Update

ZCC·CT

Machining for
Stainless Steel and Super Alloy

Berarbeitung von rostfreiem Stahl und warmfesten Superlegierungen

New ER chipbreaker, grade YBG205
Neu ER Spanbrecher, Sorte YBG205

Perfect combination of chip breaker and grade. Excellent solution for the machining of stainless steel, adhesive material and super alloys.

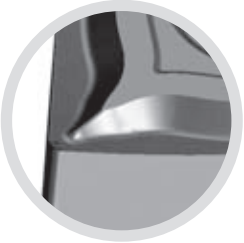
Perfekte Kombination von Spanbrecher und Sorte. Hervorragende Lösung für die Bearbeitung von rostfreiem Stahl, warmfesten Superlegierungen (Inconel, Hastelloy, Waspaloy, Nimonic und Titanlegierungen).

ZCC·CT

ZCC Cutting Tools Europe GmbH

EF EM ER

Special chip breaker series for soft steel, stainless steel and heat resistant superalloy
Spezielle Spanbrecherserie besonders für die Zerspanung von weichem Stahl, rostfreien (M) Stählen und warmfesten Superlegierungen.



-EF

Sharp positive cutting edge for finishing and semifinishing of austenitic stainless steel, soft steel and low carbon steel. Suitable for continuous to light interrupted cut.

Scharfer, positiver Spanbrecher für die Schlichtbearbeitung von rostfreien Stählen, weichem Stahl, Automatenstahl und für Stähle mit niedrigem Kohlenstoffgehalt. Für glatte bis leicht unterbrochene Schnitte.

-EM

Sharp cutting edge with stronger edge line for medium cut even in interrupted cut.

Scharfe, stabile Schneidkante für die mittlere Bearbeitung von Werkstoffen auch im unterbrochenen Schnitt.

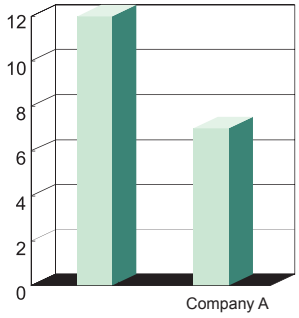
New

-ER

Special edge design with exellent balance between egde strength and sharpness. Suitable for roughing operation.

Speziell entwickelter Spanbrecher mit exzellenter Kantenstabilität bei gleichzeitiger Schneidenschärfe, für die Schruppbearbeitung.

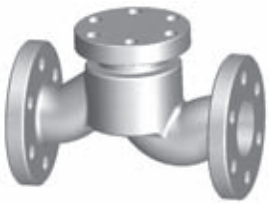
CNMG120408-**EM**
YBG202



piece·edge

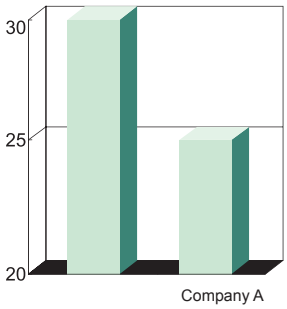
Example · Beispiel:

Parameter:	
D	135mm
V_C	150 m/min
f	0.25mm/rev
ap	2.5 mm



Valve · Ventil

CNMG120408-**EF**
YBG202



piece·edge

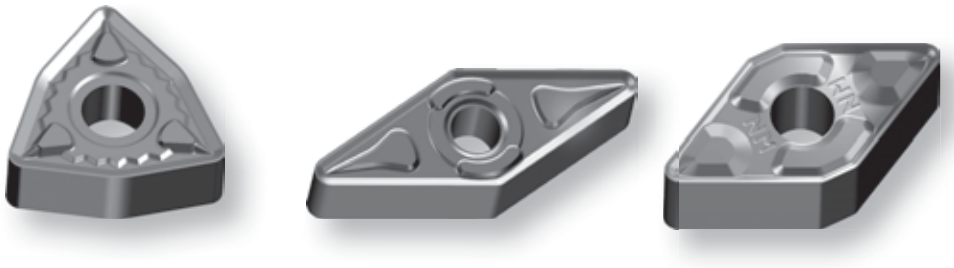
Example · Beispiel:

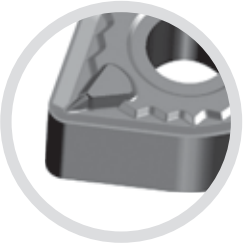
Parameter:	
D	89 mm
V_C	180 m/min
f	0.15mm/rev
ap	1.0 mm

NF NM

NEW

Special chip breaker series for machining heat resistant and super alloy material.
Neue Spanbrecherserie für die Bearbeitung von hochlegierten, warmfesten Materialien.





-NF

Grounded insert with sharp and positive cutting edge. NF combined with grade YBG102 is a good solution for the finishing of heat resistant super alloys (nickel-based such as Inconel 700,718, iron-based and cobalt-based alloys). ap=0.2~1.0mm,Vc=40~100m/min.

Geschliffene Wendeschneidplatte mit einer scharfen, positiven Schneidkante. NF in Kombination mit der Sorte YBG102 ist eine gute Lösung für Schlichtbearbeitungen von warmfesten Superlegierungen (Ni-basiert wie Inconel 700,718, Fe-basiert und Co-basiert) ap=0.2~1.0mm,Vc=40~100m/min.

-NM

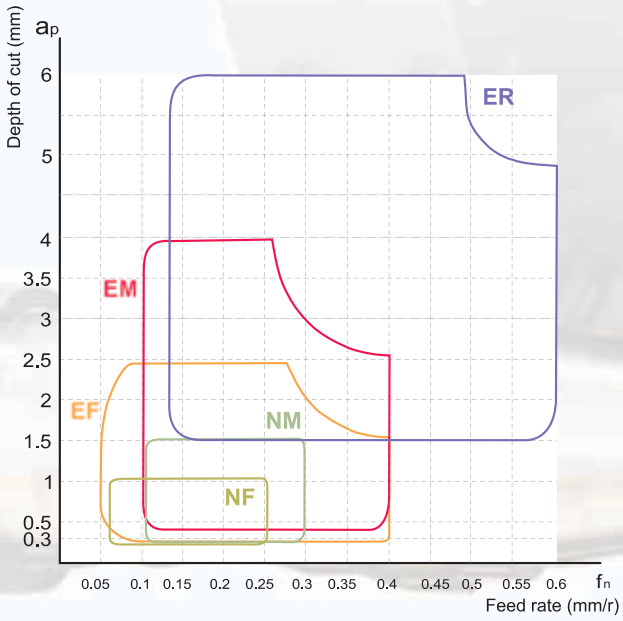
Sharp cutting edge with positive multi-rakes. Special for the semifinishing of heat resistant super alloys.

