TNMA (60° Negative)



Series	L	IC	S
TN** 1604	15.7	9.525	4.76
TN** 2204	22	12.7	4.76

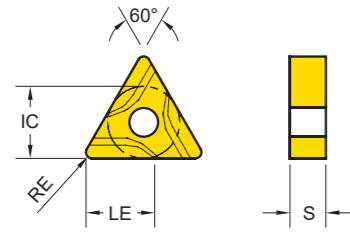
EDP 2200.. ●: Stock item ○: Order made item

TNMA TNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					P05 K10	P10 K20	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20						
-MF Stainless steel Finishing	TNMG 160404 - MF	0.4	0.05~0.3	0.2~1.5																
	TNMG 160408 - MF	0.8	0.05~0.3	0.15~1.5						●	●									
-MM Stainless steel Medium	TNMG 160404 - MM	0.4	0.2~0.35	0.5~3						●	●									
	TNMG 160408 - MM	0.8	0.15~0.3	1~3.5						●	●									
	TNMG 160412 - MM	1.2	0.15~0.3	1.5~3.5						●	●									
-MR Stainless steel Roughing	TNMG 160408 - MR	0.8	0.30~0.55	2.0~5.5						●	●									
	TNMG 160412 - MR	1.2	0.30~0.55	2.0~5.5							●	●								

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min Max	Min Max	Min Max	Min Max	Min Max	Min Max	Min Max	Min Max	Min Max	Min Max
P	1~5	Non-Alloyed Steel	220 480	170 450	180 380	150 350	120 200	- -	- -	- -	- -	- -
	6~9	Low-Alloyed Steel	220 420	180 380	110 350	90 300	70 200	- -	- -	- -	- -	- -
	10~11	High-Alloyed Steel	- -	100 330	60 300	70 250	- -	- -	- -	- -	- -	- -
M	12~13	Ferritic & Martensitic	- -	- -	- -	120 230	- -	130 230	110 180	80 150	- -	- -
	14	Austenitic Stainless Steel	- -	- -	- -	80 200	- -	100 200	40 130	30 120	- -	- -
K	15~16	Grey Cast Iron	170 420	120 300	- -	- -	- -	- -	- -	- -	- -	- -
	17~18	Nodular Cast Iron	120 410	120 280	- -	- -	- -	- -	- -	- -	- -	- -
N	21~30	Non-Ferrous Metals (Al)	- -	- -	- -	- -	- -	- -	- -	- -	350 1200	250 800
S	31~37	Superalloys & Titanium	- -	- -	- -	35 80	- -	30 90	20 40	20 40	- -	- -
H	38~41	Hard Materials	- -	- -	- -	- -	- -	- -	- -	- -	- -	- -

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min Max	Min Max	Min Max	Min Max	Min Max	Min Max	Min Max	Min Max	Min Max	Min Max
P	1~5	Non-Alloyed Steel	220 480	170 450	180 380	150 350	120 200	- -	- -	- -	- -	- -
	6~9	Low-Alloyed Steel	220 420	180 380	110 350	90 300	70 200	- -	- -	- -	- -	- -
	10~11	High-Alloyed Steel	- -	100 330	60 300	70 250	- -	- -	- -	- -	- -	- -
M	12~13	Ferritic & Martensitic	- -	- -	- -	120 230	- -	130 230	110 180	80 150	- -	- -
	14	Austenitic Stainless Steel	- -	- -	- -	80 200	- -	100 200	40 130	30 120	- -	- -
K	15~16	Grey Cast Iron	170 420	120 300	- -	- -	- -	- -	- -	- -	- -	- -
	17~18	Nodular Cast Iron	120 410	120 280	- -	- -	- -	- -	- -	- -	- -	- -
N	21~30	Non-Ferrous Metals (Al)	- -	- -	- -	- -	- -	- -	- -	- -	350 1200	250 800
S	31~37	Superalloys & Titanium	- -	- -	- -	35 80	- -	30 90	20 40	20 40	- -	- -
H	38~41	Hard Materials	- -	- -	- -	- -	- -	- -	- -	- -	- -	- -

