


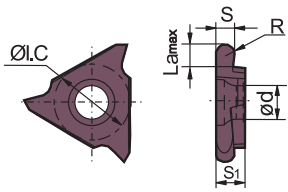


















A

Turning

Parting inserts

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

QC** turning/milling insert								HC ¹ (CVD)		HC ¹ (PVD)			HW		
 <p>Right hand style</p>	P														
	M														
	K														
	N														
	S														
H															

B

Milling

ISO	La max	S±0.025	R/C	Øl.C	S1	ød	f	YBC252		YBC251		YBG105		YBG102		YBG320		YBG205		YBG202		YBG302		YD101		YD201	
QC16R100R	2	1	0.5	12.7	3.18	4.4	0,02-0,03																				
QC16R120R	2	1.2	0.6	12.7	3.18	4.4	0,02-0,03																				
QC16R150R	2	1.5	0.75	12.7	3.18	4.4	0,02-0,06																				
QC16R200R	2.5	2	1	12.7	3.18	4.4	0,02-0,07																				
QC16L200R	2.5	2	1	12.7	3.18	4.4	0,02-0,07																				
QC16R250R	2.5	2.5	1.25	12.7	3.18	4.4	0,02-0,08																				
QC16L280R	2.5	2.8	1.4	12.7	3.18	4.4	0,02-0,08																				
QC16R300R	2.5	3	1.5	12.7	3.18	4.4	0,03-0,11																				
QC16L300R	2.5	3	1.5	12.7	3.18	4.4	0,03-0,11																				
QC22R100R	2	1	0.5	12.7	4.76	5.5	0,02-0,03																				
QC22L100R	2	1	0.5	12.7	4.76	5.5	0,02-0,03																				
QC22R150R	3.5	1.5	0.75	12.7	4.76	5.5	0,02-0,06																				
QC22L150R	3.5	1.5	0.75	12.7	4.76	5.5	0,02-0,06																				
QC22R170R	3.5	1.7	0.85	12.7	4.76	5.5	0,02-0,06																				
QC22R200R	3.5	2	1	12.7	4.76	5.5	0,02-0,07																				
QC22L200R	3.5	2	1	12.7	4.76	5.5	0,02-0,07																				
QC22R250R	4	2.5	1.25	12.7	4.76	5.5	0,02-0,08																				
QC22L250R	4	2.5	1.25	12.7	4.76	5.5	0,02-0,08																				
QC22R300R	4	3	1.5	12.7	4.76	5.5	0,03-0,11																				
QC22L300R	4	3	1.5	12.7	4.76	5.5	0,03-0,11																				
QC22R320R	4	3.2	1.6	12.7	4.76	5.5	0,03-0,11																				
QC22R400R	5	4	2	12.7	4.76	5.5	0,05-0,14																				
QC22L400R	5	4	2	12.7	4.76	5.5	0,05-0,14																				

C

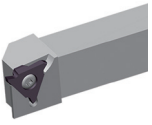
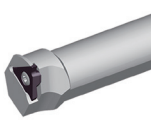
Drilling

D

Technical Information

● Ex stock ○ On demand

HC¹ Coated carbide
HW Uncoated carbide

Tool holders	
GQCR/L	S***-QC**R/L
	
A453	A454

E

Index




System code > A416

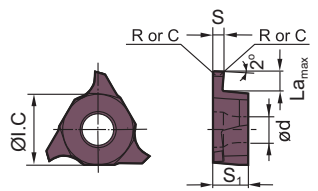

















Grade selection > A394

Technical info > A501

Cutting data > A456

Parting inserts

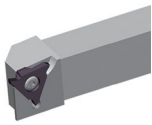
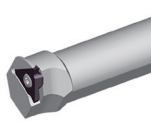
-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