Scharfe Schneidkante mit positivem Multi-Spanwinkel. Besonders geeignet für die Bearbeitung von warmfesten Superlegierungen.

Range of chip breaker / Anwendungsbereich Spanbrecher

-EF
-EM
-ER

-NF
-NM



Application field CVD, turning grade for stainless Steel

Anwendungsbereich CVD, Drehsorten für rostfreien Stahl

YBM 151

Substrate with special structure, in combination with TiCN, thin layer AL_2O_3, TIN coating with resistance against diffusion wear and plastic deformation it is good for finishing and semi-finishing of stainless steel.

CVD-beschichtetes Hartmetall. Die besondere Struktur in Kombination mit TiCN und Al2O3, TiN Auflage hat eine ausgezeichnete Schichthaftung und Widerstandsfähigkeit gegen plastische Verformung. Gut geeignet für die Schlicht- bis mittlere Bearbeitung von rostfreiem Stahl.

YBM 251

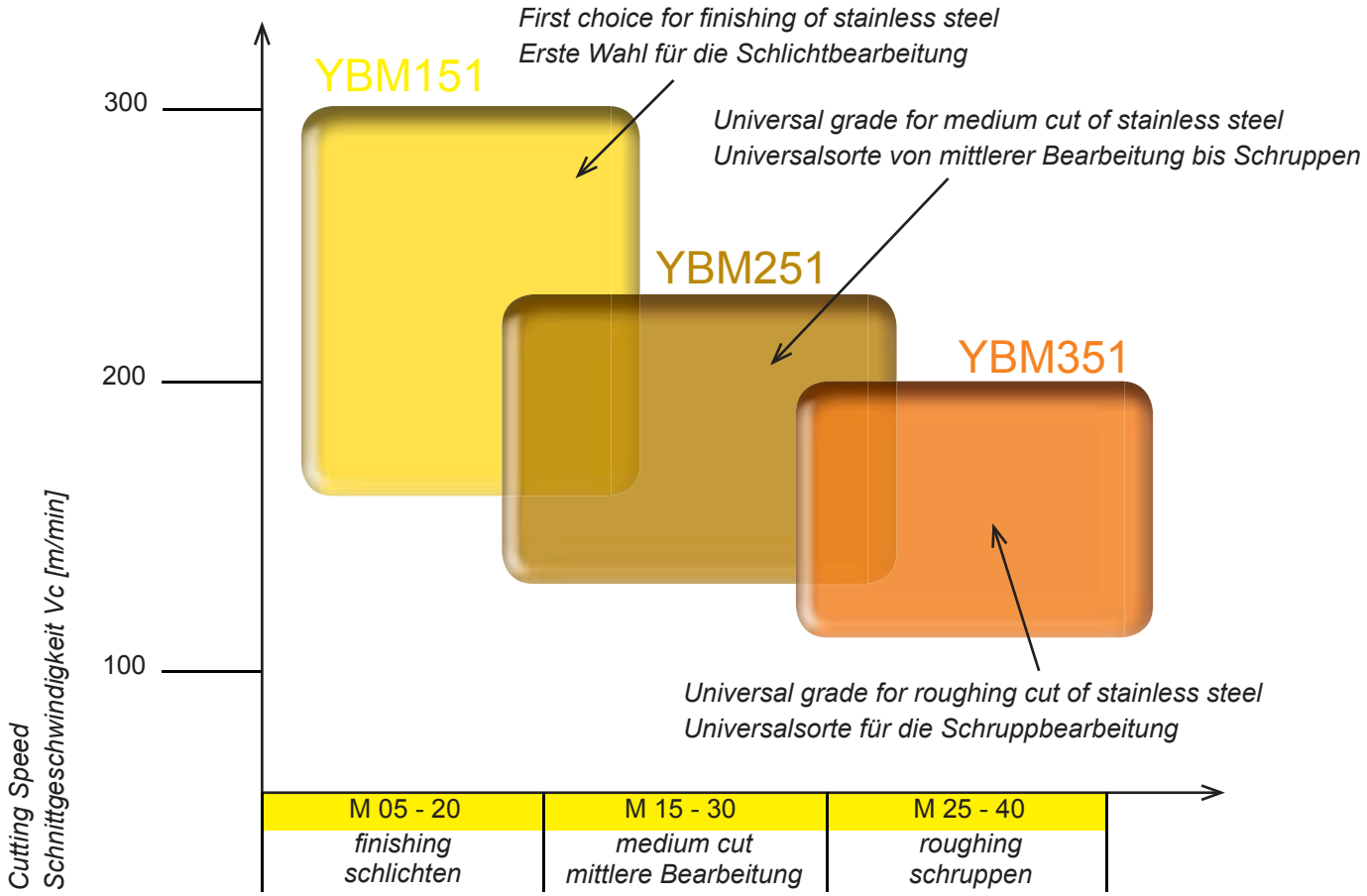
Substrate with good toughness and strength, in combination with Ti(CN), thin layer AL_2O_3, TiN coating. It is a premium grade for semi-finishing to light roughing of stainless steel at continuous and intermittent machining conditions.

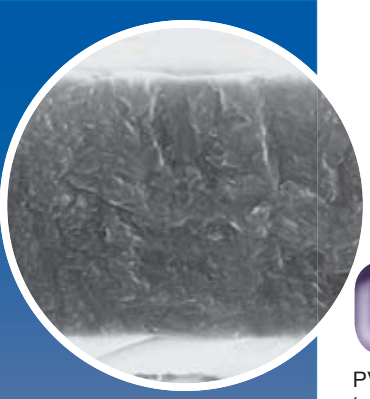
Universal einsetzbares CVD-beschichtetes Hartmetall aus TiCN, Al2O3 und TiN mit guter Zähigkeit und Verschleißfestigkeit. Optimiert für mittlere Drehbearbeitung von rostfreiem Stahl mit und ohne Schnittunterbrechung.

YBM 351

Coated carbide grade with very good strength and impact resistance. It is suitable for rough turning of stainless steel at low to moderate cutting speed or interrupted cutting.

