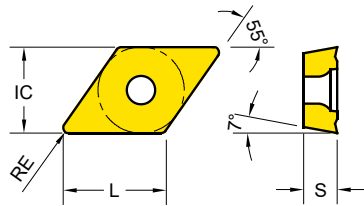


Turning Inserts - Positive

DCMT / DCGT (55° Positive)



Series	L	IC	S
DC** 0702	7.5	6.35	2.38
DC** 11T3	11.2	9.53	3.97

EDP 2200..

● : Stock item ○ : Order made item

						P05	P10	P20	P30	P20	M15	M30	M40	N20	N20
						K10	K20		M20		S10	S20	S30		
DCGT		Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
DCMT															
-AL	 Aluminum	DCGT 11T302 - AL	0.2	0.02 ~ 0.08	0.5 ~ 1									● 0341	● 0342
		DCGT 11T304 - AL	0.4	0.05 ~ 0.25	0.5 ~ 2									● 0083	● 0332
		DCGT 11T308 - AL	0.8	0.1 ~ 0.3	1 ~ 2.5									● 0084	● 0333
-UF	 Finishing	DCMT 070204 - UF	0.4	0.05 ~ 0.2	0.5 ~ 1.5		● 0207	● 0208							
		DCMT 11T304 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2		● 0213	● 0214							
		DCMT 11T308 - UF	0.8	0.05 ~ 0.25	1 ~ 2.5		● 0219	● 0220							
-UG	 General	DCMT 070204 - UG	0.4	0.1 ~ 0.25	0.5 ~ 1.5		● 0210	● 0211		● 0013					
		DCMT 070208 - UG	0.8	0.1 ~ 0.25	0.8 ~ 1.5		● 0484	● 0717							
		DCMT 11T304 - UG	0.4	0.15 ~ 0.3	0.5 ~ 2	● 0677	● 0216	● 0217		● 0014					
		DCMT 11T308 - UG	0.8	0.15 ~ 0.3	0.8 ~ 2.5	● 0678	● 0222	● 0223	● 0224	● 0015					

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

Product Overview

Turning Grades

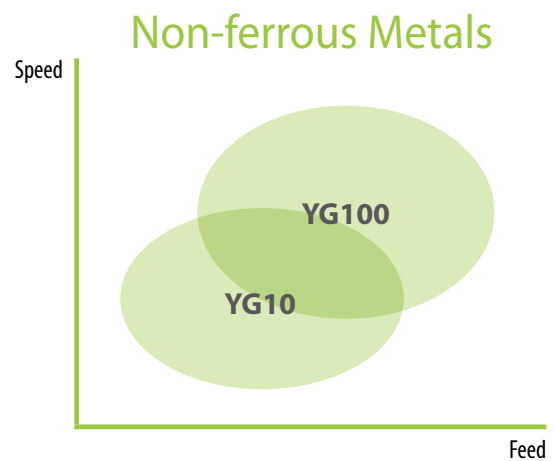
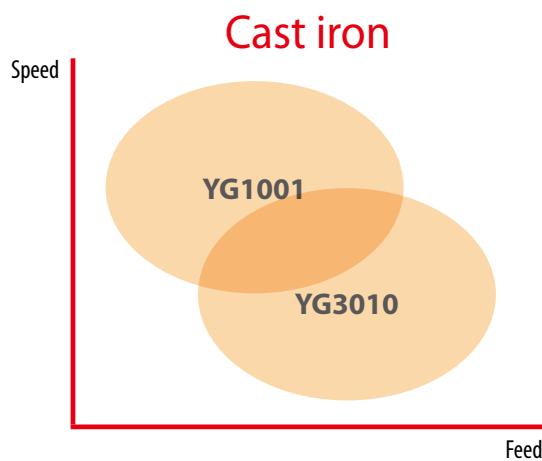
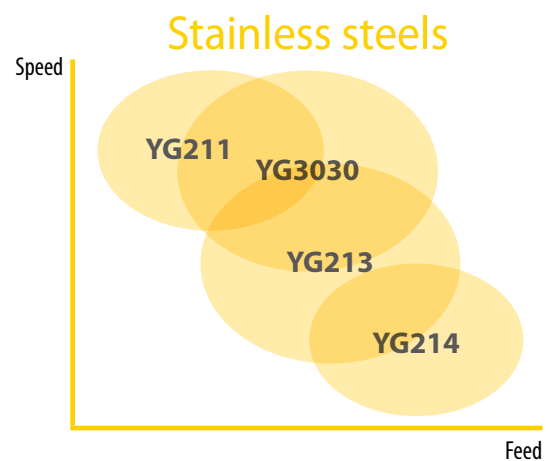
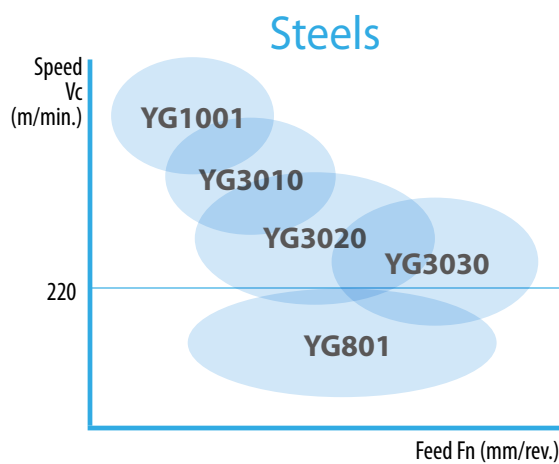
Turning Grades		P Steel				M Stainless steel			K Cast iron			N Non-ferrous		S Superalloys	
		P10	P20	P30	P40	M10	M20	M30	K10	K20	K30	N10	N20	S10	S20
CVD	YG1001	1001							1001						
	YG3010	3010							3010						
	YG3020		3020												
	YG3030		3030			3030									
PVD	YG801	801													
	YG211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

