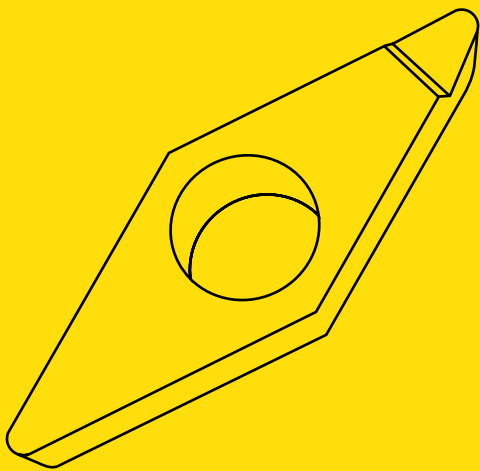
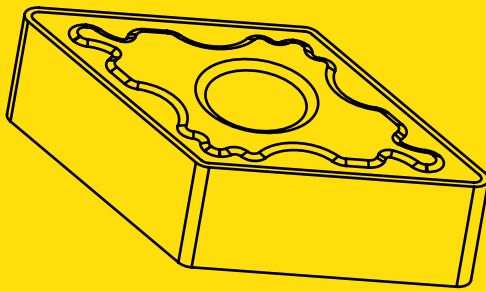


TURNING / diamond



D**C****G****W****11****T3****04**

1

2

3

4

5

6

7

1 Geometry

C		80
D		55
R		360
S		90
T		60
V		35
W		80

2 Clearance Angle

B		5°
C		7°
P		11°
N		0°

3 Tolerance

G	±0,025	±0,13
M	±0,05 ±0,15	±0,13
U	±0,08 ±0,25	±0,13

4 Shape

A	
G	
M	
W	
X	Special

5 Shape (mm)

C	06 09 12 16 19 25	
D	07 11 15	
R	06 09 12 15 19 25	
S	09 12 15 19 25	
T	09 11 16 22	
V	11 16 22	
W	06 08	

6 Thickness (mm)

02	2,38
03	3,18
T3	3,97
04	4,76
06	6,35
07	7,94
09	9,52
10	10,00

7 Corner Radius

02	0,20 mm
04	0,40 mm
08	0,80 mm
12	1,20 mm
16	1,60 mm
24	2,40 mm

1C

8

PC

9

150

10

8	Number of Edges
1C	1 Corner
2C	2 Corners
3C	3 Corners
FE	Full Edge

9	
PC	PCD

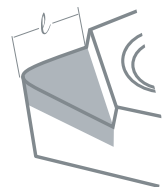
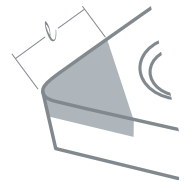
10	Application
1	Non - Ferrous Metal
3	

- TURNING
- GROOVING
- THREADING
- MILLING
- DRILLING
- ENDMILLS
- DRILLS
- SPARE PARTS
- INDEX

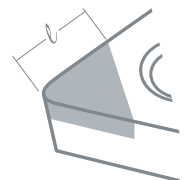
Grades	ISO DIN 513				
	N01	N10	N20	N30	N40
TURNING	N				
GROOVING					
THREADING			PC100		
MILLING		PC150			
DRILLING		PC200			
ENDMILLS	PC300				
DRILLS					
SPARE PARTS					
INDEX					

CUTTING EDGE STYLE

POSITIVE INSERTS

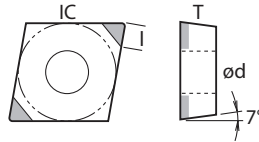


NEGATIVE INSERTS



**POSITIVE 7°
with hole**

CC□□



CC □□	0602 □□	09T3 □□	1204 □□
IC	6,35	9,525	12,7
T	2,38	3,97	4,76
Ød	2,80	4,40	5,50
Holder	126	126	126

