



# Turning

Stainless steel and super alloys

# *Drehbearbeitung*

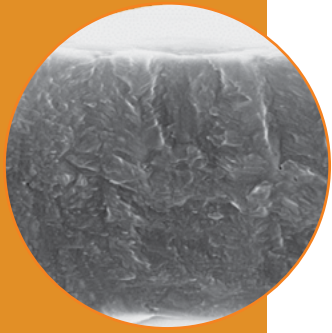
*Nichtrostender Stahl und warmfeste Legierungen*



ZCC Cutting Tools Europe GmbH

your Partner | your Value

# YB9320 **NEW**



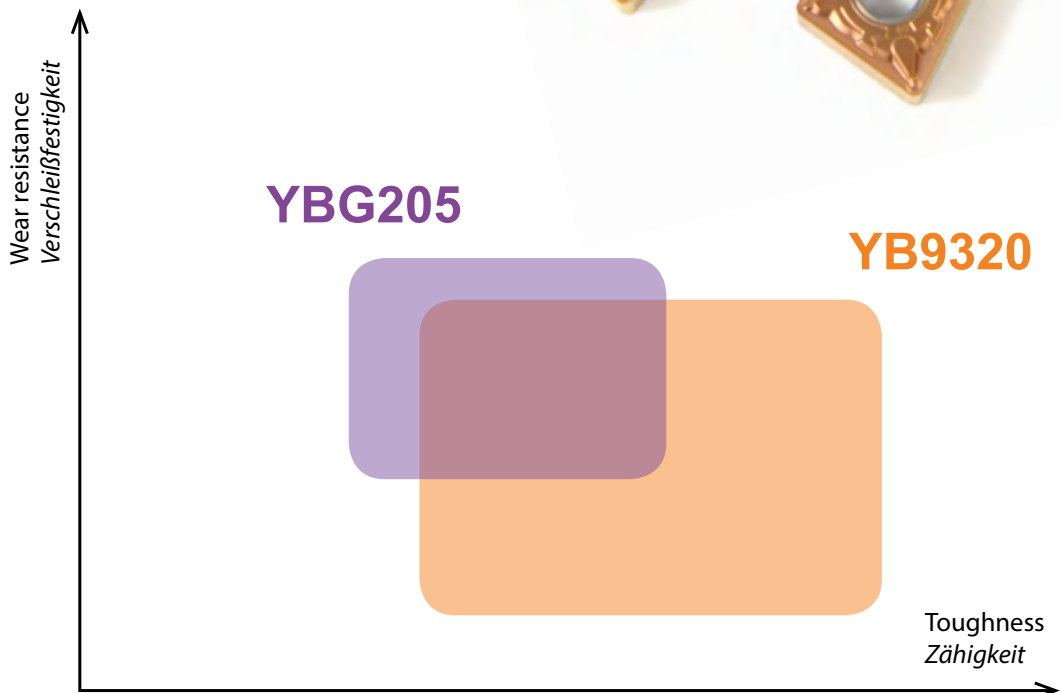
# PVD

## NEW

**PVD Coated Cemented Carbide  
PVD beschichtetes Hartmetall**

New coating technology with increased adhesion between coating and substrate and an excellent combination of toughness and hardness. The new grade also has a high temperature resistance. Suitable for a wide application range in stainless steel and also heat resistance material.

*Neue Beschichtungstechnologie mit optimaler Schichthaftung und einer guten Kombination aus Zähigkeit und Härte. Die neue Sorte hat auch eine hohe Temperaturbeständigkeit. Für ein breites Anwendungsspektrum in rostfreien und warmfesten Materialien.*



# ADF·AHF **NEW**

**Optimized geometry series for stainless steel.**

**Optimale Geometrie besonders für die Zerspantung von rostfreien Stählen.**



## **-ADF**

Negative inserts  
Negative WSP  
e.g. CNMG ...

Optimised geometry for negative inserts giving perfect chip control at a wide range of cutting data. Mainly applied for finishing and semi-finishing machining of steels and stainless steel materials. The precision grinding techniques gives high dimension accuracy and high indexing repeatability. Specially designed rake face structure ensures insert strength while greatly reducing the cutting forces. Advanced edge preparation and new coating for excellent surface finish.

*Neu entwickelter Spanbrecher für negative Wendeschneidplatten mit verbessertem Spanbruchverhalten für ein größeres Anwendungsspektrum. Zum Schlichten- bis mittlere Zerspantung von Stahl, rostfreiem Stahl. Umfangsgeschliffene Platte für hohe Qualität und Wiederholgenauigkeit. Optimiertes 3-D Spanbrecherdesign für besseres Verschleißverhalten und höhere Plattenstabilität. Verbesserte Kantenvorbereitung und neue Beschichtungstechnologie für bessere Oberflächengüte.*