QC** turning/milling insert									HC ¹ (CVD)		HC ¹ (PVD)			HW							
 <p>Right hand style</p>									P												
									M												
									K												
									N												
									S												
									H												
ISO	La max	S±0.025	R/C	ØI.C	S1	ød	f	YBC252	YBC251	YBG105	YBG102	YB9320	YBG205	YBG202	YBG302	YD101	YD201				
QC22R230-R02	3.5	2.3	0.2	12.7	4.76	5.5	0,02-0,07						●								
QC22L230-R02	3.5	2.3	0.2	12.7	4.76	5.5	0,02-0,07						○								
QC22R250-R03	4	2.5	0.3	12.7	4.76	5.5	0,02-0,08						●								
QC22L250-R03	4	2.5	0.3	12.7	4.76	5.5	0,02-0,08						○								
QC22R265-R03	4	2.65	0.3	12.7	4.76	5.5	0,02-0,08						●								
QC22L265-R03	4	2.65	0.3	12.7	4.76	5.5	0,02-0,08						●								
QC22R280-R03	4	2.8	0.3	12.7	4.76	5.5	0,02-0,08						●								
QC22L280-R03	4	2.8	0.3	12.7	4.76	5.5	0,02-0,08						○								
QC22R300-R03	4	3	0.3	12.7	4.76	5.5	0,03-0,11						○								
QC22L300-R03	4	3	0.3	12.7	4.76	5.5	0,03-0,11						○								
QC22R320-R03	4	3.2	0.3	12.7	4.76	5.5	0,03-0,11						○								
QC22L320-R03	4	3.2	0.3	12.7	4.76	5.5	0,03-0,11						○								
QC22R330-R03	4	3.3	0.3	12.7	4.76	5.5	0,03-0,11						○								
QC22L330-R03	4	3.3	0.3	12.7	4.76	5.5	0,03-0,11						○								
QC22R350-R03	5	3.5	0.3	12.7	4.76	5.5	0,05-0,13						○								
QC22L350-R03	5	3.5	0.3	12.7	4.76	5.5	0,05-0,13						○								
QC22R400-R04	5	4	0.4	12.7	4.76	5.5	0,05-0,14						○								
QC22L400-R04	5	4	0.4	12.7	4.76	5.5	0,05-0,14						●								
QC22R430-R04	5	4.3	0.4	12.7	4.76	5.5	0,05-0,14						○								
QC22L430-R04	5	4.3	0.4	12.7	4.76	5.5	0,05-0,14						○	○							
QC22R450-R04	5	4.5	0.4	12.7	4.76	5.5	0,06-0,18						○								
QC22L450-R04	5	4.5	0.4	12.7	4.76	5.5	0,06-0,18						○				○				
QC22R480-R04	5	4.8	0.4	12.7	5.06	5.5	0,06-0,18						○								
QC22L480-R04	5	4.8	0.4	12.7	5.06	5.5	0,08-0,2						○								

● Ex stock ○ On demand

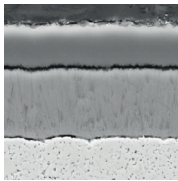
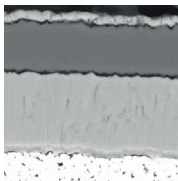
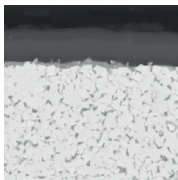
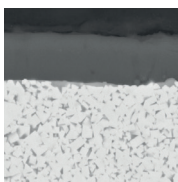
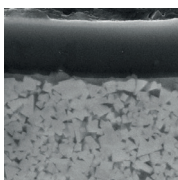
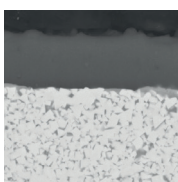
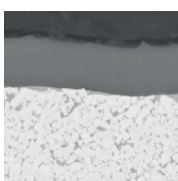
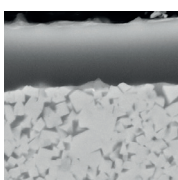
HC¹ Coated carbide
HW Uncoated carbide