Beschichtete Hartmetallsorte mit ausgezeichneter Widerstandsfähigkeit und Schneidkantensicherheit. Ideal für schwere Schruppbearbeitung von rostfreiem Stahl und Stahl bei mittleren Schnittgeschwindigkeiten oder bei Schnittunterbrechung.





Coated Cemented Carbide PVD
Beschichtestes Hartmetall PVD

Makes it easy to machine material which is hard to be machined...

Die Lösung für die Bearbeitung von schwer zu zerspanenden Materialien...

YBG 102
N10 (N01-N10)
S10 (S01-S20)

PVD nano-TiAlN coated fine grain carbide grade. It is suitable for finishing and semi-finishing turning of high-temperature alloys, nonferrous metal (Aluminium with Si>=12%) and finishing of stainless steel.

Nano-TiAlN PVD-beschichtete, feinkörnige Hartmetallsorte. Gut geeignet zum Drehen von warmfesten Superlegierungen, NE-Metallen (Aluminium mit Si>=12%) und zum Schlichten von rostfreiem Stahl.

YBG 202
P20 (P10-P25)
M20 (M10-M25)

PVD nano-TiAlN (2~4μm) coated fine grain carbide grade. Good performance in combination of toughness and wear resistance, suitable for turning, parting, grooving of steel, stainless steel, cast iron and high-temperature alloys in finishing and semi-finishing machining.

Nano-TiAlN (2~4μm) PVD beschichtete, feinkörnige Hartmetallsorte. Hervorragende Kombination von Zähigkeit und Verschleißfestigkeit. Zum Drehen, Ab- und Einstechen von Stahl, rostfreiem Stahl, Guss und warmfesten Superlegierungen bei leichter und mittlerer Bearbeitung.

YBG 205
P20 (P10-P30)
M20 (M10-M30)

New nano structure coating process ensures higher toughness but also hardness. This coating grade results in smooth surface finish on the insert, which reduces friction and improves chip flows. Excellent thermal and chemical resistance. This grade is suitable to machine stainless steel and high temperature alloy.

Neue Nano-Beschichtungsstruktur mit gleichzeitiger Härte und Verschleißfestigkeit bzw. Zähigkeit. Eine ultra glatte Schichtoberfläche vermindert die Reibung und garantiert einen optimierten Spanabfluß. Die exzellente thermische und chemische Widerstandsfähigkeit zeigt diese Sorte besonders bei der Bearbeitung von rostfreien Stählen und warmfesten Legierungen.

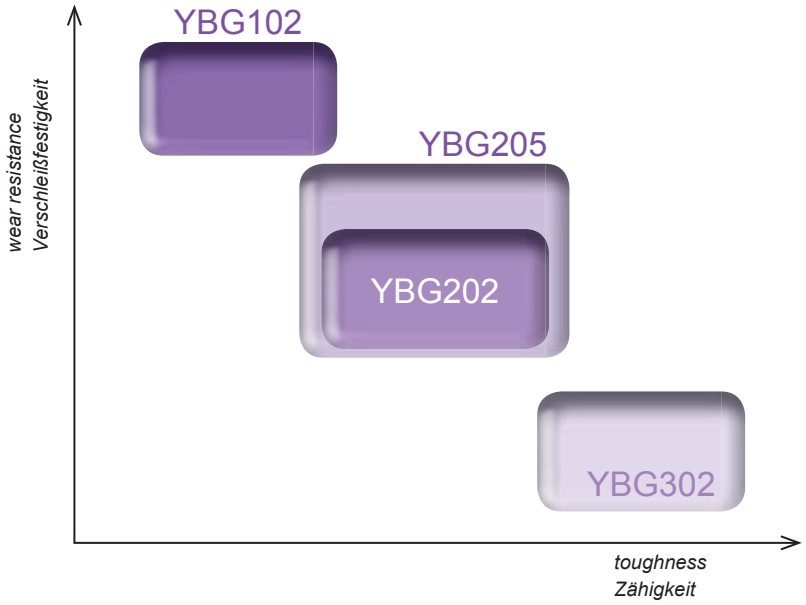
YBG 302
P30 (P20-P35)
M10 (M20-M35)

Substrate with good toughness and strength. PVD nano-TiAlN coated. It is a universial PVD grade for steel, stainless steel in turning, parting off, and grooving operation.

Universial einsetzbares PVD-beschichtetes Hartmetall mit guter Zähigkeit und Verschleißfähigkeit. Zum Drehen, Ab- und Einstechen von Stahl und rostfreiem Stahl sowie Guss.

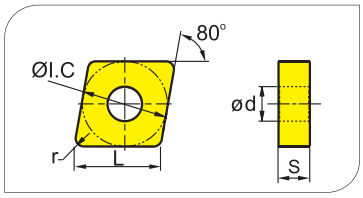
-Special coating process for smooth insert surface
-Reduce friction - best chip evacuation
-combination of wear resistance and toughness
-best thermal and chemical stability

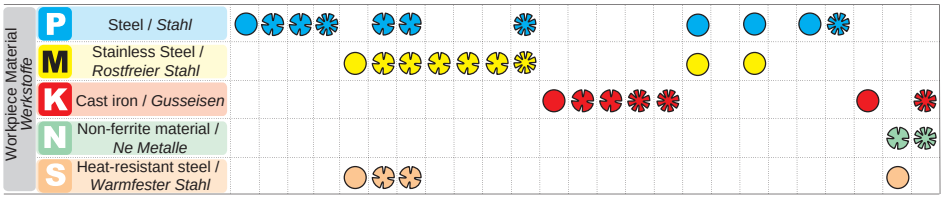
-Spezieller Beschichtungsprozeß mit sehr glatter Oberflächenstruktur
-Reduzierte Reibung - exzellenter Spanfluß
-Kombination aus Verschleißfestigkeit und Zähigkeit
-Beste thermische und chemische Stabilität



