



PARTING & GROOVING

Parting & Grooving Inserts Overview

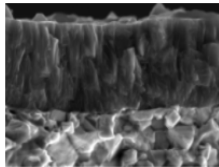
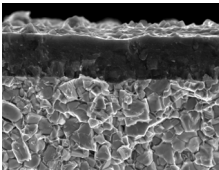
Parting & Grooving Inserts

Parting & Grooving Holders

Parting & Grooving Overview

Parting & Groove Turn Grades

Parting and Grooving Grades		P Steel				M Stainless steel				K Cast iron			N Non Ferrous		S Super Alloy	
		P10	P20	P30	P40	M10	M20	M30	M40	K10	K20	K30	N10	N20	S10	S20
PVD	YG602G (YG602)		602G				602G			602G					602G	
	YG603							603								

YG602G (YG602) P20 - P35 M20 - M40 K20 - K40 S15 - S25	PVD - TiAlN 	Universal grade for Parting & Groove Turn - Ultra Dense PVD Coating with optimal thermal resistance & strength - Sub-Micron substrate designed for demanding application - YG602G : First Choice for Low Cutting Speed, Soft and Sticky Material with Low Hardness (Gold Color) - YG602 : First Choice for General Application (Violet Color)
YG603 M30 - M50	PVD - TiAlN 	PVD Parting & Grooving Grade for Stainless Steel - Ultra high toughness substrate and strong adhesion - Excellent cutting edge strength and chipping resistance - Stable machinability and tool life for stainless steel

Parting & Grooving Inserts

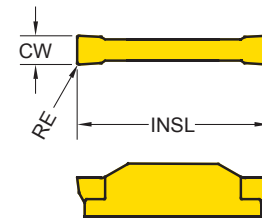
	TD. Series	Inserts	2, 3, 4, 5, 6, 8
		TDN, TDP, TDY	

Parting & Grooving Chipbreakers

Parting & Grooving	-P			- For Parting & Grooving - For Low Feed Rate and Difficult to Cut Materials
	-N			- For External Parting And Grooving - For General Use
Turning & Grooving	-Y			- For External Turning & Grooving - For Medium feed rate
	GL			- For External, Internal turning and Grooving - Face grooving and Face turning - For low feed rate
	GM			- For External, Internal turning and Grooving - First choice Face Grooving and Face turning - For Medium feed rate
	RG			- For External, Internal turning and Grooving - Full radius Insert for Profiling

Parting & Grooving Inserts

Recommended Cutting Conditions : p.190

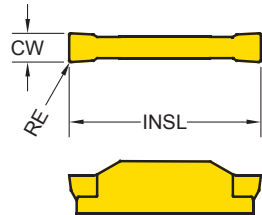


Series	INSL	CW	Series	INSL	CW
TD * 2	.787	.079	TD * 5	.984	.197
TD * 3	.787	.118	TD * 6	.984	.236
TD * 4	.787	.157	TD * 8	1.181	.315

