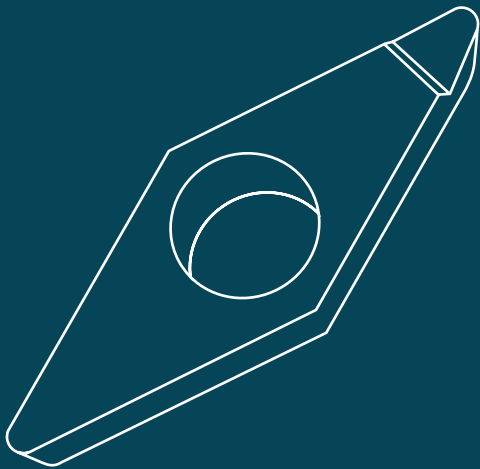
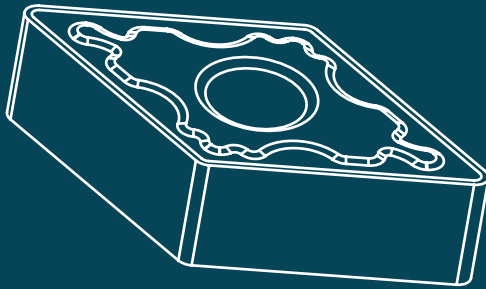


TURNING / carbide



TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS








DRILLS

SPARE PARTS

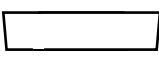
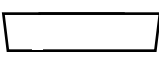
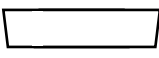
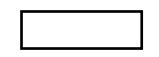
INDEX

<b>C</b>	<b>N</b>	<b>M</b>	<b>G</b>	<b>12</b>	<b>04</b>	<b>08</b>
1	2	3	4	5	6	7



### 1 Geometry

<b>C</b>		80
<b>D</b>		55
<b>K</b>		55
<b>S</b>		90
<b>T</b>		60
<b>V</b>		35
<b>W</b>		80

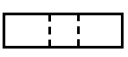



### 2 Clearance Angle

<b>B</b>		5°
<b>C</b>		7°
<b>P</b>		11°
<b>N</b>		0°








### 3 Tolerance

		
<b>G</b>	±0,025	±0,13
<b>M</b>	±0,05 ±0,15	±0,13
<b>U</b>	±0,08 ±0,25	±0,13

### 4 Shape

<b>A</b>	
<b>G</b>	
<b>M</b>	
<b>T</b>	
<b>X</b>	Special

### 5 Shape

<b>C</b>	06 09 12 16 19 25	
<b>D</b>	07 11 15	
<b>K</b>	16	
<b>S</b>	09 12 15 19 25	
<b>T</b>	09 11 16 22	
<b>V</b>	11 16 22	
<b>W</b>	06 08	

### 6 Thickness

<b>02</b>	2,38
<b>03</b>	3,18
<b>T3</b>	3,97
<b>04</b>	4,76
<b>06</b>	6,35
<b>09</b>	9,52

### 7 Corner Radius

<b>02</b>	0,20
<b>04</b>	0,40
<b>08</b>	0,80
<b>12</b>	1,20
<b>16</b>	1,60
<b>24</b>	2,40

<b>U</b>	<b>M</b>
8	9

<b>CS</b>	<b>5</b>	<b>2</b>	<b>25</b>	<b>S</b>
10	11	12	13	14

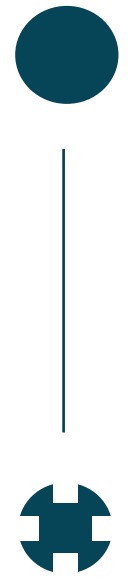
<b>8</b>	Series of C/B
<b>H</b>	Huskar Series
<b>U</b>	Undying Series
<b>S</b>	Spirit Series
<b>T</b>	Tusk Series
<b>A</b>	Aluminium

<b>9</b>	ISO Grade	
Heavy Machining	<b>P</b>	H. Roughing
	<b>R</b>	Roughing
	<b>F</b>	Functional
Turning	<b>R</b>	Roughing
	<b>M</b>	Medium
	<b>F</b>	Finishing
	<b>J</b>	Ultra Finishing
Stainless Steel	<b>S</b>	Standart
	<b>K</b>	Roughing
Aluminium	<b>LU</b>	Functional

<b>10</b>	Coating & Material
<b>CS</b>	CVD Coated Carbide
<b>CD</b>	Double CVD Coated
<b>PS</b>	PVD Coated Carbide
<b>PB</b>	New PVD Coating
<b>KS</b>	Ceramic
<b>SS</b>	Cermet
<b>US</b>	Uncoated

<b>11</b>	Workpiece Material
<b>2</b>	Non-Ferrous Material
<b>4</b>	Hardened Steel
<b>5</b>	Steel
<b>7</b>	Stainless Steel
<b>8</b>	Cast Iron
<b>9</b>	General Machining

<b>12</b>	Machining
<b>1~3</b>	Turning
<b>4</b>	Threading
<b>5</b>	Grooving
<b>9</b>	Milling

<b>13</b>	ISO Grade
<b>05</b>	
<b>10</b>	
<b>15</b>	
<b>20</b>	
<b>25</b>	
<b>30</b>	
<b>35</b>	
<b>40</b>	
<b>45</b>	

<b>14</b>	Grade
<b>S</b>	Premium
<b>non</b>	Normal

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

DRILLS












SPARE PARTS

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### CVD Turning Grades

MATERIAL	GRADE	ISO	Color	Operation
P	CS5215	P05-P25	BLACK	MT-TiCN+TiC+Al2O3+TiN
				Optimization for high speed machining due to combining the substrate of superior wear resistance and toughness with the coating of excellent thermal crack/plastic deformation
	CS5215S	P05-P25	YELLOW	MT-TiCN+TiC+Al2O3+TiN
				Optimization for high speed machining due to combining the substrate of superior wear resistance and toughness with the coating of excellent thermal crack/plastic deformation
	CS5225	P15-P35 M10-M20	BLACK	MT-TiCN+TiC+Al2O3+TiN
				First recommended grade for general machining with the use of high toughness substrate and coating layer with improved welding/chipping resistance
	CS5225S	P15-P35 M10-M20	YELLOW	MT-TiCN+TiC+Al2O3+TiN
				First recommended grade for general machining with the use of high toughness substrate and coating layer with improved welding/chipping resistance
	CS5235	P25-P40 M25-M40	YELLOW - BLACK	MT-TiCN+TiC+Al2O3+TiN
				Medium to low speed machining of steel
CS5240	P30-P40 M30-M40	YELLOW - BLACK	MT-TiCN+TiC+Al2O3+TiN	
			Medium to high speed machining of stainless steel	
M	CS7125S	M20-M30	BLACK	MT-TiCN+TiC+α-Al2O3
				For high speed machining of stainless steel
K	CS8205	K01-K10	BLACK	MT-TiCN+TiC+Al2O3+TiN
				As adapting highly hard substrate with superior CVD coated which has excellent resistance for thermal & oxidation, Excellent performance in casting iron continuous machining
	CS8115	K10-K20	BLACK	MT-TiCN+TiC+Al2O3+TiN
				Medium speed machining of cast iron
	CS8215	K10-K20	BLACK	MT-TiCN+TiC+Al2O3+TiN
			Medium speed machining of cast iron	
CS8125	K20-K30	BLACK	MT-TiCN+TiC+Al2O3+TiN	
	Interrupted cutting for gray cast iron and ductile cast iron			

### CS5225S

Universal grade especially for machining forged automobile components and bearing steel both in continuous and interrupted cutting. Available for all kinds of steels - carbon steel, alloy steel, rolled steel, tool steel, mild steel, bearing steel and other special kinds of steel. New coating technology increases welding resistance and chipping resistance, which leads to longer tool life



TiN coating layer with superior welding resistance

TiC + Al2O3 coating layer with superior heat resistance

TiCN coating layer with superior chipping resistance

Exclusive substrate material for coating with improved wear resistance.

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### PVD Turning Grades

MATERIAL	GRADE	ISO	Color	Operation
<b>P</b>	<b>PS5125</b>	P05-P25	DARK GRAY	2-4 micron Nano TiAlN PVD Coating
				Stable machinability with chipping resistance fracture resistance and welding resistance, Medium, roughing and heavy interrupted cutting for stainless steel and forged steel
<b>M</b>	<b>PS7110S</b>	M20-M30	COPPER	PVD(Cotated) - TiAlSiN, Premium grade
				As adapting highly hard substrate, Excellent in medium speed machining of stainless steel. As adapting Salina coating which has excellent resistance for thermal & oxidation
	<b>PS7120</b>	M15-M25	YELLOW	2-4 micron Nano AlCrN AlCrSiN Coating
				Medium, roughing and heavy interrupted cutting for st. steel and forged steel
<b>PS7220S</b>	M10-M30	COPPER	PVD(Cotated) - TiAlSiN, Premium grade	
				Excellent in medium speed machining of stainless steel. As adapting Salina coating which has excellent resistance for thermal & oxidation

### Uncoated Carbide Grades







































































MATERIAL	GRADE	ISO	Color	Operation
<b>N</b>	<b>US2115</b>	K05-K25	Silver	Ultra fine substrate
				Increased wear & chipping resistance as using a ultra fine substrate, Excellent tool life with special surface treatment & and sharp cutting edge of ALU chip breaker

### Cermet Carbide Grades

MATERIAL	GRADE	ISO	Color	Operation
<b>UNI</b>	<b>SS9115</b>	P05-P25	SILVER	For continuous machining of cold/hot forged steel and Sintered ferrous alloy at high speed and low depth of cut
				
	<b>SS9125</b>	P05-P25	SILVER	For high interrupted machining of cold/hot forged steel and Sintered ferrous alloy at high feed and high depth of cut
				