## **-AHF**

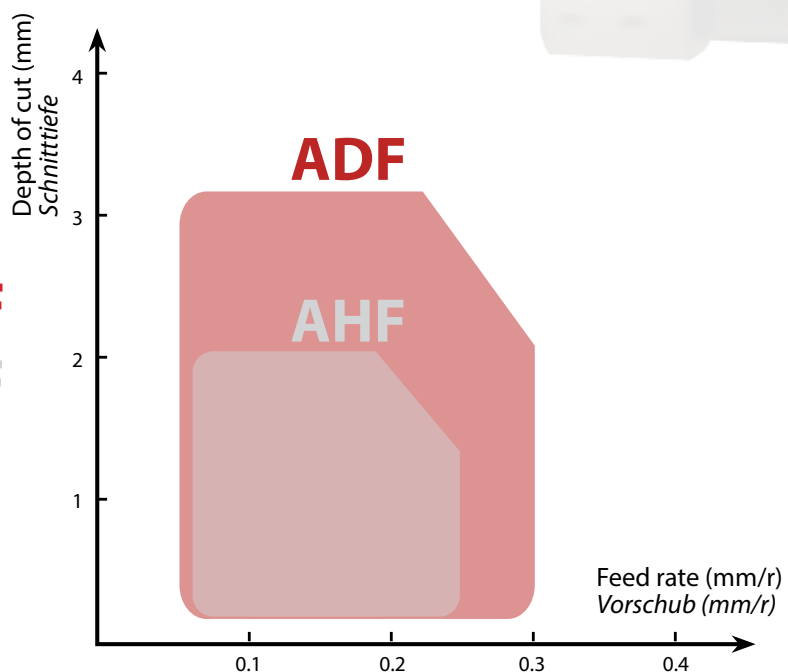
Positive inserts  
Positive WSP  
e.g. CCMT ...

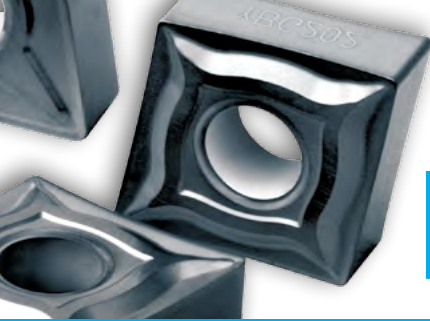
New chip breaker for positive inserts giving good surface quality and precision. With rigid design and sharp edge to reduce vibration especially on long slender parts. Excellent chip control in a wide range of application. For finishing and semi-finishing machining of steel and stainless steel materials. Improved edge geometry for high productivity and stability.

*Neu entwickelter Spanbrecher für positive Wendeschneidplatten für hohe Oberflächengüte und Genauigkeit durch weniger Vibrationen. Perfekte Spankontrolle in großem Anwendungsspektrum. Für Schlicht- bis mittlere Bearbeitung von P und M Materialien. Positive Platten mit verbesserter Kantenausbildung. Hohe Produktivität und Stabilität.*

Range of chip breaker  
Anwendungsbereich  
Spanbrecher

**-ADF**  
**-AHF**



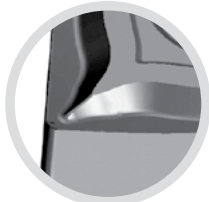


# EF·EM·EG·ER

**NEW**

Special chip breaker series for soft steel, stainless steel and heat resistant superalloy.

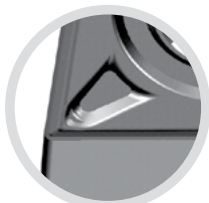
*Spezielle Spanbrecherserie besonders für die Zerspaltung von weichem Stahl, rostfreien Stählen und warmfesten Superlegierungen.*



**-EF**

Sharp positive cutting edge for finishing and semifinishing application. Suitable for continuous to light interrupted cut.

*Scharfer, positiver Spanbrecher für die Schlichtbearbeitung. Für glatte bis leicht unterbrochene Schnitte.*



**-EM**

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

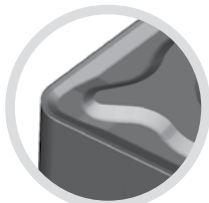
*Scharfe, stabile Schneidkante für die mittlere Bearbeitung auch im unterbrochenen Schnitt.*



**-EG**

Universal chip breaker with deep rounded chip groove and sharp cutting edge. Finishing to medium cutting with very good chip control over a wide range of applications.

*Universalspanbrecher mit umlaufender Spanleitstufe sowie scharfer Schneidkantenausbildung. Vom Schlichten bis hin zur mittleren Bearbeitung hat er eine hervorragende Spankontrolle mit breitem Anwendungsfeld.*