* CDX : Cutting Depth Maximum

● : Stock item ○ : Order made item

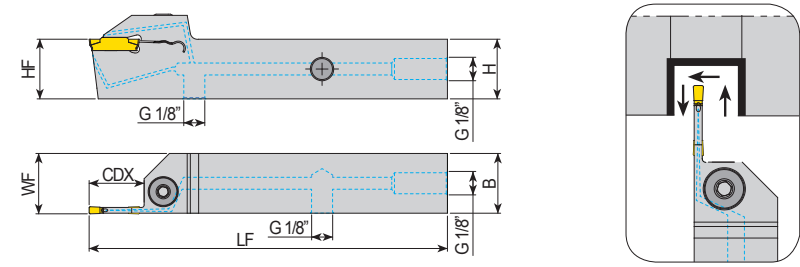
TD.	Designation	RE (In)	Parting & Grooving		Turning		EDP 5200..		
			Fn (In/rev.)	CDX (In)	Fn (In/rev.)	Ap	YG602	YG602G	YG603
-P	 Parting & Grooving (Sharp edge)	TDP 2002	.008	.002 ~ .005	.748	-	-	● 0012	○ 0036 ● 0078
		TDP 3002	.008	.002 ~ .006	.748	-	-	● 0029	○ 0030 ● 0076
		TDP 4003	.012	.002 ~ .007	.748	-	-	● 0023	○ 0038 ● 0080
		TDP5003	.012	.002 ~ .008	.945	-	-	● 0142	○ 0143 ● 0144
	 Parting & Grooving Right Hand Shown (Sharp edge) *  6° Angled Parting	TDP6003	.012	.002 ~ .009	.945	-	-	● 0145	○ 0146 ● 0147
		* TDPR 2002 - 6	.008	.001 ~ .003	.748	-	-	● 0045	○ 0085
		* TDPR 3002 - 6	.008	.002 ~ .005	.748	-	-	● 0048	○ 0089
		* TDPL 2002 - 6	.008	.001 ~ .003	.748	-	-	● 0046	○ 0086
		* TDPL 3002 - 6	.008	.002 ~ .005	.748	-	-	● 0049	○ 0090
		TDN 2002	.008	.002 ~ .007	.748	-	-	● 0010	○ 0035 ● 0077
		TDN 3002	.008	.003 ~ .009	.748	-	-	● 0024	○ 0025 ● 0075
		TDN 4003	.012	.003 ~ .011	.748	-	-	● 0022	○ 0037 ● 0079
		TDN 5003	.012	.004 ~ .014	.945	-	-	● 0042	○ 0136 ● 0130
		TDN6003	.012	.004 ~ .014	.945	-	-	● 0132	○ 0137 ● 0133
-N	 Parting & Grooving Right Hand Shown (General) *  6° Angled Parting	TDN8004	.016	.005 ~ .016	1.142	-	-	● 0138	○ 0139 ● 0140
		* TDNR 2002 - 6	.008	.002 ~ .006	.748	-	-	● 0043	○ 0083
		* TDNR 3002 - 6	.008	.002 ~ .007	.748	-	-	● 0040	○ 0087
		* TDNL 2002 - 6	.008	.002 ~ .006	.748	-	-	● 0044	○ 0084
		* TDNL 3002 - 6	.008	.002 ~ .007	.748	-	-	● 0047	○ 0088
		* TDNL 4003 - 6	.012	.002 ~ .009	.748	-	-	● 0096	○ 0096



* CDX : Cutting Depth Maximum

● : Stock item ○ : Order made item

TD.	Designation	RE (In)	Parting & Grooving		Turning		EDP 5200..		
			Fn (In/rev.)	CDX (In)	Fn (In/rev.)	Ap	YG602	YG602G	YG603
	TDY3E - 0.4	.016	.002 ~ .009	.394	.005 ~ .009	.020 ~ .094	●	0027	
	TDY4E - 0.4	.016	.003 ~ .011	.394	.006 ~ .012	.020 ~ .110	●	0020	
	TDY5E - 0.4	.016	.003 ~ .009	.394	.006 ~ .012	.020 ~ .126	●	0082	
	TDY2E - 0.3 - GL	.012	.002 ~ .008	.394	.002 ~ .007	.016 ~ .059	●	0123	● 0124
	TDY3E - 0.3 - GL	.012	.002 ~ .009	.394	.003 ~ .008	.016 ~ .079	●	0125	● 0126
	TDY4E - 0.4 - GL	.016	.002 ~ .010	.394	.004 ~ .010	.020 ~ .091	●	0112	● 0127
	TDY5E - 0.4 - GL	.016	.003 ~ .012	.492	.004 ~ .012	.020 ~ .118	●	0157	● 0158
	TDY6E - 0.4 - GL	.016	.005 ~ .014	.492	.006 ~ .014	.020 ~ .138	●	0159	● 0160
	TDY8E - 0.8 - GL	.031	.006 ~ .020	.591	.008 ~ .020	.039 ~ .177	●	0164	● 0165
	TDY3E - 0.4 - GM	.016	.002 ~ .009	.394	.005 ~ .009	.020 ~ .094	●	0118	● 0119
	TDY4E - 0.4 - GM	.016	.003 ~ .011	.394	.006 ~ .012	.020 ~ .110	●	0113	● 0120
	TDY4E - 0.8 - GM	.031	.004 ~ .011	.394	.007 ~ .013	.031 ~ .110	●	0114	● 0122
	TDY5E - 0.4 - GM	.016	.003 ~ .011	.492	.007 ~ .014	.020 ~ .118	●	0134	● 0135
	TDY5E - 0.8 - GM	.031	.004 ~ .011	.492	.007 ~ .015	.031 ~ .118	●	0148	● 0149
	TDY6E - 0.4 - GM	.016	.005 ~ .012	.492	.007 ~ .016	.031 ~ .142	●	0150	● 0153
	TDY6E - 0.8 - GM	.031	.005 ~ .014	.492	.007 ~ .017	.039 ~ .142	●	0129	● 0154
	TDY8E - 0.8 - GM	.031	.004 ~ .010	.591	.008 ~ .020	.039 ~ .177	●	0155	● 0156
	TDY2E - 1.0 - RG	.039	.002 ~ .006	.394	.004 ~ .012	.004 ~ .031	●	0111	● 0115
	TDY3E - 1.5 - RG	.059	.003 ~ .007	.394	.006 ~ .014	.004 ~ .047	●	0108	● 0116
	TDY4E - 2.0 - RG	.079	.004 ~ .008	.394	.007 ~ .018	.004 ~ .063	●	0109	● 0117
	TDY5E - 2.5 - RG	.098	.005 ~ .009	.492	.008 ~ .020	.004 ~ .079	●	0166	● 0167
	TDY6E - 3.0 - RG	.118	.006 ~ .011	.492	.010 ~ .024	.004 ~ .094	●	0168	● 0169
	TDY8E - 4.0 - RG	.157	.007 ~ .012	.591	.010 ~ .028	.004 ~ .126	●	0170	● 0171