TECHNICAL INFORMATION	YG1001 P01 - P10 K10 - K25		First choice for stable machining of Cast iron - Substrate especially designed for high wear resistance - Thick Al₂O₃ layer ensures good wear resistance at high cutting speeds including dry machining
	YG3010 P05 - P20 K15 - K35		First choice for Finishing Steels, and Ductile Cast iron - Finishing and light machining of steel under in stable condition - New Al₂O₃ coating technology and excellent surface smoothness increase wear resistance and chipping resistance
	YG3020 P15 - P30		First Choice grade for general Steel application - Substrate especially designed for good toughness - Excellent surface smoothness increases wear resistance and reliability
	YG3030 P20 - P35 M10 - M30		Interrupted cut of Steel and Stainless steel - Heavy interrupted cut for Steel - High cutting speed for Stainless steel
	YG801 P10 - P30		for Carbon Steel with Low cutting speed - Recommended for mild steel and boring application - Substrate and special PVD coating for excellent wear resistance
	YG100 N05 - N25		First Choice grade for aluminum with DLC coating - Submicron carbide for high wear resistance - DLC coating minimizes Built Up Edge tendency. - Improve tool life in sticky non-ferrous alloy
	YG10 N05 - N25		Uncoated Grade for General Aluminum - Substrate consisted of submicron carbide for high wear resistance - Shining surface to prevent built up edge

