

FOCUS ON ISO TURNING INSERTS

YOUR UNIVERSAL CHOICE

Production characteristics

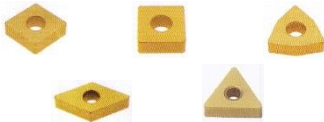
- Limited series
- Various daily production set ups

Tooling characteristics

- Multiple application environment
- Reliable cutting features

YUC Edition

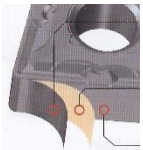
- 5 Negative shapes



- 4 Positive shapes



- 2 Coated grades



CVD

PVD

substrate

- 5 Finish CN.. chip breakers



- 5 Rough CN.. chip breakers



YOUR DEDICATED CHOICE

Production characteristics

- Large series
- Extreme intensive production

Tooling characteristics

- Focussed application environment
- High cutting performance

YDC Edition

- Shapes, grades and chip breakers for

P - Steel

M - Stainless steel

K - Cast iron

N - Non ferrous materials

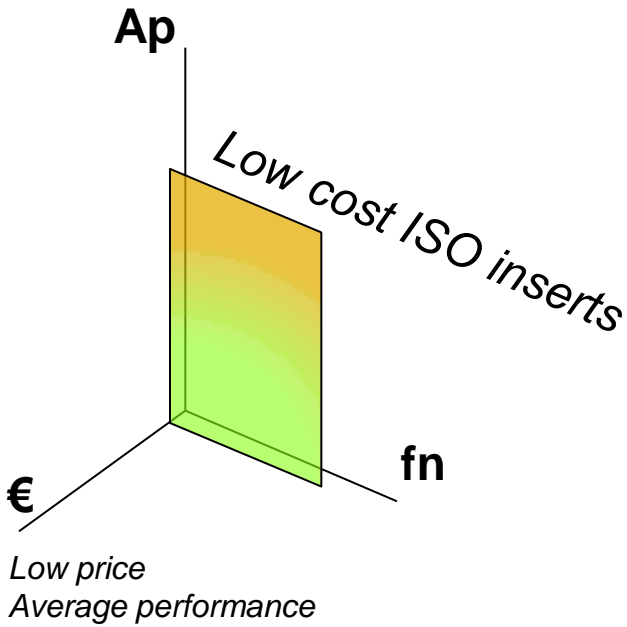
S - Heat resistant materials

- 4 Standard CN.. chip breakers

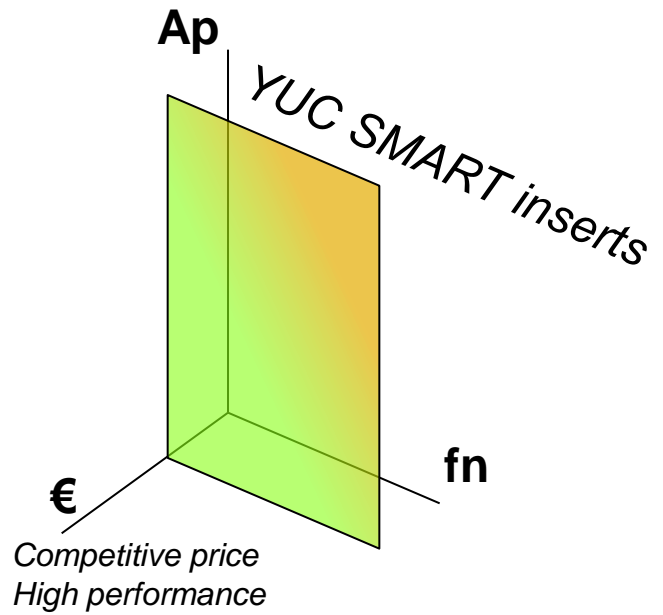


- 4 Positive CC.. chip breakers

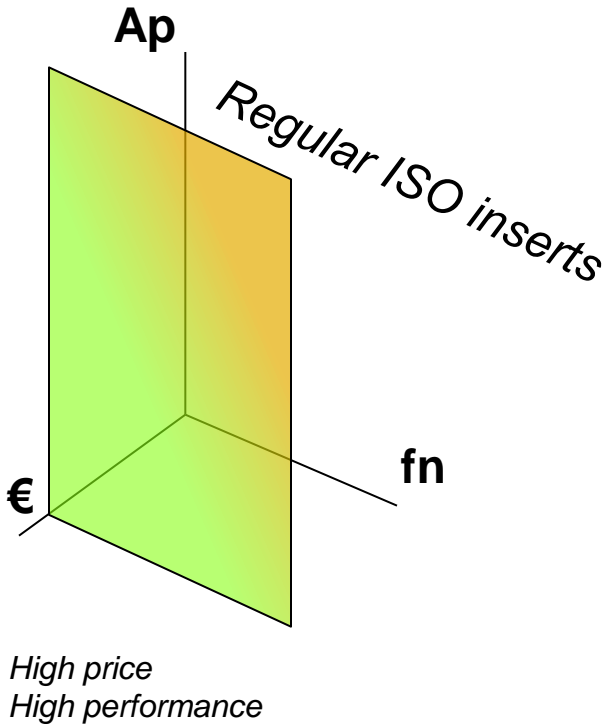




Poor price / performance ratio

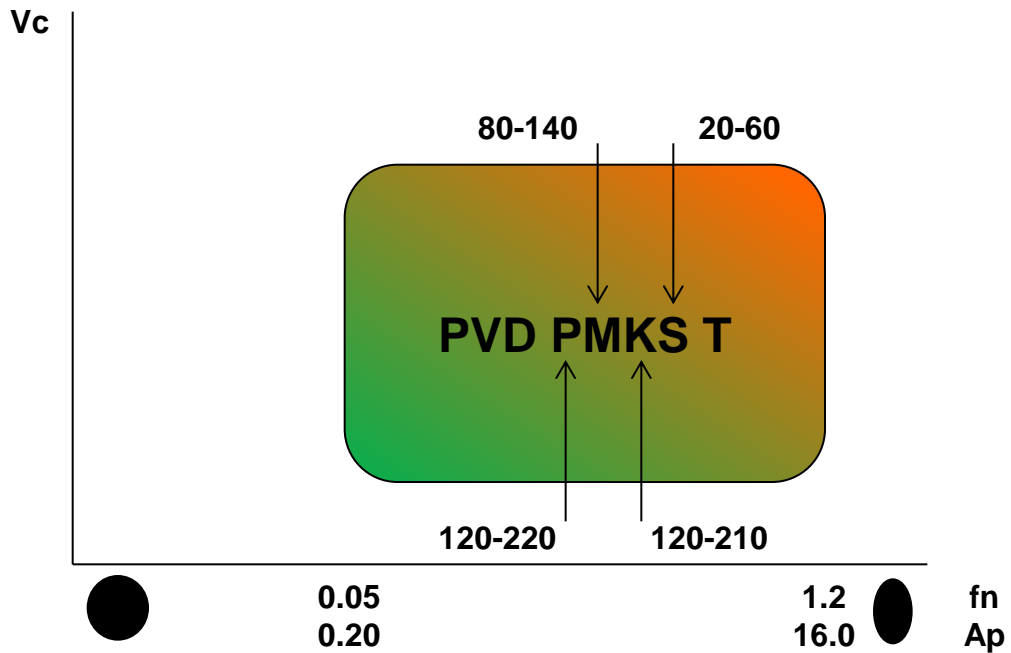
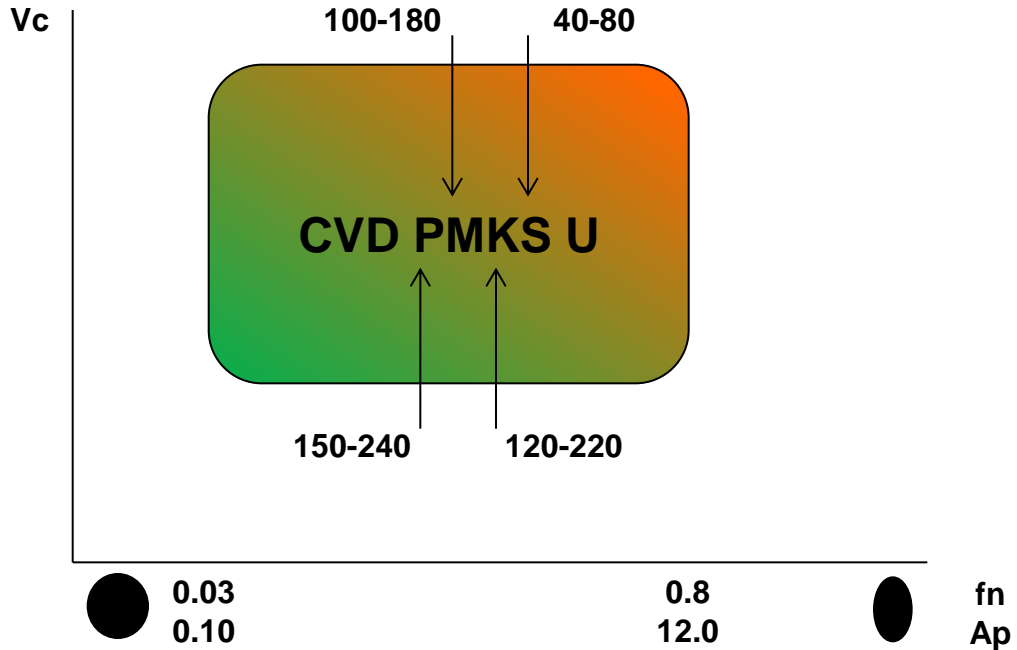


