

A

Turning

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Technical Information



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| RC** | L | I.C | S | d |
|--------------|----|-----|------|------|
| 08 03 | 8 | 8 | 3.18 | 3.36 |
| 10 T3 | 10 | 10 | 3.97 | 3.6 |
| 12 04 | 12 | 12 | 4.76 | 44.4 |
| 16 06 | 16 | 16 | 6.35 | 5.5 |
| 20 06 | 20 | 20 | 6.35 | 6.5 |
| 25 07 | 25 | 25 | 7.94 | 7.7 |

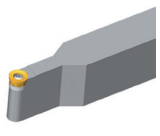
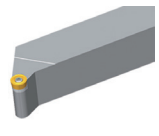
- Ideal machining conditions
- ⊗ Normal machining conditions
- ⊗ Unfavourable machining conditions

Turning inserts

| RC** positive insert | | | | HC ¹ (CVD) | | | | | | | | HC ¹ (PVD) | | | | HT | HC ² | HW | | | | | | | | |
|--|----------------------|---------|----------------------|-----------------------|--------|--------|--------|--------|--------|--------|-----------------------|-----------------------|--------|---------|--------|-----------------|-----------------|--------|--------|--------|--------|--------|--------|---------|-------|-------|
| ISO | a _p | f | RC** positive insert | | | | | | | | HC ¹ (PVD) | | | | HT | HC ² | HW | | | | | | | | | |
| | | | YBC103 | YB6315 | YBC152 | YBC203 | YBC252 | YBC352 | YBM153 | YBM253 | YBD102 | YB7315 | YBD152 | YBD152C | YBG101 | YBG102 | YBG105 | YBG205 | YB9320 | YPD201 | YBS103 | YNG151 | YNT251 | YNG151C | YD101 | YD201 |
| Basic  | RCMT0803MO | 0.5-3.0 | 0.1-0.4 | | | | | ● | | | | | | | | | | | | | | | | | | |
| | RCMT10T3MO | 0.5-4.0 | 0.1-0.5 | | | | | ○ | | | | | | | | | | | | | | | | | | |
| | RCMT1204MO | 0.8-5.0 | 0.1-0.6 | | | | | ○ | ● | | | | | | | | | | | | | | | | | |
| | RCMT1606MO | 1-6 | 0.1-0.8 | | | | | ● | ● | | ○ | ● | | | | | | | | | | | | | | |
| | RCMT2006MO | 1.2-8.0 | 0.1-1.0 | | | | | ○ | ● | | | | | | | | | | | | | | | | | |
| LH  | RCGX0803MO-LH | 1-4 | 0.2-0.5 | | | | | | | | | | | | | | | | | | | | | | | ● |
| | RCGX1204MO-LH | 1.2-5.0 | 0.2-0.6 | | | | | | | | | | | | | | | | | | | | | | | ● |
| Alum Machining | | | | | | | | | | | | | | | | | | | | | | | | | | |

● Ex stock ○ On demand
 YBC152F, YBC252F, YBM153F, YBM253F available

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

| Tool holder | |
|---|---|
| SRDCN | SRGCR/L |
|  |  |
| A288 | A289 |

System code > A48

Grade selection > A42

Technical info > A501

















Cutting data > A366












ISO standard

T N M G 22 04 08 (N) – DM

1 2 3 4 5 6 7 8 9

| Insert shape | | |
|--|---|---|
| A  | B  | C  |
| D  | E  | H  |
| K  | L  | M  |
| O  | P  | R  |
| S  | T  | V  |
| W  | Z Special | |















| Clearance angle | |
|--|---|
| A  | B  |
| C  | D  |
| E  | F  |
| G  | N  |
| P  | O Special |









| Tolerance class | | | |
|-----------------|------------|------------|--------|
| Code | I.C [mm] | m [mm] | S [mm] |
| A | ±0,025 | ±0,005 | ±0,025 |
| C | ±0,025 | ±0,013 | ±0,025 |
| E | ±0,025 | ±0,025 | ±0,025 |
| F | ±0,013 | ±0,005 | ±0,025 |
| G | ±0,025 | ±0,025 | ±0,130 |
| H | ±0,013 | ±0,013 | ±0,025 |
| J | ±0,05–0,15 | ±0,005 | ±0,025 |
| K | ±0,05–0,15 | ±0,013 | ±0,025 |
| L | ±0,05–0,15 | ±0,025 | ±0,025 |
| M | ±0,05–0,15 | ±0,08–0,20 | ±0,130 |
| N | ±0,05–0,15 | ±0,08–0,20 | ±0,025 |
| U | ±0,08–0,25 | ±0,13–0,38 | ±0,130 |

1

2

3

| Fastening features (metric) | |
|---|---|
| Insert shape | |
| A  | B  |
| C  | F  |
| G  | H  |
| J  | M  |
| N  | Q  |
| R  | T  |
| U  | W  |
| X Special | |

| Cutting edge length l [mm] | | | | | | | | |
|----------------------------|---|---|--|---|---|---|---|---|
| I.C [mm] | Insert shape | | | | | | | |
| |  |  |  |  |  |  |  |  |
| 3,97 | 06 | | | | | | | |
| 5,0 | 05 | | | | | | | |
| 5,56 | 09 | | | | | | | |
| 6,0 | 06 | | | | | | | |
| 6,35 | 06 | 07 | 11 | | | 11 | | |
| 8,0 | 08 | | | | | | | |
| 9,525 | 09 | 11 | 09 | 09 | 16 | 16 | 06 | 16 |
| 10,0 | 10 | | | | | | | |
| 12,0 | 12 | | | | | | | |
| 12,7 | 12 | 15 | 12 | 12 | 22 | 22 | 08 | |
| 15,875 | 16 | | 15 | 15 | 27 | | | |
| 16,0 | 19 | | | | | | | |
| 19,05 | 19 | | 19 | 19 | 33 | | | |
| 20,0 | 20 | | | | | | | |
| 25,0 | 25 | 25 | 25 | | | | | |
| 25,4 | 25 | | | | | | | |
| 31,75 | 31 | | | | | | | |
| 32 | 32 | | | | | | | |