## TURNING

### Chipbreakers Selection (Negative )

	CN	DN	SN	TN	VN	WN
MA FLAT	21 	26 	32 	38 		47 
MG BOX	21 	26 	32 	38 	45 	47 
ALU	21 	26 	32 	38 		47 
HQ	21 	26 		39 		47 
PM	22 			39 	45 	47 
ST		26 		39 		48 
TK	22 	27 	32 	39 		48 
TM	22 	27 				48 
TS	22 	27 	32 	39 	45 	48 
UF		27 	33 	39 	45 	48 
UM	22 	27 	33 	39 	45 	48 
UR	23 	28 	33 	39 		48 
US	23 	28 	33 	39 		49 
OTHERS			32  (TF)	38  (R/L-P)		47  (HA)
			33  (ZR)	39  (R/L-C)		
			34  (HTR)	39  (UH)		
				39  (VQ)		

TURNING

GROOVING

THREADING

MILLING

DRILLING












































ENDMILLS

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### Chipbreakers Selection (Positive )

	CC	DC	SC	TC	VB	VC
ER/L-U	18 	24 				
L-F	18 					
L/R-W	18 					
L-Y					42 	
ALU	18 	24 	31 	36 	42 	44 
CG	19 	24 		36 	42 	44 
HF	19 	24 	31 	36 		
HM	19 	24 	31 	36 		
HQ	19 	25 		37 	42 	
HR	19 	25 		37 	42 	
TS	19 	25 		37 	43 	
VM	19 	25 		37 	43 	
VQ	19 	25 				
VW		25 				

### Machining Examples

P Carbon Steel (1.1040)								
■Workpiece	Hub							
■Cutting Conditions	Vc (m/min)= 250	fn (mm/rev)= 0.2						
	ap (mm)= 1,5	Wet						
■Designation	Insert	CNMG120408-UM CS5225						
	Toolholder	DCLNR2525-M12						
■Test Result								
<table border="1"> <caption>Test Result Data for Carbon Steel (1.1040)</caption> <thead> <tr> <th>Tool</th> <th>pcs/corner</th> </tr> </thead> <tbody> <tr> <td>CS5225</td> <td>120</td> </tr> <tr> <td>competitor</td> <td>80</td> </tr> </tbody> </table>			Tool	pcs/corner	CS5225	120	competitor	80
Tool	pcs/corner							
CS5225	120							
competitor	80							

P Alloy Steel (2379)								
■Workpiece	Automobile Part							
■Cutting Conditions	Vc (m/min)= 250	fn (mm/rev)= 0.2						
	ap (mm)= 1,5	Wet						
■Designation	Insert	CNMG120408-UM CS5215S						
	Toolholder	DCLNR2525-M12						
■Test Result								
<table border="1"> <caption>Test Result Data for Alloy Steel (2379)</caption> <thead> <tr> <th>Tool</th> <th>pcs/corner</th> </tr> </thead> <tbody> <tr> <td>CS5215S</td> <td>60</td> </tr> <tr> <td>competitor</td> <td>40</td> </tr> </tbody> </table>			Tool	pcs/corner	CS5215S	60	competitor	40
Tool	pcs/corner							
CS5215S	60							
competitor	40							

M Stainless Steel (316L)								
■Workpiece	Valve							
■Cutting Conditions	Vc (m/min)= 120	fn (mm/rev)= 0.2						
	ap (mm)= 1,5	Wet						
■Designation	Insert	CNMG120408-TS PS7220S						
	Toolholder	DCLNR2525-M12						
■Test Result								
<table border="1"> <caption>Test Result Data for Stainless Steel (316L)</caption> <thead> <tr> <th>Tool</th> <th>pcs/corner</th> </tr> </thead> <tbody> <tr> <td>PS7220S</td> <td>30</td> </tr> <tr> <td>competitor</td> <td>20</td> </tr> </tbody> </table>			Tool	pcs/corner	PS7220S	30	competitor	20
Tool	pcs/corner							
PS7220S	30							
competitor	20							

K Gray Cast Iron (GG25)								
■Workpiece	Disc							
■Cutting Conditions	Vc (m/min)= 350	fn (mm/rev)= 0.25						
	ap (mm)= 1,5	Wet						
■Designation	Insert	CNMA120408 CS8215						
	Toolholder	DCLNR2525-M12						
■Test Result								
<table border="1"> <caption>Test Result Data for Gray Cast Iron (GG25)</caption> <thead> <tr> <th>Tool</th> <th>pcs/corner</th> </tr> </thead> <tbody> <tr> <td>CS8215</td> <td>15</td> </tr> <tr> <td>competitor</td> <td>11</td> </tr> </tbody> </table>			Tool	pcs/corner	CS8215	15	competitor	11
Tool	pcs/corner							
CS8215	15							
competitor	11							