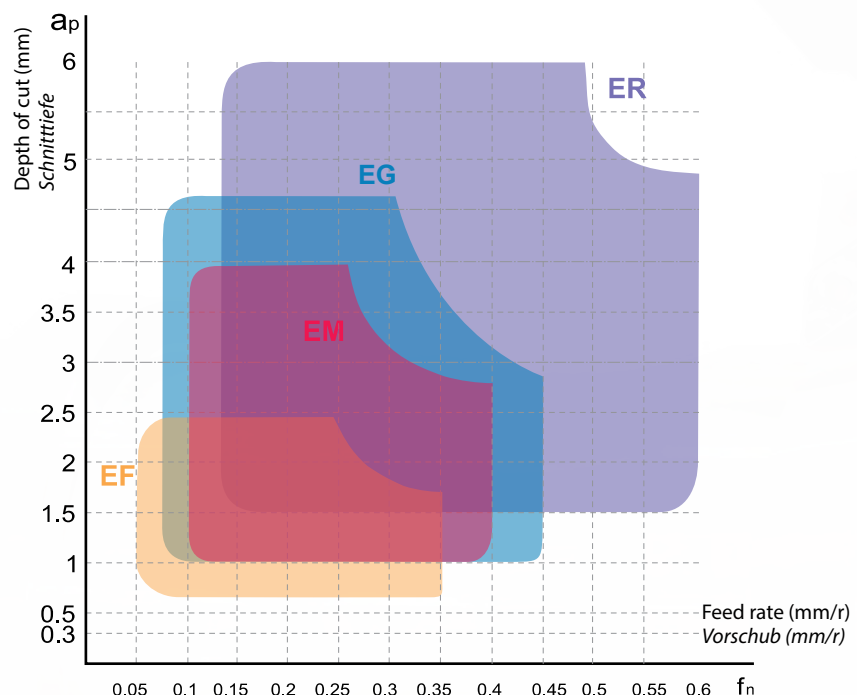
**-ER**

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

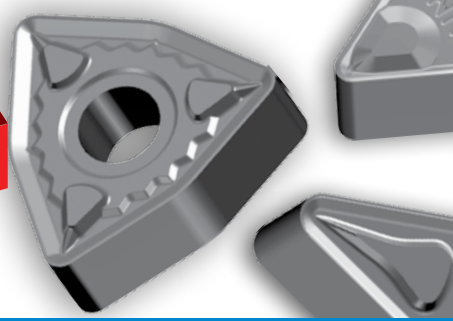
*Speziell entwickelter Spanbrecher mit exzellenter Kantenstabilität bei gleichzeitiger Schneidenschärfe für die Schruppbearbeitung.*

Range of chip breaker  
Anwendungsbereich  
Spanbrecher

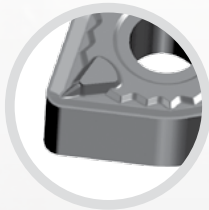
**-EF**  
**-EM**  
**-EG**  
**-ER**



# NF·NM·SNR **NEW**



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



**-NF**

Grounded insert with sharp and positive cutting edge. NF is a good solution for the finishing operation.

*Geschliffene Wendeschneidplatte mit einer scharfen, positiven Schneidkante. NF ist eine gute Lösung für Schlichtbearbeitungen.*



**-NM**

Sharp cutting edge with positive multi-rakes. Special for the semifinishing to medium cut.

*Scharfe Schneidkante mit positivem Multi-Spanwinkel. Besonders geeignet für die Schlicht- bis mittlere Bearbeitung.*



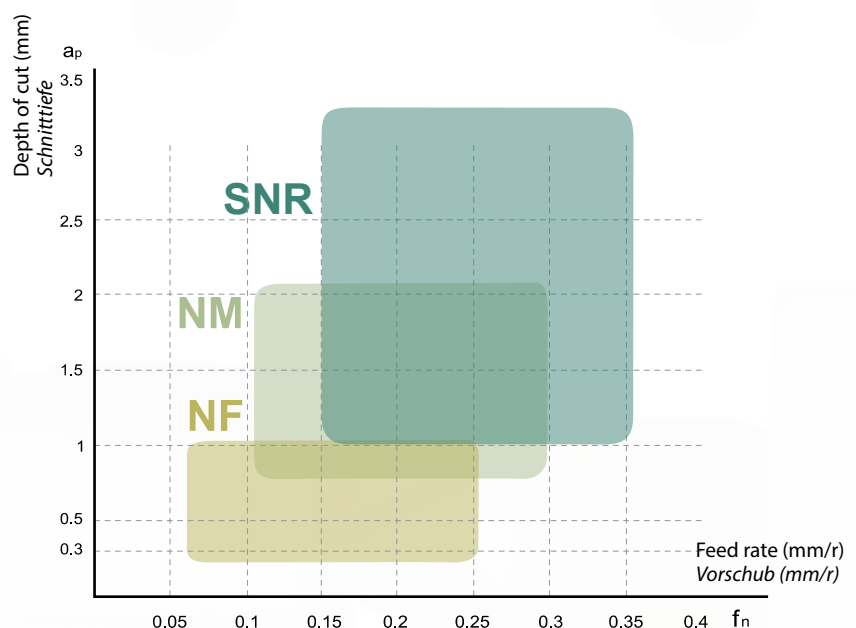
**-SNR**

Sharp cutting edge with large & variable rake angles and optimum chip breaker design. SNR is a good solution for the roughing operation.