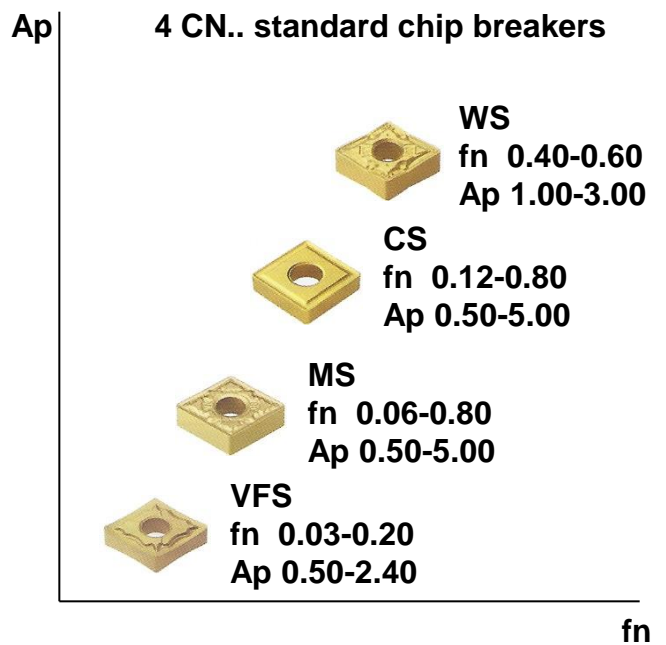
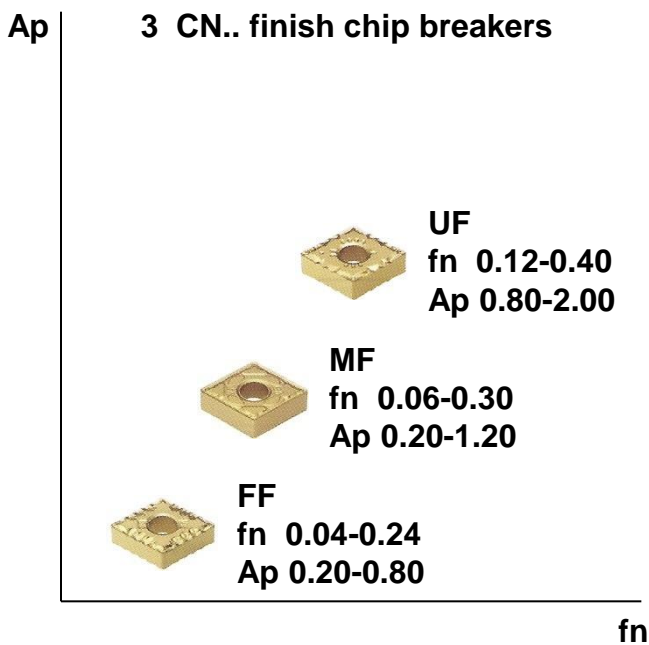
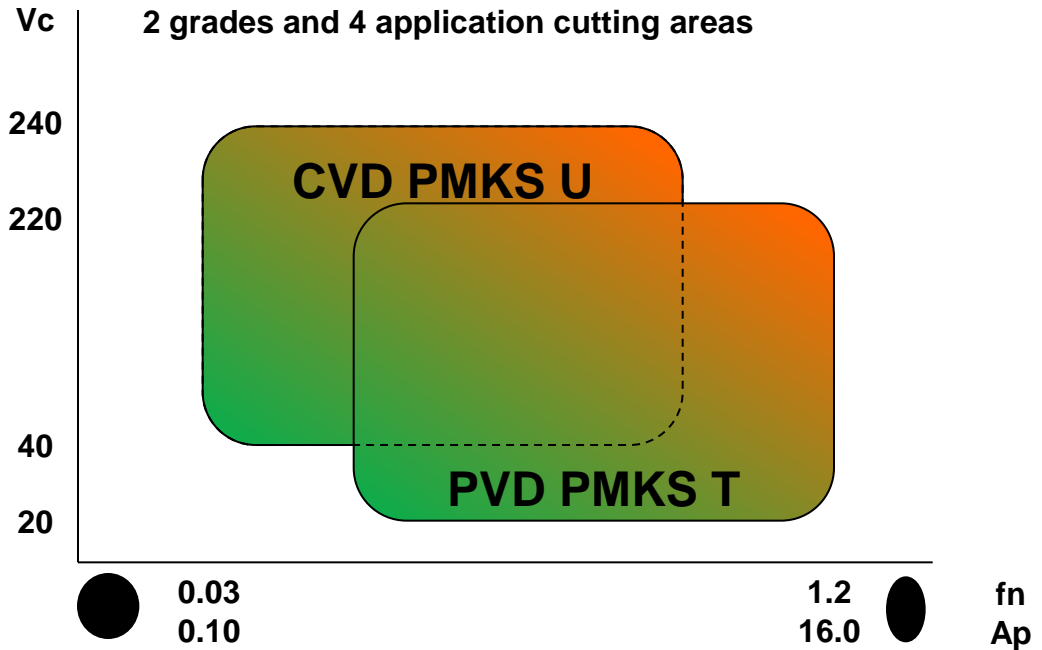
Strong price / performance ratio