4

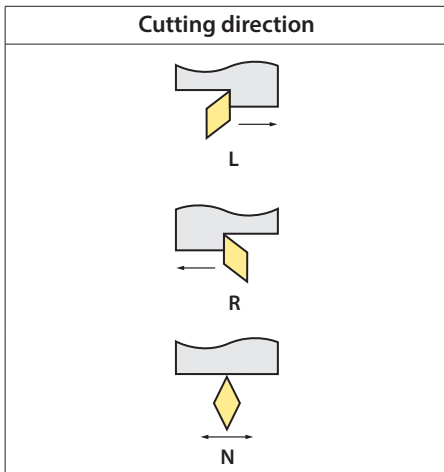
5

| Insert thickness S [mm] | | | |
|-------------------------|------|------|-------|
| | | | |
| Code | S | Code | S |
| 00 | 0,79 | T5 | 5,95 |
| T0 | 0,99 | 06 | 6,35 |
| 01 | 1,59 | T6 | 6,75 |
| T1 | 1,98 | 07 | 7,94 |
| 02 | 2,38 | 09 | 9,52 |
| T2 | 2,58 | T9 | 9,72 |
| 03 | 3,18 | 11 | 11,11 |
| T3 | 3,97 | 12 | 12,70 |
| 04 | 4,76 | | |
| T4 | 4,96 | | |
| 05 | 5,56 | | |

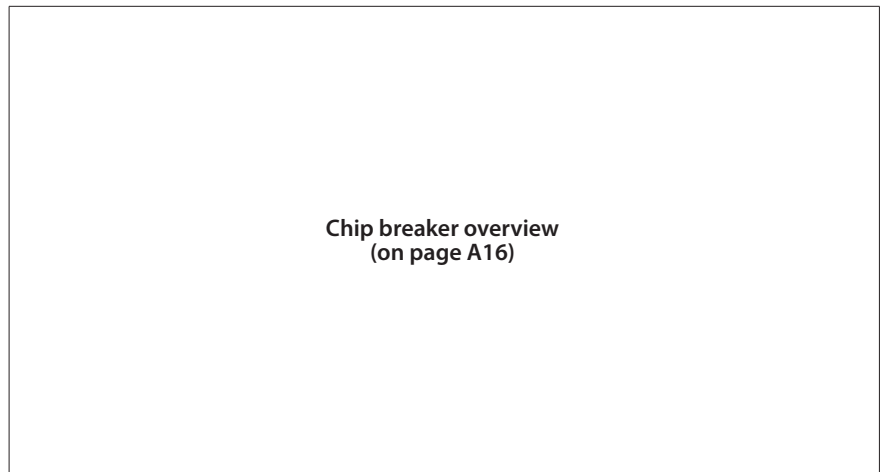
6

| Nose radius r [mm] | |
|--------------------|---------------|
| | |
| Code | r |
| 00 | – |
| 02 | 0,2 |
| 04 | 0,4 |
| 08 | 0,8 |
| 12 | 1,2 |
| 16 | 1,6 |
| 20 | 2,0 |
| 24 | 2,4 |
| 32 | 3,2 |
| X | Special |
| MO | Round inserts |

7

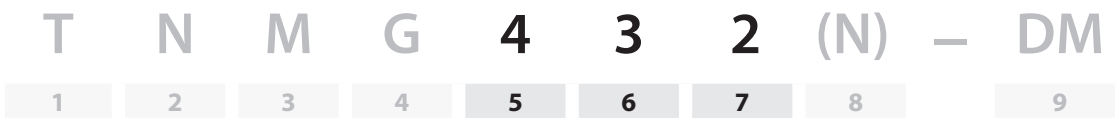


8



9

ANSI standard



| Inner circle | | |
|--------------|--------|-------|
| Code | [mm] | Pouce |
| 2 | 6.35 | 0.250 |
| 3 | 9.525 | 0.375 |
| 4 | 12.7 | 0.500 |
| 5 | 15.875 | 0.625 |
| 6 | 19.05 | 0.750 |
| 8 | 25.4 | 1.000 |

5

| Insert thickness | | |
|------------------|------|-------|
| Code | [mm] | Pouce |
| 2 | 3.18 | 0.125 |
| 3 | 4.76 | 0.187 |
| 4 | 6.35 | 0.250 |
| 5 | 7.94 | 0.313 |
| 6 | 9.52 | 0.375 |

6

| Nose radius | | |
|-------------|------|-------|
| Code | [mm] | Pouce |
| 0 | 0.2 | 0.008 |
| 1 | 0.4 | 0.016 |
| 2 | 0.8 | 0.031 |
| 3 | 1.2 | 0.047 |
| 4 | 1.6 | 0.063 |
| 5 | 2.0 | 0.079 |
| 6 | 2.4 | 0.094 |

7

A

Turning

Positive inserts

Aluminium machining

LC N



Single sided chip breaker with excellent cutting edge design. Sharp cutting edge with positive rake angle. G-tolerance for high repeatability.

