



**INDEXABLE INSERTS**



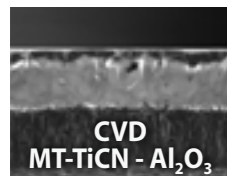
**YGTURN**  
**YG3115** NEW

First choice grade for high cutting speed in Steels



**YGTURN**  
**YG2025** NEW

High Cutting Speed for Stainless steels

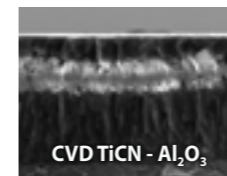
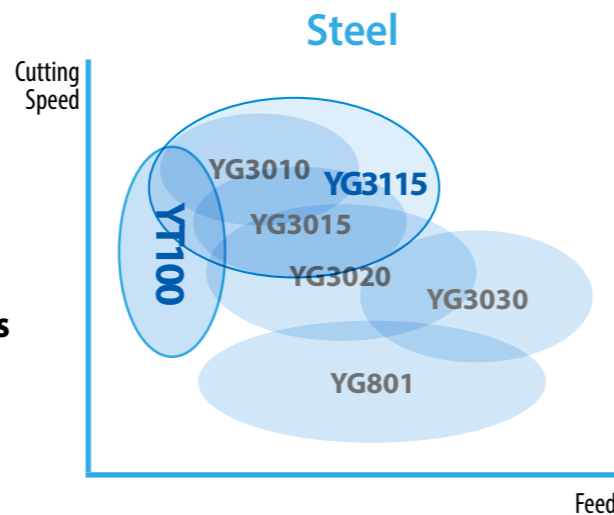


**YG3115**

P10 - P25

**First choice grade for high cutting speed in Steels**

- Suitable for mass production due to stable and predictable tool life
- Minimizing built up edge due to new post surface treatment in mild steels, low carbon steel and low carbon alloy steel.
- Best choice for both continuous as well as interrupted cuts

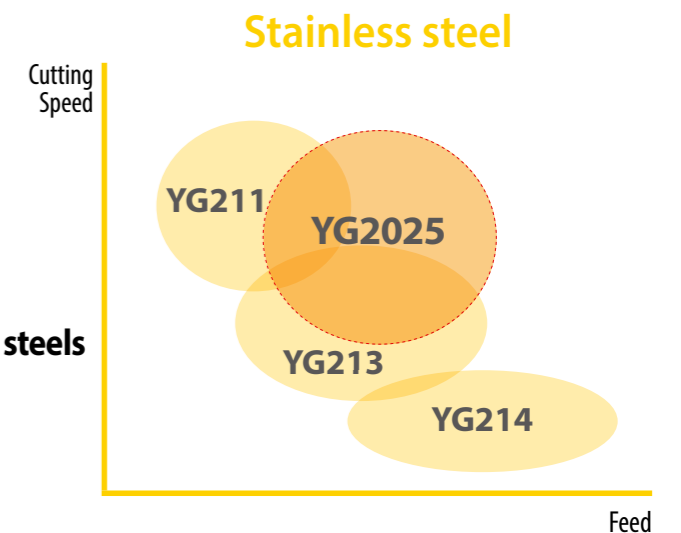


**YG2025**

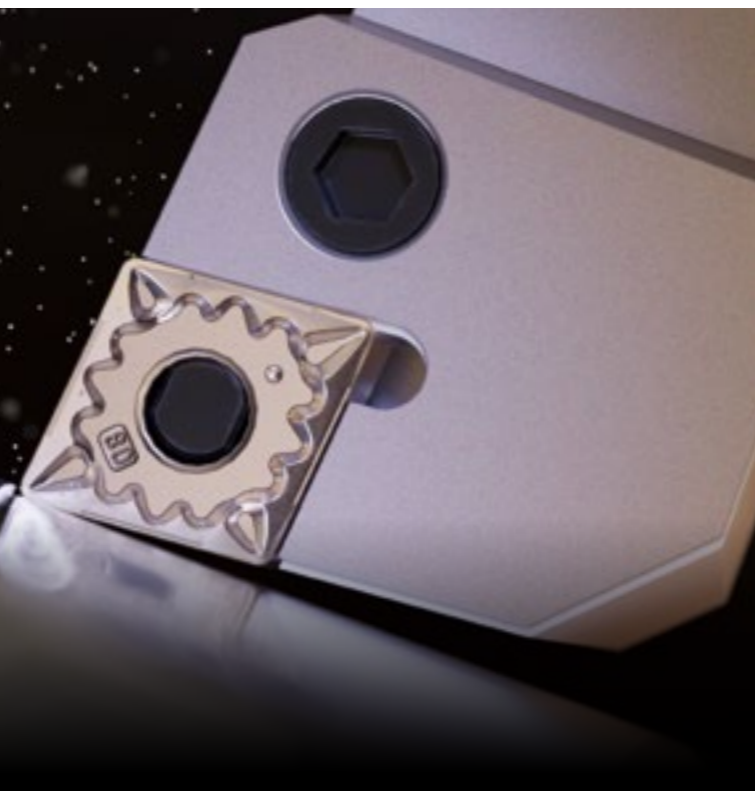
M15 - M35

**CVD grade for High Cutting Speed for Stainless steels**

- Utilizing a new carbide substrate and new coating
- Excellent combination of wear resistance and chipping resistance
- Minimized built up edge due to post surface treatment



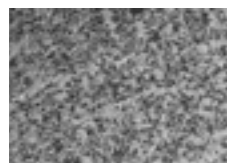
## YG TURN YT100 NEW Cermet Turning Grade



## YG TURN UT, UH NEW Single sided inserts for heavy turning



### Grades



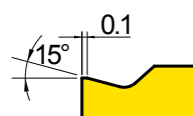
<Micro structure>

**YT100** P10 - P20 M10 - M20 K10 - K20

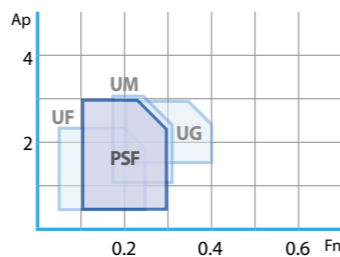
- Enhanced wear resistance & chipping resistance
- Excellent fracture resistance
- Superior surface finish with special edge preparation

### Chipbreakers

**PSF**



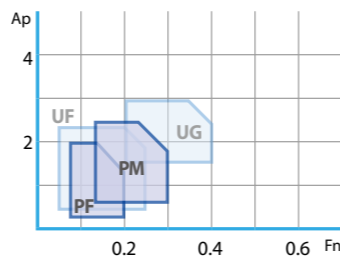
- For negative chip breaker insert
- 3 dimensional chip breakers give low cutting force
- For semi-finishing to semi-medium



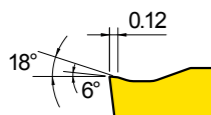
**PF**



- For positive chip breaker insert
- Excellent chip breaking at small depth of cut and low feed rate
- Good for low carbon contents steel in Finishing



**PM**



- For positive chip breaker insert
- High positive rake angle
- Good for low carbon contents steel
- For medium

### Chipbreakers



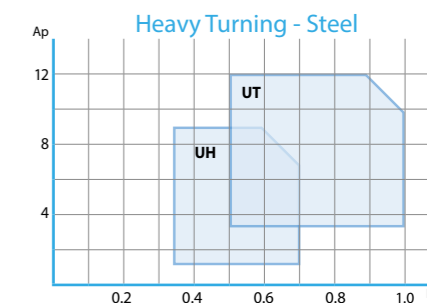
**UH**

Low cutting force

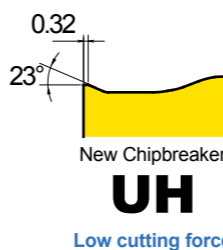


**UT**

Heavy roughing

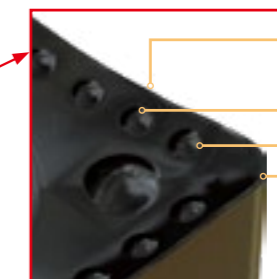
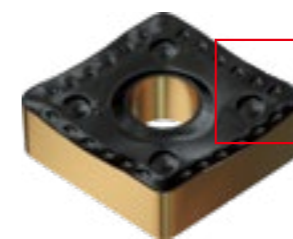