*Scharfe Schneidkante mit variablem großen Spanwinkel. SNR ist der optimale Spanbrecher für Schruppbearbeitungen.*

Range of chip breaker  
 Anwendungsbereich  
 Spanbrecher

**-NF**  
**-NM**  
**-SNR**



# YBM153

For finishing and continuous cut of stainless steel  
*Geeignet für die Schlichtbearbeitung von rostfreien Stählen*

- good surface quality
- higher cutting performance
- stable cutting condition
- hohe Oberflächengüten
- höhere Schnittleistungen
- stabile Schnittbedingungen (glatter Schnitt)

# YBM253

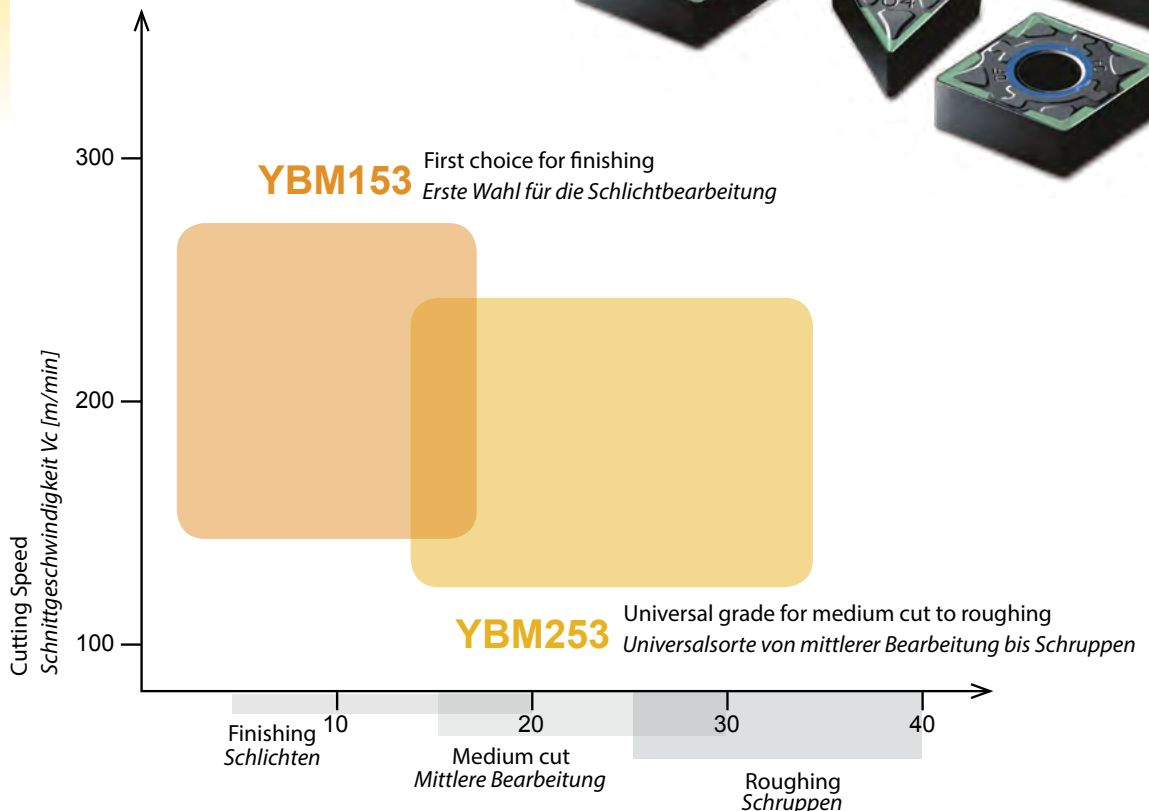
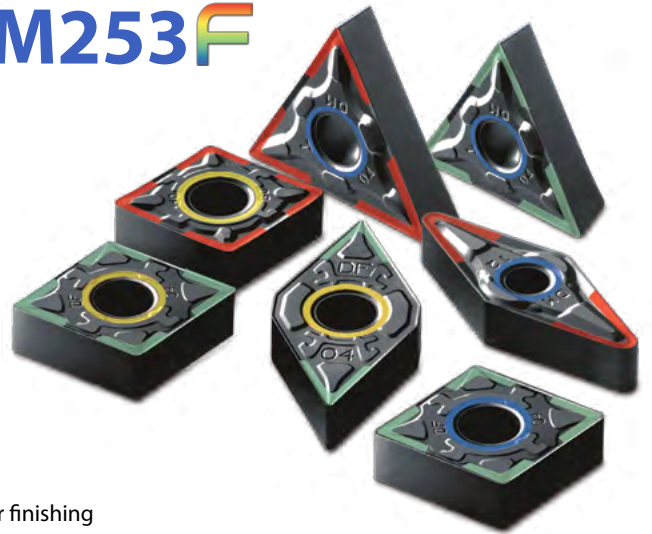
For medium application in stainless steel  
*Geeignet für die mittlere bis Schruppbearbeitung von rostfreien Stählen*

- reliable tool life
- excellent toughness & wear resistance
- continuous cut to interrupted cut
- stabile Standzeiten
- exzellente Zähigkeit bei guter Verschleißfestigkeit
- Glattschnitt bis Schnittunterbrechung