DESCRIPTION	EDGE	Image	PCD						
			PC100	PC150	PC200	PC300			
	CCGT060202	1C			•	•	•		
	CCGT060204	1C		•	•	•	•		
	CCGT060208	1C		•	•		•		
	CCGT09T302	1C		•	•	•	•		
	CCGT09T304	1C		•	•	•	•		
	CCGT09T308	1C		•	•		•		
	CCGT120404	1C		•	•	•	•		
	CCGT120408	1C		•	•		•		
	CCGT09T302	2C			•	•	•		
	CCGT09T304	2C		•	•	•	•		
	CCGT09T308	2C		•	•		•		
	CCGT120404	2C		•	•	•	•		
	CCGT120408	2C		•	•		•		
	CCGW060202	1C			•	•	•		
	CCGW060204	1C		•	•	•	•		
	CCGW060208	1C		•	•		•		
	CCGW09T302	1C		•	•	•	•		
	CCGW09T304	1C		•	•	•	•		
	CCGW09T308	1C		•	•		•		
	CCGW120404	1C		•	•	•	•		
	CCGW120408	1C		•	•		•		
	CCGW09T302	2C			•	•	•		
	CCGW09T304	2C		•	•	•	•		
	CCGW09T308	2C		•	•		•		
	CCGW120404	2C		•	•	•	•		
	CCGW120408	2C		•	•		•		
	CCGX060204R/L	FE			•		•		
	CCGX09T304R/L	FE		•			•		

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TURNING
GROOVING
THREADING
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DRILLING
ENDMILLS
DRILLS
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INDEX

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

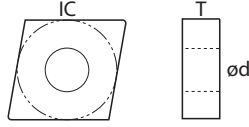
DRILLS

SPARE PARTS

INDEX

**NEGATIVE
with hole**

CN□□



CN□□ 1204□□

IC 12,7

T 4,76

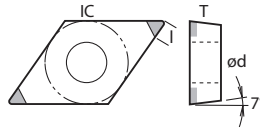
ød 5,16



DESCRIPTION		EDGE	Image	PCD				Image	Image
				PC100	PC150	PC200	PC300		
	CNGA120404	1C			•	•	•		
	CNGA120408	1C		•	•		•		
	CNGA120404	2C			•	•	•		
	CNGA120408	2C		•	•		•		

**POSITIVE 7°
with hole**

DC□□

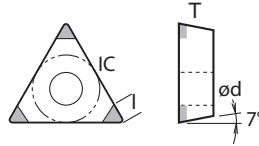


DC □□	0702 □□	11T3 □□
IC	6,35	9,525
T	2,38	3,97
ød	2,80	4,40
Holder	139	139

DESCRIPTION	EDGE	Image	PCD					
			PC100	PC150	PC200	PC300		
	DCGT070202	1C		•	•	•		
	DCGT070204	1C	•	•	•	•		
	DCGT070208	1C	•	•		•		
	DCGT11T302	1C		•	•	•		
	DCGT11T304	1C	•	•	•	•		
	DCGT11T308	1C	•	•		•		
	DCGT11T302	2C		•	•	•		
	DCGT11T304	2C	•	•	•	•		
	DCGT11T308	2C	•	•		•		
	DCGW070202	1C		•	•	•		
	DCGW070204	1C	•	•	•	•		
	DCGW070208	1C	•	•		•		
	DCGW11T302	1C		•	•	•		
	DCGW11T304	1C	•	•	•	•		
	DCGW11T308	1C	•	•		•		
	DCGW11T302	2C		•	•	•		
	DCGW11T304	2C	•	•	•	•		
	DCGW11T308	2C	•	•		•		
	DCGX070204R/L	FE		•		•		
	DCGX11T304R/L	FE		•		•		

**POSITIVE 7°
with hole**

TC □ □



TC □ □	0902 □ □	1102 □ □	16T3 □ □
IC	5,56	6,35	9,525
T	2,38	2,38	3,97
Ød	2,50	2,80	4,40
Holder	171	171	171

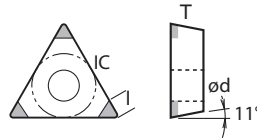
DESCRIPTION	EDGE	Image	PCD					
			PC100	PC150	PC200	PC300		
	TCGT090202	1C		•	•	•		
	TCGT090204	1C	•	•	•	•		
	TCGT110202	1C		•	•	•		
	TCGT110204	1C	•	•	•	•		
	TCGT110208	1C	•	•		•		
	TCGT16T304	1C	•	•	•	•		
	TCGT16T308	1C	•	•		•		
	TCGT16T304	3C	•	•	•	•		
	TCGT16T308	3C	•	•		•		
	TCGW090202	1C		•	•	•		
	TCGW090204	1C	•	•	•	•		
	TCGW110202	1C		•	•	•		
	TCGW110204	1C	•	•	•	•		
	TCGW110208	1C	•	•		•		
	TCGW16T304	1C	•	•	•	•		
	TCGW16T308	1C	•	•		•		
	TCGW16T304	3C	•	•	•	•		
	TCGW16T308	3C	•	•		•		
	TCGX090204R/L	FE		•		•		
	TCGX110204R/L	FE		•		•		
	TCGX16T304R/L	FE		•		•		