B

Milling

LH N



Single sided chipbreaker for machining of cast aluminium alloys. Sharp cutting edge with positive rake angle. G-tolerance for high repeatability.

PCBN & PCD inserts

C

Drilling

Flat N H



With brazed CBN or PCD cutting edge. For machining of hardened steel (CBN) or non-ferrous metals (PCD).

D

Technical Information

MED N



Laser-cut chip breaker for finishing and medium machining operations.

E

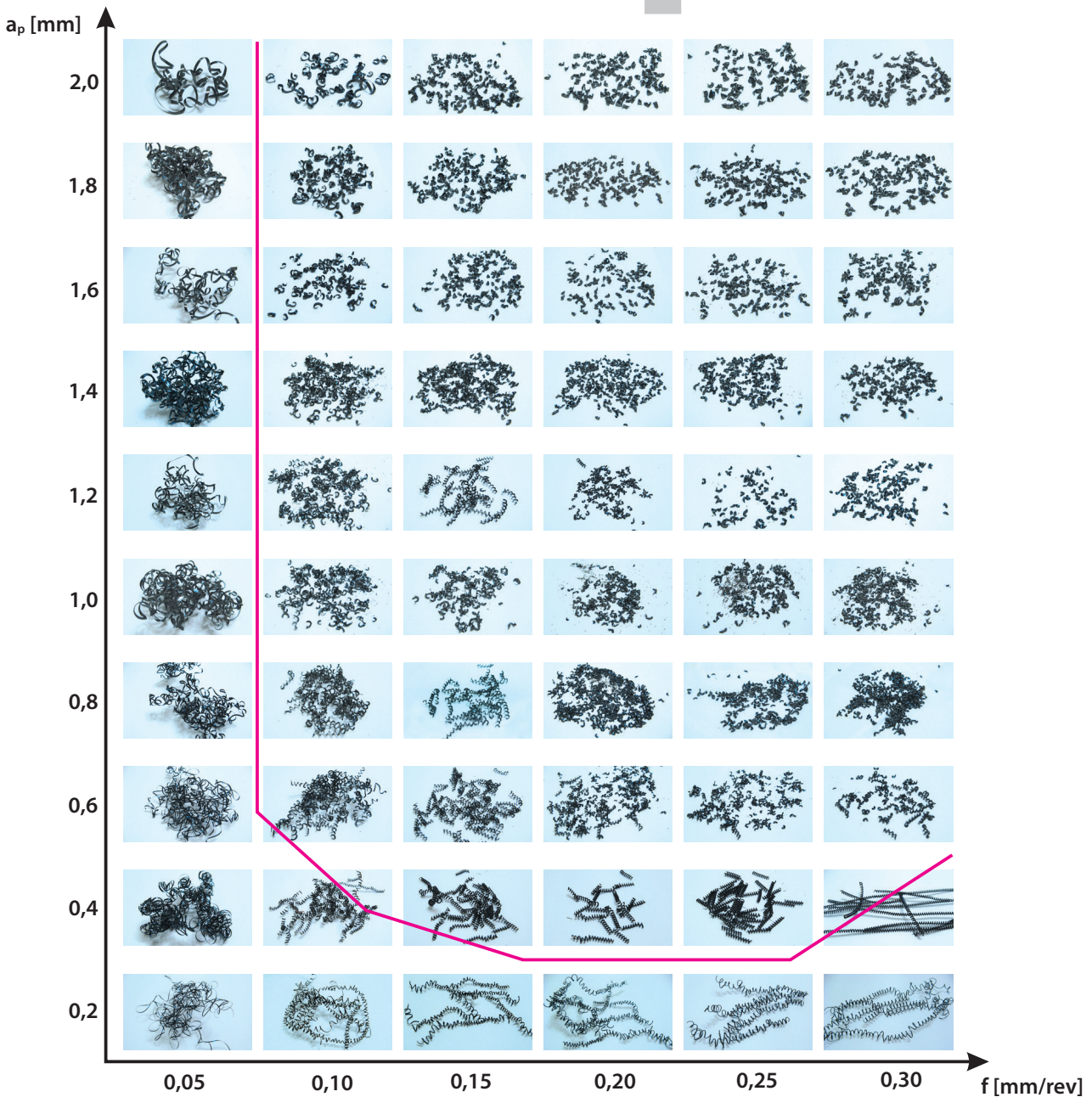
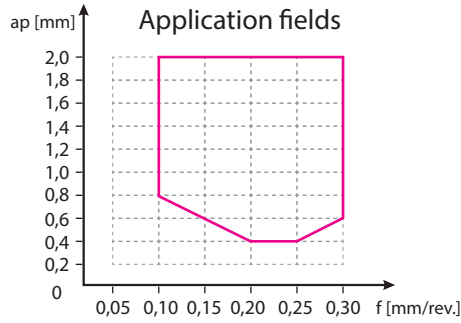
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General turning

Application fields of chip breakers

Example

Insert: CNMG120408-DF
 Holder: PCLNL2525M12
 Material: C45 steel
 V_C : 200 m/min



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Turning

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Drilling


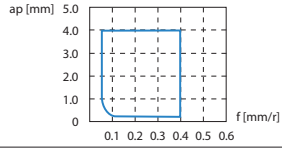
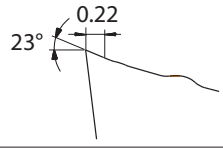