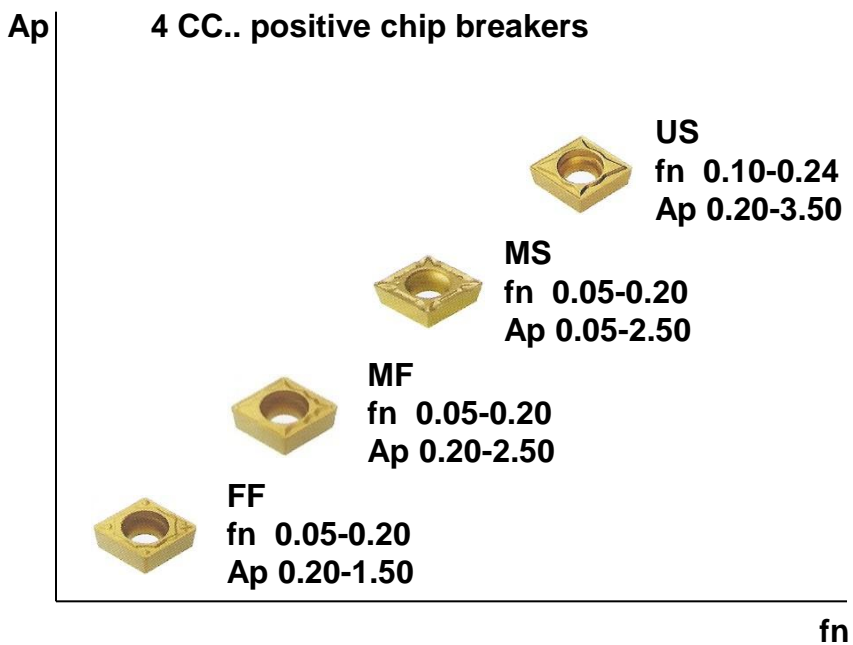
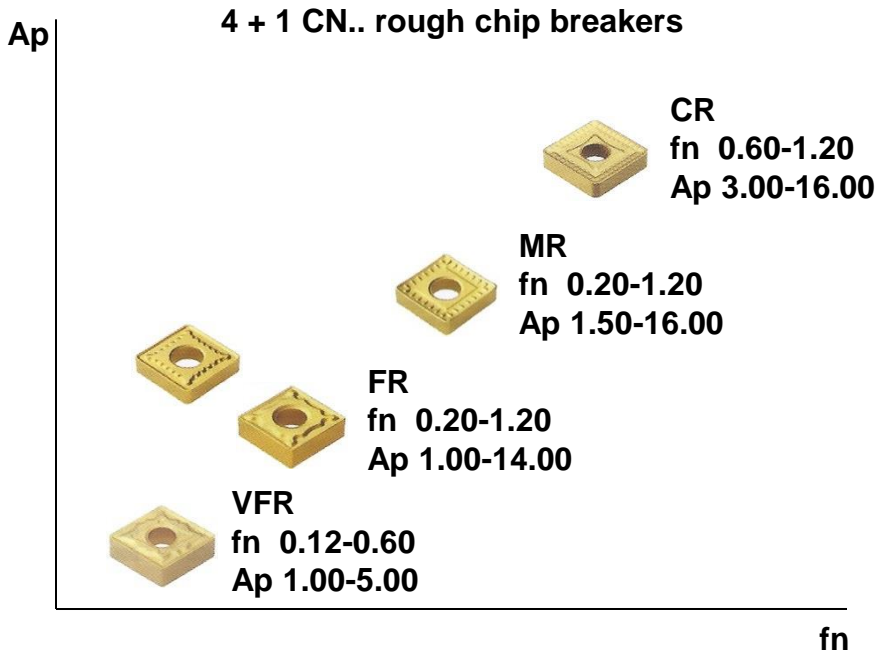