CN** Negative Insert · Negative WSP

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



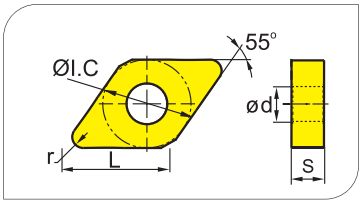


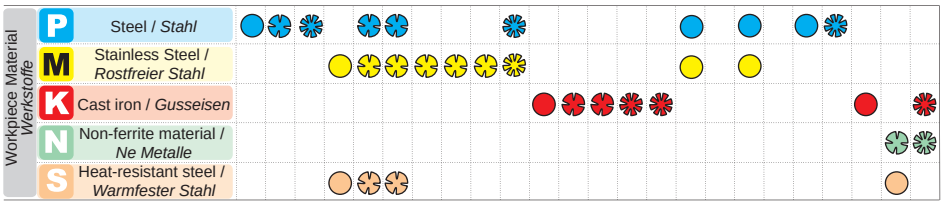
Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC252	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**CNMG090304-EF**	9.7	9.525	3.18	3.81	0.4						●	○																	
	CNMG090308-EF	9.7	9.525	3.18	3.81	0.8						●	○																	
	CNMG120404-EF	12.9	12.7	4.76	5.16	0.4		●				●	○		●	●														
	CNMG120408-EF	12.9	12.7	4.76	5.16	0.8	○	●				●	●	○	●	●														
	CNMG120412-EF	12.9	12.7	4.76	5.16	1.2						●	○	○	●	●														
EM Medium Cut/ Mittl. Bearb.	**CNMG120404-EM**	12.9	12.7	4.76	5.16	0.4						●	●	●		●														
	CNMG120408-EM	12.9	12.7	4.76	5.16	0.8						●	●	●	●	●														
	CNMG120412-EM	12.9	12.7	4.76	5.16	1.2						●		○		●														
	CNMG160608-EM	16.1	15.875	6.35	6.35	0.8								●																
	CNMG160612-EM	16.1	15.875	6.35	6.35	1.2						●		○																
	CNMG160616-EM	16.1	15.875	6.35	6.35	1.6								○																
ER Roughing / Schruppen	**CNMG120408-ER**	12.9	12.7	4.76	5.16	0.8									●															
	CNMG120412-ER	12.9	12.7	4.76	5.16	1.2									●															
	CNMG160612-ER	16.1	15.875	6.35	6.35	1.2									●															
	CNMG160616-ER	16.1	15.875	6.35	6.35	1.6									●															
	CNMG190612-ER	19.3	19.05	6.35	7.94	1.2							○		●															
	CNMG190616-ER	19.3	19.05	6.35	7.94	1.6									●															
ER Roughing / Schruppen	**CNMM250724-ER**	25.79	25.4	7.94	9.12	2.4			●						○		○													
	CNMM250732-ER	25.79	25.4	7.94	9.12	3.2									○		○													
	CNMM250924-ER	25.79	25.4	9.525	9.12	2.4			●						○		○													
	CNMM250932-ER	25.79	25.4	9.525	9.12	3.2									○		○													
NM Medium Cut/ Mittl. Bearb.	**CNMG120404-NM**	12.9	12.7	4.76	5.16	0.4																								
	CNMG120408-NM	12.9	12.7	4.76	5.16	0.8					●																		○	
	CNMG120412-NM	12.9	12.7	4.76	5.16	1.2					●																			
NF Finishing Schlichten	**CNEG120404-NF**	12.9	12.7	4.76	5.16	0.4					●																		○	
	CNEG120408-NF	12.9	12.7	4.76	5.16	0.8					●																		○	
	CNEG120412-NF	12.9	12.7	4.76	5.16	1.2					○																		○	

● ex stock / ab Lager ○ on demand /auf Anfrage

DN** Negative Insert·Negative WSP

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

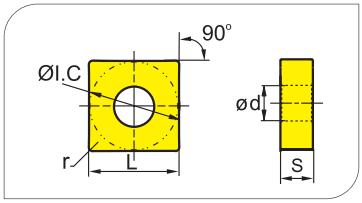


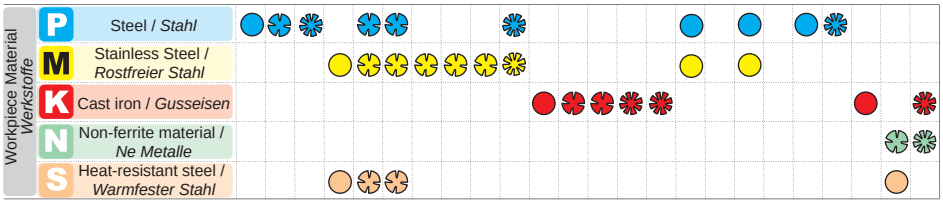


Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**DNMG110404-EF**	11.6	9.525	4.76	3.81	0.4					●	○		●																
	DNMG110408-EF	11.6	9.525	4.76	3.81	0.8					●	○		●																
	DNMG110412-EF	11.6	9.525	4.76	3.81	1.2						○																		
	DNMG150404-EF	15.5	12.7	4.76	5.16	0.4					●	○																		
	DNMG150408-EF	15.5	12.7	4.76	5.16	0.8					●	○																		
	DNMG150412-EF	15.5	12.7	4.76	5.16	1.2						○																		
	DNMG150604-EF	15.5	12.7	6.35	5.16	0.4		●			●	●		●	●															
	DNMG150608-EF	15.5	12.7	6.35	5.16	0.8		●			●	●		●	●															
	DNMG150612-EF	15.5	12.7	6.35	5.16	1.2					●																			
EM Medium Cut/ Mittl. Bearb.	**DNMG110404-EM**	11.6	9.525	4.76	3.81	0.4					●	○																		
	DNMG110408-EM	11.6	9.525	4.76	3.81	0.8					●	○			●															
	DNMG110412-EM	11.6	9.525	4.76	3.81	1.2						○																		
	DNMG150404-EM	15.5	12.7	4.76	5.16	0.4					●	○																		
	DNMG150408-EM	15.5	12.7	4.76	5.16	0.8					●	○																		
	DNMG150412-EM	15.5	12.7	4.76	5.16	1.2						○																		
	DNMG150604-EM	15.5	12.7	6.35	5.16	0.4					●	●			●															
	DNMG150608-EM	15.5	12.7	6.35	5.16	0.8					●	●	○	●	●															
	DNMG150612-EM	15.5	12.7	6.35	5.16	1.2					●	○			●															
ER Roughing/ Schruppen	**DNMG150608-ER**	15.5	12.7	6.35	5.16	0.8								●																
	DNMG150612-ER	15.5	12.7	6.35	5.16	1.2								●																
ER Roughing/ Schruppen	**DNMM150608-ER**	15.5	12.7	6.35	5.16	0.8								○																
	DNMM150612-ER	15.5	12.7	6.35	5.16	1.2								○																
NM Medium Cut/ Mittl. Bearb.	**DNMG150412-NM**	15.5	12.7	4.76	5.16	1.2																								
	DNMG150612-NM	15.5	12.7	6.35	5.16	1.2				○					○														○	
NF finishing Schlichten	**DNEG150404-NF**	15.5	12.7	4.76	5.16	0.4																								
	DNEG150408-NF	15.5	12.7	4.76	5.16	0.8																								
	DNEG150604-NF	15.5	12.7	6.35	5.16	0.4				●																			○	
	DNEG150608-NF	15.5	12.7	6.35	5.16	0.8				●																			○	