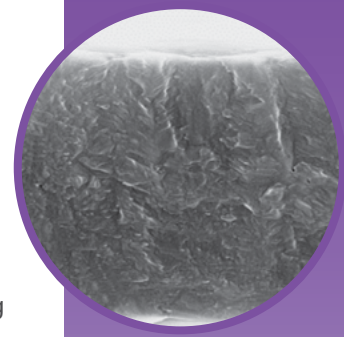
Available as  
*Auch verfügbar als*

Simply coloured

YBM153F YBM253F



**Solution for stainless steel and materials which are hard to machine**  
*Die Lösung für die Bearbeitung von rostfreien Stählen und schwer zu zerspanenden Materialien*



# YBG102

**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 and finishing of stainless steel.

*Nano-TiAlN PVD-beschichtete, feinkörnige Hartmetallsorte. Gut geeignet zum Drehen von warmfesten Superlegierungen und zum Schlichten von rostfreiem Stahl.*

# YBG105

**N10** (N01-N10)  
**S10** (S01-S20)

Fine grain grade with improved coating for higher wear resistance and tool life for finishing and semi-finishing turning of high alloy material and stainless steel.

*Feinkornsorte mit verbesserter Beschichtung für höhere Verschleißfestigkeit und Standzeit bei der Schlicht- und mittleren Drehbearbeitung von hochlegierten, warmfesten Stählen und rostfreien Werkstoffen.*

# YBG202

**P20** (P10-P25)  
**M20** (M10-M25)

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

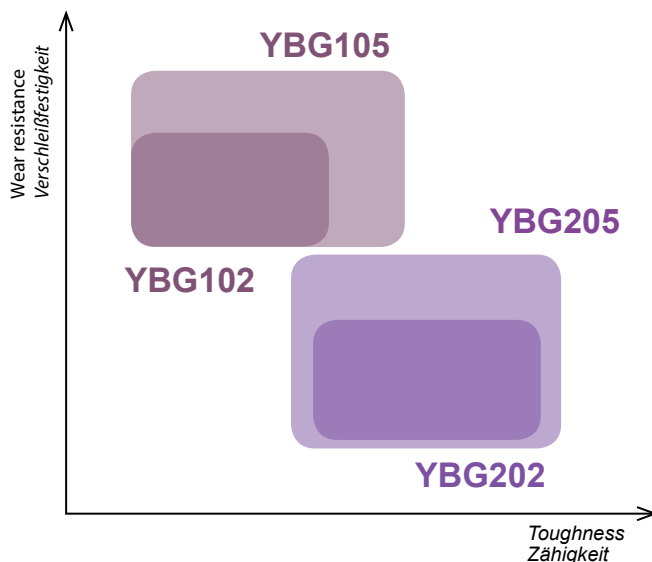
*Nano-TiAlN (2~4um) PVD beschichtete, feinkörnige Hartmetallsorte. Hervorragende Kombination von Zähigkeit und Verschleißfestigkeit. Zum Drehen, Ab- und Einstechen von Stahl, rostfreiem Stahl und warmfesten Superlegierungen bei leichter und mittlerer Bearbeitung.*

# YBG205

**M20** (M10-M30)  
**S20** (S10-S30)

Fine grain carbide with PVD coating of nano-TiAlxN adopted from high temperature resistant element. Excellent wear resistance and chemical resistance suitable for turning of stainless steel under higher cutting speed.

*Nano-TiAlxN PVD beschichtete, feinkörnige Hartmetallsorte, ausgezeichnete Verschleißfestigkeit und chemische Widerstandsfähigkeit. Sehr gut geeignet zum Drehen von rostfreiem Stahl mit höherer Schnittgeschwindigkeit.*



- 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.*

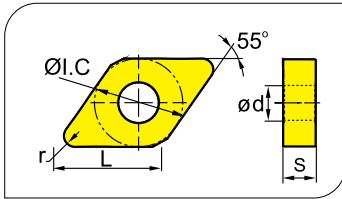
**PVD**  
**PVD Coated Cemented Carbide**  
**PVD beschichtetes Hartmetall**