Average price / performance ratio

2 grades and 4 application material workpiece groups

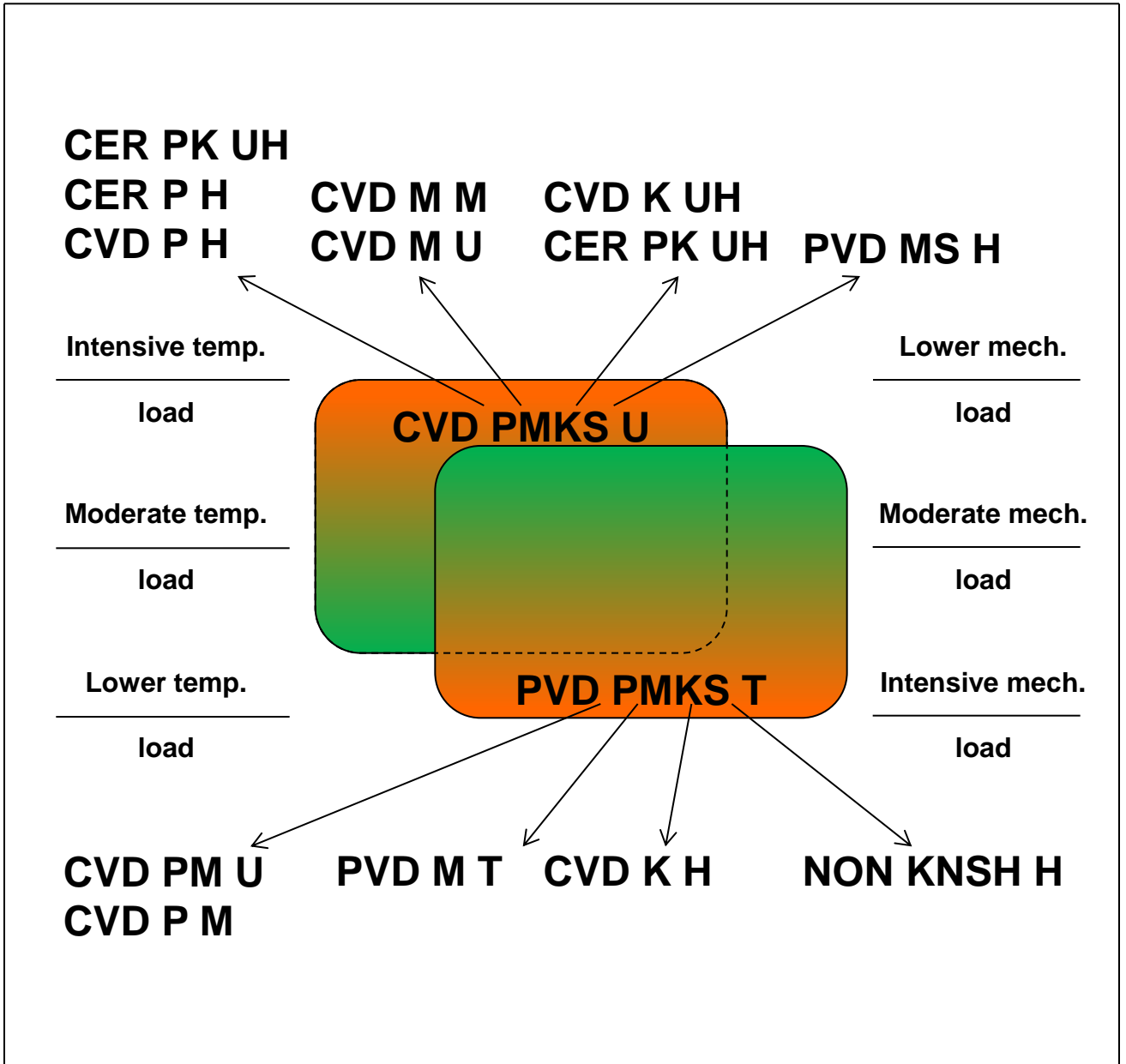






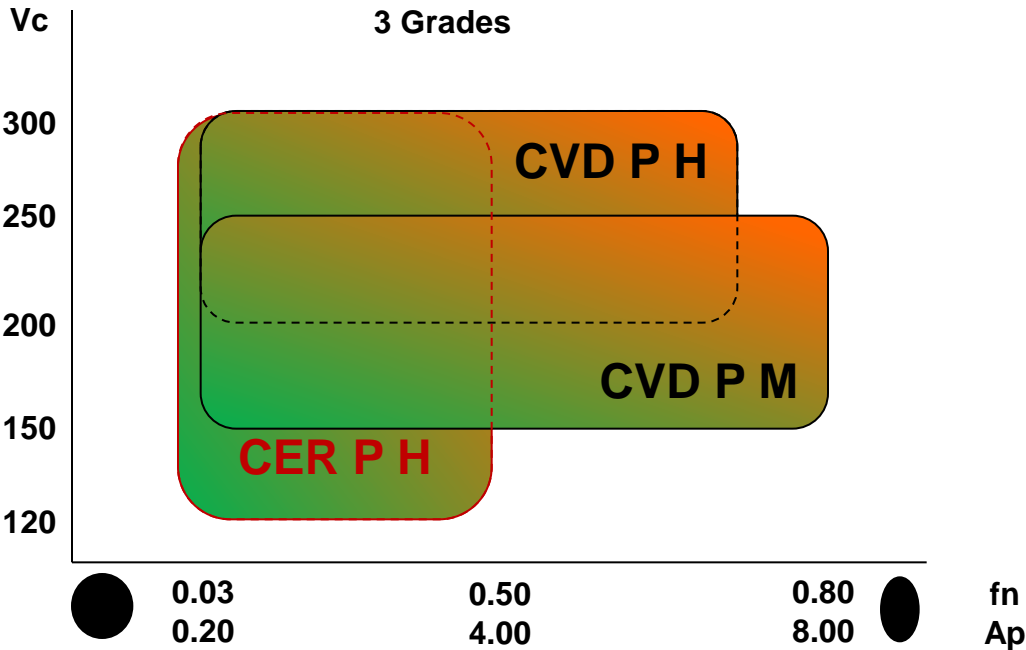