### Features

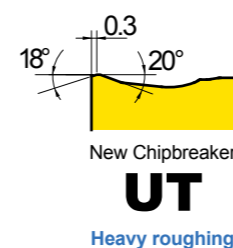


**UH**

Low cutting force

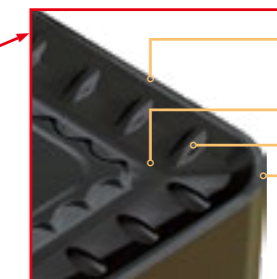


- ① Reduce cutting force due to the helix angle on the cutting edge
- ② The central dot helps chip breaking to be efficient
- ③ Decoration dot reduces friction area and helps heat release
- ④ Insert corner radius range available from 1.2mm to 2.4mm

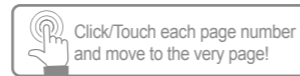



**UT**

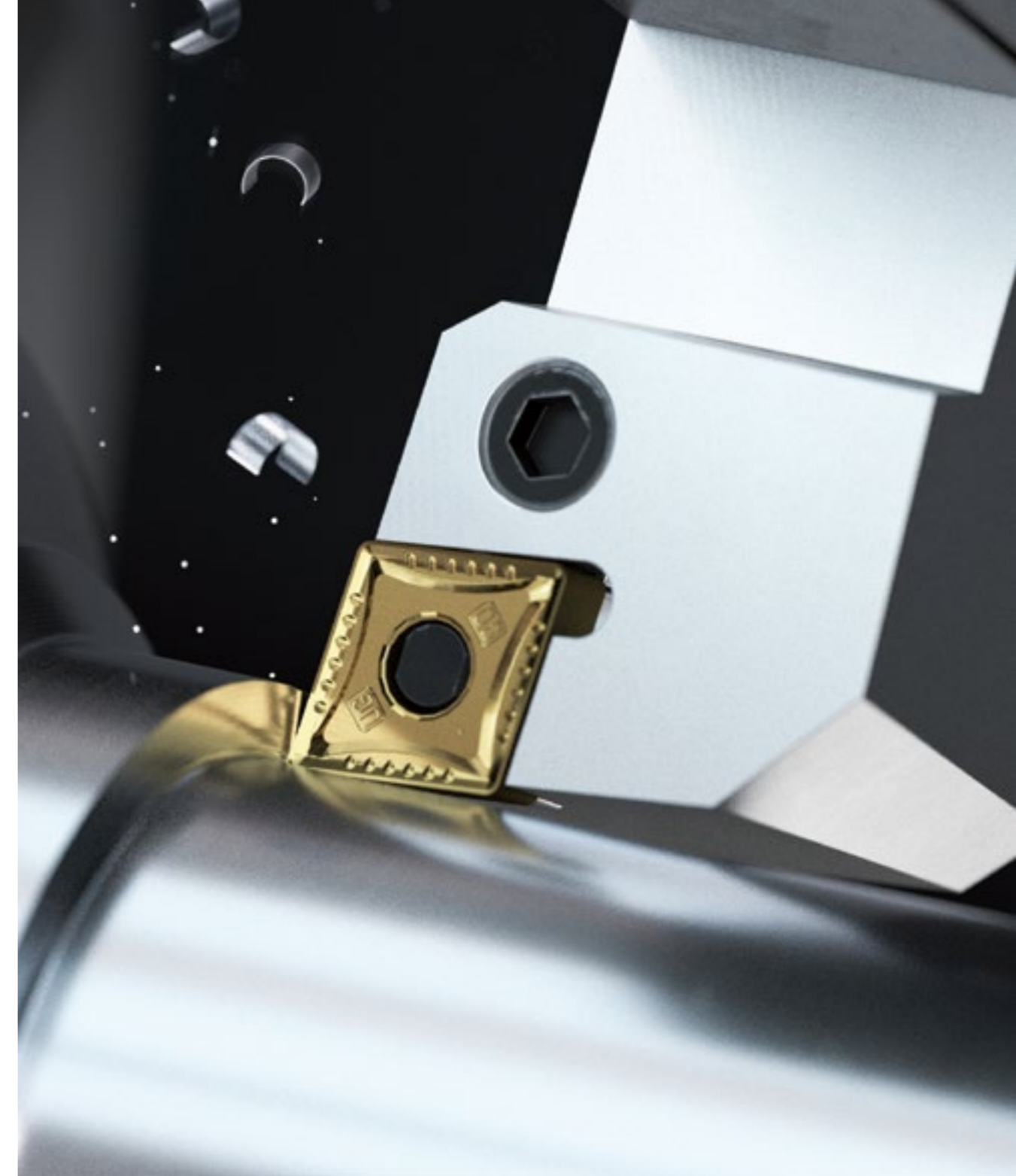
Heavy roughing



- ① Reinforced edge type with high rigidity and is suitable for irregular surface cutting
- ② Chip breaker is formed widely, suitable for heavy roughing application
- ③ Decoration dot reduces friction area and helps heat release
- ④ Insert corner radius range available from 1.2mm to 2.4mm



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# ISO TURNING

- Product Overview**
- Application Guide**
- Turning Inserts Overview**
- Turning Inserts**
- Turning Holders Overview**
- Turning Holders**

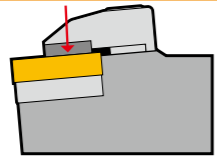
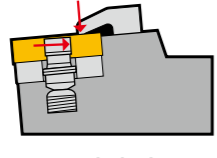
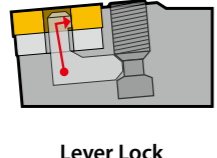
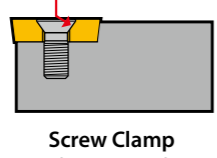



Scan this QR code to see our Turning Grades at work.

**External Turning Holder Code**

1	2	3	4	5	6	7	8	9	10
<b>P</b>	<b>C</b>	<b>L</b>	<b>N</b>	<b>R</b>	<b>25</b>	<b>25</b>	<b>M</b>	<b>12</b>	<b>(C)</b>
Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Shank Height (H)	Shank Width (B)	Length (LF)	Insert Size	(Optional Clamp)

**1 - Clamping System**

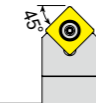
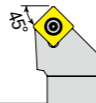



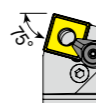
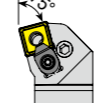
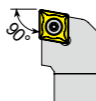
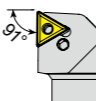
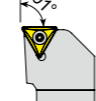
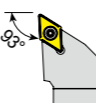
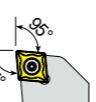

Symbol	System
<b>C</b>	 <b>Top Clamp</b> (No Clamping Hole Insert)
<b>M</b>	 <b>Multi lock</b> (Straight Clamping Hole Insert)
<b>P</b>	 <b>Lever Lock</b> (Straight Clamping Hole Insert)
<b>S</b>	 <b>Screw Clamp</b> (Screw Clamping Hole Insert)
<b>T (D, A)</b>	 <b>Double Clamp</b> (Straight Clamping Hole Insert)

**2, 4 - Insert Compatibility \***



\* Related to Insert Designation to check compatibility  
\* Refer to '1-shape' of page 20

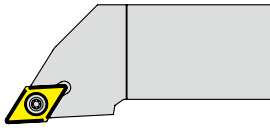
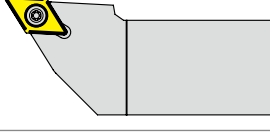
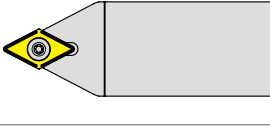
**3 - Tool Style**