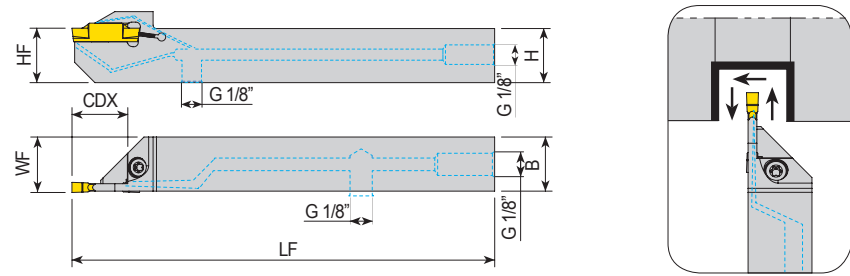


: p. 95~96 Unit : inch

Designation		EDP 5700..		CW	CDX	H (= HF)	B	LF	Insert
		R	L						
YTER/L 08 - 2T059 - C	●	0261	0238	.079	.591	.500	0.500	3.937	TD.2..
YTER/L 10 - 2T059 - C	●	0264	0241	.079	.591	.625	0.625	4.921	
YTER/L 12 - 2T035 - C	●	0271	0247	.079	.354	.750	0.750	4.921	
YTER/L 12 - 2T059 - C	●	0268	-	.079	.591	.750	0.750	4.921	
YTER/L 12 - 2T066 - C	●	0269	-	.079	.669	.750	0.750	4.921	
YTER/L 12 - 2T078 - C	●	0270	0246	.079	.787	.750	0.750	4.921	TD.3..
YTER/L 16 - 2T066 - C	●	0275	0251	.079	.669	1.000	1.000	5.906	
YTER/L 08 - 3T059 - C	●	0263	0240	.118	.591	.500	0.500	3.937	
YTER/L 10 - 3T059 - C	●	0266	0243	.118	.591	.625	0.625	4.921	
YTER/L 12 - 3T059 - C	●	-	0245	.118	.591	.750	0.750	4.921	
YTER/L 12 - 3T078 - C	●	0272	0248	.118	.787	.750	0.750	4.921	
YTER/L 12 - 3T098 - C	●	0273	0249	.118	.984	.750	0.750	4.921	
YTER/L 12 - 3T118 - C	●	0274	0250	.118	1.181	.750	0.750	4.921	
YTER/L 16 - 3T035 - C	●	0279	0255	.118	.354	1.000	1.000	5.906	
YTER/L 16 - 3T086 - C	●	0276	0252	.118	.866	1.000	1.000	5.906	
YTER/L 16 - 3T098 - C	●	0277	0253	.118	.984	1.000	1.000	5.906	TD.4..
YTER/L 16 - 3T118 - C	●	0278	0254	.118	1.181	1.000	1.000	5.906	
YTER/L 20 - 3T098 - C	●	0284	0259	.118	.984	1.250	1.250	6.693	
YTER/L 16 - 4T086 - C	●	0280	0256	.157	.866	1.000	1.000	5.906	TD.5..
YTER/L 16 - 4T098 - C	●	0281	-	.157	.984	1.000	1.000	5.906	
YTER/L 16 - 4T118 - C	●	0282	0257	.157	1.181	1.000	1.000	5.906	
YTER/L 16 - 5T098 - C	●	0283	0258	.197	.984	1.000	1.000	5.906	

