

TURNING

THREADING

GROOVING

MILLING

DRILLING

ACCESSORIES

<h2 style="text-align: center;">DC</h2> <p style="text-align: center;">2 edges</p>		CARBIDE Positive					ISO513 P M K N S H	HC-CVD						HC-PVD		HW		HT						
		Size	IC	S	D1	AN		180	150	150	180	140	150	120	80	60	600	600	500	200	200			
		0702□□	6.35	2.38	2.80	7°		380	380	360	300	280	240	160	120	80	60				280	300		
		11T3□□	9.525	3.97	4.40	7°		380	300	380	300	280	240	160	120	80	60	600	2000	1500	200	200		
		1504□□	12.70	4.76	5.50	7°										40	80				400	400		
																40	80				400	400		
GRADE APPLICATION AREA		Stable machining, continuous cut				+	-	+	-	○	○	○	○	○	○	○	○	○	○	○	○	○		
main application		General machining, light interruption				+	-	+	-	○	○	○	○	○	○	○	○	○	○	○	○	○		
applicable		Unstable machining, interrupted cut				-	+	-	+	○	○	○	○	○	○	○	○	○	○	○	○	○		

FINISHING	PPF P M <p style="font-size: small;">ground chipbreaker, picture: right-hand</p>	DCET	070202%-PPF	RE 0.2	a_p 0.10	0.40	0.70											●					●			
			070204%-PPF	RE 0.4	a_p 0.10	0.40	0.70													●					●	
		DCET	11T302%-PPF	RE 0.2	a_p 0.10	0.50	0.90													●					●	
			11T304%-PPF	RE 0.4	a_p 0.10	0.50	0.90													●					●	
		PFU P M S <p style="font-size: small;">sharp edge</p>	DCMT	070202-PFU	RE 0.2	a_p 0.20	0.80	1.40																●	○	
				070204-PFU	RE 0.4	a_p 0.20	0.80	1.40																	●	●
	DCMT		11T302-PFU	RE 0.2	a_p 0.30	1.00	1.70																	●	○	
			11T304-PFU	RE 0.4	a_p 0.30	1.00	1.70																	●	●	
	PPM P M <p style="font-size: small;">ground chipbreaker, picture: right-hand</p>		DCET	070204%-PPM	RE 0.4	a_p 0.40	1.00	1.60																●		
				11T302%-PPM	RE 0.2	a_p 0.50	1.50	2.50												●					●	
	PMU P M K <p style="font-size: small;">general purpose</p>	DCMT	070202-PMU	RE 0.2	a_p 0.50	1.50	2.50																●	○		
			070204-PMU	RE 0.4	a_p 0.50	1.50	2.50												●					●	●	
070208-PMU			RE 0.8	a_p 0.50	1.50	2.50												●					●			
DCMT		11T302-PMU	RE 0.2	a_p 0.60	1.80	3.00																	●	○		
		11T304-PMU	RE 0.4	a_p 0.60	1.80	3.00												●					●	●		
		11T308-PMU	RE 0.8	a_p 0.60	1.80	3.00												●					●	○		
DCMT		150404-PMU	RE 0.4	a_p 0.80	2.20	3.60												○								
		150408-PMU	RE 0.8	a_p 0.80	2.20	3.60												○								
		150412-PMU	RE 1.2	a_p 0.80	2.20	3.60												○								
PMN N <p style="font-size: small;">polished surface</p>	DCGX	070202-PMN	RE 0.2	a_p 0.30	1.50	2.70																●				
		070204-PMN	RE 0.4	a_p 0.30	1.50	2.70																	○	○		
		070208-PMN	RE 0.8	a_p 0.30	1.50	2.70																	○	○		
	DCGX	11T302-PMN	RE 0.2	a_p 0.50	2.00	3.50																	○	●		
		11T304-PMN	RE 0.4	a_p 0.50	2.00	3.50																	●	●		
		11T308-PMN	RE 0.8	a_p 0.50	2.00	3.50																	●	●		

● stock standard, ○ non-standard stock



DC	CARBIDE Positive					ISO513	HC-CVD						HC-PVD		HW		HT						
	Size	IC	S	D1	AN		JC7010	JC7020	JC8005	JC8015	JC8025	JC9010	JC9025	JPS015	JPS025	JPS010	JU6010	JU6020	JU4015	JP4020			
						P			200 380	180 360	140 300		80 220	60 180				200 380	200 400				
	0702	6.35	2.38	2.80	7°	M					150 280	120 240	80 160	60 120				160 280	160 300				
	11T3	9.525	3.97	4.40	7°	K	180 380	150 300						80 170				200 400	200 420				
	1504	12.70	4.76	5.50	7°	N									600 2200	600 2000	500 1500						
							S							40 80									
						H																	
GRADE APPLICATION AREA	Stable machining, continuous cut					+ - Hardness Toughness 																	
main application	General machining, light interruption																						
applicable	Unstable machining, interrupted cut																						
ROUGHING reinforced edge	DCMT 11T304-PRU	RE 0.4	a_p 1.50 f_n 0.10	2.50 0.19	3.50 0.28	●																	
	11T308-PRU	RE 0.8	a_p 1.50 f_n 0.12	2.50 0.22	3.50 0.32	●																	

● stock standard

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