Approach Angle (KAPR)	Side Direction		End Direction
	Straight Shank	Offset Shank	
45°	<b>D</b> 	<b>S</b> 	
60°		<b>T</b> 	
62.5°	<b>N</b> 		
72.5°	<b>V</b> 		
75°	<b>B</b> 		<b>K</b> 
90°/91°	<b>A</b> 	<b>G</b> 	<b>F</b> 
93°		<b>J</b> 	<b>U</b>
95°		<b>L (Both Direction)</b> 	
107.5°		<b>H</b> 	

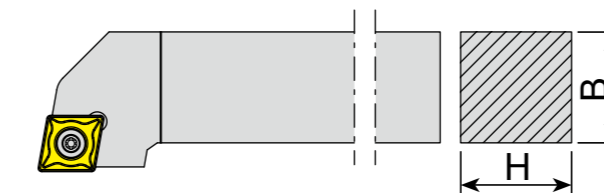
**External Turning Holder Code**

1	2	3	4	5	6	7	8	9
<b>S</b>	<b>D</b>	<b>J</b>	<b>C</b>	<b>R</b>	<b>20</b>	<b>20</b>	<b>K</b>	<b>11</b>
Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Shank Height (H)	Shank Width (B)	Length (LF)	Insert Size

**5 - Hand Direction**

Symbol	Hand Direction
<b>R</b>	Right Hand 
<b>L</b>	Left Hand 
<b>N</b>	Neutral 

**6, 7 - Shank Height (H) Shank Width (B)**



**8 - Length (LF)**

Symbol	Length (mm)	Symbol	Length (mm)
<b>E</b>	70	<b>Q</b>	180
<b>F</b>	80	<b>R</b>	200
<b>H</b>	100	<b>S</b>	250
<b>K</b>	125	<b>T</b>	300
<b>M</b>	150	<b>U</b>	350
<b>P</b>	170	<b>V</b>	400

**9 - Insert Size \***

Examples	is Compatible with...
<b>PCLNR 2525M 12</b>	<b>CNMG 1204**</b>
<b>SCLCR 2020K 09</b>	<b>CCMT 09T3**</b>
<b>TWLNR 2525M 08</b>	<b>WNMG 0804**</b>

\* Related to Insert Designation to check compatibility

**(10 - Optional Clamp)**

Symbol	Optional Clamp
<b>C</b>	<b>Included</b>

**Internal Turning Holder Code**

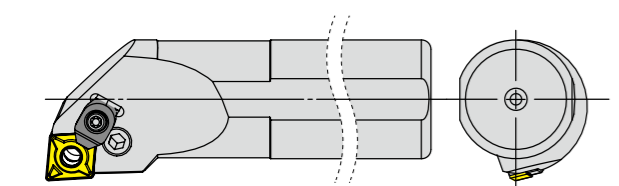
\*Metric

1	2	3	4	5	6	7	8	9	10	
<b>A</b>	<b>32</b>	<b>S</b>	<b>-</b>	<b>P</b>	<b>W</b>	<b>L</b>	<b>N</b>	<b>R</b>	<b>12</b>	<b>(C)</b>
Coolant & Material	Shank Diameter (DCON)	Legth (LF)	Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Insert Size	(Optional Clamp)	

**1 - Coolant and Tool Material**

Symbol	Internal Coolant	Tool Material
<b>A</b>	<b>O</b>	<b>Steel</b>
<b>S</b>	<b>X</b>	
<b>E</b>	<b>O</b>	<b>Carbide</b>
<b>C</b>	<b>X</b>	<b>Carbide</b>

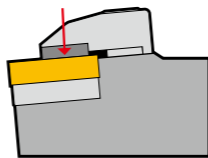
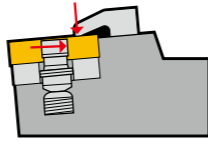
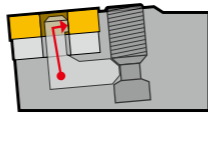
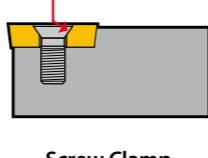

**2 - Shank Diameter (DCON)**



**3 - Length (LF)**

Symbol	Length (mm)	Symbol	Length (mm)
<b>E</b>	70	<b>Q</b>	180
<b>F</b>	80	<b>R</b>	200
<b>H</b>	100	<b>S</b>	250
<b>K</b>	125	<b>T</b>	300
<b>M</b>	150	<b>U</b>	350
<b>P</b>	170	<b>V</b>	400

**4 - Clamping System**

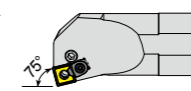
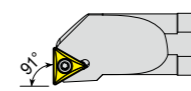
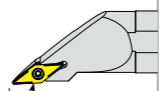
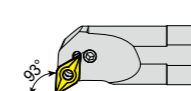
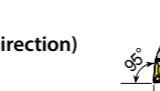
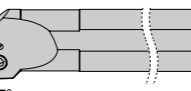
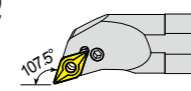
Symbol	System
<b>C</b>	 <b>Top Clamp</b> (No Clamping Hole Insert)
<b>M</b>	 <b>Multi lock</b> (Straight Clamping Hole Insert)
<b>P</b>	 <b>Lever Lock</b> (Straight Clamping Hole Insert)
<b>S</b>	 <b>Screw Clamp</b> (Screw Clamping Hole Insert)
<b>T</b> <b>(D, A)</b>	 <b>Double Clamp</b> (Straight Clamping Hole Insert)

**Internal Turning Holder Code**

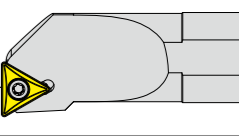
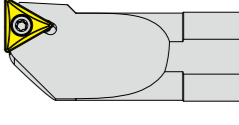
\*Metric

1	2	3	4	5	6	7	8	9	
<b>A</b>	<b>25</b>	<b>R</b>	<b>-</b>	<b>S</b>	<b>C</b>	<b>L</b>	<b>C</b>	<b>R</b>	<b>09</b>
Coolant & Material	Shank Diameter (DCON)	Legth (LF)	Clamping System	Insert Shape (1st Letter of Insert)	Tool Style	Insert Clearance (2nd Letter of Insert)	Tool Hand	Insert Size	

**6 - Tool Style**

Approach Angle (KA/PR)	Side Direction	End Direction
	Offset Shank	
75°		<b>K</b> 
91°		<b>F</b> 
93°	<b>J</b> 	<b>U</b> 
95°	<b>L</b> (Both Direction) 	
107.5°		<b>Q</b> 

**8 - Hand Direction**

Symbol	Hand Direction
<b>R</b>	Right Hand 
<b>L</b>	Left Hand 

**9 - Insert Size \***

Examples	is Compatible with...
<b>PCLNR 2525M 12</b>	<b>CNMG 1204**</b>
<b>SCLCR 2020K 09</b>	<b>CCMT 09T3**</b>
<b>TWLNLR 2525M 08</b>	<b>WNMG 0804**</b>

\* Related to Insert Designation to check compatibility

**5, 7 - Insert Compatibility \***



\* Related to Insert Designation to check compatibility  
\* Refer to '1-Shape' of page 20

**(10 - Optional Clamp)**

Symbol	Optional Clamp
<b>C</b>	<b>Included</b>

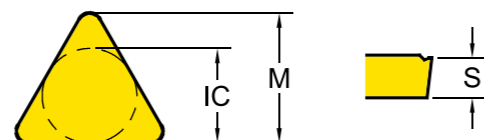
## Insert ISO Code System

\*Metric : According to ISO 1832

1	2	3	4	5	6	7	8	9
<b>C</b>	<b>N</b>	<b>M</b>	<b>G</b>	<b>12</b>	<b>04</b>	<b>08</b>	<b>-UG</b>	<b>YG3115</b>
Shape	Clearance	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