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

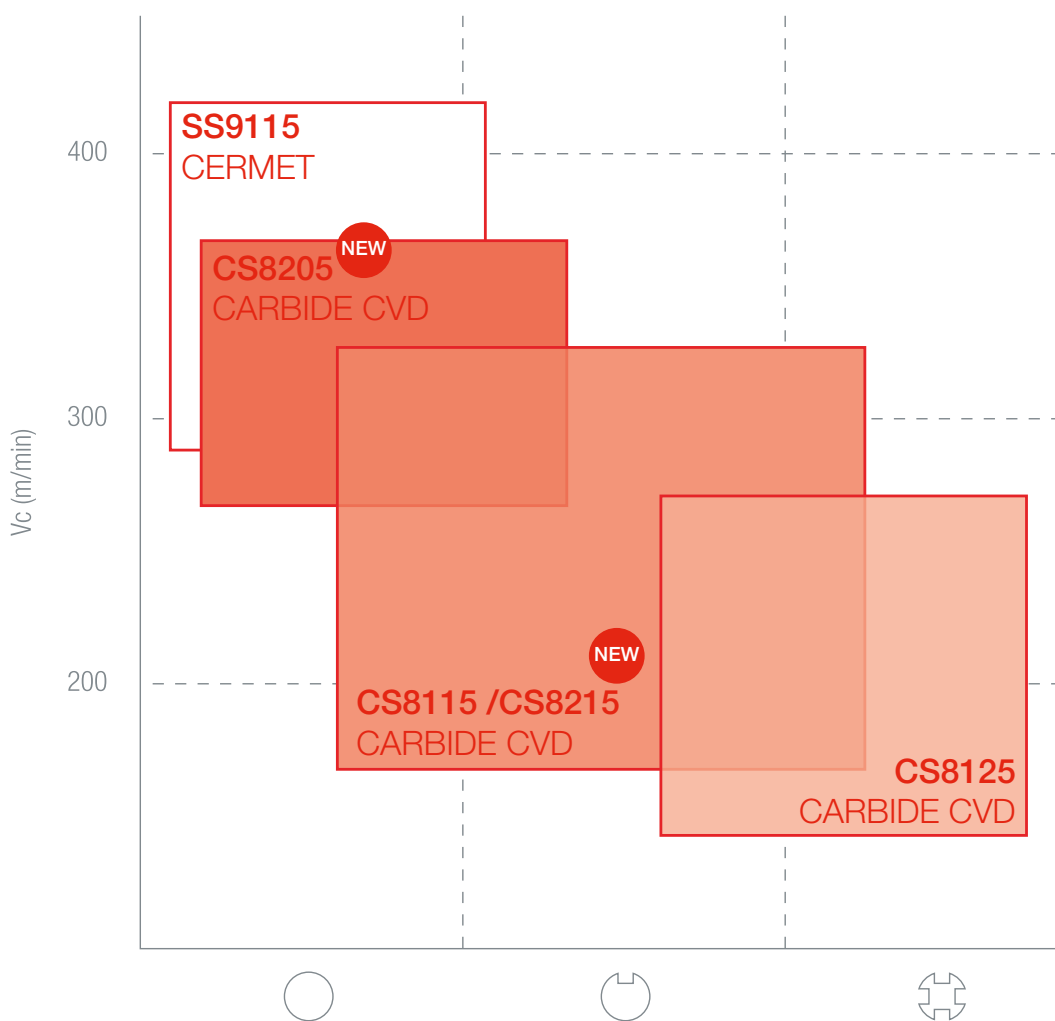
DRILLS

SPARE PARTS

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Range ISO **K**

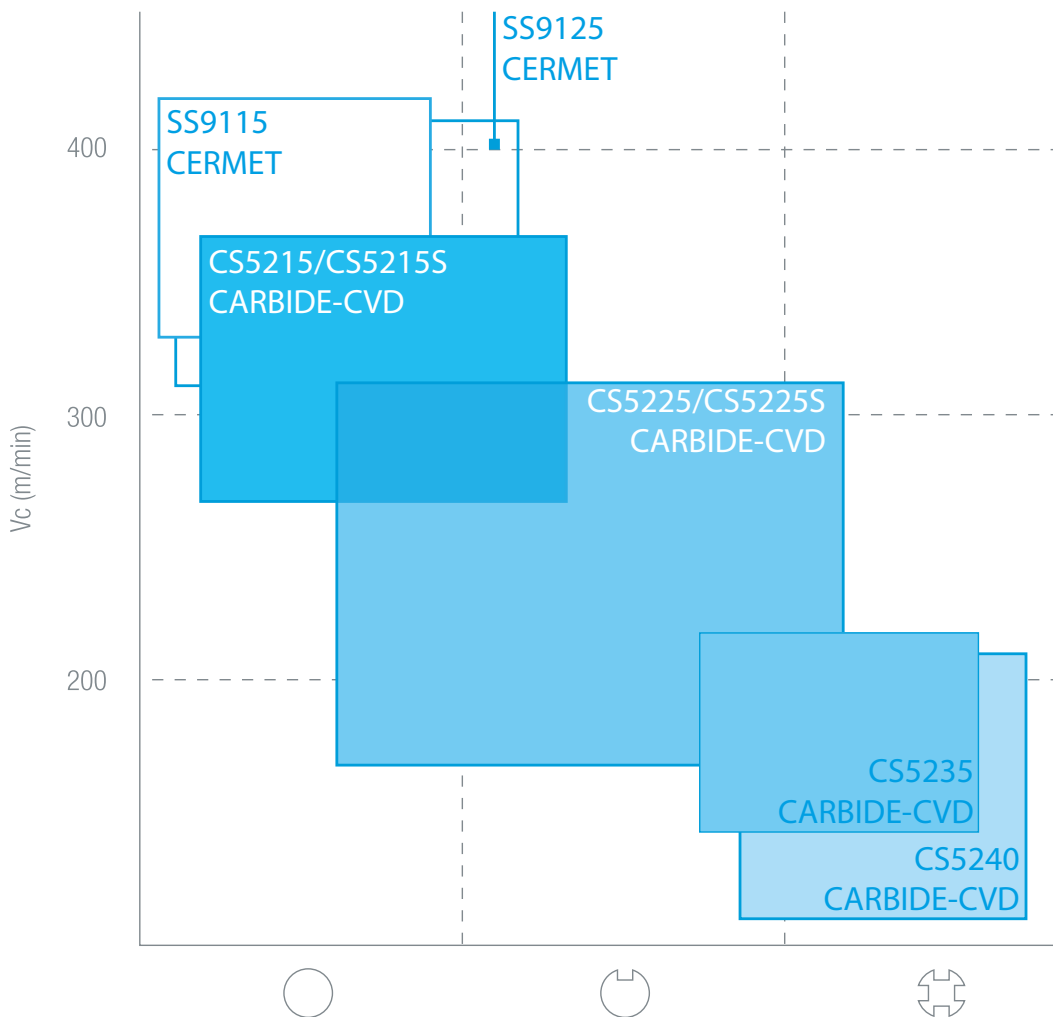
Grades



## TURNING

Range ISO **P**

### Grades



TURNING

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ENDMILLS

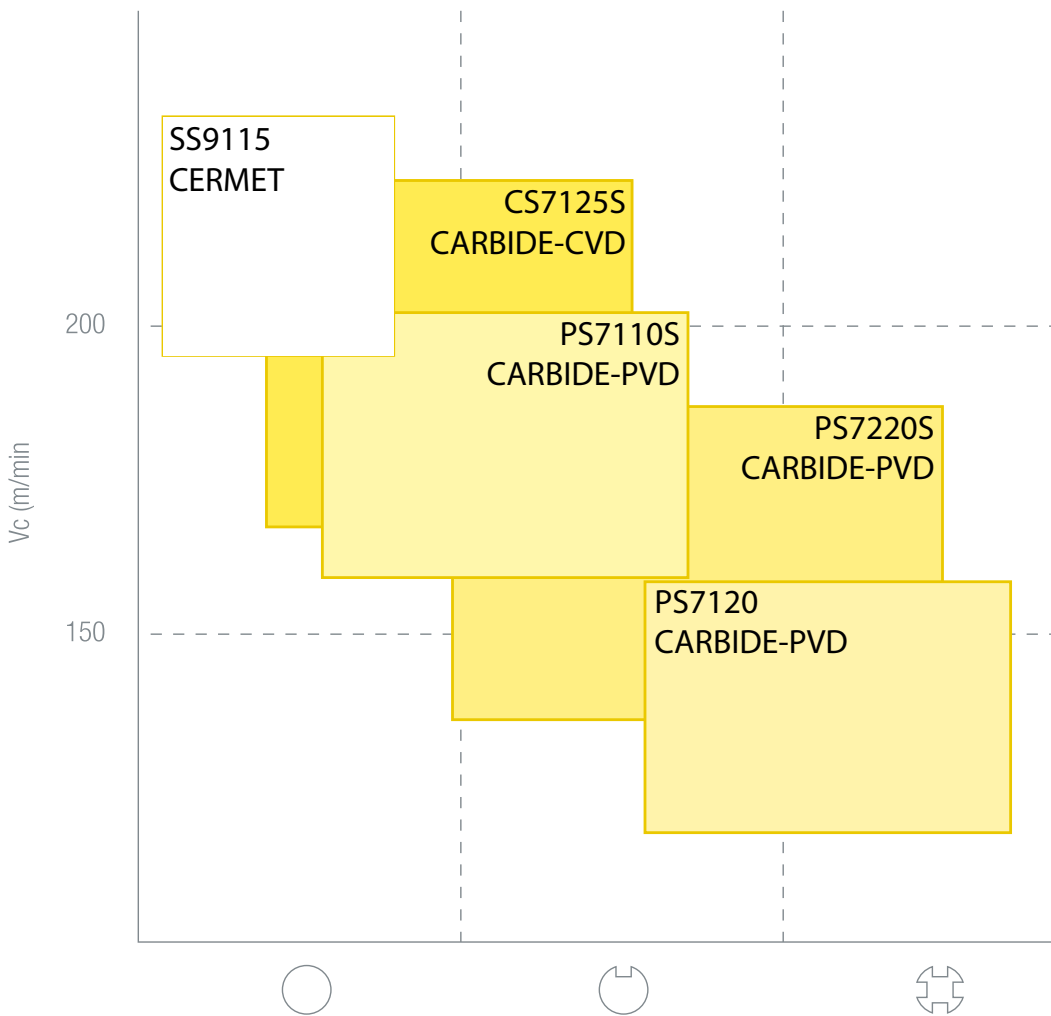
DRILLS

SPARE PARTS

INDEX

Range ISO **M**

Grades

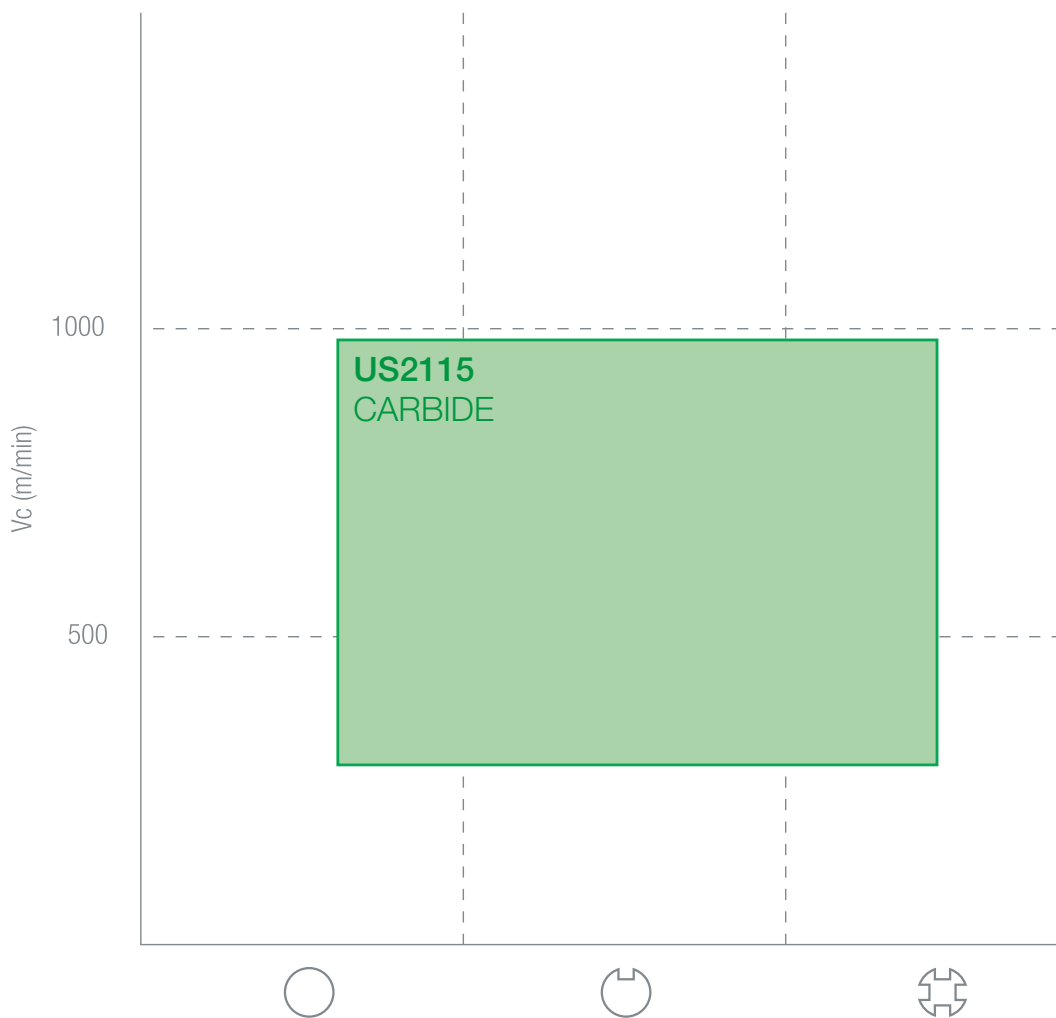




## TURNING

Range ISO **N**

### Grades



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MILLING

DRILLING

ENDMILLS

DRILLS

SPARE PARTS

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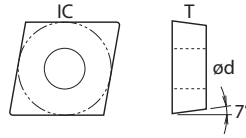
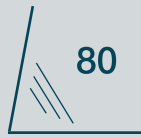
DRILLS