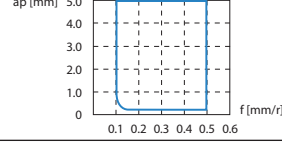
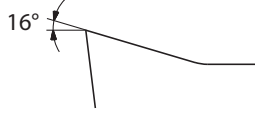
D

Technical Information

E

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N Positive inserts

| Chip breaker | Application | | Application fields | Cutting edge design |
|--------------|-------------|---|--|---|
| LC | Finishing |  |  |  |
| LH | Finishing |  |  |  |

A

Turning

B

Milling

C

Drilling

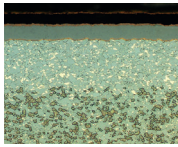
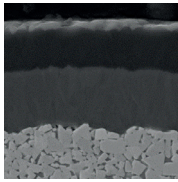
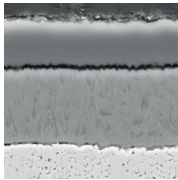
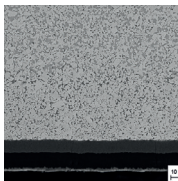
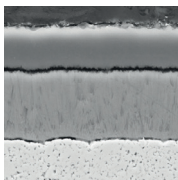
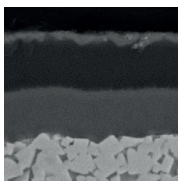
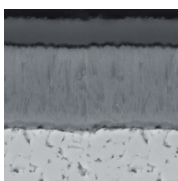
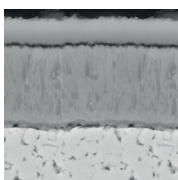
D

Technical Information

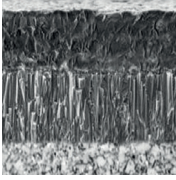
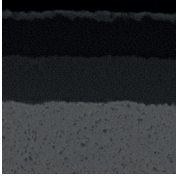
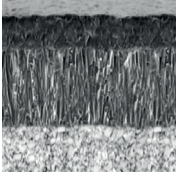
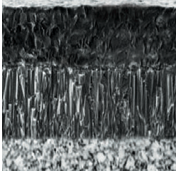
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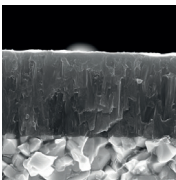
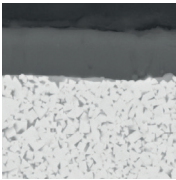
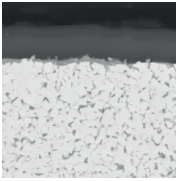
Coated cemented carbide CVD

| Grade | ISO | Micro structure | Grade description |
|-----------------------------------|---------------|--|---|
| A Turning | YBC103 | P05 – P15  | P10 grade with excellent wear resistance at higher cutting speeds. Latest sinter processes and CVD coating technologies enable a wide range of applications in the P material range. |
| | YB6315 | P05 – P20  | CVD coated P10–P20 carbide grade for finishing to medium operation of steel, casting steel and high chrome material. Outstanding performance under high cutting speed and temperature with excellent wear resistance. |
| B Milling | YBC152 | P10 – P20  | CVD coated P10–P20 carbide grade for finishing to medium operation of steel and casting steel. Outstanding performance under higher cutting speed and temperature with excellent wear resistance. |
| | YBC203 | P15 – P25  | P20 grade with exceptional wear resistance and toughness for reliable machining operations. Ultra-modern sintering technique and CVD coating technologies allow for a wide range of applications in the P material range. |
| C Drilling | 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. |
| | YBC352 | P20 - P40  | CVD coated P20–P40 carbide grade for roughing operation of steel and casting steel. Optimal performance of wear resistance and toughness for a wide application field. |
| D Technical Information | YBM153 | M10 - M25  | CVD coated M10–M25 carbide grade for finishing to medium application in stainless steel. High wear resistance and capability against plastic deformation at higher cutting speed. |
| | YBM253 | M15 - M35  | CVD coated M15–M35 carbide grade for medium to roughing operation in stainless steel with wide application field. High wear resistance and capability against plastic deformation at higher cutting speed. |
| E Index | | | |

Coated cemented carbide CVD

| Grade | ISO | Micro structure | Grade description |
|----------------|-----------|--|---|
| YBD102 | K05 - K20 |  | CVD coated K05-K20 carbide substrate. Optimized for medium operation of cast iron, special nodular cast iron and hard steel at high cutting speed. |
| YB7315 | K10 - K25 |  | CVD coated K10-K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Improved wear resistance and toughness at high cutting speed. |
| YBD152 | K10 - K25 |  | CVD coated K10-K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Good wear resistance and toughness at higher cutting speed. |
| YBD152C | K10 - K25 |  | Thick Al ₂ O ₃ CVD coated K05-K25 carbide substrate. Optimized for medium to roughing operation of cast iron. Higher wear resistance and toughness at higher cutting speed in combination with TC chip breaker. |

Coated cemented carbide PVD

| Grade | ISO | Micro structure | Grade description |
|---------------|-----------|---|---|
| YBG101 | N05 - N20 |  | PVD coated N05-N20 carbide substrate for finishing to semi-finishing in aluminium materials. Coating only on the top face, in combination with the aluminium chip breakers, prevents built-up edges and gives a smooth cut. |
| 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. |
| 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. |

A

Turning

B

Milling

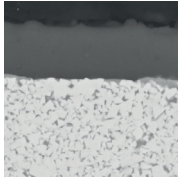
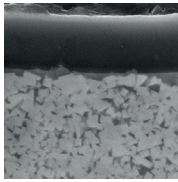
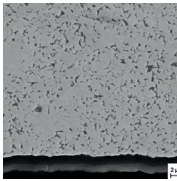
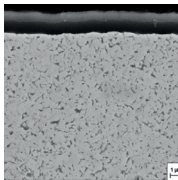
C