● ex stock / ab Lager ○ on demand /auf Anfrage

SN** Negative Insert·Negative WSP

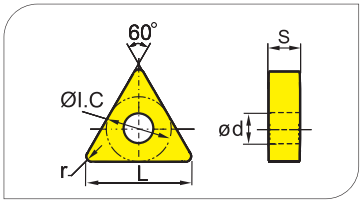


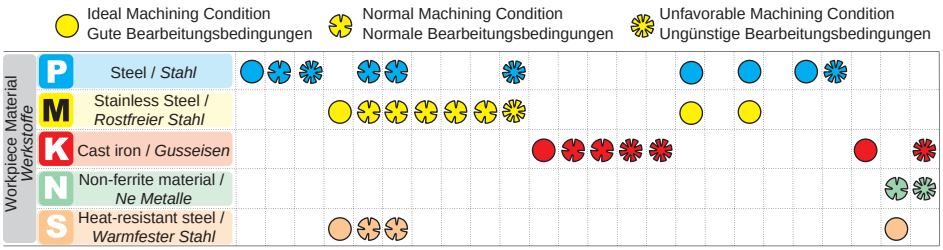


Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**SNMG090304-EF**	9.525	9.525	3.18	3.81	0.4					●	○																		
	SNMG090308-EF	9.525	9.525	3.18	3.81	0.8					●	○																		
	SNMG090312-EF	9.525	9.525	3.18	3.81	1.2						○																		
	SNMG120404-EF	12.7	12.7	4.76	5.16	0.4					○	●																		
	SNMG120408-EF	12.7	12.7	4.76	5.16	0.8					●	○																		
	SNMG120412-EF	12.7	12.7	4.76	5.16	1.2					●	○		●																
	SNMG150608-EF	15.875	15.875	6.35	6.35	0.8					○	○																		
	SNMG150612-EF	15.875	15.875	6.35	6.35	1.2						○																		
EM Medium Cut/ Mittl. Bearb.	**SNMG120404-EM**	12.7	12.7	4.76	5.16	0.4					○	●																		
	SNMG120408-EM	12.7	12.7	4.76	5.16	0.8					●	●			●	○														
	SNMG120412-EM	12.7	12.7	4.76	5.16	1.2					●	○			●	○														
	SNMG120416-EM	12.7	12.7	4.76	5.16	1.6						○																		
	SNMG150612-EM	15.875	15.875	6.35	6.35	1.2						○																		
	SNMG150616-EM	15.875	15.875	6.35	6.35	1.6						○																		
ER Roughing/ Schruppen	**SNMG120408-ER**	12.7	12.7	4.76	5.16	0.8																								
	SNMG120412-ER	12.7	12.7	4.76	5.16	1.2																								
	SNMG150608-ER	15.875	15.875	6.35	6.35	0.8																								
	SNMG150612-ER	15.875	15.875	6.35	6.35	1.2								●																
	SNMG190612-ER	19.05	19.05	6.35	7.94	1.2								●																
	SNMG190616-ER	19.05	19.05	6.35	7.94	1.6								●																
ER Roughing/ Schruppen	**SNMM250724-ER**	25.4	25.4	7.94	9.12	2.4								●																
	SNMM250732-ER	25.4	25.4	7.94	9.12	3.2		○																						
	SNMM250924-ER	25.4	25.4	9.525	9.12	2.4		○						○		●														
	SNMM250932-ER	25.4	25.4	9.525	9.12	3.2		○								●														
NM Medium Cut/ Mittl. Bearb.	**SNMG120408-NM**	12.7	12.7	4.76	5.16	0.8				●																				
	SNMG120412-NM	12.7	12.7	4.76	5.16	1.2																								

● ex stock / ab Lager ○ on demand /auf Anfrage

TN** Negative Insert·Negative WSP

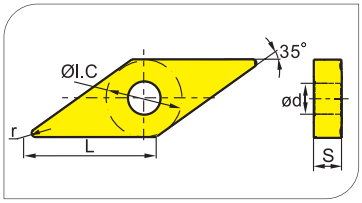


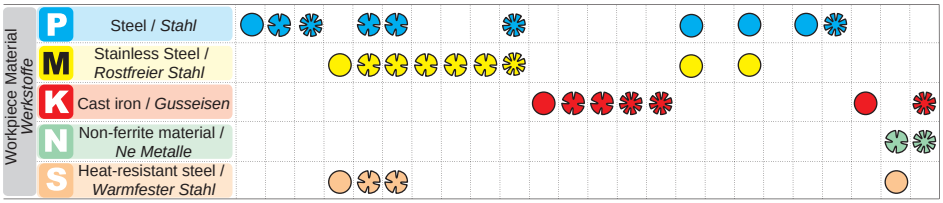


Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**TNMG110304-EF**	11	6.35	3.18	2.26	0.4						○																		
	TNMG110308-EF	11	6.35	3.18	2.26	0.8						●																		
	TNMG160404-EF	16.5	9.525	4.76	3.81	0.4					●	●		●																
	TNMG160408-EF	16.5	9.525	4.76	3.81	0.8					●	●		●	○															
	TNMG160412-EF	16.5	9.525	4.76	3.81	1.2					●	○																		
	TNMG220404-EF	22	12.7	4.76	5.16	0.4					●	●																		
	TNMG220408-EF	22	12.7	4.76	5.16	0.8					●	●																		
	TNMG220412-EF	22	12.7	4.76	5.16	1.2					●	○																		
EM Medium Cut/ Mittl. Bearb.	**TNMG160404-EM**	16.5	9.525	4.76	3.81	0.4					●	●																		
	TNMG160408-EM	16.5	9.525	4.76	3.81	0.8					●	●			●															
	TNMG160412-EM	16.5	9.525	4.76	3.81	1.2					●	○																		
	TNMG220408-EM	22	12.7	4.76	5.16	0.8					●	●			●															
	TNMG220412-EM	22	12.7	4.76	5.16	1.2					●	●			●															
	TNMG220416-EM	22	12.7	4.76	5.16	1.6					●	●			●															
ER Roughing/ Schruppen	**TNMG160408-ER**	16.5	9.525	4.76	3.81	0.8								○																
	TNMG160412-ER	16.5	9.525	4.76	3.81	1.2								○																
	TNMG220408-ER	22	12.7	4.76	5.16	0.8								○																
	TNMG220412-ER	22	12.7	4.76	5.16	1.2								●																