SPARE PARTS

INDEX

**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	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE							
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115			
  CCGT060202EL-U CCGT060204EL-U CCGT09T302EL-U CCGT09T304EL-U CCGT060202ER-U CCGT060204ER-U CCGT09T302ER-U CCGT09T304ER-U																•					
	  CCGT030102L-F CCGT030104L-F CCGT040102L-F CCGT040104L-F																•				
		  CCGT060202L-W15 CCGT060204L-W15 CCGT060202R-W15 CCGT060204R-W15																•			
			  CCGT09T302L-W20 CCGT09T304L-W20 CCGT09T302R-W20 CCGT09T304R-W20																•		
				  CCGT060202-ALU CCGT060204-ALU CCGT060208-ALU CCGT09T302-ALU CCGT09T304-ALU CCGT09T308-ALU CCGT09T312-ALU CCGT120404-ALU CCGT120408-ALU																	

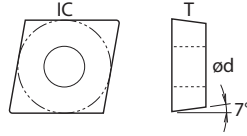
finishing
 medium
 roughing

Vc • fn • ap 50

## TURNING

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	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
 	CCMT060202-CG															•			
	CCMT060204-CG															•			
	CCMT060208-CG															•			
	CCMT09T304-CG															•			
	CCMT09T308-CG															•			
 	CCMT060202-HF	•													•				
	CCMT060204-HF	•	•		•	•			•	•				•	•				
	CCMT09T302-HF	•												•	•				
	CCMT09T304-HF	•	•		•	•			•	•				•	•				
 	CCMT060204-HM	•	•		•	•			•	•				•	•				
	CCMT060208-HM	•	•		•	•			•	•				•	•				
	CCMT09T302-HM	•												•	•				
	CCMT09T304-HM	•	•		•	•			•	•				•	•				
	CCMT09T308-HM	•	•		•	•			•	•				•	•				
	CCMT120404-HM	•	•		•	•			•	•				•	•				
	CCMT120408-HM	•	•		•	•			•	•				•	•				
CCMT120412-HM								•											
 	CCMT060204-HQ																•		
	CCMT09T304-HQ				•												•		
	CCMT09T308-HQ																•		
 	CCMT060208-HR								•										
	CCMT09T308-HR								•										
	CCMT120408-HR								•										
 	CCMT060204-TS													•					
	CCMT060208-TS													•					
	CCMT09T304-TS													•					
	CCMT09T308-TS													•					

finishing
 medium
 roughing

Vc • fn • ap 50

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

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

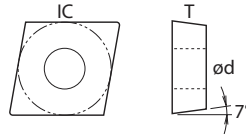
DRILLS

SPARE PARTS







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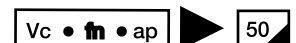
POSITIVE 7°  
with hole

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

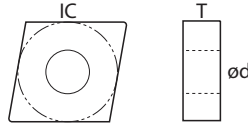
DESCRIPTION	CARBIDE-CVD						CARBIDE-PVD				CERMET	CARBIDE							
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
  CCMT060204-VM CCMT09T304-VM CCMT09T308-VM		●		●							●	●	●						
		●		●							●	●	●						
		●		●							●	●	●						
  CCMT060204-VQ CCMT09T304-VQ		●		●							●	●	●						
		●		●							●	●	●						
  CCMW060204 CCMW09T304 CCMW09T308 CCMW120404 CCMW120408									●										
									●										
									●										
									●										
									●										











## TURNING

NEGATIVE  
with hole


CN□□



CN □□	1204 □□	1606 □□	1906 □□
IC	12,7	15,875	12,7
T	4,76	6,35	4,76
ød	5,16	6,35	5,50
Holder	131	131	131

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
 	CNMA120404								•	•									
	CNMA120408						•	•	•	•									
	CNMA120412						•	•	•	•									
	CNMA120416									•	•								
	CNMA160608						•	•	•	•									
	CNMA160612						•	•	•	•									
	CNMA160616						•	•	•	•									
	CNMA190612						•	•	•	•									
	CNMA190616						•	•	•	•									
 	CNMG120404								•	•		•	•						
	CNMG120408	•	•	•	•	•	•	•	•	•		•	•	•	•				
	CNMG120412	•	•	•	•	•	•	•	•	•		•	•	•	•				
	CNMG120416	•		•		•	•	•	•	•				•	•				
	CNMG160608	•	•	•	•	•	•	•	•	•		•	•	•	•				
	CNMG160612	•	•	•	•	•	•	•	•	•		•	•	•	•				
	CNMG160616	•	•	•	•		•	•				•	•						
	CNMG190608	•	•	•	•							•	•						
	CNMG190612						•	•											
CNMG190616	•	•	•	•		•	•				•	•							
 	CNMG120402-ALU																	•	
	CNMG120404-ALU																		•
	CNMG120408-ALU																		•
	CNMG120412-ALU																		•
 	CNMG120404-HQ				•						•	•	•			•			
	CNMG120408-HQ															•			

 finishing
  medium
  roughing

Vc • fn • ap  50

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

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

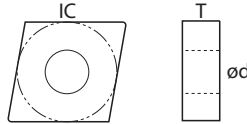
DRILLS

SPARE PARTS

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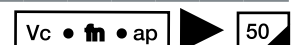
**NEGATIVE**  
with hole

**CN□□**



CN □□	0904 □□	1204 □□	1606 □□
IC	9,525	12,7	15,875
T	4,76	4,76	6,35
ød	3,81	5,16	6,35
Holder	131	131	131

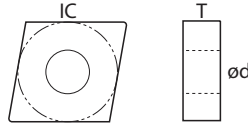
DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE				
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 CNMG120404-PM CNMG120408-PM		•		•			•											
		•		•			•											
 CNMG120404-TF CNMG120408-TF														•	•			
														•	•			
 CNMG090412-TK CNMG120408-TK CNMG120412-TK														•	•			
														•	•			
														•	•			
 CNMG090408-TM			•		•													
 CNMG090408-TS CNMG090412-TS CNMG120404-TS CNMG120408-TS CNMG120412-TS CNMG160608-TS CNMG160612-TS CNMG190608-TS CNMG190612-TS CNMG190616-TS												•	•					
												•	•					
				•								•	•	•	•			
				•								•	•	•	•			
												•	•					
												•	•					
												•	•					
												•	•					
												•	•					
												•	•					



## TURNING

NEGATIVE  
with hole

CN□□



CN □□	1204 □□	1606 □□	1906 □□
IC	12,7	15,875	12,7
T	4,76	6,35	4,76
ød	5,16	6,35	5,50
Holder	131	131	131

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
	CNMG120404-UM	•		•		•	•		•	•				•	•				
	CNMG120412-UM	•		•		•	•		•	•				•	•				
	CNMG120416-UM	•		•		•	•		•	•				•	•				
	CNMG120616-UM	•		•		•	•		•	•				•	•				
	CNMG160608-UM	•		•		•	•		•	•				•	•				
	CNMG160612-UM	•		•		•	•		•	•				•	•				
	CNMG160616-UM	•		•		•	•		•	•				•	•				
	CNMG190608-UM	•		•		•	•		•	•				•	•				
	CNMG190612-UM	•		•		•	•		•	•				•	•				
	CNMG190616-UM	•		•		•	•		•	•				•	•				
	CNMG120408-UR	•		•		•													
	CNMG120412-UR	•		•		•													
	CNMG120612-UR	•		•		•													
	CNMG160612-UR	•		•		•													
	CNMG160616-UR	•		•		•													
	CNMG190612-UR	•		•		•	•			•				•	•				
	CNMG190616-UR	•		•		•	•		•	•				•	•				
	CNMG190624-UR			•		•													
	CNMM190612-UR			•		•													
	CNMM190616-UR			•		•													
	CNMG120404-US	•		•		•													
	CNMG120408-US	•		•		•													

finishing
 medium
 roughing

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- MILLING
- DRILLING
- ENDMILLS
- DRILLS
- SPARE PARTS
- INDEX

TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

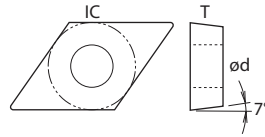
DRILLS

SPARE PARTS

INDEX

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	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115		
 DCGT070202-ALU DCGT070204-ALU DCGT070208-ALU DCGT11T302-ALU DCGT11T304-ALU DCGT11T308-ALU DCGT11T312-ALU																			•	
																				•
																				•
																				•
																				•
																				•
																				•
 DCGT11T302EL-U DCGT11T304EL-U DCGT11T302ER-U DCGT11T304ER-U																			•	
																				•
																				•
																				•
 DCMT070204-CG DCMT11T302-CG DCMT11T304-CG DCMT11T308-CG																			•	
																				•
																				•
																				•
 DCMT070202-HF DCMT070204-HF DCMT11T304-HF	•		•		•	•								•	•				•	
	•		•		•	•								•	•				•	
	•		•		•	•								•	•				•	
 DCMT070204-HM DCMT070208-HM DCMT11T302-HM DCMT11T304-HM DCMT11T308-HM DCMT11T312-HM	•		•		•	•									•				•	
	•		•		•	•									•				•	
	•		•		•	•									•				•	
	•		•		•	•									•				•	
	•		•		•	•									•				•	
	•		•		•										•				•	

finishing   
 medium   
 roughing

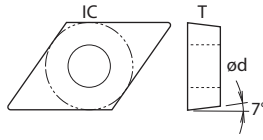
Vc • fn • ap 50















## TURNING

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	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE				
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115
 	DCMT070202-HQ															•		
	DCMT070204-HQ															•		
	DCMT11T302-HQ															•		
	DCMT11T304-HQ															•		
	DCMT11T308-HQ															•		
 	DCMT11T304-HR	•	•	•	•			•	•					•	•			
 	DCMT070204-TS														•			
	DCMT070208-TS														•			
	DCMT11T302-TS														•			
	DCMT11T304-TS														•			
	DCMT11T308-TS														•			
 	DCMT11T304-VM			•	•							•	•					
 	DCMT070204-VQ			•	•							•	•					
	DCMT070208-VQ			•	•							•	•					
 	DCMT11T304-VW			•	•							•	•					
	DCMT11T308-VW			•	•							•	•					

 finishing
  medium
  roughing

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- MILLING
- DRILLING
- ENDMILLS
- DRILLS
- SPARE PARTS
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TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