Turning Inserts - Negative
TNUX (60° Negative)



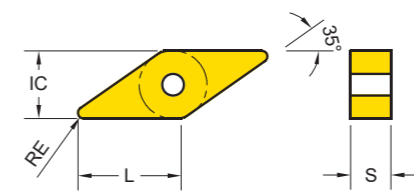
Series	LE	IC	S
TN** 1604	9.4	9.525	4.76

EDP 2200.. ●: Stock item ○: Order made item

	P05	P10	P20	P30	P20	M15	M30	M40	N20	N20
TNUX										
Designation										
RE										
Fn (mm/rev.)										
Ap (mm)										
YG1001										
YG3010										
YG3020										
YG3030										
YG801										
YG211										
YG213										
YG214										
YG100										
YG10										

	RE	Fn (mm/rev.)	Ap (mm)	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
TNUX 160404 L	0.4	0.1~0.3	0.5~4		●	●		●					
TNUX 160408 L	0.8	0.1~0.4	0.5~6		●	●	●	●	●				
TNUX 160404 R	0.4	0.1~0.3	0.5~4		●	●		●					
TNUX 160408 R	0.8	0.1~0.4	0.5~6		●	●	●	●					

Turning Inserts - Negative
VNMG / VNMA (35° Negative)



Series	L	IC	S
VN** 1604	15.8	9.525	4.76

EDP 2200.. ●: Stock item ○: Order made item

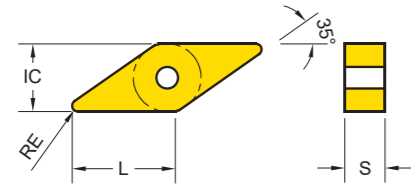
	P05	P10	P20	P30	P20	M15	M30	M40	N20	N20
VNMA										
Designation										
RE										
Fn (mm/rev.)										
Ap (mm)										
YG1001										
YG3010										
YG3020										
YG3030										
YG801										
YG211										
YG213										
YG214										
YG100										
YG10										

	RE	Fn (mm/rev.)	Ap (mm)	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
VNMA 160408	0.8	0.15~0.5	1~3	●									
VNMG 160404 - UF	0.4	0.05~0.25	0.5~2		●	●	●	●					
VNMG 160408 - UF	0.8	0.05~0.25	1~2.5		●	●	●						
VNMG 160408 - UL	0.8	0.10~0.30	1~2.5		●	●							
VNMG 160412 - UM	1.2	0.15~0.3	1.5~3		●	●							
VNMG 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	YG213	YG214	YG100	YG10										
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max										
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200	-	-	-	-	-	-				
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200	-	-	-	-	-	-				
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-	-	-	-	-	-	-				
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Cutting Speed			Vc (m/min.)																			
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10										
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max										
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200	-	-	-	-	-	-				
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200	-	-	-	-	-	-				
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-	-	-	-	-	-	-				
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800
S	31~37	Superalloys & Titanium	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative
VNMG (35° Negative)



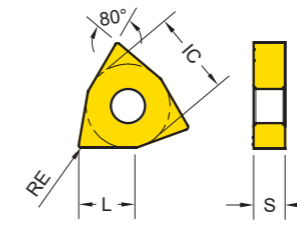
Series	L	IC	S
VN** 1604	15.8	9.525	4.76

EDP 2200.. ●: Stock item ○: Order made item

VNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10						
-UC Cast iron and Medium roughing	VNMG 160404 - UC	0.4	0.2~0.4	0.5~2.5	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	VNMG 160408 - UC	0.8	0.2~0.4	1~3	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
-UR Roughing	VNMG 160412 - UR	1.2	0.3~0.5	1.2~3	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	VNMG 160408 - MF	0.8	0.05~0.3	0.2~1.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
-MM Stainless steel Medium	VNMG 160404 - MM	0.4	0.2~0.35	0.5~3.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	VNMG 160408 - MM	0.8	0.2~0.35	0.5~3.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
-MR Stainless steel Roughing	VNMG 160408 - MR	0.8	0.30~0.55	2.0~5.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative
WNMG / WNMA (80° Trigonal Negative)