Tool holders

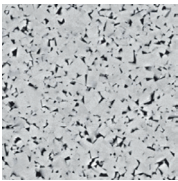
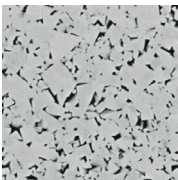
GQCR/L	S***_QC**R/L
	
A453	A454

A	Turning	B	Milling	C	Drilling	D	Technical Information	E	Index

Parting & grooving

Grade	ISO	Micro structure	Grade description
YBC252	P20 - P35		CVD coated P20-P35 carbide grade for medium operation to roughing of steel and casting steel. Optimal performance of wear resistance and toughness for a wide application field.
YBC251	P20 - P35		CVD coated P20-P35 carbide grade for medium operation to roughing of steel and casting steel in lower cutting speed.
YBG105	S05 - S20		PVD multilayer coated S05-S20 carbide substrate for finishing to medium application of super alloy material but also stainless steel. Good wear resistance and thermal stability in a wide application field.
YBG102	S05 - S15		PVD coated S05-S15 carbide substrate for finishing to medium application of super alloy material, stainless steel and aluminum. Good wear resistance in a wide application field.
YB9320	P10 - P30 M10 - M25		PVD multilayer coated P10-P30/M10-M25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (grooving/milling). Optimised coating stability for higher wear resistance and thermal stability in a wide range of applications.
YBG205	P10 - P30 M20 - M40 S15-S25		PVD multilayer coated P10-P30/M20-M40/S15-S25 carbide substrate for finishing to medium machining of stainless steel, super alloys and steel (milling). Excellent wear resistance and thermal stability in a wide range of applications.
YBG202	P10 - P30 M10 - M25		PVD coated P10-P30/M10-M25 carbide substrate for finishing to medium application of stainless steel and steel (milling). Good wear resistance in a wide application field.
YBG302	P15 - P30 M25 - M40		PVD coated P15-P30/M25-M40 carbide substrate for medium roughing application of stainless steel and steel (milling). Good wear resistance and toughness.

Parting & grooving

Grade	ISO	Micro structure	Grade description
YD101	K05 - K20 N05 - N20		Uncoated K05–K20/N05–N20 carbide substrate for fine to medium application in aluminum and other material.
YD201	K10 - K30 N10 - N30		Uncoated K10–K30/N10–N30 carbide substrate for medium application in aluminum and other material.