● ex stock / ab Lager ○ on demand /auf Anfrage

VN** Negative Insert·Negative WSP

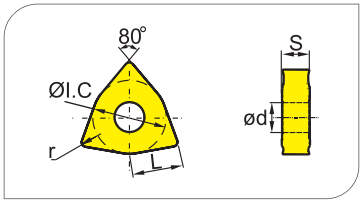


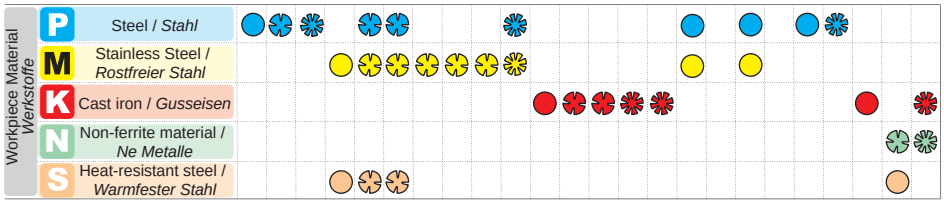


Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**VNMG160404-EF**	16.6	9.525	4.76	3.81	0.4					●	●		●																
	VNMG160408-EF	16.6	9.525	4.76	3.81	0.8					●	●																		
	VNMG160412-EF	16.6	9.525	4.76	3.81	1.2						○																		
EM Medium Cut/ Mittl. Bearb.	**VNMG160404-EM**	16.6	9.525	4.76	3.81	0.4					●	●																		
	VNMG160408-EM	16.6	9.525	4.76	3.81	0.8					●	●																		
NF Finishing Schlichten	**VNEG160404-NF**	16.6	9.525	4.76	3.81	0.4				●																			○	
	VNEG160408-NF	16.6	9.525	4.76	3.81	0.8				●																			○	
NM Medium Cut/ Mittl. Bearb.	**VNMG160412-NM**	16.6	9.525	4.76	3.81	1.2																								

● ex stock / ab Lager ○ on demand /auf Anfrage

WN** Negative Insert·Negative WSP

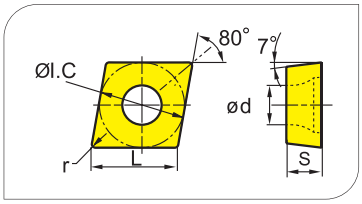




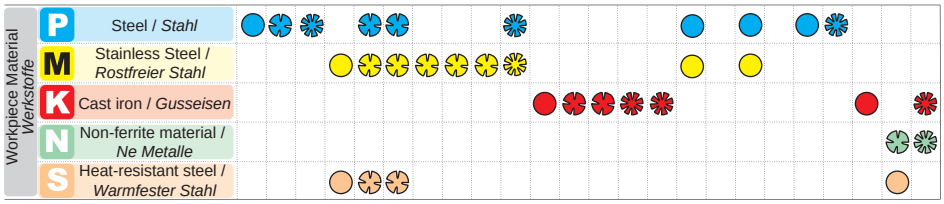
Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**WNMG06T304-EF**	6.5	9.525	3.97	3.81	0.4																								
	WNMG06T308-EF	6.5	9.525	3.97	3.81	0.8																								
	WNMG06T312-EF	6.5	9.525	3.97	3.81	1.2																								
	WNMG060404-EF	6.5	9.525	4.76	3.81	0.4					●	○		●																
	WNMG060408-EF	6.5	9.525	4.76	3.81	0.8					●	○		●	○															
	WNMG080404-EF	8.7	12.7	4.76	5.16	0.4		●			●	○		●	●															
	WNMG080408-EF	8.7	12.7	4.76	5.16	0.8		●		●	●	●	○	●	●															
EM Medium Cut/ Mittl. Bearb.	**WNMG06T304-EM**	6.5	9.525	3.97	3.81	0.4																								
	WNMG06T308-EM	6.5	9.525	3.97	3.81	0.8																								
	WNMG06T312-EM	6.5	9.525	3.97	3.81	1.2																								
	WNMG060404-EM	6.5	9.525	4.76	3.81	0.4					●				○															
	WNMG060408-EM	6.5	9.525	4.76	3.81	0.8					●				●															
	WNMG080404-EM	8.7	12.7	4.76	5.16	0.4					●	●		●	●															
	WNMG080408-EM	8.7	12.7	4.76	5.16	0.8					●	●		●	●	●														
	WNMG080412-EM	8.7	12.7	4.76	5.16	1.2					●	○																		
NF Finishing Schlichten	**WNEG080404-NF**	8.7	12.7	4.76	5.16	0.4				●																				
	WNEG080408-NF	8.7	12.7	4.76	5.16	0.8																								
NM Medium Cut/ Mittl. Bearb.	**WNMG080408-NM**	8.7	12.7	4.76	5.16	0.8				●		○																		
	WNMG080412-NM	8.7	12.7	4.76	5.16	1.2				●		○																		

● ex stock / ab Lager ○ on demand /auf Anfrage

CC** Positive Insert/ Positive WSP

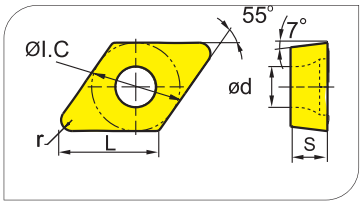


Ideal Machining Condition / Gute Bearbeitungsbedingungen
Normal Machining Condition / Normale Bearbeitungsbedingungen
Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