### 1 - Shape

Symbol	Shape	
<b>H</b>	Hexagonal	
<b>O</b>	Octagonal	
<b>P</b>	Pentagonal	
<b>S</b>	Square	
<b>T</b>	Triangular	
<b>C</b>	Rhombic 80°	
<b>D</b>	Rhombic 55°	
<b>V</b>	Rhombic 35°	
<b>W</b>	Trigon	
<b>L</b>	Rectangular	
<b>K</b>	Parallelogram 55°	
<b>R</b>	Round	



### 3 - Tolerance Class

Symbol	Inner Circle IC (mm)	Nose Height M (mm)	Thickness S (mm)
<b>C</b>	± 0.025	± 0.013	± 0.025
<b>E</b>	± 0.025	± 0.025	± 0.025
<b>G</b>	± 0.025	± 0.025	± 0.13
<b>H</b>	± 0.013	± 0.013	± 0.025
<b>K*</b>	± 0.05~0.15*	± 0.013	± 0.025
<b>M*</b>	± 0.05~0.15*	± 0.08~0.2*	± 0.13
<b>U*</b>	± 0.08~0.25*	± 0.13~0.38*	± 0.13

\*Tolerance is different by insert IC size. Please see ISO 1832

### 4 - Clamping & Chipbreaker

Symbol	Clamping	Chipbreaker	Figure
<b>N</b>	No clamping hole	X	
<b>R</b>		One Face	
<b>A</b>	Cylindrical Clamping hole	X	
<b>M</b>		One Face	
<b>G</b>		Both Faces	
<b>W</b>	Screw Hole	X	
<b>T</b>		One Face	
<b>U</b>		Both Faces	
<b>X</b>		Special	

### 2 - Relief Angle (AN)

Symbol	Relief Angle (AN)	
<b>N</b>	No Relief Angle	
<b>B</b>	Relief 5°	
<b>C</b>	Relief 7°	
<b>P</b>	Relief 11°	
<b>D</b>	Relief 15°	
<b>E</b>	Relief 20°	
<b>F</b>	Relief 25°	
<b>O</b>	Special	

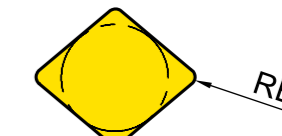
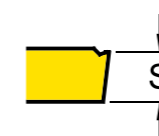
## Insert ISO Code System

\*Inch

1	2	3	4	5	6	7	8	9
<b>C</b>	<b>N</b>	<b>M</b>	<b>G</b>	<b>4</b>	<b>3</b>	<b>2</b>	<b>-UG</b>	<b>YG3115</b>
Shape	Clearance	Tolerance	Clamping & Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

### 5 - Insert Size

Metric							Inner Circle IC (mm)	Inch
S	T	C	D	V	W	R		
06	11	06	07	11			6.35	2
07	13	08	09	13	15		7.94	2.5
09	16	09	11	16	06	09 (00)	9.525	3
12	22	12	15	22	08	12 (00)	12.7	4
15	27	16	19	27	10		15.875	5
19	33	19	23	33	13		19.05	6
25		25					25.4	8
						06 (M0)	6	
						08 (M0)	8	
						10 (M0)	10	
						12 (M0)	12	
						16 (M0)	16	



### 6 - Insert Thickness (S)

Metric	Thickness - S (mm)	Inch
<b>T1</b>	1.98	<b>1.2</b>
<b>02</b>	2.38	<b>1.5</b>
<b>03</b>	3.18	<b>2</b>
<b>T3</b>	3.97	<b>2.5</b>
<b>04</b>	4.76	<b>3</b>
<b>05</b>	5.56	<b>3.5</b>
<b>06</b>	6.35	<b>4</b>
<b>07</b>	7.94	<b>5</b>
<b>09</b>	9.525	<b>6</b>

### 7 - Corner Radius (RE)

Metric	Corner Radius - RE (mm)	Inch
<b>01</b>	0.1	<b>03</b>
<b>02</b>	0.2	<b>05</b>
<b>04</b>	0.4	<b>1</b>
<b>08</b>	0.8	<b>2</b>
<b>12</b>	1.2	<b>3</b>
<b>16</b>	1.6	<b>4</b>
<b>20</b>	2.0	<b>5</b>
<b>24</b>	2.4	<b>6</b>

## Grade Naming System

1	2	3	4	5	(6)
<b>YG</b>	<b>3</b>	<b>1</b>	<b>1</b>	<b>5</b>	<b>(G)</b>
YG Brand	Workpiece Material	Grade Version	Application Range (1st Digit)	Application Range (2nd Digit)	Minor Variation
Carbide CVD (4 Digits)	●	●	●	●	<b>YG3115</b>
Carbide PVD (3 Digits)	●	●	●		<b>YG211</b>
Carbide Uncoated (2 Digits)	●	●			<b>YG10</b>

### 1 - YG Brand

### 2 - Workpiece Material

Symbol	Workpiece Material	Turning	Milling	Drilling	Parting
<b>1</b>	<b>K</b> Cast Iron or <b>N</b> Non-Ferrous	●			
<b>2</b>	<b>M</b> Stainless Steel	●			
<b>3</b>	<b>P</b> Steel	●			
<b>4</b>	<b>S</b> Superalloys	●			
<b>5</b>	<b>K</b> Cast Iron or <b>N</b> Non-Ferrous		●	●	●
<b>6</b>	<b>M</b> Stainless Steel or <b>Universal</b>		●	●	●
<b>7</b>	<b>P</b> Steel		●	●	●
<b>8</b>	<b>Universal</b>	●			
<b>0</b>	<b>Hardened Steel</b>		●		