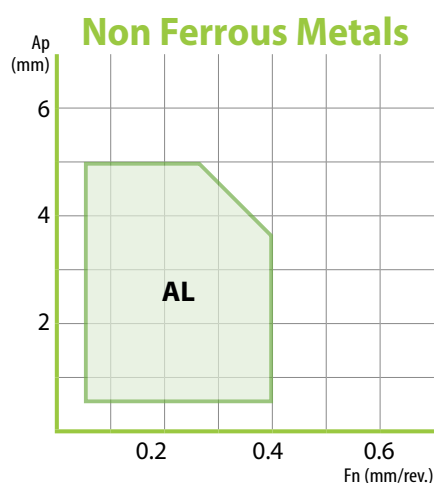
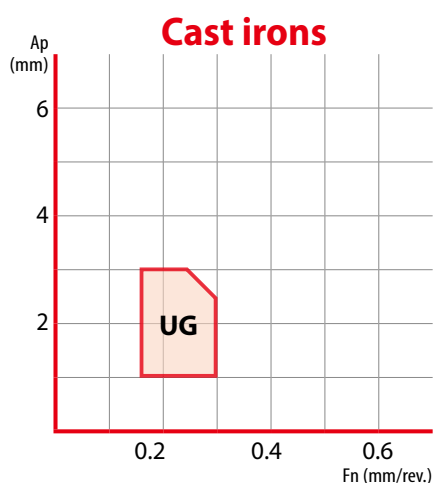
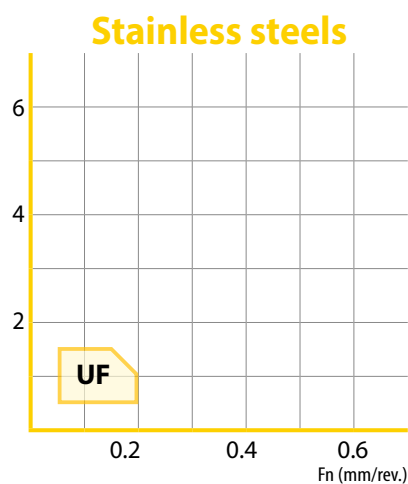
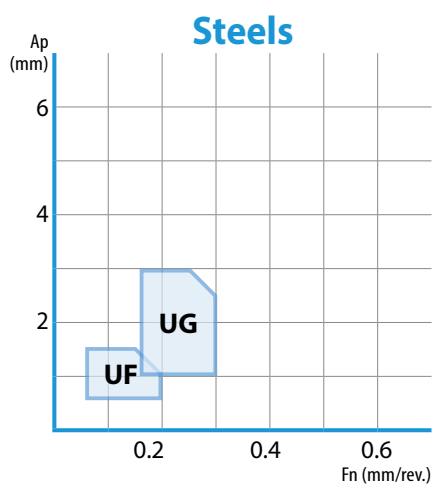
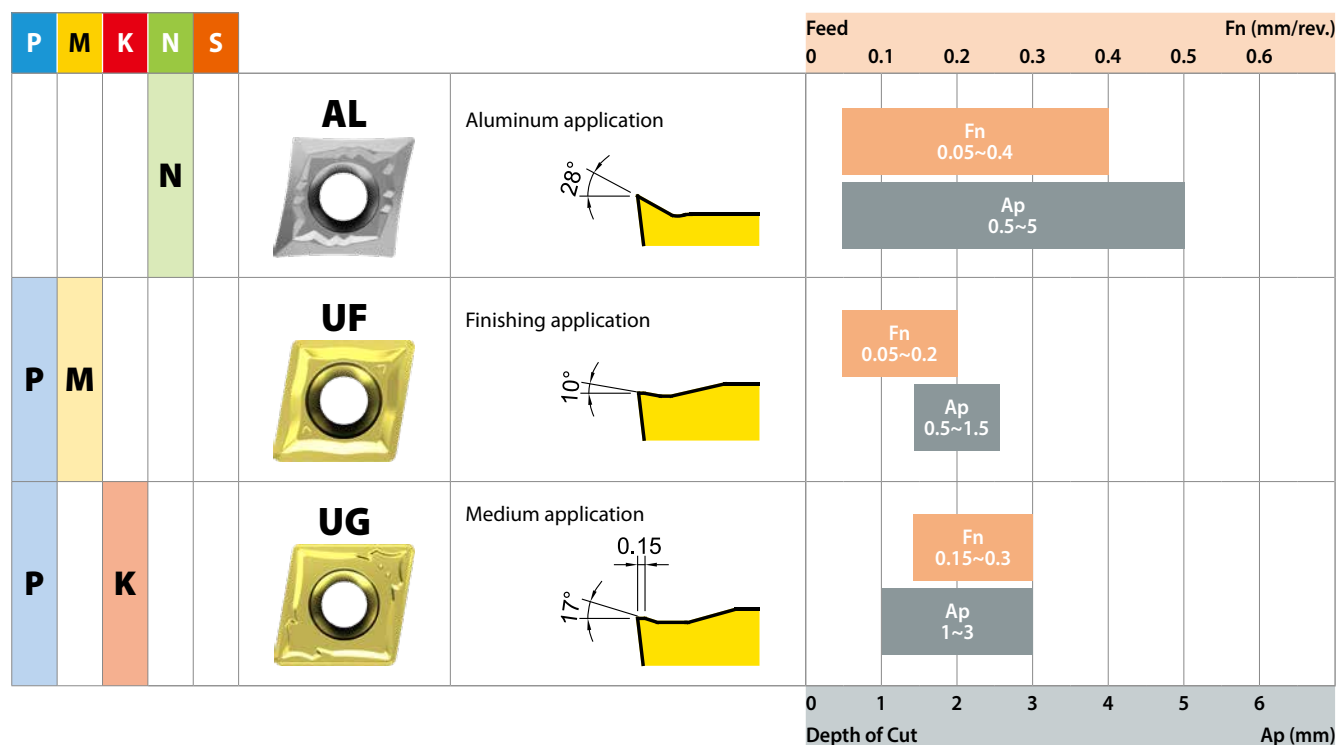
Product Overview

Turning Grade Map

YG211 M05 - M25 S05 - S20		High wear resistance grade for Super alloys and Stainless steel - Finishing Stainless steel - Finishing Super alloys and Titanium
YG213 M20 - M35 S15 - S25		First Choice Grade on low cutting speed of Stainless steel - First choice on Stainless steel for Low cutting speed - For Medium to low cutting speed
YG214 M30 - M40 S25 - S30		Heavy Interrupted cut for Stainless steel - For Heavy Interrupted cut on Stainless steel - Minimize risk of Mechanical fracture or Chipping



Turning Chipbreakers - Positive



Insert ISO Code System

*Metric : According to ISO 1832

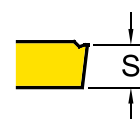
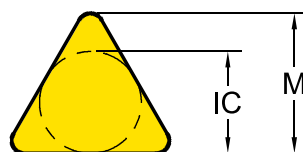
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1	2	3	4	5	6	7	8	9
C	N	M	G	12	04	08	-UG	YG3020
Shape	Clearance	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

1 - Shape

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



3 - Tolerance Class

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

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

4 - Clamping & Chipbreaker

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

2 - Relief Angle (AN)

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

Insert ISO Code System

*Inch

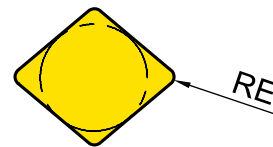
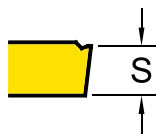
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1	2	3	4	5	6	7	8	9
C	N	M	G	4	3	2	-UG	YG3020
Shape	Clearance	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

5 - Insert Size

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



6 - Insert Thickness (S)

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

7 - Corner Radius (RE)

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