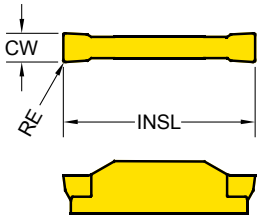
Parting & Grooving

Parting & Grooving Inserts

Recommended Cutting Conditions : p.258



Series	INSL	CW	Series	INSL	CW
TD* 2	20.00	2.00	TD* 5	25.00	5.00
TD* 3	20.00	3.00	TD* 6	25.00	6.00
TD* 4	20.00	4.00	TD* 8	30.00	8.00

* CDX : Cutting Depth Maximum

● : Stock item ○ : Order made item

TD.		Designation	RE	Parting & Grooving Fn (mm/rev.)	Parting & Grooving CDX (mm)	Turning Fn (mm/rev.)	Turning Ap (mm)	EDP 5200.. YG602	YG602G	YG603
-P	 Parting & Grooving (Sharp edge)	TDP 2002	0.2	0.04 - 0.12	19	-	-	● 0012	○ 0036	● 0078
		TDP 3002	0.2	0.05 - 0.16	19	-	-	● 0029	○ 0030	● 0076
		TDP 4003	0.3	0.06 - 0.18	19	-	-	● 0023	○ 0038	● 0080
		TDP5003	0.3	0.06 - 0.20	24	-	-	● 0142	○ 0143	● 0144
		TDP6003	0.3	0.06 - 0.22	24	-	-	● 0145	○ 0146	● 0147
	 Parting & Grooving Right Hand Shown (Sharp edge)  * 6° Angled Parting	*TDPR 2002 - 6	0.2	0.03 - 0.08	19	-	-	● 0045		● 0085
		*TDPR 3002 - 6	0.2	0.04 - 0.12	19	-	-	● 0048		● 0089
		*TDPL 2002 - 6	0.2	0.03 - 0.08	19	-	-	● 0046		● 0086
		*TDPL 3002 - 6	0.2	0.04 - 0.12	19	-	-	● 0049		● 0090
-N	 Parting & Grooving (General)	TDN 2002	0.2	0.05 - 0.18	19	-	-	● 0010	○ 0035	● 0077
		TDN 3002	0.2	0.07 - 0.23	19	-	-	● 0024	○ 0025	● 0075
		TDN 4003	0.3	0.08 - 0.28	19	-	-	● 0022	○ 0037	● 0079
		TDN 5003	0.3	0.09-0.30	24	-	-	● 0042	○ 0136	● 0130
		TDN6003	0.3	0.10 - 0.35	24	-	-	● 0132	○ 0137	● 0133
		TDN8004	0.4	0.12 - 0.40	29	-	-	● 0138	○ 0139	● 0140
	 Parting & Grooving Right Hand Shown (General)  * 6° Angled Parting	*TDNR 2002 - 6	0.2	0.04 - 0.14	19	-	-	● 0043		● 0083
		*TDNR 3002 - 6	0.2	0.06 - 0.18	19	-	-	● 0040		● 0087
		*TDNL 2002 - 6	0.2	0.04 - 0.14	19	-	-	● 0044		● 0084
		*TDNL 3002 - 6	0.2	0.06 - 0.18	19	-	-	● 0047		● 0088
		*TDNL 4003 - 6	0.3	0.06 - 0.24	19	-	-	● 0096		

Parting & Grooving

Parting & Grooving Overview

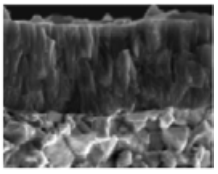
Parting & Groove Turn Grades

Parting and Grooving Grades		P Steel				M Stainless steel				K Cast iron			N Non Ferrous		S Super Alloy	
		P10	P20	P30	P40	M10	M20	M30	M40	K10	K20	K30	N10	N20	S10	S20
PVD	YG602G (YG602)		602G				602G				602G					602G
	YG603							603								

YG602G
(YG602)

P20 - P35 | M20 - M40 | K20 - K40 | S15 - S25

PVD - TiAlN

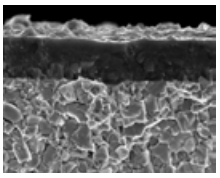


Universal grade for Parting & Groove Turn

- Ultra Dense PVD Coating with optimal thermal resistance & strength
- Sub-Micron substrate designed for demanding application
- YG602G : First Choice for Low Cutting Speed, Soft and Sticky Material with Low Hardness (Gold Color)
- YG602 : First Choice for General Application (Violet Color)

YG603
M30 - M50

PVD - TiAlN



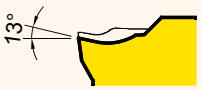
PVD Parting & Grooving Grade for Stainless Steel

- Ultra high toughness substrate and strong adhesion
- Excellent cutting edge strength and chipping resistance
- Stable machinability and tool life for stainless steel

Parting & Grooving Inserts

TD. Series	Inserts	2, 3, 4, 5, 6, 8
	TDN, TDP, TDY	

Parting & Grooving Chipbreakers

Parting & Grooving	-P			• For Parting & Grooving • For Low Feed Rate and Difficult to Cut Materials
	-N			• For External Parting And Grooving • For General Use
Turning & Grooving	-Y			• For External Turning & Grooving • For Medium feed rate
	GL			• For External, Internal turning and Grooving • Face grooving and Face turning • For low feed rate
	GM			• For External, Internal turning and Grooving • First choice Face Grooving and Face turning • For Medium feed rate
	RG			• For External, Internal turning and Grooving • Full radius Insert for Profiling

Grade Naming System

1	2	3	4	5	(6)
YG	**3**	**0**	**2**	**0**	**(G)**
YG Brand	Workpiece Material	Grade Version	Application Range (1st Digit)	Application Range (2nd Digit)	Minor Variation
Carbide CVD (4 Digits)	●	●	●	●	YG3020
Carbide PVD (3 Digits)	●	●	●		YG211
Carbide Uncoated (2 Digits)	●	●			YG10

1 - YG Brand

2 - Workpiece Material

Symbol	Workpiece Material	Turning	Milling	Drilling	Parting
1	K Cast Iron or N Non-Ferrous	●			
2	M Stainless Steel	●			
3	P Steel	●			
4	S Superalloys	●			
5	K Cast Iron or N Non-Ferrous		●	●	●
6	M Stainless Steel or Universal		●	●	●
7	P Steel		●	●	●
8	Universal	●			

4 & 5 — Application Range

Symbol	
05	Stable — Wear Resistant Grade, Stable Application, Continuous Cut, Finishing
10	
15	
20	General — Balanced Grade, High Versatility, General Application
25	
30	
35	
40	Unstable — Tougher Grade, Unstable Application, Interrupted Cut, Chipping Resistance, Roughing
45	

3 — Grade Version

(6) — (Minor Variation)

G — Gold Coated Version