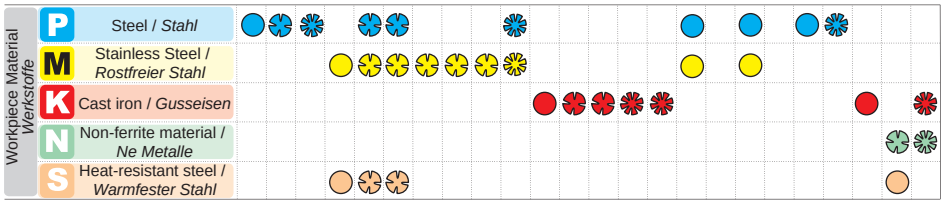


Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**CCMT060202-EF**	6.4	6.35	2.38	2.8	0.2						●																		
	CCMT060204-EF	6.4	6.35	2.38	2.8	0.4					○	●																		
	CCMT09T302-EF	9.7	9.525	3.97	4.4	0.2						●																		
	CCMT09T304-EF	9.7	9.525	3.97	4.4	0.4					○	●																		
	CCMT09T308-EF	9.7	9.525	3.97	4.4	0.8						●																		
	CCMT120404-EF	12.9	12.7	4.76	5.56	0.4						●																		
	CCMT120408-EF	12.9	12.7	4.76	5.56	0.8						●																		
EM Medium Cut/ Mittl. Bearb.	**CCMT060204-EM**	6.4	6.35	2.38	2.8	0.4					○	●																		
	CCMT060208-EM	6.4	6.35	2.38	2.8	0.8					○	●																		
	CCMT09T304-EM	9.7	9.525	3.97	4.4	0.4					○	●		○	○															
	CCMT09T308-EM	9.7	9.525	3.97	4.4	0.8					○	●			○															
	CCMT120404-EM	12.9	12.7	4.76	5.56	0.4					○	●																		
	CCMT120408-EM	12.9	12.7	4.76	5.56	0.8					○	●																		
	CCMT120412-EM	12.9	12.7	4.76	5.56	1.2					○	○																		

DC** Positive Insert/ Positive WSP



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

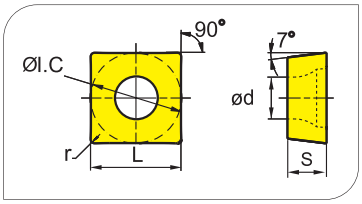


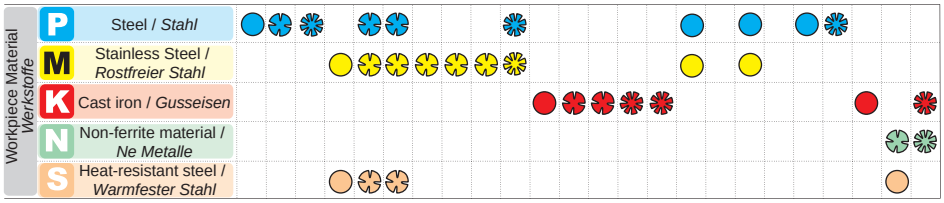
Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**DCMT070202-EF**	7.8	6.35	2.38	2.8	0.2						●																		
	DCMT070204-EF	7.8	6.35	2.38	2.8	0.4					○	●																		
	DCMT11T302-EF	11.6	9.525	3.97	4.4	0.2						●																		
	DCMT11T304-EF	11.6	9.525	3.97	4.4	0.4					○	●																		
	DCMT11T308-EF	11.6	9.525	3.97	4.4	0.8						●																		
EM Medium Cut/ Mittl. Bearb.	**DCMT070204-EM**	7.8	6.35	2.38	2.8	0.4					○	●																		
	DCMT070208-EM	7.8	6.35	2.38	2.8	0.8						○																		
	DCMT11T304-EM	11.6	9.525	3.97	4.4	0.4					○	●		○	○															
	DCMT11T308-EM	11.6	9.525	3.97	4.4	0.8					○	●																		

● ex stock / ab Lager ○ on demand /auf Anfrage

CC** Positive Insert/ Positive WSP

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

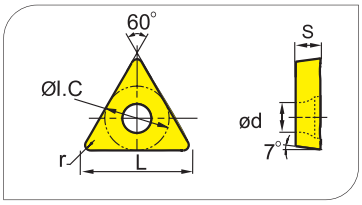


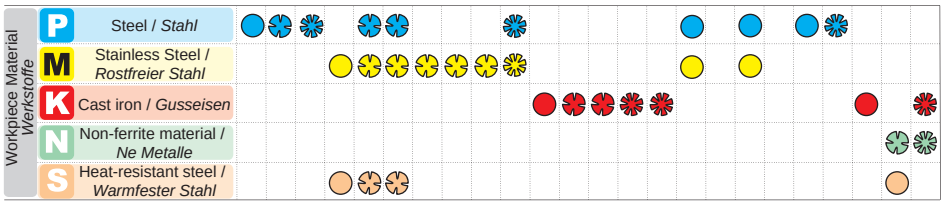


Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung L	I.C	S	d	r	Coated Carbide Beschichtetes Hartmetall YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	Cermet unbeschichtet YNG151	Cermet Coated beschicht. Cerm. YNG151C	Uncoated Carbide unbeschicht. Hartmetall YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**SCMT09T302-EF**	9.525	9.525	3.97	4.4	0.2						○																
	SCMT09T304-EF	9.525	9.525	3.97	4.4	0.4						●																
	SCMT09T308-EF	9.525	9.525	3.97	4.4	0.8						●																
EM Finishing Schlichten	**SCMT09T304-EM**	9.525	9.525	3.97	4.4	0.4						●																
	SCMT09T308-EM	9.525	9.525	3.97	4.4	0.8						●																
	SCMT120404-EM	12.7	12.7	4.76	5.56	0.4						●																
	SCMT120408-EM	12.7	12.7	4.76	5.56	0.8						●																
	SCMT120412-EM	12.7	12.7	4.76	5.56	1.2						○																

