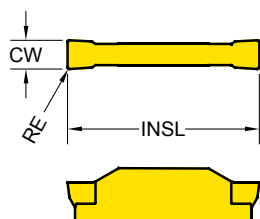


Parting & Grooving

Parting & Grooving Inserts

Recommended Cutting Conditions : p.258



Series	INSL	CW	Series	INSL	CW
TD* 2	20.00	2.0	TD* 5	25.00	5.0
TD* 3	20.00	3.0	TD* 6	25.00	6.0
TD* 4	20.00	4.0	TD* 8	30.00	8.0

* CDX : Cutting Depth Maximum

● : Stock item ○ : Order made item

TD.	Designation	RE	Parting & Grooving		Turning		EDP 5200..		
			Fn (mm/rev.)	CDX (mm)	Fn (mm/rev.)	Ap (mm)	YG602	YG602G	YG603
 Turn Groove	TDY3E - 0.4	0.4	0.06 ~ 0.24	10	0.12 ~ 0.22	0.5 ~ 2.4		● 0027	
	TDY4E - 0.4	0.4	0.08 ~ 0.27	10	0.15 ~ 0.30	0.5 ~ 2.8		● 0020	
	TDY5E - 0.4	0.4	0.08 ~ 0.23	10	0.15 ~ 0.30	0.5 ~ 3.2		● 0082	
 GL	TDY2E - 0.3 - GL	0.3	0.04 ~ 0.20	10	0.06 ~ 0.18	0.4 ~ 1.5		● 0123	● 0124
	TDY3E - 0.3 - GL	0.3	0.05 ~ 0.23	10	0.08 ~ 0.20	0.4 ~ 2.0		● 0125	● 0126
	TDY4E - 0.4 - GL	0.4	0.06 ~ 0.26	10	0.10 ~ 0.25	0.5 ~ 2.3		● 0112	● 0127
	TDY5E - 0.4 - GL	0.4	0.08 ~ 0.30	12.5	0.10 ~ 0.30	0.5 ~ 3.0		● 0157	● 0158
	TDY6E - 0.4 - GL	0.4	0.12 ~ 0.35	12.5	0.15 ~ 0.35	0.5 ~ 3.5		● 0159	● 0160
	TDY8E - 0.8 - GL	0.8	0.15 ~ 0.50	15	0.20 ~ 0.50	1.0 ~ 4.5		● 0164	● 0165
	TDY3E - 0.4 - GM	0.4	0.06 ~ 0.24	10	0.12 ~ 0.22	0.5 ~ 2.4		● 0118	● 0119
 GM	TDY4E - 0.4 - GM	0.4	0.08 ~ 0.27	10	0.15 ~ 0.30	0.5 ~ 2.8		● 0113	● 0120
	TDY4E - 0.8 - GM	0.8	0.10 ~ 0.27	10	0.18 ~ 0.32	0.8 ~ 2.8		● 0114	● 0122
	TDY5E - 0.4 - GM	0.4	0.08 ~ 0.27	12.5	0.18 ~ 0.35	0.5 ~ 3.0		● 0134	● 0135
	TDY5E - 0.8 - GM	0.8	0.10 ~ 0.27	12.5	0.18 ~ 0.37	0.8 ~ 3.0		● 0148	● 0149
	TDY6E - 0.4 - GM	0.4	0.12 ~ 0.30	12.5	0.18 ~ 0.40	0.8 ~ 3.6		● 0150	● 0153
	TDY6E - 0.8 - GM	0.8	0.12 ~ 0.35	12.5	0.18 ~ 0.42	1.0 ~ 3.6		● 0129	● 0154
	TDY8E - 0.8 - GM	0.8	0.10 ~ 0.25	15	0.20 ~ 0.50	1.0 ~ 4.5		● 0155	● 0156
	TDY2E - 1.0 - RG	1.0	0.05 ~ 0.15	10	0.10 ~ 0.30	0.1 ~ 0.8		● 0111	● 0115
	TDY3E - 1.5 - RG	1.5	0.08 ~ 0.18	10	0.15 ~ 0.35	0.1 ~ 1.2		● 0108	● 0116
	TDY4E - 2.0 - RG	2.0	0.10 ~ 0.20	10	0.18 ~ 0.45	0.1 ~ 1.6		● 0109	● 0117
 RG	TDY5E - 2.5 - RG	2.5	0.12 ~ 0.23	12.5	0.20 ~ 0.50	0.1 ~ 2.0		● 0166	● 0167
	TDY6E - 3.0 - RG	3.0	0.15 ~ 0.28	12.5	0.25 ~ 0.60	0.1 ~ 2.4		● 0168	● 0169
	TDY8E - 4.0 - RG	4.0	0.18 ~ 0.30	15	0.25 ~ 0.70	0.1 ~ 3.2		● 0170	● 0171

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

TURNING

PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

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	•			

3 — Grade Version

4 & 5 — Application Range

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

(6) — (Minor Variation)

G — Gold Coated Version