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- TURNING
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- THREADING
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- DRILLING
- ENDMILLS
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**POSITIVE 11°
with hole**

TP □ □



TP □ □	0802 □ □	0902 □ □	1103 □ □
IC	4,76	5,56	6,35
T	2,38	2,38	3,18
ød	2,30	3,00	3,40
Holder	177	177	177

DESCRIPTION	EDGE	Image	PCD					
			PC100	PC150	PC200	PC300		
 TPGT080202 TPGT080204 TPGT090202 TPGT090204 TPGT110302 TPGT110304	1C			•	•	•		
	1C			•	•	•		
	1C			•	•	•		
	1C			•	•	•		
	1C			•	•	•		
	1C			•	•	•		
 TPGW080202 TPGW080204 TPGW090202 TPGW090204 TPGW110302 TPGW110304	1C			•	•	•		
	1C			•	•	•		
	1C			•	•	•		
	1C			•	•	•		
	1C			•	•	•		
	1C			•	•	•		

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

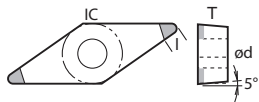
DRILLS

SPARE PARTS

INDEX

POSITIVE 5°
with hole

VB □□



VB □□	1103 □□	1604 □□
IC	6,35	9,525
T	3,18	4,76
ød	2,80	4,40
Holder	183	183

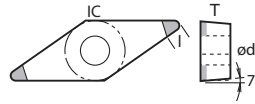
DESCRIPTION	EDGE	Image	PCD					
			PC100	PC150	PC200	PC300		
 VBGT110302 VBGT110304 VBGT160402 VBGT160404 VBGT160408	1C			•	•	•		
	1C		•	•	•	•		
	1C		•	•	•	•		
	1C		•	•	•	•		
	1C		•	•	•	•		
 VBGT110302 VBGT110304 VBGT160402 VBGT160404 VBGT160408	2C			•	•	•		
	2C		•	•	•	•		
	2C		•	•	•	•		
	2C		•	•	•	•		
	2C		•	•	•	•		
 VBGW110302 VBGW110304 VBGW160402 VBGW160404 VBGW160408	1C			•	•	•		
	1C		•	•	•	•		
	1C		•	•	•	•		
	1C		•	•	•	•		
	1C		•	•	•	•		
 VBGW110302 VBGW110304 VBGW160402 VBGW160404 VBGW160408	2C			•	•	•		
	2C		•	•	•	•		
	2C		•	•	•	•		
	2C		•	•	•	•		
	2C		•	•	•	•		

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POSITIVE 7°
with hole

VC □ □



VC □ □	1103 □ □	1604 □ □
IC	6,35	9,525
T	3,18	4,76
Ød	2,80	4,40
Holder	189	189

DESCRIPTION	EDGE	Image	PCD					
			PC100	PC150	PC200	PC300		
	VCGT110302	1C		•	•	•		
	VCGT110304	1C	•	•	•	•		
	VCGT160402	1C		•	•	•		
	VCGT160404	1C	•	•	•	•		
	VCGT160408	1C	•	•		•		
	VCGT110302	2C		•	•	•		
	VCGT110304	2C	•	•	•	•		
	VCGT160402	2C		•	•	•		
	VCGT160404	2C	•	•	•	•		
	VCGT160408	2C	•	•		•		
	VCGW110302	1C		•	•	•		
	VCGW110304	1C	•	•	•	•		
	VCGW160402	1C		•	•	•		
	VCGW160404	1C	•	•	•	•		
	VCGW160408	1C	•	•		•		
	VCGW110302	2C		•	•	•		
	VCGW110304	2C	•	•	•	•		
	VCGW160402	2C		•	•	•		
	VCGW160404	2C	•	•	•	•		
	VCGW160408	2C	•	•		•		
	VCGX110304R/L	FE		•		•		
	VCGX160404R/L	FE		•		•		