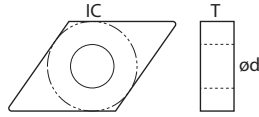
DRILLS

SPARE PARTS

INDEX

**NEGATIVE**  
with hole

**DN**□□



DN □□	1104 □□	1504 □□	1506 □□
IC	9,525	12,7	12,7
T	4,76	4,76	6,35
ød	3,81	5,16	5,16
Holder	149	149	149

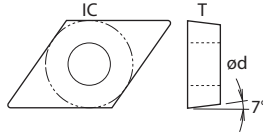
DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
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 DNMA150408 DNMA150412 DNMA150608 DNMA150612 DNMA150616									•	•										
									•	•										
								•	•	•	•									
								•	•	•	•									
								•	•	•	•									
 DNMG110408 DNMG150404 DNMG150408 DNMG150412 DNMG150604 DNMG150608 DNMG150612		•		•					•	•		•	•							
		•		•					•	•		•	•							
		•		•					•	•		•	•							
		•		•					•	•		•	•							
		•	•	•	•	•	•	•	•	•		•	•	•	•					
		•	•	•	•	•	•	•	•	•		•	•	•	•					
		•	•	•	•	•	•	•	•	•		•	•	•	•					
 DNMG150602-ALU DNMG150604-ALU DNMG150608-ALU DNMG150612-ALU																			•	
																				•
																				•
																				•
 DNMG150608-HA														•						
 DNMG150608-HQ																•				
 DNMG150604L-ST DNMG150608L-ST DNMG150604R-ST DNMG150608R-ST		•		•								•	•							
		•		•								•	•							
		•		•								•	•							
		•		•								•	•							



## TURNING

NEGATIVE  
with hole

DN□□



DN □□	1104 □□	1504 □□	1506 □□
IC	9,525	12,7	12,7
T	4,76	4,76	6,35
ød	3,81	5,16	5,16
Holder	149	149	149

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115		
 DNMG110404-TK DNMG110408-TK DNMG150608-TK														•	•					
															•	•				
															•					
 DNMG150608-TM		•		•									•	•						
 DNMG110404-TS DNMG110408-TS DNMG110412-TS DNMG150408-TS DNMG150412-TS DNMG150604-TS DNMG150608-TS DNMG150612-TS														•	•					
														•	•	•	•			
														•	•	•	•			
														•	•	•	•			
														•	•	•	•			
														•	•	•	•			
														•	•	•	•			
														•	•	•	•			
 DNMG150404-UF DNMG150408-UF DNMG150604-UF	•	•		•																
	•	•		•																
	•	•		•																
 DNMG110404-UM DNMG110408-UM DNMG110412-UM DNMG150404-UM DNMG150408-UM DNMG150412-UM DNMG150604-UM DNMG150608-UM DNMG150612-UM	•	•		•	•				•	•				•	•					
	•	•		•	•				•	•				•	•					
	•	•		•											•	•				
	•	•		•	•				•	•				•	•					
	•	•		•	•				•	•				•	•					
	•	•		•	•				•	•				•	•					
	•	•		•	•				•	•				•	•					
	•	•		•	•				•	•				•	•					



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- ENDMILLS
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TURNING

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MILLING

DRILLING

ENDMILLS

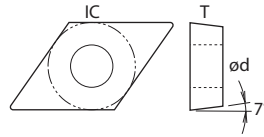
DRILLS

SPARE PARTS

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**NEGATIVE**  
with hole

**DN**□□



DN □□	1104 □□	1504 □□	1506 □□
IC	9,525	12,7	12,7
T	4,76	4,76	6,35
ød	3,81	5,16	5,16
Holder	149	149	149

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
 DNMG150608-UR DNMG150612-UR	•		•		•														
	•		•		•														
 DNMG150404-US DNMG150408-US DNMG150604-US	•		•		•														
	•		•		•														
	•		•		•														

finishing
 medium
 roughing

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DRILLING

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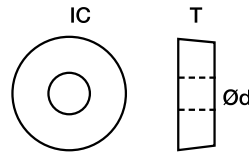
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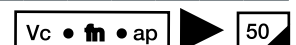
POSITIVE 7°  
with hole

RC□□



RC □□	0602 □□	0803 □□	10T3 □□
IC	6,0	8,0	10,0
T	2,36	3,18	3,18
Ød	2,80	3,35	3,60
Holder	157	157	157

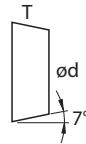
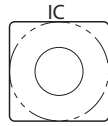
DESCRIPTION	CARBIDE-CVD						CARBIDE-PVD				CERMET	CARBIDE								
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 	RCGT0602M0-ALU																		●	
	RCGT0803M0-ALU																			●
	RCGT1003M0-ALU																			●
	RCGT10T3M0-ALU																			●
	RCGT1204M0-ALU																			●
 	RCMX0803M0	●		●								●	●							
	RCMX1003M0	●		●								●	●							
	RCMX1204M0	●		●								●	●							
	RCMX1606M0	●		●						●		●	●	●						
	RCMX2006M0	●		●			●	●	●			●	●							
	RCMX2507M0	●		●		●	●	●				●	●							
	RCMX3209M0	●		●		●						●	●							



## TURNING

POSITIVE 7°  
with hole

SC□□



SC □□	09T3 □□	1204 □□
IC	9,525	12,7
T	3,97	4,76
ød	4,40	5,16
Holder	160	160

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115		
 	SCGT09T302-ALU																		•	
	SCGT09T304-ALU																			•
	SCGT09T308-ALU																			•
	SCGT09T312-ALU																			•
	SCGT120404-ALU																			•
	SCGT120408-ALU																			•
 	SCMT09T304-HF					•								•						
 	SCMT09T304-HM						•	•						•						
	SCMT09T308-HM	•		•		•	•							•	•					
	SCMT120404-HM	•		•		•	•							•	•					
	SCMT120408-HM	•		•		•	•							•	•					

finishing
 medium
 roughing

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TURNING

GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

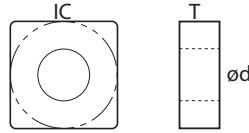
DRILLS

SPARE PARTS

INDEX

**NEGATIVE**  
with hole

**SN** □ □



SN □ □	1204 □ □	1206 □ □	1506 □ □
IC	12,7	12,7	15,875
T	4,76	6,35	6,35
ød	5,16	5,16	6,35
Holder	163	163	163

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
 SNMA120408 SNMA120412 SNMA120416 SNMA150612 SNMA150616 SNMA190612 SNMA190616 SNMA250924							•	•	•	•				•					
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
 SNMG120404 SNMG120408 SNMG120412 SNMG120416 SNMG190612	•	•	•	•	•		•	•	•	•		•	•						
	•	•	•	•	•		•	•	•	•		•	•						
	•	•	•	•	•		•	•	•	•		•	•						
	•	•	•	•	•		•	•	•	•		•	•						
	•	•	•	•	•		•	•	•	•		•	•						
 SNMG120402-ALU SNMG120404-ALU SNMG120408-ALU SNMG120412-ALU																		•	
																			•
																			•
																			•
 SNMG120408-TF			•											•	•				
 SNMG120404-TK SNMG120408-TK SNMG120412-TK SNMG120612-TK														•	•				
														•	•				
														•	•				
														•	•				
														•	•				
 SNMG120404-TS SNMG120408-TS SNMG120412-TS SNMG150608-TS		•		•									•	•	•	•			
													•	•	•	•			
													•	•	•	•			
													•	•	•	•			
													•	•	•	•			

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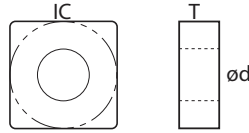
Vc • fn • ap 50



## TURNING

NEGATIVE  
with hole

SN □□



SN □□	1906 □□	2507 □□	2509 □□
IC	19,05	25,4	25,4
T	6,35	7,94	9,52
ød	7,93	9,12	9,12
Holder	163	163	163

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
SNMG120404-UF	●		●		●														
SNMG120404-UM	●		●		●	●			●	●				●	●				
SNMG120408-UM	●		●		●	●			●	●				●	●				
SNMG120412-UM	●		●		●	●			●	●				●	●				
SNMG120616-UM	●		●		●														
SNMG150608-UM	●		●		●	●			●	●				●	●				
SNMG190612-UM	●		●		●														
SNMG190616-UM			●		●										●				
SNMG120408-UR	●		●		●														
SNMG120412-UR	●		●		●														
SNMG120612-UR	●		●		●														
SNMG150612-UR	●		●		●	●			●	●				●	●				
SNMG190612-UR	●		●		●	●			●	●				●	●				
SNMG190616-UR	●		●		●	●			●	●				●	●				
SNMG190624-UR	●		●		●	●			●	●				●	●				
SNMG250724-UR	●		●		●														
SNMG250924-UR	●		●		●	●			●	●				●	●				
SNMG120404-US	●		●		●														
SNMG120408-US	●		●		●	●			●	●				●	●				
SNMG120412-US	●		●		●														
SNMG120412-ZR									●	●									
SNMG120416-ZR									●	●									

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MILLING

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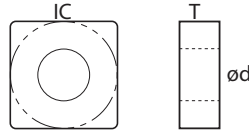
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SPARE PARTS

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**NEGATIVE**  
with hole

**SN** □ □



SN □ □	1204 □ □	1206 □ □	1506 □ □
IC	12,7	12,7	15,875
T	4,76	6,35	6,35
ød	5,16	5,16	6,35
Holder	163	163	163

