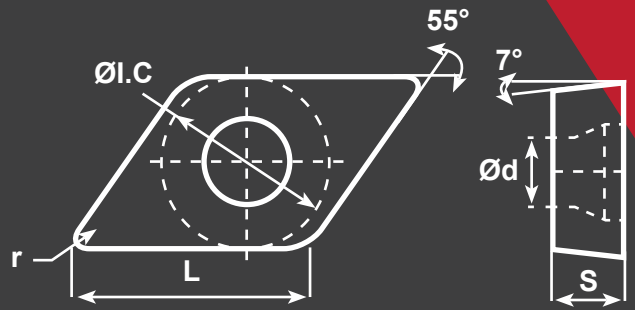


DCGX

Compatible Workpiece Materials

N
Ferrite Materials

S
Heat-Resistant Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1231	DCGX-21.50-LH	DCGX070202LH	0.307	0.25	0.094	0.110	0.008	N Vc: 4590sfm (980-4920) fz: 0.003in/z (0.002-0.006)	
424-1232	DCGX-21.51-LH	DCGX070204LH	0.307	0.25	0.094	0.110	0.016	N Vc: 3940sfm (980-4920) fz: 0.006in/z (0.002-0.012)	
424-1233	DCGX-32.50-LH	DCGX11T302LH	0.457	0.375	0.156	0.173	0.008	N Vc: 4590sfm (980-4920) fz: 0.003in/z (0.002-0.006)	
424-1234	DCGX-32.51-LH	DCGX11T304LH	0.457	0.375	0.156	0.173	0.016	N Vc: 3940sfm (980-4920) fz: 0.006in/z (0.002-0.012)	
424-1235	DCGX-32.52-LH	DCGX11T308LH	0.457	0.375	0.156	0.173	0.031	N Vc: 3280sfm (980-4920) fz: 0.01in/z (0.004-0.020)	

Material	Coated cemented carbide																Cermets	Coated Cermets	Cemented Carbide							
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103				YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C
P Steel	+	+	○	○	-	-	+		○	○													+	+		
M Stainless Steel							+		○	○		+	○	○	○								+	+		
K Cast Iron																	+	○	○	-	-					-
N Ferrite Materials																								○	-	
S Heat-resistant steel							+	+			+				+									+		
SKU#	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YD101	YD201	
424-1231																									●	
424-1232																									●	
424-1233																									●	
424-1234																									●	
424-1235																									●	

+ Good Working Conditions
 ○ General Working Conditions
 - Adverse Working Conditions

LH CHIP BREAKER

The LH chip breaker G class tolerance with big rake angle, polish and ground on surface, LH geometry is resistant to chip built-up on the insert edge, maximize surface finish on aluminum machining and insert tool life.