Drilling

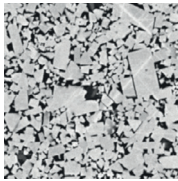
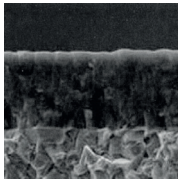
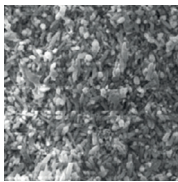
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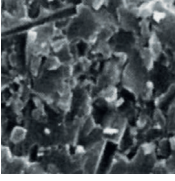
Coated cemented carbide PVD

| Grade | ISO | Micro structure | Grade description |
|---------------|-----------------------------------|--|--|
| 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. |
| 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. |
| YPD201 | S20 - S30 |  | Carbide grade for semi-roughing to chip breaking of high-strength and high-alloy materials. High-performance grade with high wear resistance. Balanced hardness and internal stress ratio provide a wide range of applications. |
| YBS103 | S10 - S20 |  | Turning grade for processing nickel-base materials. A special carbide substrate and the latest PVD coating technology enable a very good wear behaviour and high thermal stability. |

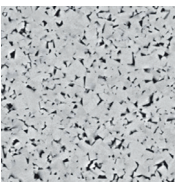
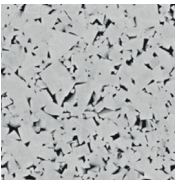
Ceramic

| Grade | ISO | Micro structure | Grade description |
|---------------|------------------------|---|---|
| CA1000 | K10 - K25 H10 - H25 |  | Uncoated H10–H25/K10–K25 mixed ceramic grade for finishing to medium operation in hardened steel and nodular cast iron. Good wear resistance and toughness. |
| CM1000 | K10 - K25 H10 - H25 |  | Coated H1–H25/K10–K25 mixed ceramic grade for finishing to medium operations in hardened steel, tool steel, HSS material and nodular cast iron. Good wear resistance and toughness. |
| CN1000 | K05 - K15 |  | Uncoated K05–K15 Si ₃ N ₄ ceramic grade for finishing to medium operation in grey cast iron. Good wear resistance and thermal stability. |

Ceramic

| Grade | ISO | Micro structure | Grade description |
|---------------|----------------------|---|---|
| CS1000 | S05 – S20 | | Uncoated SiAlON ceramic grade for medium machining to roughing of nickel- and cobalt-based alloys at medium to low cutting speeds. |
| CW1400 | S10 – S20 H10-H20 |  | Uncoated whisker ceramic grade for medium and low speed cutting in HSS steel, high chrome steel and cobalt-base alloy also with interrupted cut. Good wear resistance, notch wear resistance and thermal stability. |
| CW1800 | S10 – S25 | | Uncoated whisker ceramic grade for finishing to rough operations in Ni-base alloy material like Inconel, Nimonic or Hastelloy. Good wear resistance, notch wear resistance and thermal stability. |

Uncoated cemented carbide

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

CBN

| Grade | ISO | Micro structure | Grade description |
|---------------|-----------|-----------------|---|
| YCB112 | S10 – S20 | | Uncoated, brazed S10–S20 CBN grade for fine finishing operations on hardened steel and super alloys. Excellent wear resistance and thermal stability. |

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CBN

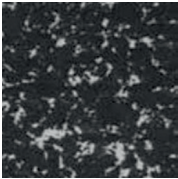
| Grade | ISO | Micro structure | Grade description |
|----------------|-----------|---|--|
| YCB113 | H01 - H10 | | Uncoated, brazed H01–H10 CBN grade for fine finishing operation in hardened steel with continuous cut. High wear resistance and productivity at higher cutting speed. |
| YCB121 | H10 - H25 |  | Uncoated, brazed H10–H25 CBN grade for fine to medium application in hardened steel from continuous to light interrupted cut. Good wear resistance and toughness for universal use. |
| YCB131 | H20 - H35 |  | Uncoated, brazed H20–H35 CBN grade for fine to medium application in hardened steel with interrupted cut. Good wear resistance and optimized toughness for safe process. |
| YCB113C | H01 - H10 | | Coated, brazed H01–H10 CBN grade for fine finishing operations on hardened steel with a continuous cut. High wear resistance and productivity at higher cutting speeds |
| YCB121C | H10 - H25 | | Coated, brazed H10–H25 CBN grade for fine to medium machining operations on hardened steel with a continuous to partially interrupted cut. Good wear resistance and toughness for universal application. |
| YCB131C | H20 - H25 | | Coated, brazed H20–H35 CBN grade for fine to medium machining operations on hardened steel with an interrupted cut. Good wear resistance and optimum toughness for reliable operations. |
| YCB215 | K10 - K20 | | Uncoated, brazed K10–K20 CBN grade for fine to medium machining operations on cast iron. Excellent wear resistance and thermal conductivity. |
| YZB630 | H20 - H30 | | Uncoated H20–H30 solid CBN grade for medium machining operations on hardened steel with a slight to medium interrupted cut. Excellent combination of wear resistance and thermal stability. |

CBN

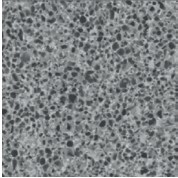
| Grade | ISO | Micro structure | Grade description |
|----------------|-----------|-----------------|---|
| YZB630C | H20 - H30 | | Coated H20–H30 solid CBN grade for medium machining operations on hardened steel with a slight to medium interrupted cut. Excellent combination of wear resistance and thermal stability. |