### 3 - Grade Version

### 4 & 5 - Application Range

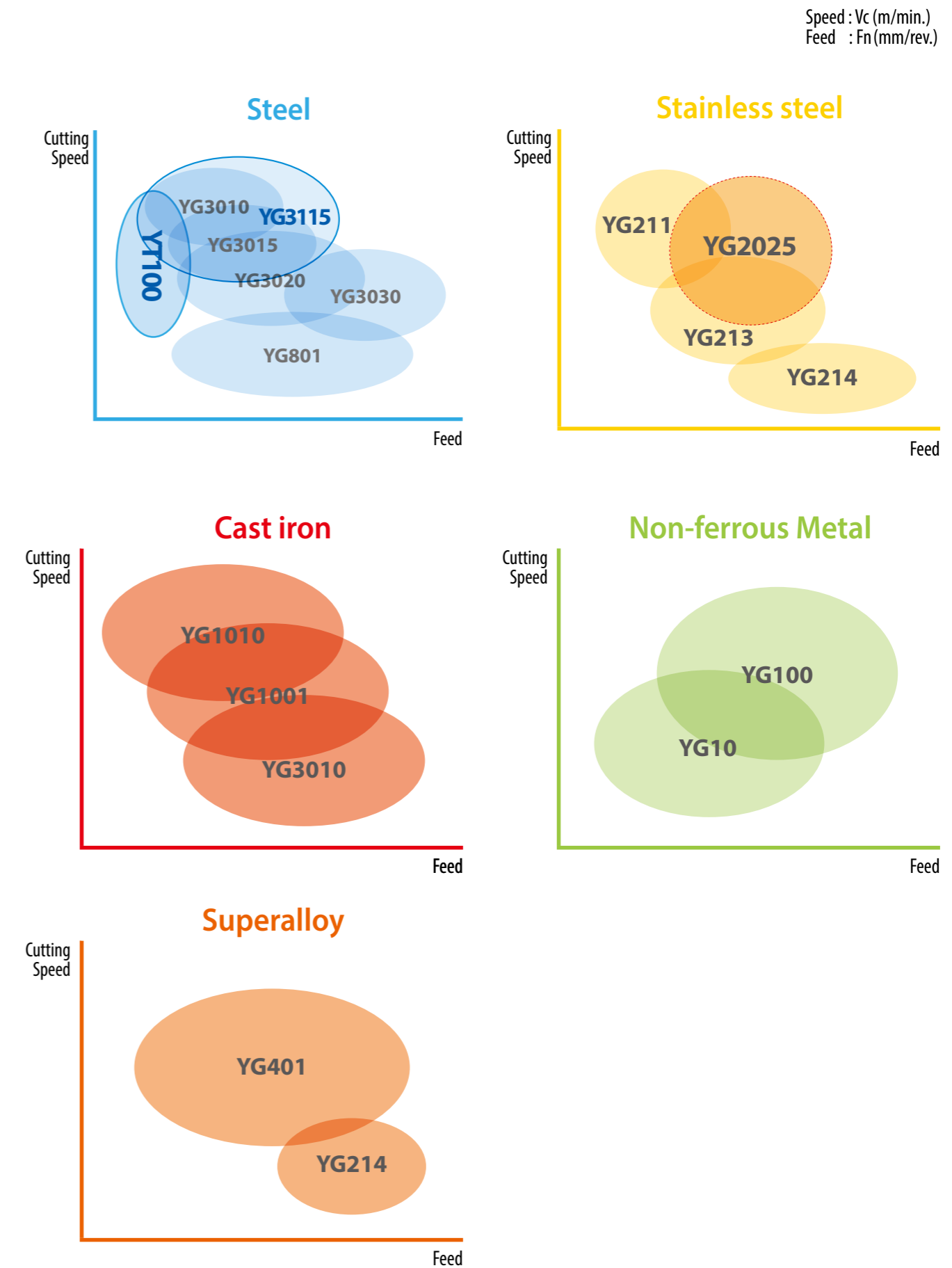
Symbol	Description
<b>05</b>	<b>Stable</b> Wear Resistant Grade Stable Application Continuous Cut Finishing
<b>10</b>	
<b>15</b>	
<b>20</b>	
<b>25</b>	
<b>25</b>	<b>General</b> Balanced Grade High Versatility General Application
<b>30</b>	
<b>35</b>	
<b>40</b>	
<b>45</b>	
	<b>Unstable</b> Tougher Grade Unstable Application Interrupted Cut Chipping Resistance Roughing

### (6) - (Minor Variation)

G - Gold Coated Version

## Product Overview

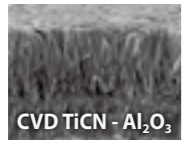
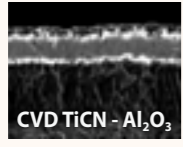
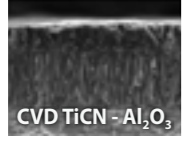


## Turning Grades Map



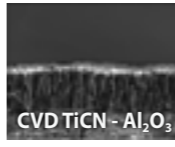
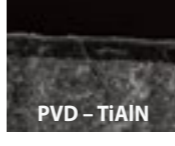



Product Overview  
**Turning Grades**

Turning Grades	P Steel				M Stainless steel			K Cast iron			N Non-ferrous		S Superalloys	
	P10	P20	P30	P40	M10	M20	M30	K10	K20	K30	N10	N20	S10	S20
CVD	YG1010							1010						
	YG1001	1001						1001						
	YG3010	3010						3010						
	YG3015	3015												
	YG3115	3115												
	YG3020	3020												
	YG3030	3030												
PVD	YG2025					2025								
	YG801	801												
	YG211					211								
	YG213					213								
	YG214					214							214	
Cermet	YG401												401	
	YT100	YT100				YT100		YT100						
DLC	YG100										100			
	YG10										10			

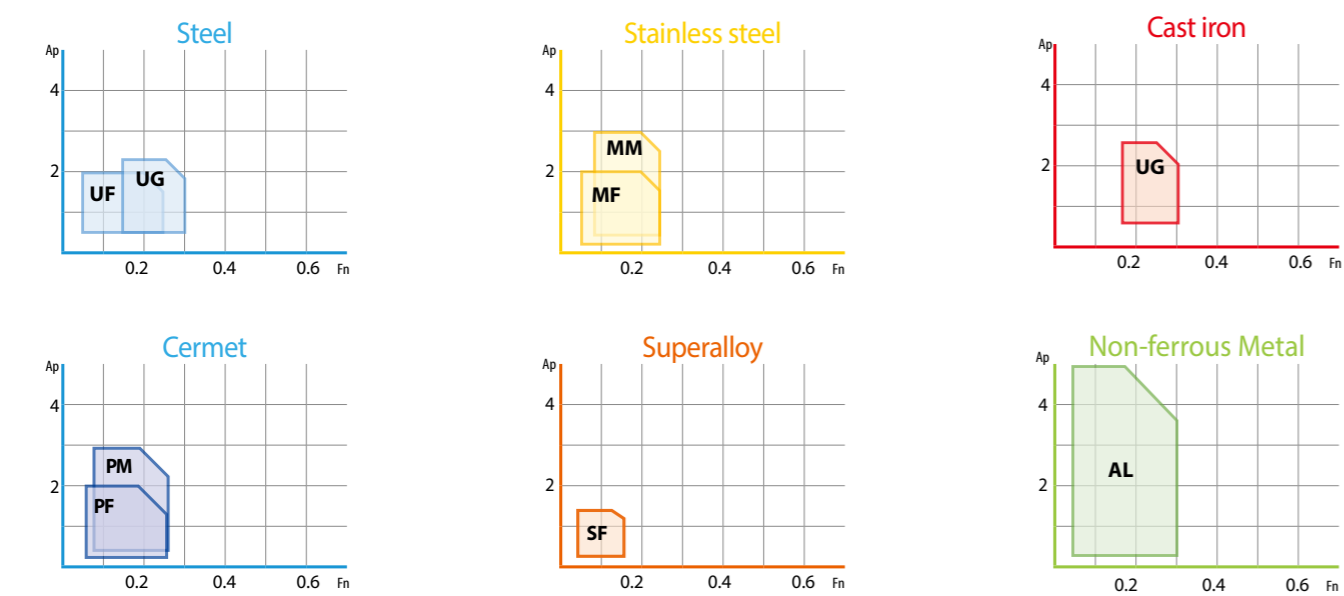
<b>YG1010</b> K05 - K15		<b>First Choice for Cast Iron</b> • Effective coating structure enables high speed machining • Special post treatment for improved chipping resistance
<b>YG1001</b> P01 - P10 K10 - K25		<b>Stable Machining of Cast Iron</b> • Substrate especially designed for high wear resistance • Thick Al <sub>2</sub> O <sub>3</sub> layer ensures good wear resistance at high cutting speeds including dry machining
<b>YG3010</b> P05 - P20 K15 - K35		<b>First choice for Finishing Steels, and Ductile Cast iron</b> • Finishing and light machining of steel under in stable condition • New Al <sub>2</sub> O <sub>3</sub> coating technology and excellent surface smoothness increase wear resistance and chipping resistance
<b>YG3015</b> P10 - P25		<b>Balanced Productivity for Continuous cut</b> • High wear resistance and improved toughness ensures high productivity with less trouble
<b>NEW YG3115</b> P15 - P25		<b>First choice grade for high cutting speed in Steels</b> • Suitable for mass production due to stable and predictable tool life • Minimizing built up edge due to new post surface treatment in mild steels, low carbon steel and low carbon alloy steel. • Best choice for both continuous as well as interrupted cuts