High hardness

High chemical resistant

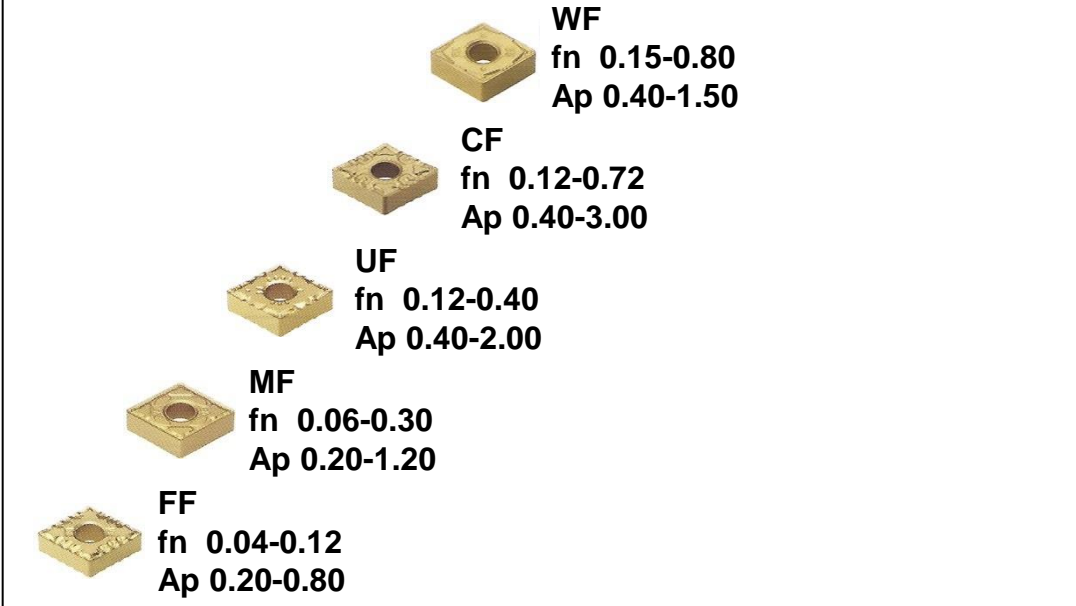


High toughness

High mechanical resistant

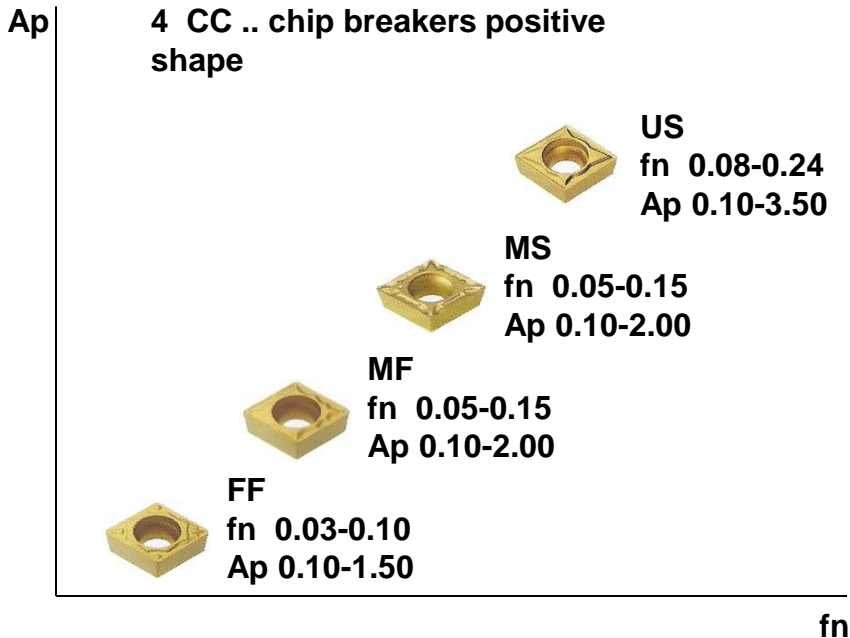