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115		
 SNMM250724-HTR SNMM250732-HTR SNMM250924-HTR SNMM250932-HTR	●		●		●															
	●		●		●															
	●		●		●															
	●		●		●															
 SNMM150612-UR SNMM150616-UR SNMM190612-UR SNMM190616-UR SNMM190624-UR SNMM250724-UR SNMM250924-UR	●		●		●															
	●		●		●															
	●		●		●															
	●		●		●															
	●		●		●															

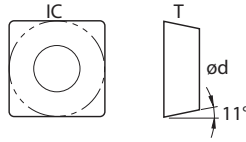
finishing
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## TURNING

POSITIVE 11°  
with hole

SP □□

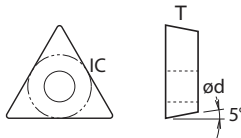


SP □□	1203 □□	1204 □□
IC	12,7	12,7
T	3,18	4,76
$\phi d$	5,16	5,16

DESCRIPTION		CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
		CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115		
	SPMT120408														●	●					
	SPMT120412																				
	SPMT120416																				
	SPMT120420																				
	SPMT120408-HM			●											●	●					

POSITIVE 5°  
with hole

TB □□



TB □□	0601 □□
IC	3,97
T	1,59
$\phi d$	2,16

DESCRIPTION		CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
		CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115		
	TBGT060102L																●				
	TBGT060104L																	●			

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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	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
	TCGT090202-ALU																		•
	TCGT090204-ALU																		•
	TCGT090208-ALU																		•
	TCGT110202-ALU																		•
	TCGT110204-ALU																		•
	TCGT110208-ALU																		•
	TCGT16T302-ALU																		•
	TCGT16T304-ALU																		•
	TCGT16T308-ALU																		•
	TCGT16T312-ALU																		•
	TCGW16T304								•	•									•
	TCGW16T308								•	•									•
	TCGW16T312								•	•									•
	TCMT110204-CG															•			•
	TCMT090204-HF	•	•	•	•				•	•				•	•				•
	TCMT110204-HF	•	•	•	•				•	•				•	•				•
	TCMT16T304-HF	•	•	•	•				•	•				•	•				•
	TCMT090204-HM	•	•	•	•				•	•				•	•				•
	TCMT090208-HM	•	•	•	•				•	•				•	•				•
	TCMT110204-HM	•	•	•	•				•	•				•	•				•
	TCMT110208-HM	•	•	•	•				•	•				•	•				•



## TURNING

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	CARBIDE-CVD						CARBIDE-PVD				CERMET	CARBIDE						
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115
TCMT16T304-HM TCMT16T308-HM TCMT16T312-HM TCMT220408-HM	•		•		•	•			•	•					•			
	•		•		•	•			•	•					•			
	•		•															
	•		•															
TCMT090204-HQ TCMT110204-HQ TCMT110208-HQ TCMT16T304-HQ																•		
																•		
																•		
																	•	
TCMT110208-HR									•	•								
TCMT110204-TS TCMT16T304-TS TCMT16T308-TS															•			
															•			
															•			
TCMT16T304-VM TCMT16T308-VM		•		•								•	•					
		•		•								•	•					

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NEGATIVE  
with hole

TN □□



TN □□	1604 □□	2204 □□	2706 □□
IC	9,525	12,7	15,875
T	4,76	4,76	6,35
ød	3,81	5,16	6,35
Holder	178	178	178

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
 TNGG160402L-P TNGG160404L-P TNGG160402R-P TNGG160404R-P																•		•	
																•		•	
																•		•	
																•		•	
 TNMA160404 TNMA160408 TNMA160412 TNMA160416 TNMA220404 TNMA220408 TNMA220412 TNMA220416							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
							•	•	•	•									
 TNMG160404 TNMG160408 TNMG160412 TNMG220408 TNMG220412 TNMG220416 TNMG270612 TNMG270616 TNMG330704 TNMG330724 TNMG330924	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•				
	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•				
	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•				
	•		•		•	•	•	•	•	•				•	•				
			•		•		•	•	•	•			•	•	•				
	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•			
	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•			
						•													•
						•													•
						•													•
						•													•



## TURNING

NEGATIVE  
with hole

TN □□



TN □□	1604 □□	2204 □□	2706 □□
IC	9,525	12,7	15,875
T	4,76	4,76	6,35
ød	3,81	5,16	6,35
Holder	178	178	178

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE				
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115
 TNMG160404-HQ  TNMG160408-HQ																•		
																	•	
 TNMG160404L-C  TNMG160408L-C  TNMG160404R-C  TNMG160408R-C																•		
																•		
																•		
																•		
 TNMG160404-PM  TNMG160408-PM  TNMG160412-PM		•		•						•	•	•						
		•		•						•	•	•						
				•							•	•	•					
 TNMG160404L-ST  TNMG160408L-ST  TNMG160404R-ST  TNMG160408R-ST	•		•											•	•			
	•		•											•	•			
	•		•											•	•			
	•		•											•	•			
 TNMG160404-TK  TNMG220408-TK														•	•			
														•	•			
 TNMG160404-TS  TNMG160408-TS  TNMG160412-TS  TNMG220404-TS  TNMG220408-TS				•			•	•		•	•	•	•	•				
				•			•	•		•	•	•	•	•	•			
														•	•			
 TNMG160404-UF  TNMG160408-UF	•		•		•													
	•		•		•													

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NEGATIVE  
with hole

TN □□



TN □□	1604 □□	2204 □□	2706 □□
IC	9,525	12,7	15,875
T	4,76	4,76	6,35
Ød	3,81	5,16	6,35
Holder	178	178	178

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115		
 TNMG220412-UH TNMG220416-UH	•		•																	
	•		•																	
 TNMG160404-UM TNMG160408-UM TNMG160412-UM TNMG160416-UM TNMG220404-UM TNMG220408-UM TNMG220412-UM	•		•		•	•			•	•				•	•					
	•		•		•	•			•	•				•	•					
	•		•		•	•			•	•				•	•					
	•		•		•	•			•	•				•	•					
	•		•		•	•			•	•				•	•					
	•		•		•	•			•	•				•	•					
 TNMG160408-UR TNMG160412-UR TNMG220416-UR TNMG270612-UR TNMG330924-UR	•		•		•	•			•	•				•	•					
	•		•		•	•			•	•				•	•					
	•		•		•	•			•	•				•	•					
 TNMG160404-US TNMG160408-US	•		•		•															
	•		•		•															
 TNMG160404-VQ TNMG160408-VQ				•							•	•	•							
				•							•	•	•							
 TNMM220412-UR TNMM220416-UR TNMM270616-UR			•		•	•														
			•		•	•														
			•		•	•														

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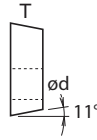
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## TURNING

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	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
 TPGH080202L  TPGH080204L TPGH090202L TPGH090204L TPGH110302L TPGH110304L												•	•			•			
												•	•			•			
												•	•			•			
												•	•			•	•		
												•	•			•			
												•	•			•	•		
 TPGN160308  TPGN220416	•		•		•														
	•		•		•														
 TPGT110204-HM	•		•		•														
 TPMT110304-CG																•			
 TPMT110304-HQ  TPMT110308-HQ																•			
																•			
 TPUN160304  TPUN160308  TPUN220412						•													
						•													
						•							•		•				

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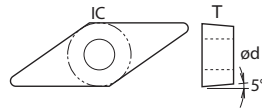
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POSITIVE 5°  
with hole

VB □□



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

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
	VBGT110302-ALU																		•
	VBGT110308-ALU																		•
	VBGT160402-ALU																		•
	VBGT160404-ALU																		•
	VBGT160408-ALU																		•
	VBGT160412-ALU																		•
	VBGT110302L-Y																•		
	VBGT110304L-Y																•		
	VBGT110302R-Y																•		
	VBGT110304R-Y																•		
	VBMT160404	•		•		•	•			•	•			•	•				
	VBMT160408	•		•		•	•			•	•			•	•				
	VBMT110302-CG																•		
	VBMT110304-CG																•		
	VBMT110304-HQ																•		
	VBMT110308-HQ																•		
	VBMT160404-HQ																•		
	VBMT160408-HQ																•		
	VBMT160408-HR													•	•				

finishing medium roughing

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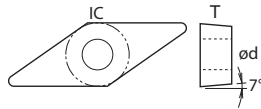
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POSITIVE 7°  
with hole

VC □ □



VC □ □	1103 □ □	1604 □ □	2205 □ □
IC	6,35	9,525	12,70
T	3,18	4,76	5,56
ød	2,80	4,40	5,60
Holder	189	189	189

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE						
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115		
 VCGT110302-ALU  VCGT110304-ALU VCGT110308-ALU VCGT160402-ALU VCGT160404-ALU VCGT160408-ALU VCGT160412-ALU VCGT220516-ALU																			•	
																				•
																				•
																				•
																				•
																				•
																				•
																				•
 VCGW110304-VF   VCGW110304 VCGW160404 VCGW160408														•	•					
 VCMT160404   VCMT160404   VCMT110302-CG VCMT110302-CG	•		•	•	•	•									•					

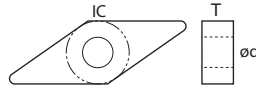
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## TURNING