A

Turning

B

Milling

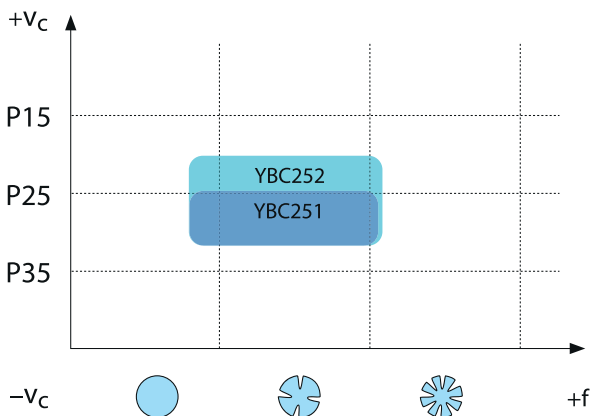
C

Drilling

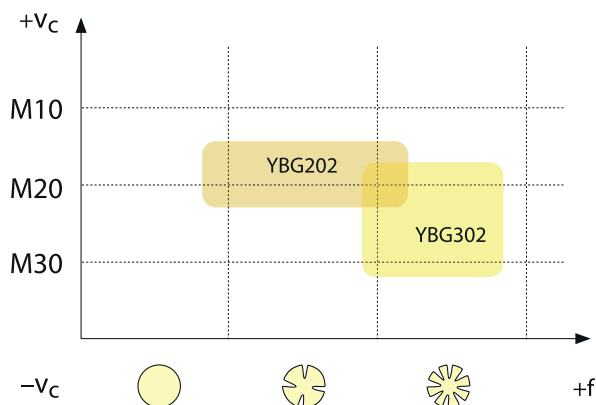
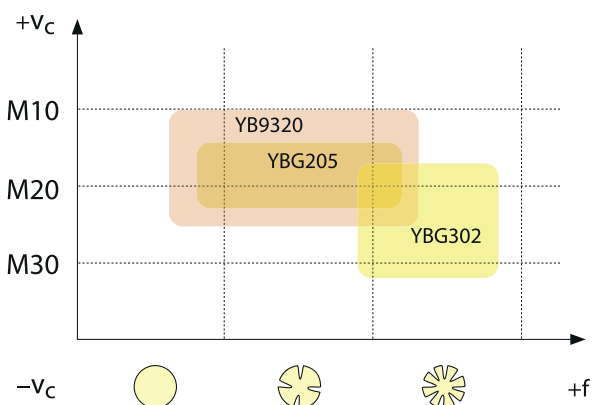
DTechnical
Information**E**

Index

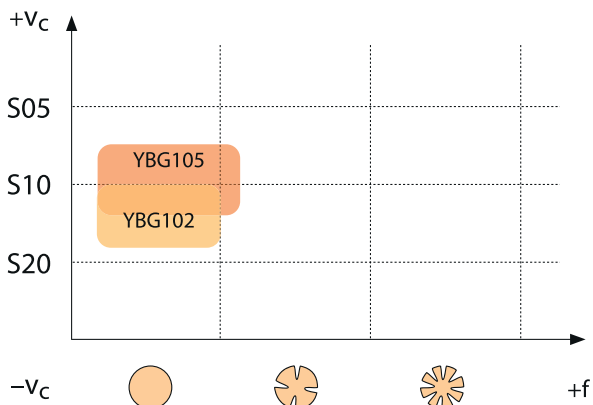
CVD coated carbide grades for steel



PVD coated carbide grades for stainless steel



PVD coated carbide grades for superalloys



A

Turning

B

Milling

C

Drilling

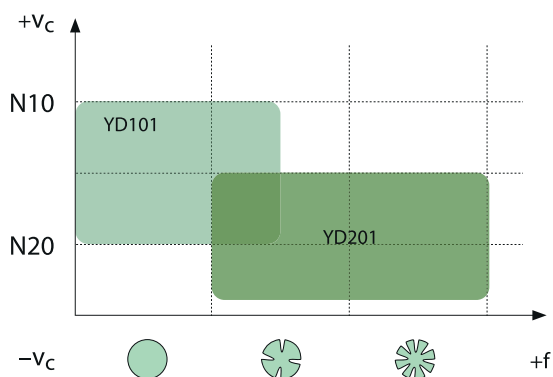
D

Technical Information

E

Index

Carbide grades for non-ferrous metals



A

Turning

B

Milling

C

Drilling

D

Technical Information

E

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Application fields of grades – parting & grooving

	ISO	HC ¹ (CVD)	HC ¹ (PVD)	HT	HC ²	Ceramic	HW	CBN	PCD
A Turning	P01								
	P10								
	P20	YBC251 YBC252							
	P30								
	P40								
B Milling	M01								
	M10								
	M20		YBG202 YBG205 YB9320 YBG302						
	M30								
	M40								
C Drilling	K01								
	K10								
	K20								
	K30								
D Technical Information	N01						YD101 YD102		
	N10								
	N20								
	N30								
E Index	S01								
	S10		YBG102 YBG105						
	S20								
	S30								
F Index	H01								
	H10								
	H20								
	H30								

P	Steel
M	Stainless steel
K	Cast iron

N	Non-ferrous metals
S	Heat-resistant alloys
H	Hardened materials

HC¹ Coated carbide
 HT Uncoated cermet
 HC² Coated cermet
 HW Uncoated carbide