Product Overview  
**Turning Grades**

<b>YG3020</b> P15 - P30		<b>First Choice Grade for General Steel Application</b> • Substrate especially designed for good toughness • Excellent surface smoothness increases wear resistance and reliability
<b>YG3030</b> P20 - P35		<b>Interrupted Cutting of Steel and Stainless steel</b> • Substrate for heavy roughing in mild steel and low carbon alloy steel • New Al <sub>2</sub> O <sub>3</sub> technology and optimized surface treatment achieves a good balance between wear resistance and chipping resistance
<b>YG801</b> P10 - P30		<b>for Carbon Steel with Low Cutting Speed</b> • Recommended for mild steel and boring application • Substrate and special PVD coating for excellent wear resistance
<b>NEW YG2025</b> M15 - M35		<b>CVD grade for High Cutting Speed for Stainless steel</b> • Utilizing a new carbide substrate and new coating • Excellent combination of wear resistance and chipping resistance • Minimized built up edge due to post surface treatment
<b>YG211</b> M05 - M25		<b>High wear Resistance Grade for Stainless steel</b> • Finishing Stainless steel
<b>YG213</b> M20 - M35		<b>First Choice Grade on Low Cutting Speed of Stainless steel</b> • First choice on Stainless steel for Low cutting speed • For Medium to low cutting speed
<b>YG214</b> M30 - M40 S25 - S30		<b>Heavy Interrupted cut for Stainless steel</b> • For Heavy Interrupted cut on Stainless steel • Minimize risk of Mechanical fracture or Chipping
<b>YG401</b> S10 - S20		<b>PVD Turning Grade for HRSA</b> • Highly heat-resistant TiAlSiN structure for excellent wear resistance • Greatly improved film coating realizes excellent boundary defect resistance • Top coating layer provides a smooth surface and lubricant effect
<b>NEW YT100</b> P10 - P20 M10 - M20 K10 - K20		<b>New Generation Cermet Grade</b> • Enhanced wear resistance & chipping resistance • Excellent fracture resistance • Superior surface finish with special edge preparation
<b>YG100</b> N05 - N25		<b>First Choice Grade for Aluminum with DLC Coating</b> • Submicron carbide for high wear resistance • DLC coating minimizes Built Up Edge tendency. • Improve tool life in sticky non-ferrous alloy
<b>YG10</b> N05 - N25		<b>Uncoated Grade for General Aluminum</b> • Substrate consisted of submicron carbide for high wear resistance • Shining surface to prevent built up edge

**Turning Chipbreakers - Positive**

P	M	K	N	S	Material	Application	Feed	
							Fn (mm/rev.)	Ap (mm)
			N		AL	Aluminum application 28°	0.02~0.30	0.1~5.0
P	M				UF	Finishing application 10°	0.05~0.25	0.5~2.0
P		K			UG	Medium application 0.15	0.15~0.30	0.5~2.5
	M				NEW MF	Stainless steel Finishing 6°	0.06~0.25	0.1~2.0
	M				NEW MM	Stainless steel Medium 18°/6°/0.12	0.08~0.25	0.25~3.0
	M				NEW SF	HRSA Finishing 18°	0.03~0.20	0.1~2.5
P	M	K			NEW PF	Cermet Finishing 6°	0.06~0.25	0.1~2.0
P	M	K			NEW PM	Cermet Medium 18°/6°/0.12	0.08~0.25	0.25~3.0



\*Insert : CCMT09T304

Click/Touch each page number and move to the very page!

**Turning Inserts Overview**

**Negative Inserts**

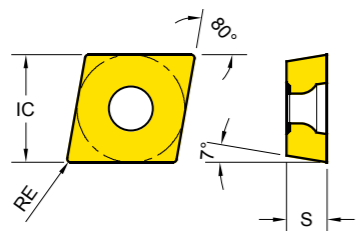
Recommended Cutting Conditions : p.222

Shape	Series	Size & Thickness				Page	
		0903	0904	1204	1606 1906		
C	CNMA			1204	1606 1906	30	
	CNMG	0903	0904	1204	1606 1906		
	CNGG			1204			
	CNMM			1204	1606 1906		
D	DNMA			1504 1506		35	
	DNMG		1104	1504 1506			
	DNGG			1504 1506			
	DNMM			1506			
	DNUX			1504 1506		40	
K	KNUX				1604	41	
S	SNMA			1204	1506	1906	42
	SNMG	0903		1204		1906	
	SNMM				1506	1906 2507 2509	
T	TNMA				1604		47
	TNMG				1604	2204	
	TNGG				1604		
	TNUX				1604		50
V	VNMA				1604		51
	VNMG				1604		
W	WNMA			0804			53
	WNGG			0804			
	WVNG	0604		0804			

**Positive Inserts**

Shape	Series	Size & Thickness				Page
		0602	0702	0803 10T3	1204	
C	CCGT	0602		09T3	1204	57
	CCMT	0602		09T3	1204	
D	DCGT		0702		11T3	59
	DCMT		0702		11T3	
R	RCMT	0602	0803	10T3	1204	61
	RCMX					1606 2006
S	SCGT			09T3		63
	SCMT			09T3	1204	
T	TCGT			1102	16T3	64
	TCMT			1102	16T3	
V	VBGT / VBMT			1103	1604	66
	VCGT / VCMT			1103	1604	67

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



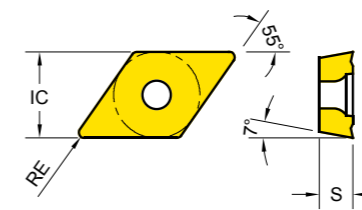
Series	IC	S
CC** 0602	6.350	2.38
CC** 09T3	9.525	3.97
CC** 1204	12.700	4.76

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

K10	P05	P10	P15	P20	P30	P20	M25	M15	M30	M40	S10	P15	M15	N20	N20
K20	K30									S30		K15			

CCGT CCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG3010	YG3015	YG3115	YG3020	YG3030	YG801	YG2025	YG211	YG213	YG214	YG401	YT100	YG100	YG10	
	CCGT 060201 - SF	0.1	0.02~0.15	0.10~1.5													●	●			
	CCGT 060202 - SF	0.2	0.02~0.15	0.10~1.5													●	●			
<b>NEW</b> -SF	CCGT 060204 - SF	0.4	0.03~0.20	0.10~2.4													●	●			
	CCGT 09T301 - SF	0.1	0.02~0.15	0.10~2.5													●	●			
	CCGT 09T302 - SF	0.2	0.02~0.15	0.10~2.5													●	●			
	CCGT 09T304 - SF	0.4	0.03~0.20	0.10~2.5													●	●			
	CCGT 09T308 - SF	0.8	0.03~0.25	0.10~2.5													●	●			
<b>NEW</b> -MF	CCMT 060208 - MF	0.8	0.05~0.20	0.08~2.0													●	●			
	CCMT 09T302 - MF	0.2	0.04~0.15	0.08~2.0													●	●			
	CCMT 09T304 - MF	0.4	0.06~0.25	0.10~2.0													●	●			
	CCMT 09T308 - MF	0.8	0.08~0.30	0.15~2.0													●	●			
<b>NEW</b> -MM	CCMT 09T304 - MM	0.4	0.08~0.25	0.25~3.0													●	●			
	CCMT 09T308 - MM	0.8	0.10~0.30	0.50~3.0													●	●			
<b>NEW</b> -PF	CCMT 09T302 - PF	0.2	0.04~0.15	0.08~2.0													●	●			
	CCMT 09T304 - PF	0.4	0.06~0.25	0.10~2.0													●	●			
	CCMT 09T308 - PF	0.8	0.08~0.30	0.15~2.0													●	●			
<b>NEW</b> -PM	CCMT 09T304 - PM	0.4	0.08~0.25	0.25~3.0													●	●			
	CCMT 09T308 - PM	0.8	0.10~0.30	0.50~3.0													●	●			

Turning Inserts - Positive  
DCGT / DCMT (55° Rhombic)



Series	IC	S
DC** 0702	6.350	2.38
DC** 11T3	9.525	3.97

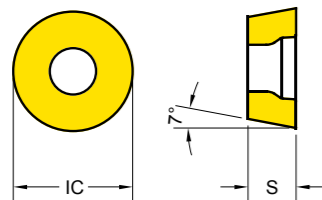
EDP 2200.. ●: Stock item ○: Order made item