DN\*\* Negative Insert-Negative WSP

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



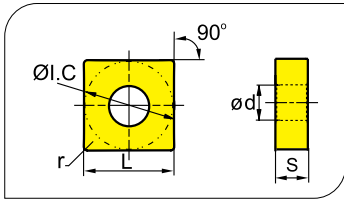
Workpiece Material / Werkstoffe	Steel Stahl	Stainless Steel Rostfreier Stahl	Cast iron Gusseisen	Non-ferrite material Ne Metalle	Heat-resistant steel Warmfester Stahl
P	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
M		●●●●●	●●●●●	●●●●●	●●●●●
K			●●●●●	●●●●●	●●●●●
N				●●●●●	●●●●●
S					●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall										
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
Finishing Schlichten	DNMG150604-ADF	15.5	12.7	6.35	5.16	0.4	●																									
	DNMG150608-ADF	15.5	12.7	6.35	5.16	0.8	●																									
	DNMG150612-ADF	15.5	12.7	6.35	5.16	1.2	●																									
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																										
	DNMG150604-EF	15.5	12.7	6.35	5.16	0.4					○		●																			
	DNMG150608-EF	15.5	12.7	6.35	5.16	0.8					○		●																			
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							●																			
	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							●	●																		
Medium Cut / Mittl. Bearb.	DNMG150604-EG	15.5	12.7	6.35	5.16	0.4							●																			
	DNMG150608-EG	15.5	12.7	6.35	5.16	0.8							●	●																		
	DNMG150612-EG	15.5	12.7	6.35	5.16	1.2							●	●																		
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								●																		
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																										
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																										
Medium Cut / Mittl. Bearb.	DNMG150608-NM	15.5	12.7	6.35	5.16	0.8																										
	DNMG150612-NM	15.5	12.7	6.35	5.16	1.2																										
Roughing / Schruppen	DNMG150608-SNR	15.5	12.7	6.35	5.16	0.8																										
	DNMG150612-SNR	15.5	12.7	6.35	5.16	1.2																										




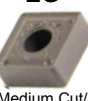



● ex stock / ab Lager ○ on demand / auf Anfrage

# SN\*\* Negative Insert-Negative WSP

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

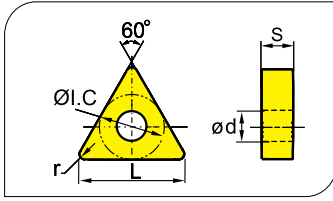


Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferite material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●






Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet beschicht. Ceram.	Uncoated Carbide unbeschicht. Hartmetall															
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C				YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201				
 Finishing / Schlichten	SNMG120404-ADF	12.7	12.7	4.76	5.16	0.4	●																														
	SNMG120408-ADF	12.7	12.7	4.76	5.16	0.8	●																														
	SNMG120412-ADF	12.7	12.7	4.76	5.16	1.2	●																														
 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						○																										
 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							●																									
 Medium Cut / Mittl. Bearb.	SNMG120404-EG	12.7	12.7	4.76	5.16	0.4																															
	SNMG120408-EG	12.7	12.7	4.76	5.16	0.8							●																								
	SNMG120412-EG	12.7	12.7	4.76	5.16	1.2							●																								
 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						○	●																									
 Roughing / Schruppen	SNMM150624-ER	25.4	25.4	7.94	9.12	2.4																															
	SNMM190624-ER	15.875	15.875	6.35	6.35	2.4																															
	SNMM250724-ER	19.08	19.05	6.35	7.94	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						●			○																							
 Medium Cut / Mittl. Bearb.	SNMG120408-NM	12.7	12.7	4.76	5.16	0.8																															

TN\*\* Negative Insert-Negative WSP

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



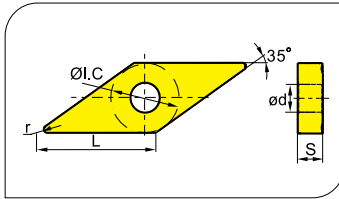
Workpiece Material / Werkstoffe	Steel Stahl	Stainless Steel Rostfreier Stahl	Cast iron Gusseisen	Non-ferrous material Ne Metalle	Heat-resistant steel Warmfester Stahl
P	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
M	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
K	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
N	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
S	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●

Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Carbide beschicht. Gem.	Uncoated Carbide unbeschicht. Hartmetall															
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C				YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201				
 Finishing / Schlichten	TNMG160404-ADF	16.5	9.525	4.76	3.81	0.4	●																														
	TNMG160408-ADF	16.5	9.525	4.76	3.81	0.8	●																														
	TNMG160412-ADF	16.5	9.525	4.76	3.81	1.2	●																														
 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							○																								
 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								●																							
 Medium Cut / Mittl. Bearb.	TNMG160404-EG	16.5	9.525	4.76	3.81	0.4							●																								
	TNMG160408-EG	16.5	9.525	4.76	3.81	0.8							●	●																							
	TNMG160412-EG	16.5	9.525	4.76	3.81	1.2							●	●																							
 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

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



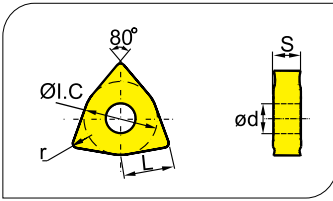
Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrous material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall								
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
<b>ADF</b>  Finishing Schichten	VNMG160404-ADF	16.6	9.525	4.76	3.81	0.4	●																●							
	VNMG160408-ADF	16.6	9.525	4.76	3.81	0.8	●																●							
<b>EF</b>  Finishing Schichten	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						○																		
<b>EM</b>  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					●												●	○						
<b>NF</b>  Finishing Schichten	VNEG160404-NF	16.6	9.525	4.76	3.81	0.4														●	●									○
	VNEG160408-NF	16.6	9.525	4.76	3.81	0.8															○	●								○
	VNEG160408-NGF	16.6	9.525	4.76	3.81	0.8																●								
<b>NM</b>  Medium Cut / Mittl. Bearb.	VNMG160412-NM	16.6	9.525	4.76	3.81	1.2															●									
<b>SNR</b>  Roughing / Schruppen	VNMG160408-SNR	16.6	9.525	4.76	4.76	0.8																○								○
	VNMG160412-SNR	16.6	9.525	4.76	4.76	1.2																○								○