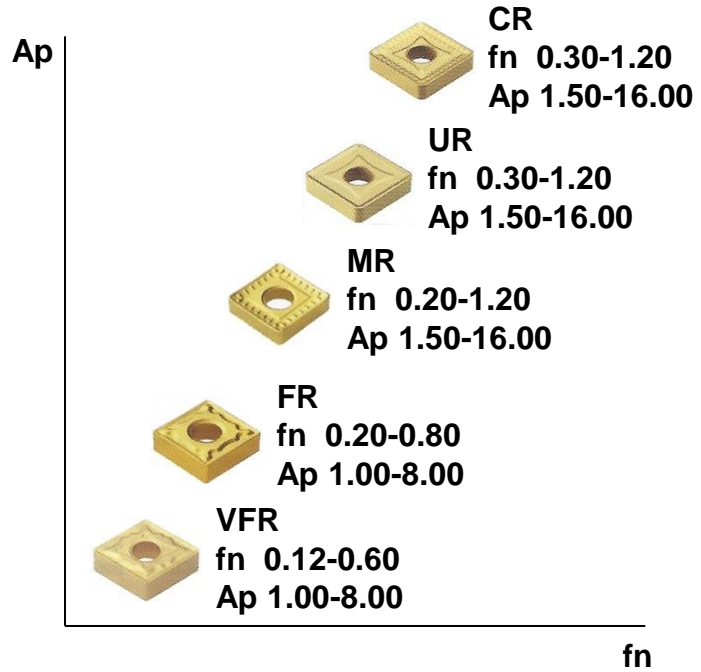
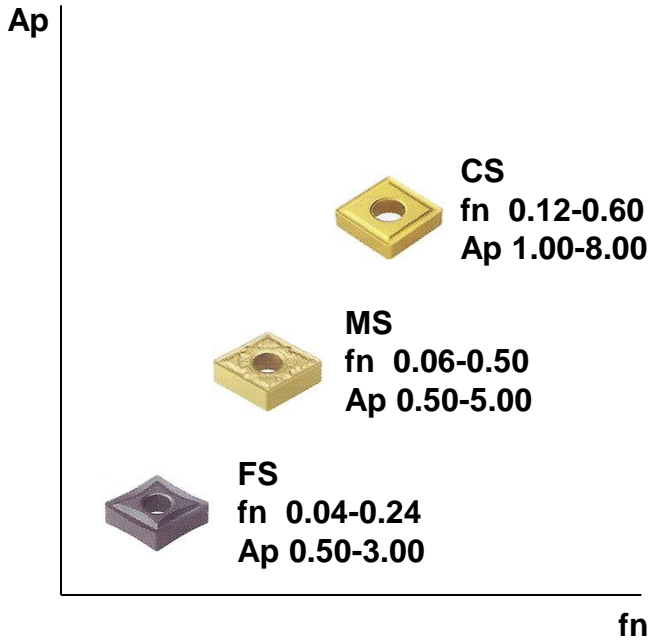


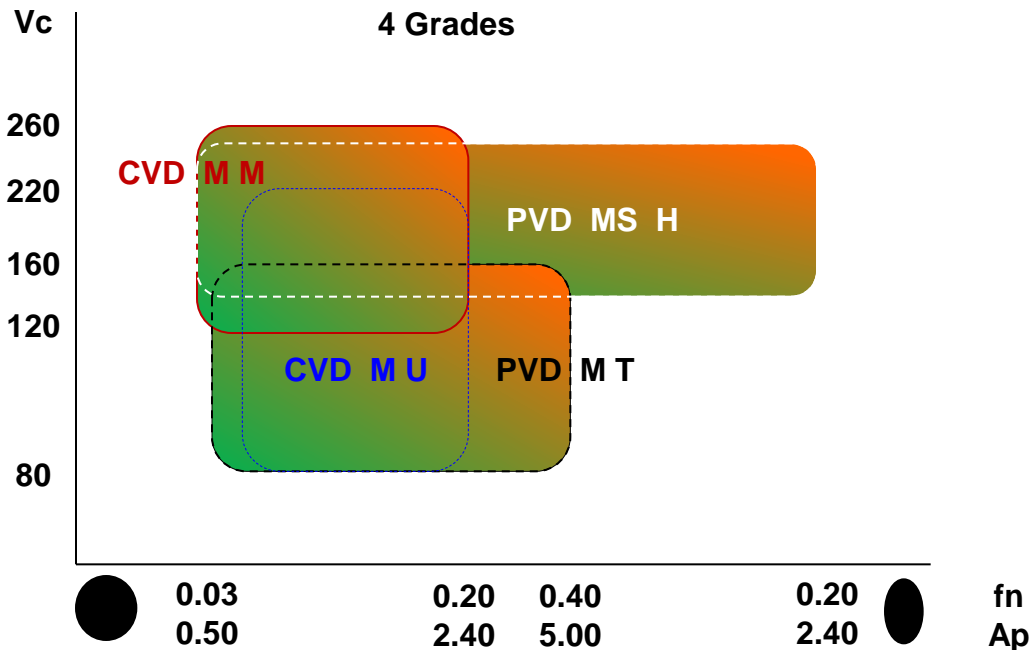
5 CN.. chip breakers negative shape - finish operations