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TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

DRILLS


SPARE PARTS

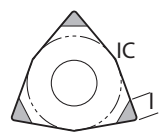

INDEX

- TURNING
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NEGATIVE with hole

WN □□



WN □□	0604 □□	0804 □□
IC	9,525	12,7
T	4,76	4,76
ød	3,81	5,16
Holder	194	194

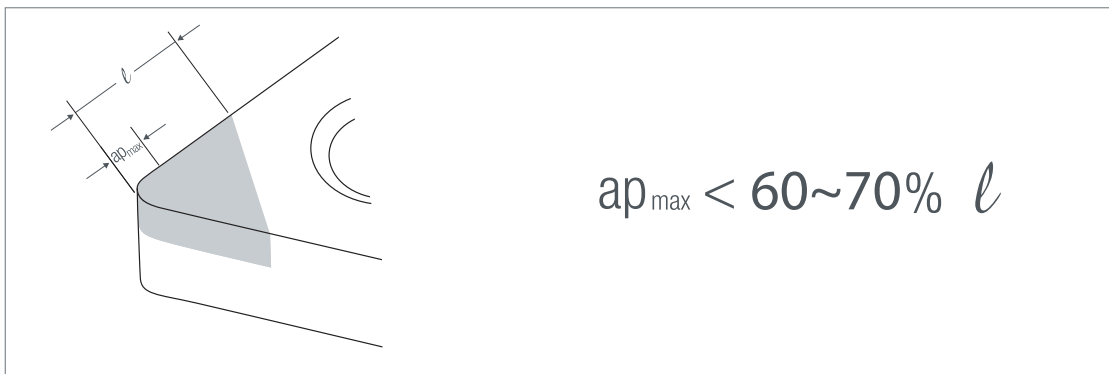
DESCRIPTION		EDGE		PCD						
				PC100	PC150	PC200	PC300			
	WNGA060404	1C			●	●	●			
	WNGA080404	1C		●	●		●			
	WNGA080408	1C		●	●		●			
	WNGA080404	3C		●	●	●	●			
	WNGA080408	3C		●	●		●			
	WNGA080404	6C		●	●	●	●			
	WNGA080408	6C		●	●		●			

TURNING

Cutting Parameters

NA	ALUMINIUM ALLOYS
NS	ALUMINIUM ALLOYS (Si≤15%)
NH	AL ALLOYS AGED AND HARDENED
NB	BRASS

NC	BRONZE AND ELECTROLYTIC COPPER
NG	GRAPHITE
HM	HARD METAL (Co≤16%)
ST	TITANIUM ALLOYS



MATERIAL	ap (mm)	fn (mm/rev)	CUTTING CONDITION	PCD						
				PC100	PC150	PC200	PC300			
N	NA	0,10~1,00	0,08~0,25	○ ⊕ ♀		600-2500		600-2500		
		1,00~2,50	0,15~0,50	○ ⊕ ♀		600-1600		600-1600		
	NS	0,10~1,00	0,05~0,20	○ ⊕ ♀			500-1800			
		1,00~2,50	0,08~0,35	○ ⊕ ♀			500-1200			
	NH	0,10~1,00	0,05~0,35	○ ⊕ ♀			400-1000			
		1,00~2,50	0,08~0,35	○ ⊕ ♀			400-800			
	NB	0,10~1,00	0,10~0,30	○ ⊕ ♀	400-1200	400-1200		400-1200		
		1,00~2,50	0,15~0,25	○ ⊕ ♀	400-1000	400-1000		400-1000		
	NC	0,10~1,00	0,10~0,30	○ ⊕ ♀	300-800	300-800		300-800		
		1,00~2,50	0,15~0,25	○ ⊕ ♀	300-500	300-500		300-500		
NG	0,10~1,00	0,08~0,25	○ ⊕ ♀		300-800	300-800	300-800			
	1,00~2,50	0,15~0,50	○ ⊕ ♀		300-600	300-600	300-600			
H	HM	0,10~0,50	0,08~0,25	○ ♀			10-40			
S	ST	0,10~1,00	0,05~0,20	○ ⊕ ♀	100-200	100-200	100-220	100-200		
		1,00~2,50	0,08~0,20	○ ⊕ ♀	100-150	100-150	100-220	100-150		

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

DRILLS

SPARE PARTS

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