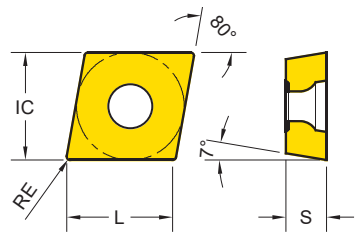


Turning Inserts - Positive
CCMT / CCGT (80° Positive)



Series	L	IC	S
CC** 0602	6.2	6.35	2.38
CC** 09T3	9.2	9.525	3.97
CC** 1204	12.4	12.7	4.76

EDP 2200.. ● : Stock item ○ : Order made item

	CCGT CCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	P05 K10	P10 K20	P20	P30 M20	P20	M15 S10	M30 S20	M40 S30	N20	N20
						YG1001	YG3010	YG3020	YG3030	YG801	YG211	YG213	YG214	YG100	YG10
-AL  Aluminum		CCGT 09T302 - AL	0.2	0.02 ~ 0.08	0.5 ~ 1									● 0339	● 0340
		CCGT 09T304 - AL	0.4	0.05 ~ 0.25	0.5 ~ 2									● 0081	● 0330
		CCGT 09T308 - AL	0.8	0.1 ~ 0.35	1 ~ 3									● 0082	● 0331
		CCGT 120402 - AL	0.2	0.04 ~ 0.15	0.1 ~ 1									● 0473	● 0474
		CCGT 120404 - AL	0.4	0.04 ~ 0.2	0.3 ~ 1.5									● 0475	● 0476
		CCGT 120408 - AL	0.8	0.04 ~ 0.2	0.6 ~ 2.5									● 0477	● 0478
-UF  Finishing		CCMT 060204 - UF	0.4	0.05 ~ 0.2	0.5 ~ 1.5		● 0163	● 0164	● 0165						
		CCMT 09T304 - UF	0.4	0.05 ~ 0.2	0.5 ~ 2		● 0169	● 0170							
-UG  General		CCMT 060204 - UG	0.4	0.1 ~ 0.25	0.5 ~ 2		● 0166	● 0167	● 0168	● 0006					
		CCMT 060208 - UG	0.8	0.1 ~ 0.25	0.8 ~ 2		● 0479	● 0683	● 0684	● 0009					
		CCMT 09T304 - UG	0.4	0.15 ~ 0.3	0.5 ~ 2		● 0172	● 0173	● 0174	● 0007					
		CCMT 09T308 - UG	0.8	0.15 ~ 0.3	0.8 ~ 2.5	● 0445	● 0150	● 0151	● 0152	● 0008					
		CCMT 120404 - UG	0.4	0.15 ~ 0.35	0.5 ~ 2.5		● 0175	● 0176							
		CCMT 120408 - UG	0.8	0.15 ~ 0.35	0.8 ~ 3.5		● 0153	● 0154	● 0155	● 0005					
		CCMT 120412 - UG	1.2	0.15 ~ 0.35	1.2 ~ 3.5		● 0483								

* YG3015 = Vc 90~430 m/min

Cutting Speed			Vc (m/min.)																			
ISO	VDI	Sub Group	YG1001		YG3010		YG3020		YG3030		YG801		YG211		YG213		YG214		YG100		YG10	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	220	480	170	450	180	380	150	350	120	200	-	-	-	-	-	-	-	-	-	-
	6~9	Low-Alloyed Steel	220	420	180	380	110	350	90	300	70	200	-	-	-	-	-	-	-	-	-	-
	10~11	High-Alloyed Steel	-	-	100	330	60	300	70	250	-	-	-	-	-	-	-	-	-	-	-	-
M	12~13	Ferritic & Martensitic	-	-	-	-	-	-	120	230	-	-	130	230	110	180	80	150	-	-	-	-
	14	Austenitic Stainless Steel	-	-	-	-	-	-	80	200	-	-	100	200	40	130	30	120	-	-	-	-
K	15~16	Grey Cast Iron	170	420	120	300	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	17~18	Nodular Cast Iron	120	410	120	280	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	350	1200	250	800	
S	31~37	Superalloys & Titanium	-	-	-	-	-	-	35	80	-	-	30	90	20	40	20	40	-	-	-	-
H	38~41	Hard Materials	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-