TC** Positive Insert/ Positive WSP

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

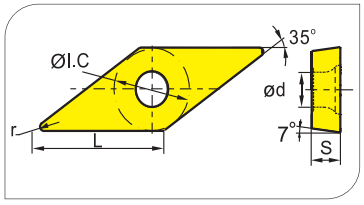


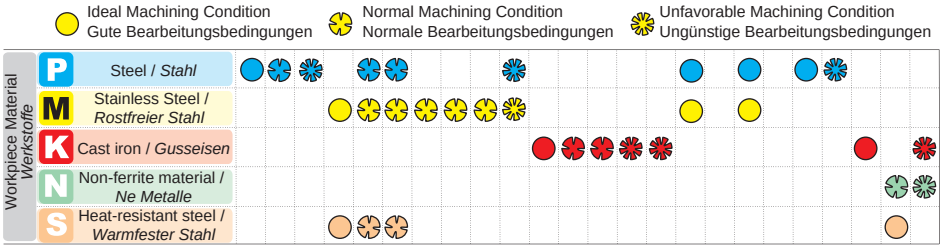


Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung L	I.C	S	d	r	Coated Carbide Beschichtetes Hartmetall YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	Cermet unbeschichtet YNG151	Cermet Coated beschicht. Cerm. YNG151C	Uncoated Carbide unbeschicht. Hartmetall YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**TCMT090202-EF**	9.6	5.56	2.38	2.5	0.2						○																
	TCMT090204-EF	9.6	5.56	2.38	2.5	0.4						○																
	TCMT110202-EF	11	6.35	2.38	2.8	0.2						○																
	TCMT110204-EF	11	6.35	2.38	2.8	0.4						●																
	TCMT110208-EF	11	6.35	2.38	2.8	0.8						●																
	TCMT16T304-EF	16.5	9.525	3.97	4.4	0.4						●																
	TCMT16T308-EF	16.5	9.525	3.97	4.4	0.8						●																
EM Medium Cut/ Mittl. Bearb.	**TCMT090204-EM**	9.6	5.56	2.38	2.8	0.4						○																
	TCMT090208-EM	9.6	5.56	2.38	2.8	0.8						○																
	TCMT110204-EM	11	6.35	2.38	2.8	0.4						○																
	TCMT110208-EM	11	6.35	2.38	2.8	0.8						○																
	TCMT110212-EM	11	6.35	2.38	2.8	1.2																						
	TCMT16T304-EM	16.5	9.525	3.97	4.4	0.4						●																
	TCMT16T308-EM	16.5	9.525	3.97	4.4	0.8						●																
	TCMT16T312-EM	16.5	9.525	3.97	4.4	1.2						○																

● ex stock / ab Lager ○ on demand /auf Anfrage

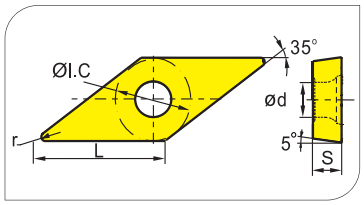
VC** Positive Insert/ Positive WSP

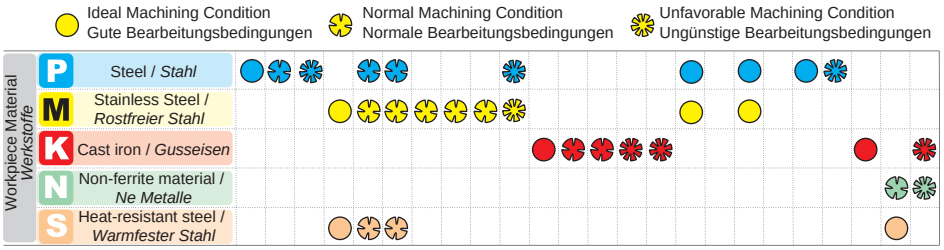




Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall														Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
NF Finishing Schlichten	**VCGT160408-NF**	16.5	9.525	4.76	4.4	0.8				●																			

VB** Positive Insert/ Positive WSP

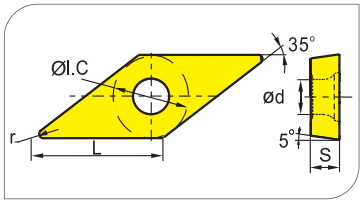




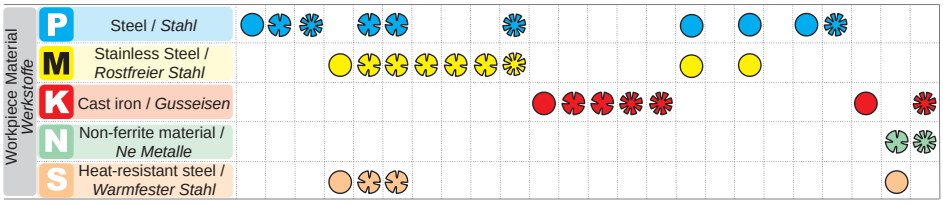
Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall														Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EF Finishing Schlichten	**VBMT110302-EF**	11	6.35	3.18	2.8	0.2						●																	
	VBMT110304-EF	11	6.35	3.18	2.8	0.4						●																	
	VBMT110308-EF	11	6.35	3.18	2.8	0.8						○																	
	VBMT160404-EF	16.5	9.525	4.76	4.4	0.4						●																	
	VBMT160408-EF	16.5	9.525	4.76	4.4	0.8						●																	
NF Finishing Schlichten	**VBET160404-NF**	16.5	9.525	4.76	4.4	0.4				●																			
	VBET160408-NF	16.5	9.525	4.76	4.4	0.8				●																			

● ex stock / ab Lager ○ on demand /auf Anfrage

VB** Positive Insert/ Positive WSP

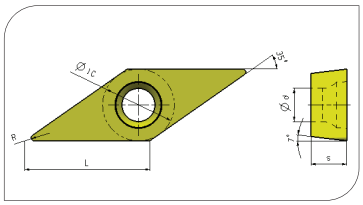


Ideal Machining Condition / Gute Bearbeitungsbedingungen
Normal Machining Condition / Normale Bearbeitungsbedingungen
Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

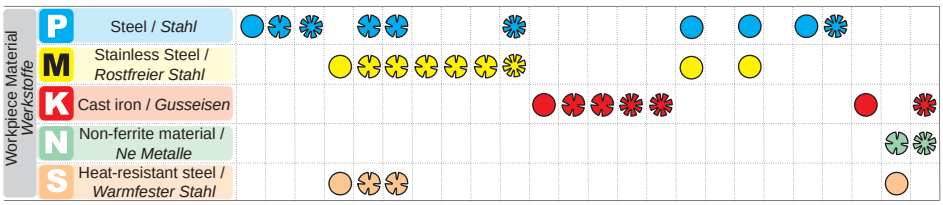


Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EM Medium Cut/ Mittl. Bearb.	**VBMT110304-EM**	11	6.35	3.18	2.8	0.4						●																		
	VBMT110308-EM	11	6.35	3.18	2.8	0.8						●																		

VC** Positive Insert/ Positive WSP



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



Insert Shape Schneid-plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall															Cermet unbeschichtet		Cermet Coated beschicht. Cerm.		Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC251	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151		YNG151C		YC10	YC40	YD051	YD101	YD201
EM Finishing Schlichten	**VCMT160404-EM**	16	9.525	4.76	4.4	0.4						●																		
	VCMT160408-EM	16	9.525	4.76	4.4	0.8						●																		

● ex stock / ab Lager ○ on demand /auf Anfrage

Chip breaker
Spanbrecher

NF NM
EF EM ER

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