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

WN\*\* Negative Insert-Negative WSP

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



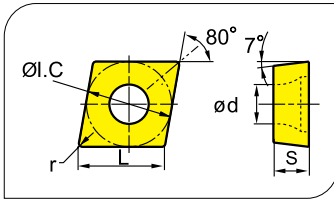
Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrite material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall										
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
 ADF Finishing Schlichten	WNMG080404-ADF	8.7	12.7	4.76	5.16	0.4	●																									
	WNMG080408-ADF	8.7	12.7	4.76	5.16	0.8	●																●		●							
	WNMG080412-ADF	8.7	12.7	4.76	5.16	1.2	●																●									
 EF Finishing Schlichten	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							●	●										●								
 EG Medium Cut / Mittl. Bearb.	WNMG080408-EG	8.7	12.7	4.76	5.16	0.8							●	●									●	●								
	WNMG080412-EG	8.7	12.7	4.76	5.16	1.2							●	●									●	●								
 NF Finishing Schlichten	WNMG060408-NF	6.5	12.7	4.76	5.16	0.8																○	●									
	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.	WNMG080404-NM	8.7	12.7	4.76	5.16	0.4																	●									
	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



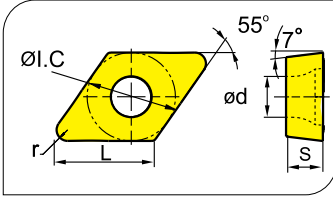
Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrite material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
M	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
K	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
N	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
S	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●

Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall									
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201	
<b>AHF</b>  Finishing Schlichten	CCMT060204-AHF	6.4	6.35	2.38	2.8	0.4	●																								
	CCMT060208-AHF	6.4	6.35	2.38	2.8	0.8	●																								
	CCMT09T304-AHF	9.7	9.525	3.97	4.4	0.4	●																								
	CCMT09T308-AHF	9.7	9.525	3.97	4.4	0.8	●																								
	CCMT120404-AHF	12.9	12.7	4.76	5.56	0.4	●																								
	CCMT120408-AHF	12.9	12.7	4.76	5.56	0.8	●																								
<b>EF</b>  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							●										●	○								
<b>EM</b>  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																									



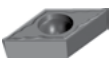
● ex stock / ab Lager    ○ on demand / auf Anfrage

DC\*\* Positive Insert/ Positive WSP

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



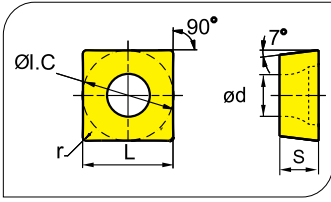
Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrite material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.		Cermet unbeschichtet	Cermet beschicht. / Cermet	Uncoated Carbide unbeschicht. Hartmetall																		
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201									
 Finishing / Schlichten	DCMT070204-AHF	7.8	6.35	2.38	2.8	0.4	●																																
	DCMT11T302-AHF	11.6	9.525	3.97	4.4	0.2	●																																
	DCMT11T304-AHF	11.6	9.525	3.97	4.4	0.4	●																																
	DCMT11T308-AHF	11.6	9.525	3.97	4.4	0.8	●																																
 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								●																									
 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								● ○																									
	DCMT150404-EM	15.5	12.7	4.76	5.63	0.4								● ●																									
	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

SC\*\* Positive Insert/ Positive WSP

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



Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrite material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

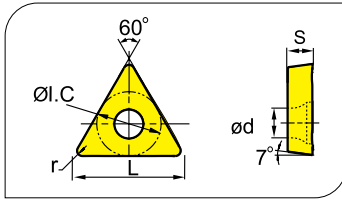
Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall										
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201		
<b>AHF</b>  Finishing Schlichten	SCMT09T304-AHF	9.525	9.525	3.97	4.4	0.4	●																									
	SCMT09T308-AHF	9.525	9.525	3.97	4.4	0.8	●																●									
<b>EF</b>  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																	●									
<b>EM</b>  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							○									●										

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






TC\*\* Positive Insert/ Positive WSP

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

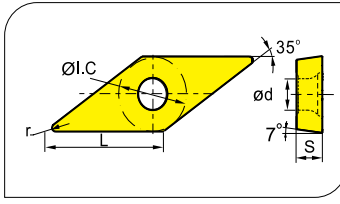


Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrous material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
M	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
K	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
N	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
S	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●

Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall												
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201				
 Finishing Schlichten	TCMT110204-AHF	11	6.35	2.38	2.8	0.8	○																											
	TCMT110208-AHF	11	6.35	2.38	2.8	0.8	○																											
	TCMT16T304-AHF	16.5	9.525	3.97	4.4	0.4	●																											
	TCMT16T308-AHF	16.5	9.525	3.97	4.4	0.8	●																											
 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																												
 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																												
	TCMT16T304-EM	16.5	9.525	3.97	4.4	0.4																												
	TCMT16T308-EM	16.5	9.525	3.97	4.4	0.8																												