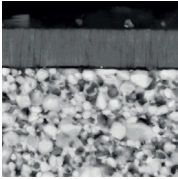
| | | | |
|---------------|-----------|--|---|
| YZB223 | K10 - K25 | | Uncoated H10–H25/K10–K25 mixed ceramic grade for finishing to medium operation in hardened steel and nodular cast iron. Good wear resistance and toughness. |
|---------------|-----------|--|---|

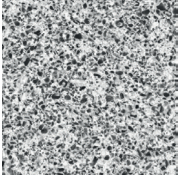
PCD

| Grade | ISO | Micro structure | Grade description |
|---------------|-----------|--|--|
| YCD421 | N01 - N10 |  | Uncoated, brazed N01–N10 PCD grade for fine finishing operation of aluminum alloys less than 12 % Si, composites, copper/magnesium and other alloys. Medium grain size grade with good wear resistance for a wide application field. |

Cermet

| Grade | ISO | Micro structure | Grade description |
|---------------|-----------|---|--|
| YNG151 | P05 - P15 |  | Uncoated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good resistance against plastic deformation for good surface finishing. |

| | | | |
|----------------|-----------|---|--|
| YNG151C | P05 - P15 |  | PVD coated P05–P15 cermet grade for fine finishing operation of steel and stainless steel. Good wear resistance and capability against plastic deformation for good surface roughness. |
|----------------|-----------|---|--|

| | | | |
|---------------|-----------|---|--|
| YNT251 | P10 - P25 |  | Uncoated P10–P25 cermet grade for fine finishing to medium operation of steel and stainless steel. Good wear resistance and toughness. Suitable also in light interrupted cut. |
|---------------|-----------|---|--|

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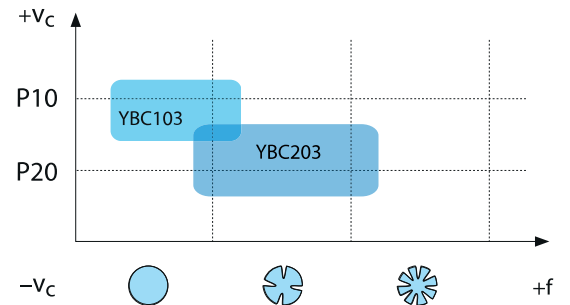
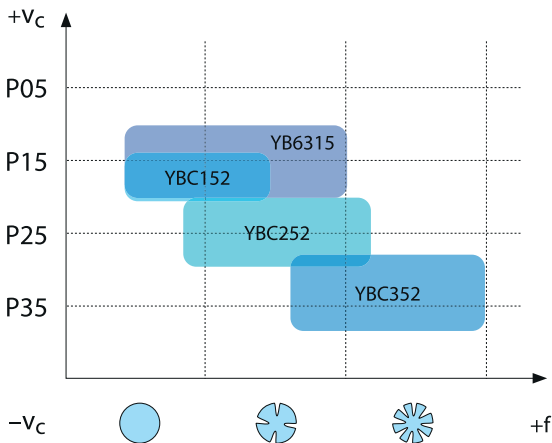
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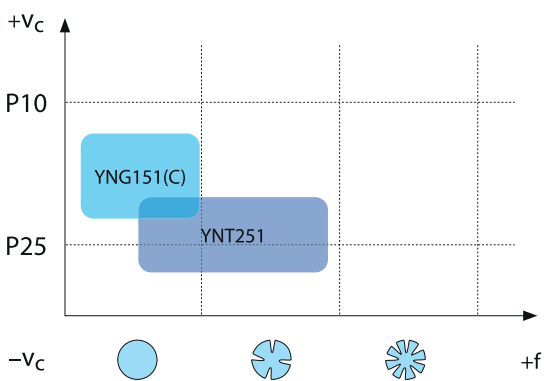
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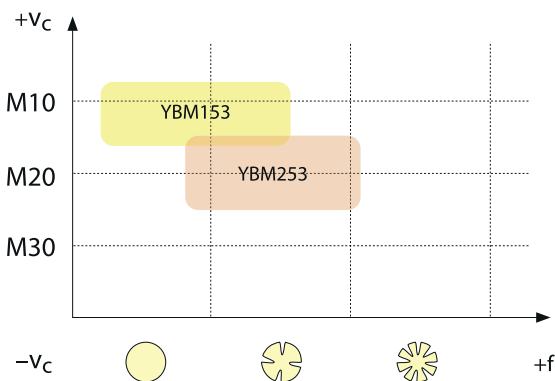
CVD coated carbide grades for steel



Cermet grades for steel



CVD coated carbide grades for stainless steel



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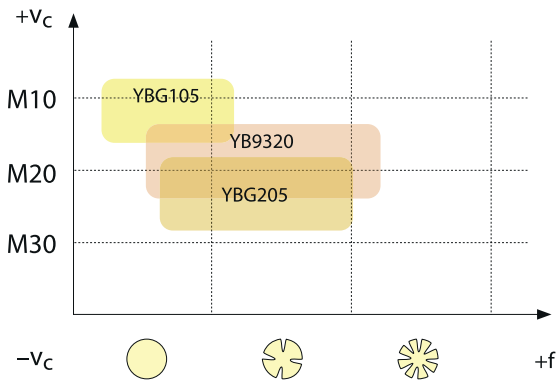
D