K10	P05	P10	P15	P20	P30	P20	M25	M15	M30	M40	S10	P15	M15	N20	N20
K20	K30									S30		K15			

DCGT DCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG3010	YG3015	YG3115	YG3020	YG3030	YG801	YG2025	YG211	YG213	YG214	YG401	YT100	YG100	YG10	
	DCGT 070202 - AL	0.2	0.01~0.20	0.05~3.0																	●
	DCGT 070204 - AL	0.4	0.02~0.30	0.10~4.0																	●
<b>-AL</b>	DCGT 11T301 - AL	0.1	0.01~0.30	0.05~4.0																	●
	DCGT 11T302 - AL	0.2	0.02~0.30	0.05~4.0																	●
	DCGT 11T304 - AL	0.4	0.03~0.50	0.10~5.0																	●
	DCGT 11T308 - AL	0.8	0.03~0.50	1.00~5.0																	●
<b>-UF</b>	DCMT 070204 - UF	0.4	0.05~0.20	0.50~2.0			○	●	●	●				○		○					●
	DCMT 11T304 - UF	0.4	0.05~0.25	0.50~2.0			○	●	●	●				○		○					●
	DCMT 11T308 - UF	0.8	0.05~0.25	1.00~2.0	●		○	●	●	●				○		○					●
<b>-UG</b>	DCMT 070204 - UG	0.4	0.10~0.25	0.50~2.0	●	○		●	●	●	○										●
	DCMT 070208 - UG	0.8	0.10~0.25	0.80~2.0	●	○		●	●	●	○										●
	DCMT 11T304 - UG	0.4	0.15~0.30	0.50~2.5	●	○	○	●	●	●	○						○	○	○		●
	DCMT 11T308 - UG	0.8	0.15~0.30	0.80~2.5	●	○	○	●	●	●	○						○	○	○		●
	DCMT 11T312 - UG	1.2	0.15~0.35	1.50~3.0				●	●												●



## Turning Inserts - Positive RCMX - Heavy Turning (Round)



Series	IC	S
RC** 1606	16	6.35
RC** 2006	20	6.35

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

K10	P05	P10	P15	P20	P30	P20	M25	M15	M30	M40	S10	P15	M15	N20	N20
K20	K30									S30		K15			

RCMX	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG3010	YG3015	YG3115	YG3020	YG3030	YG801	YG2025	YG211	YG213	YG214	YG401	YT100	YG100	YG10	
Heavy Roughing	RCMX 1606M0 - UT	8.0	0.30~0.80	1.0~7.0	● 2441																
	RCMX 2006M0 - UT	10.0	0.5~1.3	1.5~9.0					● 2169												

TURNING

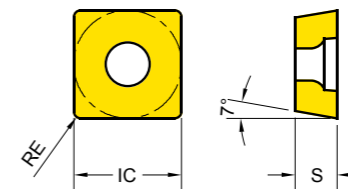
PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

## Turning Inserts - Positive SCGT / SCMT (Square)



Series	IC	S
SC** 09T3	9.525	3.97
SC** 1204	12.700	4.76

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

K10	P05	P10	P15	P20	P30	P20	M25	M15	M30	M40	S10	P15	M15	N20	N20
K20	K30									S30		K15			

SCGT SCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	YG1010	YG1001	YG3010	YG3015	YG3115	YG3020	YG3030	YG801	YG2025	YG211	YG213	YG214	YG401	YT100	YG100	YG10		
Aluminium	SCGT 09T304 - AL	0.4	0.03~0.40	0.1~5.0																	● 1516	
	SCGT 09T308 - AL	0.8	0.04~0.40	0.1~5.0																		● 1517
Finishing	SCMT 09T304 - UF	0.4	0.05~0.25	0.5~2.0			○ 0386		● 2628	● 0387	● 0783											
	SCMT 09T308 - UF	0.8	0.05~0.25	1.0~2.0	● 2083		○ 1021		● 2629	● 1022	● 0997											
General	SCMT 09T304 - UG	0.4	0.15~0.30	0.5~2.5	● 1834	○ 0455	○ 0482		● 2414	● 0916	● 1171	○ 0025										
	SCMT 09T308 - UG	0.8	0.15~0.30	0.8~2.5	● 1835	○ 0456	○ 0159		● 2383	● 0160	● 0161	○ 0026					○ 1904					
	SCMT 120408 - UG	0.8	0.15~0.35	0.8~3.0	● 1836	○ 0674	○ 0255		● 2393	● 0256	● 0257						○ 1911					
	SCMT 120412 - UG	1.2	0.15~0.35	1.5~3.0	● 2098																	
Stainless steel Finishing	SCMT 09T308 - MF	0.8	0.09~0.35	0.3~2.0																		● 2564
Stainless steel Medium	SCMT 120408 - MM	0.8	0.10~0.30	0.6~4.0													● 2519	● 1973	● 1974	● 1975	● 1976	
Cermet Medium	SCMT 120408 - PM	0.8	0.10~0.30	0.6~4.0																		● 2530

TURNING

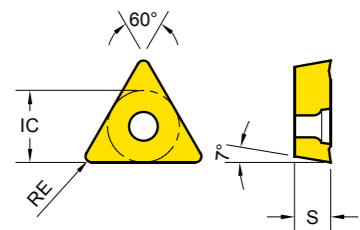
PARTING & GROOVING

MILLING

DRILLING

TECHNICAL INFORMATION

### Turning Inserts - Positive TCGT / TCMT (Triangle)

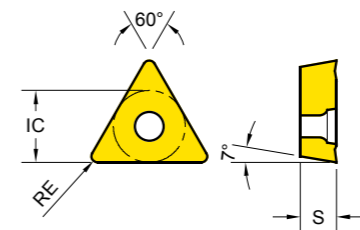


Series	IC	S
TC** 1102	6.350	2.38
TC** 16T3	9.525	3.97

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

TCGT TCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1010	YG1001	YG3010	YG3015	YG3115	YG3020	YG3030	YG801	YG2025	YG211	YG213	YG214	YG401	YT100	YG100	YG10
<b>-AL</b> Aluminum	TCGT 110204 -AL	0.4	0.03~0.30	0.10~4.0																●
	TCGT 16T302 -AL	0.2	0.02~0.30	0.05~5.0																● ●
	TCGT 16T304 -AL	0.4	0.03~0.40	0.10~5.5																● ● ●
	TCGT 16T308 -AL	0.8	0.03~0.50	0.10~5.5																● ● ● ●
<b>-UF</b> Finishing	TCMT 110204 -UF	0.4	0.05~0.20	0.5~2.0		○		● ● ●					○ ○ ○							
	TCMT 16T304 -UF	0.4	0.05~0.25	0.5~2.0		○		● ● ●	○				○ ○ ○							
	TCMT 16T308 -UF	0.8	0.05~0.25	0.8~2.0		○		● ● ●	○											
<b>-UG</b> General	TCMT 110204 -UG	0.4	0.10~0.25	0.5~2.0	● ○ ○			● ● ● ○												
	TCMT 110208 -UG	0.8	0.10~0.25	0.8~2.0	●	○		● ● ●												●
	TCMT 16T304 -UG	0.4	0.15~0.30	0.5~2.5	● ○ ○			● ● ●												●
	TCMT 16T308 -UG	0.8	0.15~0.30	0.8~2.5	● ○ ○			● ● ●	○					○						●

### Turning Inserts - Positive TCMT (Triangle)



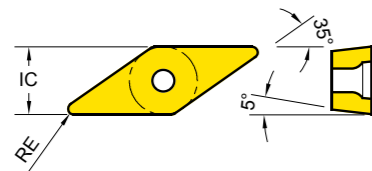
Series	IC	S
TC** 1102	6.350	2.38
TC** 16T3	9.525	3.97