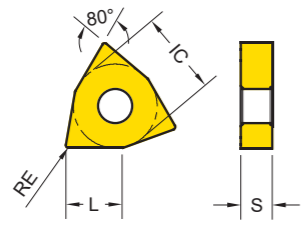
Series	L	IC	S
WN** 0604	5.7	9.525	4.76
WN** 0804	7.8	12.7	4.76

EDP 2200.. ●: Stock item ○: Order made item

WNMA WNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1001	YG3010	YG3015	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10					
..MA Cast iron	WNMA 080404	0.4	0.15~0.5	0.5~2.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMA 080408	0.8	0.15~0.5	1~3.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMA 080412	1.2	0.15~0.5	1.5~5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
-UF Finishing	WNMG 060404 - UF	0.4	0.05~0.2	0.5~1.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080404 - UF	0.4	0.05~0.25	0.5~2	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080408 - UF	0.8	0.05~0.25	1~2.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
-UL Light Machining and sticky material	WNMG 060408 - UL	0.8	0.1~0.3	1~2.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080408 - UL	0.8	0.1~0.3	1~3	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
-UM Medium Machining at unstable condition	WNMG 060404 - UM	0.4	0.15~0.30	1.0~2.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMG 060408 - UM	0.8	0.15~0.3	1~2	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080404 - UM	0.4	0.15~0.30	0.5~3.0	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080408 - UM	0.8	0.15~0.3	1~3	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080412 - UM	1.2	0.15~0.3	1.5~3	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080416 - UM	1.6	0.15~0.3	2~3.5	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Negative
WNMG / WNMA (80° Trigonal Negative)



Series	L	IC	S
WN** 0604	5.7	9.525	4.76
WN** 0804	7.8	12.7	4.76

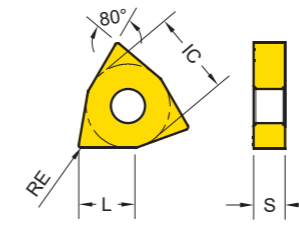
EDP 2200.. ● : Stock item ○ : Order made item

WNMA WNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05	P10	P15	P20	P30	P20	M15	M30	M40	N20	N20
					K10	K20	M20	S10	S20	S30	N20	N20			
-UG Medium Machining at stable condition	WNMG 060408 - UG	0.8	0.2~0.4	1~2.5	●	○	○	○	○	○	○	○	○	○	○
	WNMG 080404 - UG	0.4	0.2~0.4	1.5~2.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080408 - UG	0.8	0.2~0.4	1~3.5	●	○	○	○	○	○	○	○	○	○	○
	WNMG 080412 - UG	1.2	0.2~0.4	1.5~3.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080416 - UG	1.6	0.2~0.4	2~4	○	○	○	○	○	○	○	○	○	○	○
-UC Cast iron and Medium roughing	WNMG 080404 - UC	0.4	0.25~0.4	0.5~3.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080408 - UC	0.8	0.2~0.4	1~4	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080412 - UC	1.2	0.2~0.4	1.5~4.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080416 - UC	1.6	0.20~0.40	2.0~4.0	○	○	○	○	○	○	○	○	○	○	○
-UR Roughing	WNMG 080408 - UR	0.8	0.3~0.5	1.2~5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080412 - UR	1.2	0.3~0.5	1.5~5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080416 - UR	1.6	0.3~0.5	2~5	○	○	○	○	○	○	○	○	○	○	○

* YG3015 = Vc 90~430 m/min

Cutting Speed			Vc (m/min.)										
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200	
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200	
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-	
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230	
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200	
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-	
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	350 1200 250 800	
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90	
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-	

Turning Inserts - Negative
WNMG / WNMA (80° Trigonal Negative)