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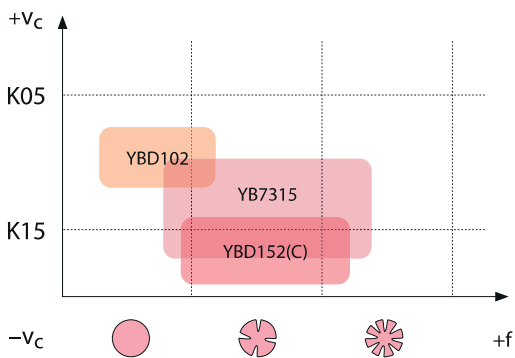
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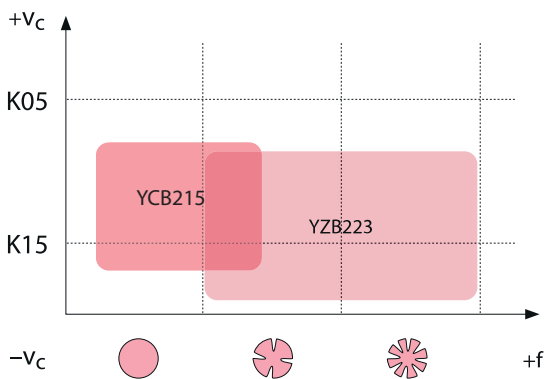
PVD coated carbide grades for stainless steel



CVD coated carbide grades for cast iron



CBN grades for cast iron



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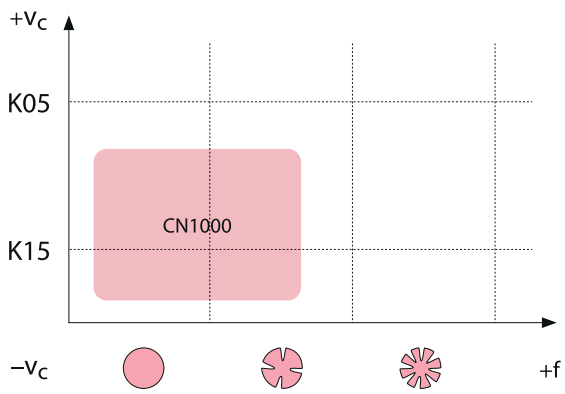
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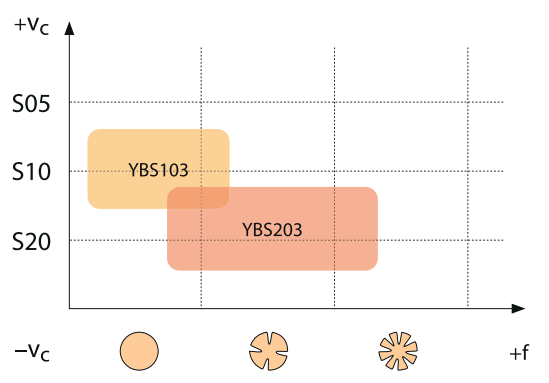
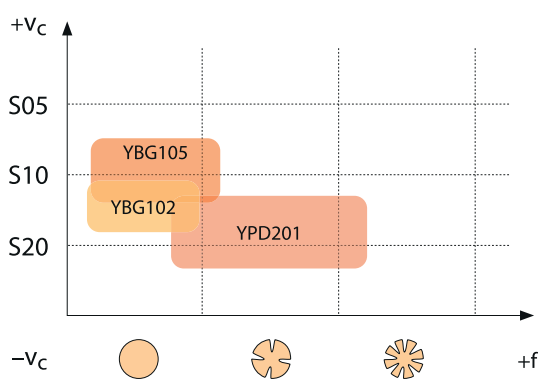
Ceramic grades for cast iron



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PVD coated carbide grades for superalloys



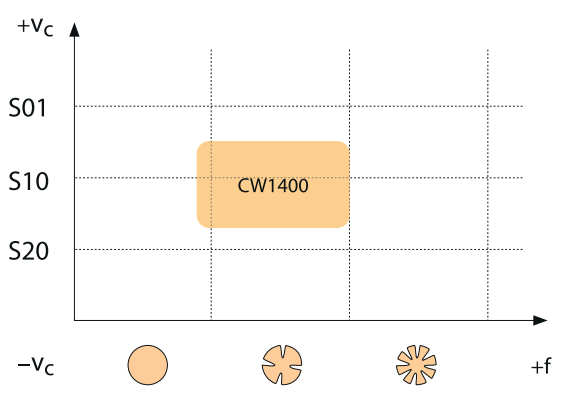
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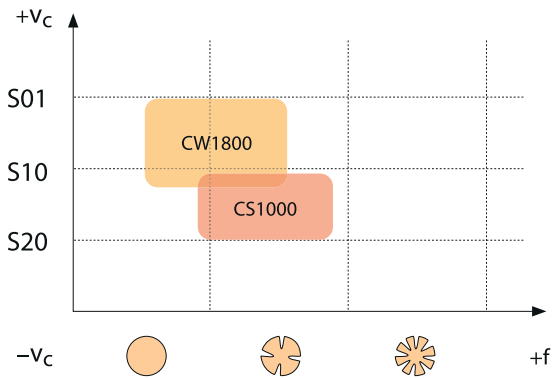
Ceramic grades for cobalt base alloys/HSS