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

TCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	EDP 2200..															
					YG1010	YG1001	YG3010	YG3015	YG3115	YG3020	YG3030	YG801	YG2025	YG211	YG213	YG214	YG401	YT100	YG100	YG10
<b>-MF</b> Stainless steel Finishing	TCMT 110204 -MF	0.4	0.07~0.20	0.20~2.0																●
	TCMT 110208 -MF	0.8	0.07~0.20	0.30~2.0																●
<b>-MM</b> Stainless steel Medium	TCMT 16T304 -MF	0.4	0.06~0.25	0.10~2.0																● ● ● ●
	TCMT 16T308 -MF	0.8	0.08~0.30	0.15~2.0																● ● ● ● ●
<b>-PM</b> Cermet Medium	TCMT 16T304 -PM	0.4	0.08~0.25	0.25~3.0																●
	TCMT 16T308 -PM	0.8	0.10~0.30	0.50~3.0																●
<b>-PF</b> Cermet Medium	TCMT 16T304 -PF	0.4	0.06~0.25	0.10~2.0																●
	TCMT 16T308 -PF	0.8	0.08~0.30	0.15~2.0																●
<b>-PM</b> Cermet Medium	TCMT 16T304 -PM	0.4	0.08~0.25	0.25~3.0																●
	TCMT 16T308 -PM	0.8	0.10~0.30	0.50~3.0																●

### Turning Inserts - Positive VBGT / VBMT (35° Rhombic)

Series	IC	S
VB** 1103	6.350	3.18
VB** 1604	9.525	4.76

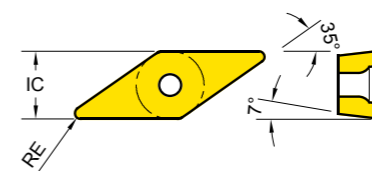


EDP 2200.. ● : Stock item ○ : Order made item

VBGT VBMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05	P10	P15	P10	P20	P30	P20	M25	M15	M30	M40	S10	P15	M15	N20	N20				
					K20	K30	P15	P10	P20	P30	P20	M25	M15	M30	M40	S30	K15	N20	N20						
<b>NEW</b> -SF HRSA Finishing	VBGT 110301 - SF	0.1	0.01 ~ 0.20	0.10 ~ 1.5																		●			
	VBGT 110302 - SF	0.2	0.02 ~ 0.20	0.10 ~ 1.5																				●	
	VBGT 110304 - SF	0.4	0.05 ~ 0.20	0.20 ~ 1.5																					●
	VBGT 160404 - SF	0.4	0.05 ~ 0.20	0.20 ~ 2.0																					●
<b>-UF</b> Finishing	VBMT 110304 - UF	0.4	0.04 ~ 0.16	0.10 ~ 0.8																				●	
	VBMT 110308 - UF	0.4	0.04 ~ 0.16	0.40 ~ 1.0																				●	
	VBMT 160404 - UF	0.4	0.05 ~ 0.25	0.50 ~ 2.0			○																	○	
	VBMT 160408 - UF	0.8	0.05 ~ 0.25	0.80 ~ 2.0			○																	○	
<b>-UG</b> General	VBMT 160404 - UG	0.4	0.15 ~ 0.30	0.50 ~ 2.5	●	○	○																	○	
	VBMT 160408 - UG	0.8	0.15 ~ 0.30	0.80 ~ 2.5	●	○	○																	○	
<b>NEW</b> -MF Stainless steel Finishing	VBMT 160402 - MF	0.2	0.04 ~ 0.15	0.10 ~ 2.0												●	●	●	●	●				●	
	VBMT 160404 - MF	0.4	0.05 ~ 0.20	0.20 ~ 2.0												●	●	●	●	●				●	
	VBMT 160408 - MF	0.8	0.07 ~ 0.27	0.30 ~ 2.0												●	●	●	●	●				●	
<b>NEW</b> -MM Stainless steel Medium	VBMT 160404 - MM	0.4	0.07 ~ 0.21	0.25 ~ 2.7												●	●	●	●	●				●	
	VBMT 160408 - MM	0.8	0.08 ~ 0.27	0.50 ~ 2.7												●	●	●	●	●				●	
<b>NEW</b> -PF Cermet Medium	VBMT 160402 - PF	0.2	0.04 ~ 0.15	0.10 ~ 2.0																				●	
	VBMT 160404 - PF	0.4	0.05 ~ 0.20	0.20 ~ 2.0																				●	
	VBMT 160408 - PF	0.8	0.07 ~ 0.27	0.30 ~ 2.0																				●	
<b>NEW</b> -PM Cermet Medium	VBMT 160404 - PM	0.4	0.07 ~ 0.21	0.25 ~ 2.7																				●	
	VBMT 160408 - PM	0.8	0.08 ~ 0.27	0.50 ~ 2.7																				●	

### Turning Inserts - Positive VCGT / VCMT (35° Rhombic)

Series	IC	S
VC** 1103	6.350	3.18
VC** 1604	9.525	4.76



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

VCGT VCMT	Designation	RE	Fn (mm/rev.)	Ap (mm)	K10	P05	P10	P15	P10	P20	P30	P20	M25	M15	M30	M40	S10	P15	M15	N20	N20			
					K20	K30	P15	P10	P20	P30	P20	M25	M15	M30	M40	S30	K15	N20	N20					
<b>-AL</b> Aluminum	VCGT 110301 - AL	0.1	0.02 ~ 0.15	0.05 ~ 3.0																				●
	VCGT 110302 - AL	0.2	0.02 ~ 0.20	0.05 ~ 3.0																				●
	VCGT 110304 - AL	0.4	0.02 ~ 0.25	0.10 ~ 4.0																				●
	VCGT 160402 - AL	0.2	0.02 ~ 0.30	0.05 ~ 5.0																				●
	VCGT 160404 - AL	0.4	0.03 ~ 0.40	0.10 ~ 5.0																				●
	VCGT 160408 - AL	0.8	0.03 ~ 0.50	0.10 ~ 5.0																				●
<b>NEW</b> -SF HRSA Finishing	VCGT 160412 - AL	1.2	0.03 ~ 0.50	0.10 ~ 5.0																			●	
	VCGT 110301 - SF	0.1	0.01 ~ 0.20	0.1 ~ 1.5																				●
	VCGT 110302 - SF	0.2	0.02 ~ 0.20	0.1 ~ 1.5																				●
	VCGT 110304 - SF	0.4	0.05 ~ 0.20	0.2 ~ 1.5																				●
<b>-UF</b> Finishing	VCGT 110308 - SF	0.8	0.05 ~ 0.20	0.4 ~ 1.5																				●
	VCGT 160404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2.0			○																	○
<b>-UG</b> General	VCGT 160408 - UF	0.8	0.05 ~ 0.25	1.0 ~ 2.0			○																	○
	VCMT 160404 - UF	0.4	0.05 ~ 0.25	0.5 ~ 2.0			○																	○
<b>-UF</b> Finishing	VCMT 160408 - UF	0.8	0.05 ~ 0.25	1.0 ~ 2.0			○																	○
	VCMT 160404 - UG	0.4	0.10 ~ 0.20	0.3 ~ 2.5																				○
<b>-UG</b> General	VCMT 160408 - UG	0.8	0.15 ~ 0.30	0.8 ~ 2.5			○																	○
	VCMT 110304 - MF	0.4	0.05 ~ 0.20	0.1 ~ 1.7																				○
<b>NEW</b> -MF Stainless steel Finishing	VCMT 160402 - MF	0.2	0.04 ~ 0.15	0.10 ~ 2.0																				●
	VCMT 160404 - MF	0.4	0.05 ~ 0.20	0.20 ~ 2.0																				●
<b>NEW</b> -PF Cermet Medium	VCMT 110304 - PF	0.4	0.05 ~ 0.20	0.1 ~ 1.7																				●
	VCMT 160408 - PF	0.8	0.07 ~ 0.27	0.30 ~ 2.0																				●



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