Series	L	IC	S
WN** 0604	5.7	9.525	4.76
WN** 0804	7.8	12.7	4.76

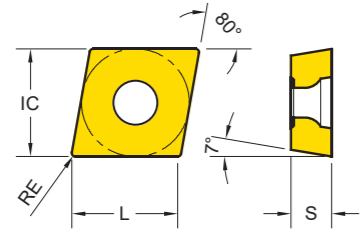
EDP 2200.. ● : Stock item ○ : Order made item

WNMA WNMG	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05	P10	P15	P20	P30	P20	M15	M30	M40	N20	N20
					K10	K20	M20	S10	S20	S30	N20	N20			
-MF Stainless steel Finishing	WNMG 060404 - MF	0.4	0.07~0.30	0.2~1.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080404 - MF	0.4	0.07~0.3	0.15~1.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080408 - MF	0.8	0.07~0.3	0.2~1.5	○	○	○	○	○	○	○	○	○	○	○
-MM Stainless steel Medium	WNMG 080404 - MM	0.4	0.2~0.35	0.5~3.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080408 - MM	0.8	0.2~0.35	1~3.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080412 - MM	1.2	0.2~0.35	1.5~3.5	○	○	○	○	○	○	○	○	○	○	○
-MR Stainless steel Roughing	WNMG 060412 - MR	1.2	0.2~0.5	1.2~4	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080408 - MR	0.8	0.30~0.55	2.0~5.5	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080412 - MR	1.2	0.30~0.55	2.0~5.5	○	○	○	○	○	○	○	○	○	○	○
-KR Cast Iron Heavy Roughing	WNMG 080408 - KR	0.8	0.30~0.60	1.0~5.0	○	○	○	○	○	○	○	○	○	○	○
	WNMG 080412 - KR	1.2	0.30~0.60	1.5~5.0	○	○	○	○	○	○	○	○	○	○	○

* YG3015 = Vc 90~430 m/min

Cutting Speed			Vc (m/min.)										
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200	
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200	
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-	
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230	
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200	
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-	
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-	
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	350 1200 250 800	
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90	
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-	

Turning Inserts - Positive
CCMT / CCGT (80° Positive)



Series	L	IC	S
CC** 0602	6.2	6.35	2.38
CC** 09T3	9.2	9.525	3.97
CC** 1204	12.4	12.7	4.76

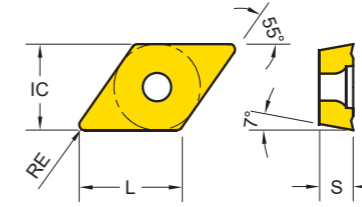
EDP 2200.. ●: Stock item ○: Order made item

CCGT CCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..											
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10		
-AL Aluminum	CCGT 09T302 - AL	0.2	0.02 ~ 0.08	0.5 ~ 1											●	●
	CCGT 09T304 - AL	0.4	0.05 ~ 0.25	0.5 ~ 2											●	●
	CCGT 09T308 - AL	0.8	0.1 ~ 0.35	1 ~ 3											●	●
	CCGT 120402 - AL	0.2	0.04 ~ 0.15	0.1 ~ 1											●	●
	CCGT 120404 - AL	0.4	0.04 ~ 0.2	0.3 ~ 1.5											●	●
	CCGT 120408 - AL	0.8	0.04 ~ 0.2	0.6 ~ 2.5											●	●
-UF Finishing	CCMT 060204 - UF	0.4	0.05 ~ 0.2	0.5 ~ 1.5	○	○	○									
	CCMT 09T304 - UF	0.4	0.05 ~ 0.2	0.5 ~ 2	○	○										
-UG General	CCMT 060204 - UG	0.4	0.1 ~ 0.25	0.5 ~ 2	●	●	●	●								
	CCMT 060208 - UG	0.8	0.1 ~ 0.25	0.8 ~ 2	●	●	●	●								
	CCMT 09T304 - UG	0.4	0.15 ~ 0.3	0.5 ~ 2	●	●	●	●								
	CCMT 09T308 - UG	0.8	0.15 ~ 0.3	0.8 ~ 2.5	●	●	●	●								
	CCMT 120404 - UG	0.4	0.15 ~ 0.35	0.5 ~ 2.5	●	●										
	CCMT 120408 - UG	0.8	0.15 ~ 0.35	0.8 ~ 3.5	●	●	●	●								