NEGATIVE  
with hole

VN □□



VN □□ 1604 □□

IC 9,525

T 4,76

Ød 3,81

Holder 191

DESCRIPTION		CARBIDE-CVD										CARBIDE-PVD				CERMET	CARBIDE		
		CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115
	VNMG160404	•		•		•	•			•	•		•	•	•	•			
	VNMG160408	•		•		•	•			•	•		•	•	•	•			
	VNMG160412	•		•		•	•			•	•		•	•	•	•			
	VNMG160404-HQ																•		
	VNMG160408-HQ																•		
	VNMG160404-PM		•		•							•	•						
	VNMG160408-PM		•		•							•	•						
	VNMG160404-TS		•		•							•	•						
	VNMG160404-UF	•		•		•													
	VNMG160408-UF	•		•		•													
	VNMG160404-UM	•		•		•	•			•	•			•	•				
	VNMG160408-UM	•		•		•	•			•	•			•	•				
	VNMG160412-UM	•		•		•	•			•	•			•	•				

finishing
 medium
 roughing

Vc • fn • ap 50

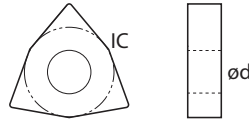
- TURNING
- GROOVING
- THREADING
- MILLING
- DRILLING
- ENDMILLS
- DRILLS
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## TURNING

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	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE				
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115
 WNMA080404  WNMA080408  WNMA080412  WNMA080416							•	•	•	•								
							•	•	•	•								
							•	•	•	•								
							•	•	•	•								
 WNMG080404  WNMG080408  WNMG080412  WNMG080416	•		•		•	•	•	•	•					•	•			
	•		•		•	•	•	•	•					•	•			
	•		•		•	•	•	•	•					•	•			
							•	•	•	•								
 WNMG080404-ALU  WNMG080408-ALU																		•
 WNMG080408-HA														•				
 WNMG080404-HQ  WNMG080408-HQ  WNMG080412-HQ																•		
		•		•								•	•			•		
																•		
 WNMG080404-PM  WNMG080408-PM  WNMG080412-PM		•		•								•	•					
		•	•	•								•	•					
		•		•								•	•					

finishing
 medium
 roughing

Vc • fn • ap 50

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GROOVING

THREADING

MILLING

DRILLING

ENDMILLS

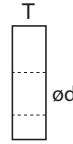
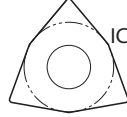
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**NEGATIVE**  
with hole

WN□□



WN □□	0604 □□	0804 □□
IC	9,525	12,7
T	4,76	4,76
ød	3,81	5,16
Holder	191	191

DESCRIPTION	CARBIDE-CVD								CARBIDE-PVD				CERMET	CARBIDE					
	CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S	PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115	
WNMG080404L-ST WNMG080408L-ST WNMG080408R-ST		•		•								•	•						
		•		•								•	•						
		•	•	•								•	•						
WNMG080408-TM		•		•								•	•						
WNMG080404-TK WNMG080408-TK WNMG080412-TK														•	•				
														•	•				
														•					
WNMG080404-TS WNMG080408-TS		•		•								•	•	•	•				
		•		•								•	•	•	•				
WNMG080404-UF WNMG080408-UF	•		•		•														
	•		•		•														
WNMG060408-UM WNMG080404-UM WNMG080408-UM WNMG080412-UM	•		•		•	•			•	•				•	•				
	•		•		•	•			•	•				•	•				
	•		•		•	•			•	•				•	•				
	•		•		•	•			•	•				•	•				
WNMG080408-UR WNMG080412-UR	•		•		•														
	•		•		•														



finishing



medium



roughing

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### Cutting Parameters Vc(m/min)

<b>KG</b>	GREY CAST IRON
<b>KN</b>	NODULAR CAST IRON
<b>PL</b>	LOW CARBON AND FREE CUTTING STEEL
<b>PM</b>	MEDIUM CARBON STEEL
<b>PH</b>	HIGH CARBON STEEL
<b>PA</b>	ALLOY STEEL

<b>MM</b>	MARTENSITIC AND FERRITIC STAINLESS STEEL
<b>MA</b>	AUSTENITIC STAINLESS STEEL
<b>NA</b>	ALUMINIUM ALLOYS
<b>NH</b>	ALUMINIUM ALLOYS AGED AND HARDENED
<b>NB</b>	BRASS
<b>NC</b>	BRONZE AND ELECTROLYTIC COPPER




MATERIAL		CARBIDE-CVD										
		CS5215	CS5215S	CS5225	CS5225S	CS5235	CS5240	CS8205	CS8215	CS8115	CS8125	CS7125S
<b>K</b>	<b>KG</b>							250-450	200-360	200-360	160-300	
	<b>KN</b>							180-300	150-280	150-280	120-250	
<b>P</b>	<b>PL</b>	250-350	200-320	200-320	200-320	160-250						
	<b>PM</b>	220-300	180-260	180-260	180-260	140-200						
	<b>PH</b>	200-280	160-250	160-250	160-250	120-180	100-160					
	<b>PA</b>	180-250	150-220	150-220	150-220	100-170	90-160					
<b>M</b>	<b>MM</b>											160-260
	<b>MA</b>											140-220

MATERIAL		CARBIDE-PVD				CERMET		CARBIDE					
		PS7110S	PS7220S	PS7120	PS5125	SS9115	SS9125	US2115					
<b>K</b>	<b>KG</b>					250-400	250-400						
	<b>KN</b>					180-300	180-300						
<b>P</b>	<b>PL</b>				100-180	280-380	280-380						
	<b>PM</b>				80-160	240-330	240-330						
	<b>PH</b>				80-140	220-300	220-300						
	<b>PA</b>				60-120	200-280	200-280						
<b>M</b>	<b>MM</b>	120-220	100-150	100-150		180-250	180-250						
	<b>MA</b>	100-180	80-120	80-120		160-220	160-220						
<b>N</b>	<b>NA</b>							600-1500					
	<b>NH</b>							300-700					
	<b>NB</b>							250-400					
	<b>NC</b>							150-250					

## TURNING

### Cutting Parameters $a_p$ (mm) & $f_n$ (mm/rev)

negative 

NEGATIVE INSERT SIZE		CN	-	1204..	1606..	1906..	2507.. 2509..
		DN	1104..	1504.. 1506..	-	-	-
		SN	0903..	1204..	-	1906..	2507.. 2509..
		TN	-	1604..	2204..	-	-
		VN	-	1604..	-	-	-
		WN	0604..	0804..	-	-	-

Chip Breaker Form	Corner Radius	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)
MA FLAT	R02										
	R04			2,00-4,00	0,20-0,35						
	R08			2,00-6,00	0,25-0,50	4,00-8,00	0,34-0,60				
	R12			2,00-6,00	0,33-0,58	4,00-10,0	0,40-0,70	5,00-11,0	0,43-0,76	8,00-16,0	0,45-1,00
	R16 / R24			2,00-7,00	0,37-0,65	4,00-10,0	0,45-0,78	5,00-13,0	0,49-0,8	8,00-18,0	0,50-1,10
MG BOX	R02										
	R04			1,00-4,00	0,16-0,25					8,00-16,0	0,45-0,89
	R08	1,00-4,00	0,23-0,40	1,00-4,00	0,22-0,38	4,00-7,00	0,34-0,58	5,00-10,0	0,42-0,76		
	R12			1,00-5,00	0,26-0,44	4,00-8,00	0,40-0,68	5,00-11,0	0,43-0,76		
	R16 / R24			1,00-5,00	0,29-0,50	4,00-8,00	0,45-0,76	5,00-11,0	0,49,0,85	8,00-18,0	0,50-1,10
ALU	R02			0,10-3,00	0,05-0,30						
	R04			0,80-3,50	0,10-0,40						
	R08			0,80-3,50	0,10-0,40						
	R12			0,80-3,50	0,10-0,42						
	R16 / R24										
HA	R02										
	R04										
	R08										
	R12			0,80-3,50	0,05-0,30						
	R16 / R24										
HQ	R02										
	R04			0,50-2,50	0,05-0,25						
	R08			0,50-4,00	0,10-0,50						
	R12			0,50-4,00	0,13-0,60						
	R16 / R24										
HTR	R02										
	R04										
	R08										
	R12										
	R16 / R24									1,80-10,00	0,30-0,80
PM	R02										
	R04										
	R08			1,00-5,00	0,10-0,50						
	R12										
	R16 / R24										

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### Cutting Parameters $a_p$ (mm) & $f_n$ (mm/rev)

negative 




NEGATIVE INSERT SIZE		CN	-	1204..	1606..	1906..	2507.. 2509..
		DN	1104..	1504.. 1506..	-	-	-
		SN	0903..	1204..	-	1906..	2507.. 2509..
		TN	-	1604..	2204..	-	-
		VN	-	1604..	-	-	-
		WN	0604..	0804..	-	-	-

Chip Breaker Form	Corner Radius	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)
ST	R02										
	R04			1,00-3,50	0,12-0,30						
	R08			1,80-7,00	0,15-0,50						
	R12										
	R16 / R24										
TF	R02										
	R04			0,05-1,00	0,04-0,28						
	R08			0,07-1,00	0,05-0,03						
	R12										
	R16 / R24										
TK	R02										
	R04	0,50-1,00	0,10-0,25	0,50-1,20	0,10-0,28						
	R08	0,50-1,20	0,10-0,28	0,50-1,50	0,10-0,30	0,80-2,00	0,10-0,35				
	R12			0,50-1,60	0,10-0,30						
	R16 / R24										
TM	R02										
	R04										
	R08			0,50-3,00	0,05-0,40						
	R12										
	R16 / R24										
TS	R02										
	R04	1,00-3,00	0,13-0,23	0,80-4,00	0,05-0,30						
	R08			0,80-4,00	0,10-0,40						
	R12			0,80-4,00	0,10-0,40						
	R16 / R24										
UF	R02										
	R04			0,30-1,80	0,05-0,35						
	R08			0,30-2,00	0,05-0,35						
	R12										
	R16 / R24										
UH	R02										
	R04										
	R08										
	R12					1,30-8,00	0,25-0,70				
	R16 / R24					1,80-8,00	0,30-0,80				