3 CN.. chip breakers negative shape - standard operations

5 CN.. chip breakers negative shape - rough operations





Ap 4 CN.. chip breakers negative shape

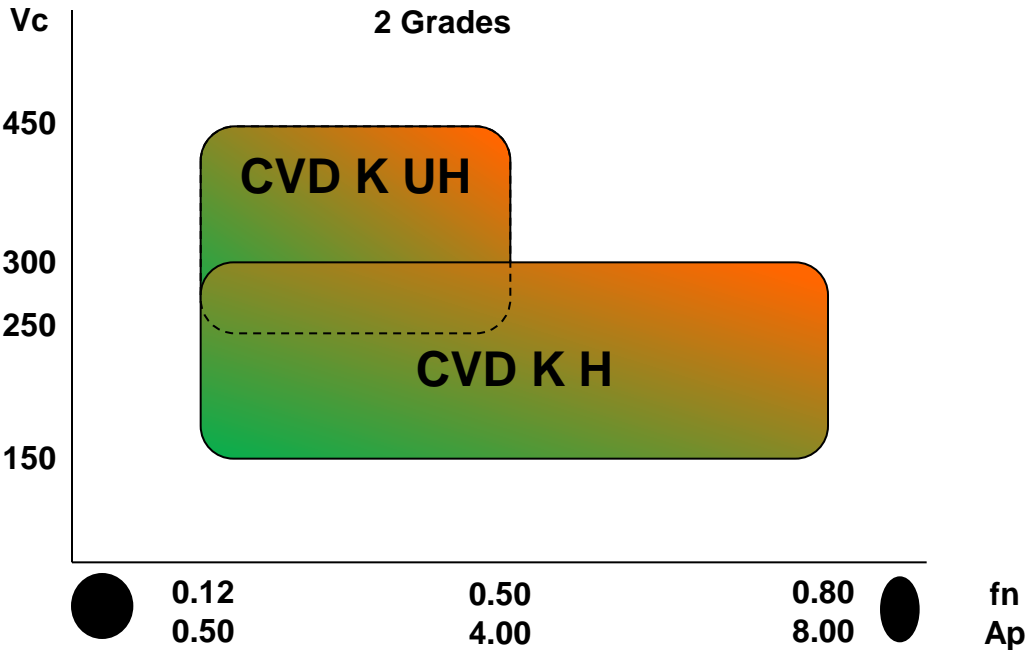
- CS**
fn 0.20-0.80
Ap 1.00-8.00
- VFR**
fn 0.12-0.60
Ap 1.00-8.00
- MS**
fn 0.16-0.40
Ap 1.00-5.00
- VFS**
fn 0.05-0.30
Ap 0.50-3.00

fn

Ap 3 CC.. chip breakers positive shape

- US**
fn 0.05-0.24
Ap 0.20-3.00
- MF**
fn 0.03-0.20
Ap 0.10-2.50
- FF**
fn 0.03-0.10
Ap 0.10-1.50