* YG3015 = Vc 90~430 m/min

Cutting Speed			Vc (m/min.)											
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10		
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200		
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200		
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-		
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230		
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200		
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-		
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-		
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200		
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90		
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-		

Turning Inserts - Positive
DCMT / DCGT (55° Positive)



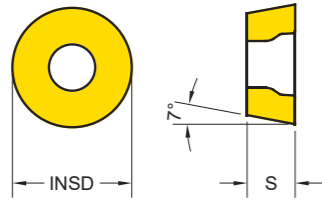
Series	L	IC	S
DC** 0702	7.5	6.35	2.38
DC** 11T3	11.2	9.525	3.97

EDP 2200.. ●: Stock item ○: Order made item

DCGT DCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..											
					YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10		
-AL Aluminum	DCGT 11T302 - AL	0.2	0.02 ~ 0.08	0.5 ~ 1											●	●
	DCGT 11T304 - AL	0.4	0.05 ~ 0.25	0.5 ~ 2											●	●
	DCGT 11T308 - AL	0.8	0.1 ~ 0.3	1 ~ 2.5											●	●
-UF Finishing	DCMT 070204 - UF	0.4	0.05 ~ 0.2	0.5 ~ 1.5		○	○									
	DCMT 11T304 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2		○	○									
	DCMT 11T308 - UF	0.8	0.05 ~ 0.25	1 ~ 2.5		○	○									
-UG General	DCMT 070204 - UG	0.4	0.1 ~ 0.25	0.5 ~ 1.5		○	○							●		
	DCMT 070208 - UG	0.8	0.1 ~ 0.25	0.8 ~ 1.5		○	○							●		
	DCMT 11T304 - UG	0.4	0.15 ~ 0.3	0.5 ~ 2		○	○	○	○					●		

Cutting Speed			Vc (m/min.)											
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10		
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200		
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200		
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-		
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230		
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200		
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-		
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-		
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200		
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90		
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-		

Turning Inserts - Positive
RCMT (Round Positive)

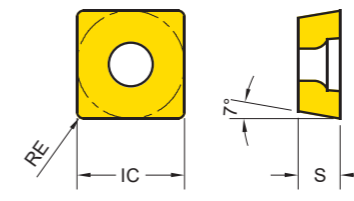


Series	INSD	S
RC** 0602	6	2.38
RC** 0803	8	3.18
RC** 10T3	10	3.97
RC** 1204	12	4.76

EDP 2200.. ●: Stock item ○: Order made item

RCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05		P10		P30		M15		M30		M40		N20	
					K10	K20	P20	M20	P20	S10	S20	S30	N20	N20				
General	RCMT 0602M0	3	0.05~0.25	0.2~1.2	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	RCMT 0803M0	4	0.05~0.3	0.5~1.5	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	RCMT 10T3M0	5	0.1~0.35	0.5~2.5	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	RCMT 1204M0	6	0.15~0.45	0.5~3	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Turning Inserts - Positive
SCMT (Square Positive)



