

TURNING		TC CARBIDE Positive	ISO513 P M K N S H	HC-CVD						HC-PVD		HW		HT													
				Size	IC	S	D1	AN		JC7010	JC7020	JC8005	JC8015	JC8025	JC9010	JC9025	JP5015	JP5025	JP6010	JU6010	JU6020	JU4015	JP4020				
				0902□	5.56	2.38	2.50	7°				200 380	180 360	140 300			80 220	60 180					200 380 400	200 380 400			
				1102□	6.35	2.38	2.80	7°		180 380	150 300				150 280	120 240	80 160	60 120						160 280 300	160 280 300		
				16T3□	9.525	3.97	4.40	7°												600 2200	600 2000	500 1500					
				2204□	12.70	4.76	5.50	7°										40 80									
				GRADE APPLICATION AREA		Stable machining, continuous cut				+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
				main application		General machining, light interruption				-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
				applicable		Unstable machining, interrupted cut				-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

THREADING	GRADE APPLICATION AREA		Stable machining, continuous cut				+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	
	main application		General machining, light interruption				-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	applicable		Unstable machining, interrupted cut				-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

FINISHING		PFU P M S	TCMT 110202-PFU	RE 0.2	a _p 0.20 f _n 0.04	0.80 0.08	1.40 0.12																	
			110204-PFU	RE 0.4	a _p 0.20 f _n 0.05	0.80 0.11	1.40 0.17																	

GROOVING		PMU P M K	TCMT 090204-PMU	RE 0.4	a _p 0.50 f _n 0.05	1.00 0.09	1.50 0.13																			
			TCMT 110202-PMU	RE 0.2	a _p 0.50 f _n 0.05	1.50 0.10	2.50 0.15																			
			110204-PMU	RE 0.4	a _p 0.50 f _n 0.06	1.50 0.13	2.50 0.20																			
			110208-PMU	RE 0.8	a _p 0.50 f _n 0.08	1.50 0.16	2.50 0.24																			
			TCMT 16T304-PMU	RE 0.4	a _p 0.60 f _n 0.07	1.80 0.16	3.00 0.25																			
			16T308-PMU	RE 0.8	a _p 0.60 f _n 0.08	1.80 0.19	3.00 0.30																			
			16T312-PMU	RE 1.2	a _p 0.60 f _n 0.10	1.80 0.22	3.00 0.34																			
			TCMT 220408-PMU	RE 0.8	a _p 0.80 f _n 0.10	2.20 0.22	3.60 0.32																			

MILLING		PMN N	TCGX 090204-PMN	RE 0.4	a _p 0.30 f _n 0.05	1.00 0.11	1.70 0.17																			
			TCGX 110202-PMN	RE 0.2	a _p 0.30 f _n 0.05	1.50 0.10	2.70 0.15																			
			110204-PMN	RE 0.4	a _p 0.30 f _n 0.06	1.50 0.13	2.70 0.20																			
			110208-PMN	RE 0.8	a _p 0.30 f _n 0.08	1.50 0.16	2.70 0.24																			
			TCGX 16T302-PMN	RE 0.2	a _p 0.50 f _n 0.06	2.00 0.11	3.50 0.16																			
			16T304-PMN	RE 0.4	a _p 0.50 f _n 0.08	2.00 0.16	3.50 0.24																			
			16T308-PMN	RE 0.8	a _p 0.50 f _n 0.10	2.00 0.20	3.50 0.30																			

DRILLING		PRU P K	TCMT 16T304-PRU	RE 0.4	a _p 1.50 f _n 0.10	2.50 0.19	3.50 0.28																	
			16T308-PRU	RE 0.8	a _p 1.50 f _n 0.12	2.50 0.22	3.50 0.32																	

● stock standard, ○ non-standard stock, ▽ stock exhaustion

ACCESSORIES	HOLDERS EXTERNAL		HOLDERS INTERNAL	
		p. 135		p. 138