fn



Ap 5 CN.. chip breakers negative shape

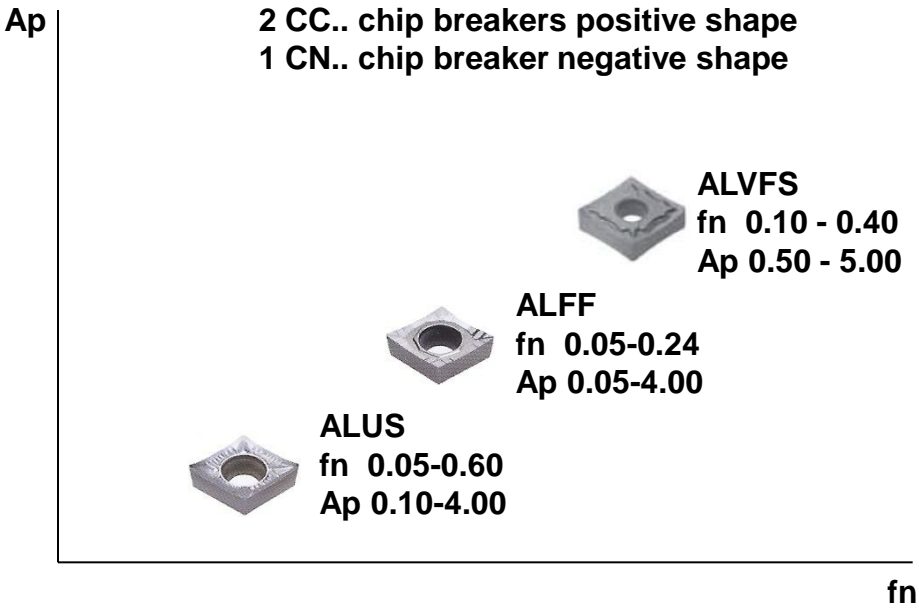
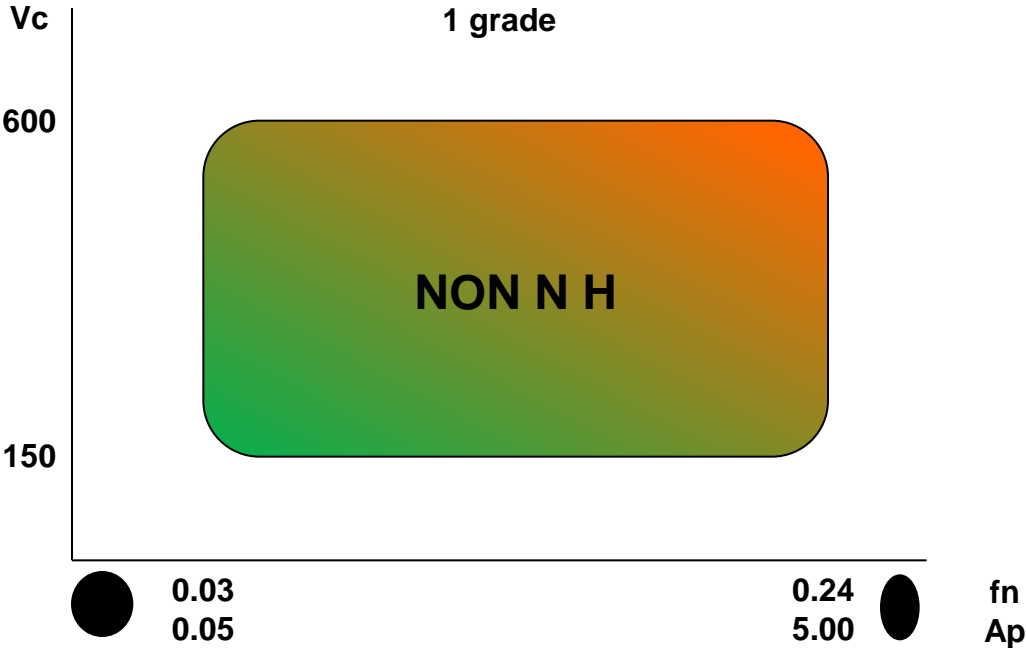
- FR**
fn 0.20-0.80
Ap 1.00-8.00
- VFR**
fn 0.12-0.60
Ap 1.00-8.00
- CS**
fn 0.12-0.60
Ap 1.00-8.00
- US**
fn 0.12-0.60
Ap 1.00-5.00
- MS**
fn 0.12-0.50
Ap 0.50-4.00

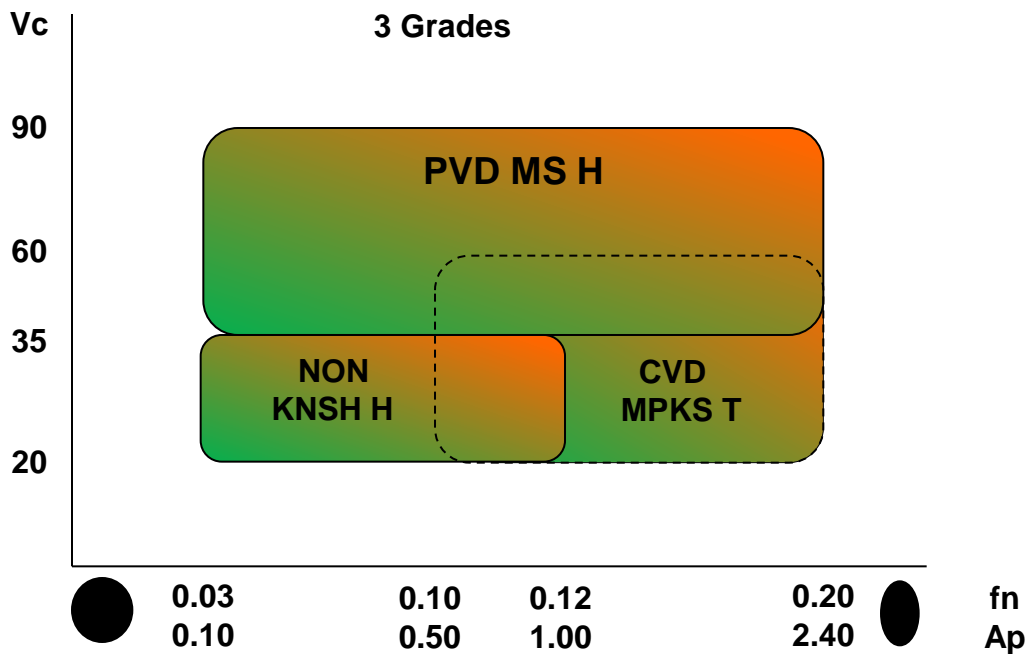
fn

Ap 2 CC.. chip breakers positive shape

- US**
fn 0.05-0.24
Ap 0.20-3.50
- MF**
fn 0.05-0.20
Ap 0.20-2.50

fn






Ap 1 CN.. chip breaker negative shape




VFS
fn 0.10-0.20
Ap 0.50-2.40

fn

Ap 2 CN.. chip breakers positive shape



MF
fn 0.05-0.12
Ap 0.15-1.50



AK
fn 0.03-0.12
Ap 0.10-1.00

fn