Series	IC	S
SC** 09T3	9.525	3.97
SC** 1204	12.7	4.76

EDP 2200.. ●: Stock item ○: Order made item

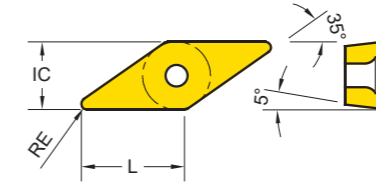
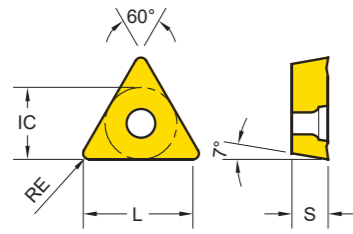
SCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05		P10		P30		M15		M30		M40		N20	
					K10	K20	P20	M20	P20	S10	S20	S30	N20	N20				
-UF Finishing	SCMT 09T304 - UF	0.4	0.05~0.25	0.5~2	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	SCMT 09T304 - UG	0.4	0.15~0.3	1~2.5	●	●	●	●	●	●	●	●	●	●	●	●	●	●
-UG General	SCMT 09T308 - UG	0.8	0.15~0.3	1~2.5	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	SCMT 120408 - UG	0.8	0.15~0.35	1~3.5	●	●	●	●	●	●	●	●	●	●	●	●	●	●
					●	●	●	●	●	●	●	●	●	●	●	●	●	●

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	30	90	20	40
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	350	1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	30	90	20	40
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-

Turning Inserts - Positive
TCMT / TCGT (Triangle Positive)

Turning Inserts - Positive
VBMT (35° Positive)



Series	L	IC	S
TC** 1102	10.3	6.35	2.38
TC** 16T3	15.6	9.525	3.97

Series	L	IC	S
VB** 1604	15.8	9.525	4.76

EDP 2200.. ●: Stock item ○: Order made item

EDP 2200.. ●: Stock item ○: Order made item

TCGT TCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..													
					P05 K10	P10 K20	P20 M20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20				
-AL Aluminum	TCGT 16T302 - AL	0.2	0.02~0.05	0.5~1													○	○
	TCGT 16T304 - AL	0.4	0.05~0.25	0.5~2													○	○
	TCGT 16T308 - AL	0.8	0.1~0.35	1~3													○	○
-UF Finishing	TCMT 110204 - UF	0.4	0.05~0.2	0.5~2		●	●											
	TCMT 16T304 - UF	0.4	0.05~0.25	0.5~3		●	●		●									
	TCMT 16T308 - UF	0.8	0.05~0.25	0.8~3		●	●											
-UG General	TCMT 110204 - UG	0.4	0.15~0.25	0.5~1.5		●				●								
	TCMT 110208 - UG	0.8	0.15~0.25	0.8~2		●	●											
	TCMT 16T304 - UG	0.4	0.15~0.3	0.5~2		●	●	●										
	TCMT 16T308 - UG	0.8	0.15~0.3	0.8~3		●	●	●	●	●								

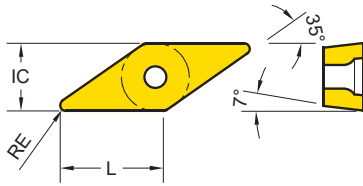
VBMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..													
					P05 K10	P10 K20	P20 M20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20				
-UF Finishing	VBMT 160404 - UF	0.4	0.05~0.25	0.5~2			●	●										
	VBMT 160408 - UF	0.8	0.05~0.25	0.5~3			●	●										
-UG General	VBMT 160404 - UG	0.4	0.15~0.30	0.5~2.5		●	●	●		●								
	VBMT 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	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	350 1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	250 800




Cutting Speed			Vc (m/min.)									
ISO	VDI	Sub Group	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	130	230
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	100	200
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	350 1200
S	31~37	Superalloys & Titanium	-	-	-	-	35	80	-	-	30	90
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	250 800

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

Series	L	IC	S
VC** 1604	15.8	9.525	4.76



EDP 2200.. ●: Stock item ○: Order made item

VCMT VCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05	P10	P20	P30	P20	M15	M30	M40	N20	N20
					K10	K20	M20	S10	S20	S30				
-AL  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									○	○
-UF  Finishing	VCMT 160404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 3		●	●							
						0716	0421							
-UG  General	VCMT 160404 - UG	0.4	0.15 ~ 0.30	0.5 ~ 2.5					●					
	VCMT 160408 - UG	0.8	0.15 ~ 0.30	1 ~ 3			●		●					
							0422		0060					
									0061					

Cutting Speed			Vc (m/min.)																			
ISO	VDI	Sub Group	YG1001		YG3010		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800	
S	31~37	Superalloys & Titanium	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-