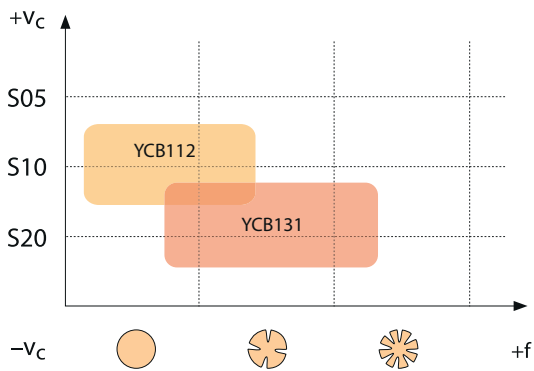
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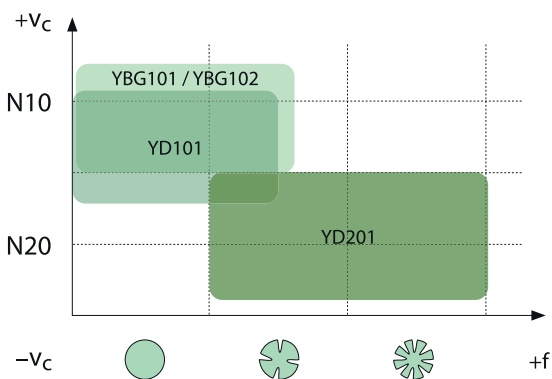
Ceramic grades for nickel base alloys



CBN grades for superalloys



Carbide grades for non-ferrous metals



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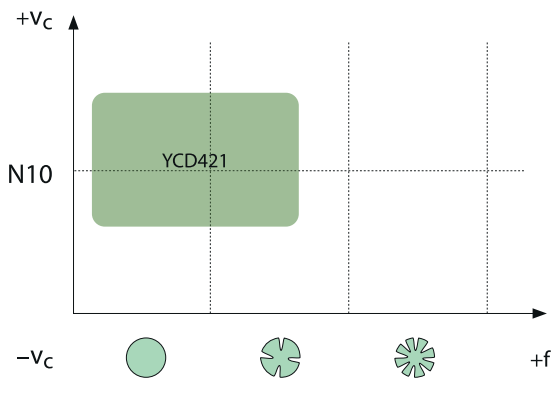
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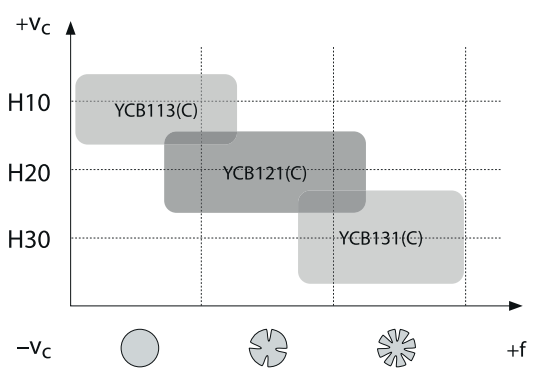
PCD grades for non-ferrous metals



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CBN grades for hardened steel



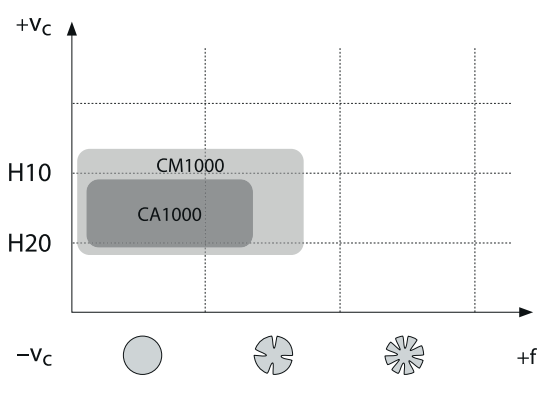
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Ceramic grades for hardened steel



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Application fields of grades – general turning

| | ISO | HC ¹ (CVD) | HC ¹ (PVD) | HT | HC ² | Ceramic | HW | CBN | PCD |
|----------|-----|-----------------------|-----------------------|--------|-----------------|---------|-------|-----------|-----------|
| P | P01 | YBC103 | | | | | | | |
| | P10 | YB6315 | | YNG151 | YNG151C | | | | |
| | P20 | YBC152 | | YNT251 | | | | | |
| | P30 | YBC203 | | | | | | | |
| | P40 | YBC252 | | | | | | | |
| | | YBC352 | | | | | | | |
| M | M01 | | YBG105 | YNG151 | YNG151C | | | | |
| | M10 | YBM153 | YB9320 | | | | | | |
| | M20 | YBM253 | YBG205 | | | | | | |
| | M30 | | | | | | | | |
| | M40 | | | | | | | | |
| K | K01 | | | | | CN1000 | | YCB215 | YZB223 |
| | K10 | YBD102 | | | | | YD201 | | |
| | K20 | YBD152 | | | | | | | |
| | K30 | YB7315 | | | | | | | |
| | | YBD152C | | | | | | | |
| N | N01 | | | | | | YD101 | | YCD421 |
| | N10 | | YBG101 | | | | YD201 | | |
| | N20 | | YBG102 | | | | | | |
| | N30 | | | | | | | | |
| S | S01 | | YBS103 | | | CS1000 | | YCB112 | |
| | S10 | | YBG102 | | | CW1400 | | YCB131 | |
| | S20 | | YBG105 | | | CW1800 | | | |
| | S30 | | YB9320 | | | | | | |
| | | YPD201 | | | | | | | |
| H | H01 | | | | | | | YCB113(C) | |
| | H10 | | | | | | | YCB121(C) | |
| | H20 | | | | | | | | YCB131(C) |
| | 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

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