## TURNING

### Cutting Parameters $a_p$ (mm) & $f_n$ (mm/rev)

negative 

NEGATIVE INSERT SIZE		CN	-	1204..	1606..	1906..	2507.. 2509..
		DN	1104..	1504.. 1506..	-	-	-
		SN	0903..	1204..	-	1906..	2507.. 2509..
		TN	-	1604..	2204..	-	-
		VN	-	1604..	-	-	-
		WN	0604..	0804..	-	-	-

Chip Breaker Form	Corner Radius	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)
UM	R02										
	R04			1,00-4,50	0,10-0,33	2,00-7,50	0,13-0,33				
	R08			1,50-5,00	0,15-0,45	2,00-8,00	0,18-0,45	3,00-9,00	0,20-0,46		
	R12			1,50-5,50	0,15-0,50	2,00-8,00	0,22-0,50	3,00-10,0	0,24-0,50		
	R16 / R24			1,50-5,50	0,15-0,60	2,00-8,00	0,25-0,60	3,00-10,0	0,32-0,50		
UT	R02										
	R04										
	R08										
	R12					1,30-7,00	0,25-0,65				
	R16 / R24										
UR	R02										
	R04										
	R08			3,00-10,0	0,30-0,72	3,00-15,0	0,27-0,48	3,00-17,0	0,34-0,60		
	R12			3,00-15,00	0,30-0,80	3,00-15,5	0,32-0,50	3,00-18,0	0,38-0,68		
	R16 / R24					3,00-16,00	0,35-0,63	3,00-18,0	0,38-0,68	5,00-17,0	0,45-0,90
US	R02										
	R04			1,50-4,50	0,15-0,45						
	R08			1,50-5,00	0,15-0,5						
	R12			1,50-5,00	0,15-0,50						
	R16 / R24										
VQ	R02										
	R04										
	R08										
	R12										
	R16 / R24										
ZR	R02										
	R04										
	R08										
	R12			1,00-7,00	0,20-0,50						
	R16 / R24			1,80-7,00	0,32-0,75						
R/L-P R/L-C	R02			0,50-3,50	0,08-0,30						
	R04			1,00-3,50	0,12-0,30						
	R08			1,30-3,50	0,15-0,35						
	R12										
	R16 / R24										

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### Cutting Parameters $a_p$ (mm) & $f_n$ (mm/rev)

positive



NEGATIVE INSERT SIZE		CC / CP	0602..	09T3.. 0903..	1204..	-	-
		DC	0702..	11T3..	..	-	-
		SC / SP	-	09T3..	1204..	-	-
		TC / TP	0902..	1102..	16T3..	2204..	-
		VB / VC	-	1103..	1604..	2205..	-
		WB	0601..	-	-	-	-

Chip Breaker Form	Corner Radius	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)
ER/L-U	R02	0,10-0,50	0,01-0,10	0,02-2,00	0,04-0,15						
	R04	0,10-0,50	0,01-0,10	0,50-3,00	0,08-0,30						
	R08										
	R12										
	R16 / R24										
L-F	R02	0,30-1,00	0,10-0,20	0,50-1,20	0,10-0,25						
	R04	0,50-1,00	0,10-0,25	0,70-1,50	0,12-0,30	0,20-4,00	0,02-0,30				
	R08					0,30-5,00	0,03-0,50				
	R12										
	R16 / R24										
L/R-W	R02	0,07-1,80	0,03-0,15	0,08-2,00	0,04-0,15						
	R04	0,1-2,00	0,05-0,2	0,1-2,20	0,08-0,2						
	R08										
	R12										
	R16 / R24										
L-Y	R02			0,06-1,70	0,03-0,13						
	R04			0,09-2,00	0,06-0,22						
	R08										
	R12										
	R16 / R24										
ALU	R02	0,03-3,00	0,01-0,12	0,05-4,00	0,02-0,30	0,05-4,00	0,02-0,30				
	R04	0,10-3,00	0,02-0,13	0,10-5,00	0,03-0,50	0,10-5,00	0,03-0,50				
	R08	0,10-4,00	0,02-0,20	0,10-5,00	0,03-0,50	0,10-5,00	0,04-0,80				
	R12			0,15-5,00	0,04-0,60	0,50-6,50	0,08-0,70	0,10-7,00	0,03-0,60		
	R16 / R24										
CG	R02	0,30-1,00	0,05-0,20								
	R04	0,30-1,00	0,10-0,25	0,30-1,5	0,10-0,25						
	R08	0,40-2,40	0,80-0,25	0,30-1,5	0,10-0,28						
	R12										
	R16 / R24										
HF	R02										
	R04										
	R08										
	R12										
	R16 / R24										

## TURNING

### Cutting Parameters $a_p$ (mm) & $f_n$ (mm/rev)

positive



NEGATIVE INSERT SIZE		CC / CP	0602..	09T3.. 0903..	1204..	-	-
		DC	0702..	11T3..	..	-	-
		SC / SP	-	09T3..	1204..	-	-
		TC / TP	0902..	1102..	16T3..	2204..	-
		VB / VC	-	1103..	1604..	2205..	-
		WB	0601..	-	-	-	-

Chip Breaker Form	Corner Radius	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)	$a_p$ (mm)	$f_n$ (mm/rev)
HM	R02	1,0-6,0	0,10-0,70								
	R04										
	R08										
	R12										
	R16 / R24										
HQ	R02	0,06-1,70	0,06-0,19	0,10-2,00	0,07-0,22						
	R04	0,10-2,00	0,11-0,25	0,80-3,00	0,08-0,30	0,80-3,00	0,08-0,28				
	R08	0,20-2,00	0,08-0,30	1,00-3,00	0,10-0,30	1,00-3,00	0,10-0,33				
	R12										
	R16 / R24										
HR	R02										
	R04										
	R08										
	R12										
	R16 / R24										
TS	R02										
	R04										
	R08										
	R12										
	R16 / R24										
VM	R02										
	R04										
	R08										
	R12										
	R16 / R24										
VQ	R02										
	R04										
	R08										
	R12										
	R16 / R24										
VW	R02										
	R04										
	R08										
	R12										
	R16 / R24										

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### TURNING CVD Comparison table

MATERIAL	SANGEO	ISCAR	SECO	TEAGUTEC	KYOCERA	SANDVIK	KENAMETAL	MITSUBISHI	WALTER	KORLOY
<b>P</b>			TP0500	TT8105	CA5505	GC4305	KCP05(B)	UE6105	WPP10S	NC3010
	CS5215	IC8150	TP0501	TT8110	CA510	GC4205		UE6110	WKP13S	
	CS5215S		TP1500	TT8115	CA515	GC4315	KCP10(B)	MY5015		NC3215
			TP2500	TT8120	CA525	GC4215		MC6025	WPP20S	NC3220
	CS5225	IC8250	TP2501	LC025P	CA5525	GC4325	KCP25(B)	UE6020	WKP23S	NC3225
	CS5225S		T350M	TT8125		GC4225				
	CS5235	IC8350	TP3500	TT5100	CA530	GC4235	KCP30(B)	UE6035	WPP30S	NC3030
				TT8135	CA5535				WKP33S	NC500H
<b>M</b>	CS5240		TGP45	TT7100			KCP40(B)			NC5330
	CS7125S	IC6015	TM2000	TT9215	CA6515	GC2015	KCM15(M)	MC7015	WAM10	NC9020
			TM4000	TT9225	CA6525	GC2025	KCM25(B)	US7020	WAM20	NC9025
<b>K</b>								US735	WAM30	NC9030
	CS8205	IC5005	TK1001	TT7005	CA4505	GC3205	KCK05(B)	MC5005	WKK10S	NC6205
					CA4010	GC3210		UC5105		
	CS8215			TT7310						NC6210
	CS8115									
	IC5015	TK2001	TT7015	CA4515	GC3215	KCK15(B)	MC5015	WKK20S	NC6215	
	CS8125		TGK1500		CA4115	GC3225		UC5115		

### TURNING Cermet

MATERIAL	SANGEO	ISCAR	SECO	TEAGUTEC	KYOCERA	SANDVIK	KENAMETAL	MITSUBISHI	WALTER	KORLOY
<b>UNI</b>										
	SS9115	IC20N	C15M	CT3000	TN60	CT525	KT125	NX2525		CC1500
	SS9125	IC520N					HT5	NX3035		CN1500



## TURNING

### TURNING PVD Comparison table

MATERIAL	SANGEO	ISCAR	SECO	TEAGUTEC	KYOCERA	SANDVIK	KENAMETAL	MITSUBISHI	WALTER	KORLOY
P	PS7110S	IC507	CP200		PR1005					
		IC808			PR915		KU10T			PC8110
	PS7220S		CP250		PR1115		KU25T			PC230
	PS7120				PR930					
		IC3028		TT5030		GC1025		VP15TF	WTA43	PC5300
		IC908			PR1025			VP20MF	WTA41	PC8115
		IC830			PR630	GC4125				
	PS5125		CP500		PR660					PC3545
M	PS7110S	IC808	CP200			GC1005		MP9005		
	PS7220S	IC907			PR915	GC1105	KC5010	VP10RT	WSM10S	PC8110
			CP250				KC5510		WSM20S	PC8115
	PS7120				PR930	GC1020				
		IC3028					KC5025	VP15TF	WSM30S	PC5300
		IC830		TT5030	PR1125	GC1025	KC5525	VP20MF	WSM40S	
					PR630	GC4125				PC9030
	PS5125		CP500	TT8020	PR660	GC2035				PC5400
S										
	PS7110S	IC808	TS2000					VP05RT	WSM10	PC8105
		IC907			PR915	GC1105				
			CP500				KC5010	VP10RT	WSM20	PC8110
	PS7120									PC8115
	PS7220S	IC328	TS2500	TT5030	PR660	GC1025		VP15TF	WSM30	
					PR1325	GC2035	KC5025			PC5300
									PC5400	

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