Series	Designation	Infomation	Screw	Ring	Wrench
YTER/L	.. - 2..	Description	Y2505 - M6x30	YABPL - 01	YAAL - 03 - 3
		EDP	18000199	18000058	18000061
	.. - 3..	Description	Y2004 - M8x1x20	-	YAAL - 05 - 4 18000062
		EDP	18000196	-	
	.. - 4..	Description	Y2004 - M8x1x20	-	
		EDP	18000196	-	
	.. - 5..	Description	Y2004 - M8x1x20	-	
		EDP	18000196	-	

External holders with Internal coolant type for Swiss Lathe



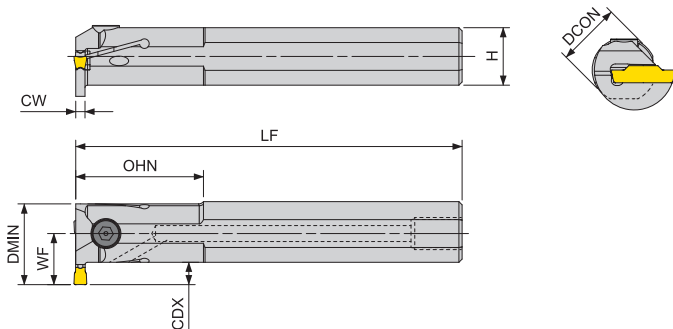
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Unit : inch

Designation		EDP 5700.. R L	CW	CDX	H (= HF)	B	LF	Insert
YTER/L 08 - 2T047 - S - C	●	0260 0237	.079	.472	.500	.500	4.921	TD.2..
YTER/L 08 - 3T047 - S - C	●	0262 0239	.118	.472	.500	.500	4.921	TD.3..
YTER/L 10 - 2T063 - S - C	●	0265 0242	.079	.630	.625	.625	4.921	TD.2..
YTER/L 10 - 3T063 - S - C	●	0267 0244	.118	.630	.625	.625	4.921	TD.3..

Series	Designation	Infomation	Screw	Ring	Wrench
YTER/L	..-2../..-3..	Description	Y4015-M4x11	-	Y80-T15
		EDP	18000119	-	18000167

Internal holders



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Unit : inch

Designation		EDP 5700.. R L	CW	DMIN	CDX	DCON	H	OHN	LF	Insert
YTIR/L 10 - 2T033 - C	●	0289 0285	.079	.984	.335	.625	.583	1.102	5.906	TD.2..
YTIR/L 12 - 3T023 - C	●	0290 0286	.118	.984	.236	.750	.720	1.575	6.693	TD.3..
YTIR/L 16 - 3T023 - C	●	0291 0287	.118	.984	.236	1.000	.906	1.575	7.874	
YTIR/L 20 - 3T019 - C	●	0292 0288	.118	1.220	.197	1.250	1.181	2.362	9.843	

Series	Designation	Infomation	Screw	Ring	Wrench
YTIR/L	10 - 2T..	Description	2503-M4x10	-	HL-05 58000041
		EDP	18000197	-	
	12 - 3T../16 - 3T..	Description	Y2504-M5X12	-	
		EDP	18000198	-	
	20 - 3T..	Description	Y2004-M8x1x20	-	
		EDP	18000196	-	