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

## VC\*\* Positive Insert/ Positive WSP

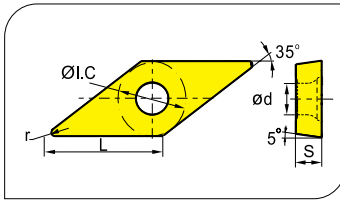


● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
● ● Normal Machining Condition / Normale Bearbeitungsbedingungen  
● ● ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoffe	P	M	K	N	S
<b>P</b> Steel / Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
<b>M</b> Stainless Steel / Rostfreier Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
<b>K</b> Cast iron / Gusseisen	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
<b>N</b> Non-ferrite material / Ne Metalle	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
<b>S</b> Heat-resistant steel / Warmfester Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●

Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Coated beschicht. Cem.	Uncoated Carbide unbeschicht. Hartmetall									
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C				YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C
<b>NF</b> 	<b>VCGT160408-NF</b>	16.5	9.525	4.76	4.4	0.8															○	●									
Finishing / Schlichten																															

## VB\*\* Positive Insert/ Positive WSP





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

Workpiece Material / Werkstoffe	P	M	K	N	S
<b>P</b> Steel / Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
<b>M</b> Stainless Steel / Rostfreier Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
<b>K</b> Cast iron / Gusseisen	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
<b>N</b> Non-ferrite material / Ne Metalle	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●
<b>S</b> Heat-resistant steel / Warmfester Stahl	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●	●●●●●●●●

Insert Shape / Schneidplattenform	Type · Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.										PVD Coating / PVD Beschicht.			Cermet unbeschichtet	Cermet Coated beschicht. Cem.	Uncoated Carbide unbeschicht. Hartmetall											
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C				YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
<b>AHF</b> 	<b>VBMT160404-AHF</b>	16.5	9.525	4.76	4.4	0.4	●																										
	<b>VBMT160408-AHF</b>	16.5	9.525	4.76	4.4	0.8	●																										
<b>EF</b> 	<b>VBMT110302-EF</b>	11	6.35	3.18	2.8	0.2																		●	○								
	<b>VBMT110304-EF</b>	11	6.35	3.18	2.8	0.4																			●	○							
	<b>VBMT110308-EF</b>	11	6.35	3.18	2.8	0.8																			○	●							
	<b>VBMT160404-EF</b>	16.5	9.525	4.76	4.4	0.4																											
	<b>VBMT160408-EF</b>	16.5	9.525	4.76	4.4	0.8																											
<b>NF</b> 	<b>VBET160404-NF</b>	16.5	9.525	4.76	4.4	0.4																		○	●								
	<b>VBET160408-NF</b>	16.5	9.525	4.76	4.4	0.8																		○	●								
	<b>VBET160408-NGF</b>	16.5	9.525	4.76	4.4	0.8																			●								
	<b>VBET160412-NGF</b>	16.5	9.525	4.76	4.4	1.2																				●							



### VB\*\* Positive Insert/ Positive WSP

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

Insert Shape Schneidplattenform	Type · Typ	Dimension (mm) Abmessung					CVD Coating CVD Beschicht.										PVD Coating PVD Beschicht.		Cermet unbeschichtet	Cermet Coating beschicht. Ceram.	Uncoated Carbide unbeschicht. Hartmetall									
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
		Workpiece Material Werkstoffe																												
 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	○						●																	
	VBMT160404-EM	16.5	9.525	4.76	4.4	0.4							●											●						
	VBMT160408-EM	16.5	9.525	4.76	4.4	0.8							●											●						
 Roughing / Schruppen	VBMT160408-SNR	16.5	9.525	4.76	4.76	0.8															○								○	
	VBMT160412-SNR	16.5	9.525	4.76	4.76	1.2																○								○

### VC\*\* Positive Insert/ Positive WSP

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

Insert Shape Schneidplattenform	Type · Typ	Dimension (mm) Abmessung					CVD Coating CVD Beschicht.										PVD Coating PVD Beschicht.		Cermet unbeschichtet	Cermet Coating beschicht. Ceram.	Uncoated Carbide unbeschicht. Hartmetall									
		L	I.C	S	d	r	YB6315	YBC152	YBC252	YBC251	YBC352	YBC351	YBM153	YBM253	YBD052	YBD102	YB7315	YBD152	YBD152C	YBG101	YBG102	YBG105	YB9320	YBG205	YBG202	YNG151	YNT251	YNG151C	YD101	YD201
		Workpiece Material Werkstoffe																												
 Finishing Schlichten	VCMT160404-EF	16	9.525	4.76	4.4	0.4																								
	VCMT160404-EM	16	9.525	4.76	4.4	0.4							●												●					
 Finishing Schlichten	VCMT160408-EM	16	9.525	4.76	4.4	0.8							●											●						



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