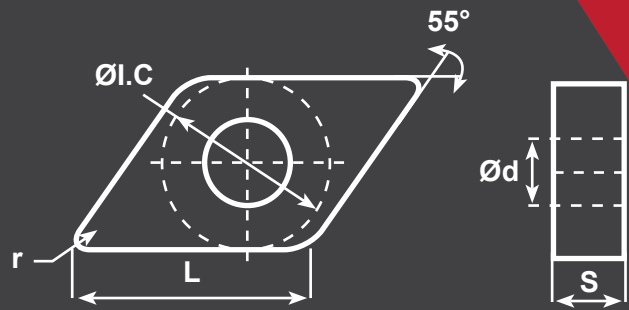


# DNMG

**P**

Steel



## Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1249	DNMG-331-DF	DNMG110404DF	0.457	0.375	0.187	0.15	0.016	<b>P</b> Vc: 1120sfm (920-1440) fz: 0.004in/z (0.002-0.008)	
424-1250	DNMG-332-DF	DNMG110408DF	0.457	0.375	0.187	0.15	0.031	<b>P</b> Vc: 1050sfm (850-1380) fz: 0.004in/z (0.002-0.008)	
424-1251	DNMG-431-DF	DNMG150404DF	0.61	0.5	0.187	0.203	0.016	<b>P</b> Vc: 1120sfm (980-1380) fz: 0.006in/z (0.002-0.012)	
424-1252	DNMG-432-DF	DNMG150408DF	0.61	0.5	0.187	0.203	0.031	<b>P</b> Vc: 980sfm (850-1250) fz: 0.008in/z (0.004-0.016)	
424-1259	DNMG-332-DF	DNMG110408DF	0.457	0.375	0.187	0.15	0.031	<b>P</b> Vc: 1310sfm (980-1640) fz: 0.004in/z (0.002-0.008)	
424-1260	DNMG-431-DF	DNMG150404DF	0.61	0.5	0.187	0.203	0.016	<b>P</b> Vc: 1310sfm (980-1640) fz: 0.006in/z (0.002-0.012)	
424-1261	DNMG-432-DF	DNMG150408DF	0.61	0.5	0.187	0.203	0.031	<b>P</b> Vc: 1310sfm (980-1640) fz: 0.008in/z (0.004-0.016)	

	Coated cemented carbide																Cermet	Coated Cermet	Cemented Carbide						
Material	+	+	○	○	-	-	+	○	○											+	+				
SKU#	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBC102	YBC105	YBC202	YBC205	YBC212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YD101	YD201
424-1249				●																					
424-1250				●																					
424-1251				●																					
424-1252				●																					
424-1259		●																							
424-1260		●																							
424-1261		●																							

**+** Good Working Conditions

**○** General Working Conditions

**-** Adverse Working Conditions

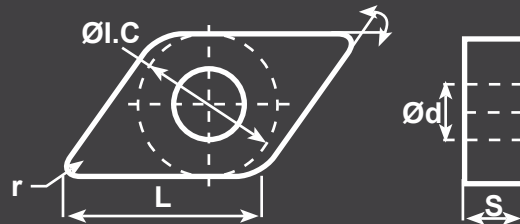
## DF CHIP BREAKER

DF is the preferred choice chip breaker on P category material semi-finish M Class tolerance double sided chip breaker, light cutting force with wide chipping range, can achieve better result on high adhesive alloy steels.



# DNMG

**P**  
Steel



## Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1285	DNMG-331-DM	DNMG110404DM	0.457	0.375	0.187	0.15	0.016	<b>P</b> Vc: 980sfm (790-1310) fz: 0.006in/z (0.004-0.012)	
424-1286	DNMG-332-DM	DNMG110408DM	0.457	0.375	0.187	0.15	0.031	<b>P</b> Vc: 920sfm (720-1180) fz: 0.008in/z (0.004-0.012)	
424-1287	DNMG-431-DM	DNMG150404DM	0.61	0.5	0.187	0.203	0.016	<b>P</b> Vc: 980sfm (850-1250) fz: 0.006in/z (0.002-0.012)	
424-1288	DNMG-432-DM	DNMG150408DM	0.61	0.5	0.187	0.203	0.031	<b>P</b> Vc: 920sfm (790-1180) fz: 0.008in/z (0.004-0.020)	
424-1289	DNMG-433-DM	DNMG150412DM	0.61	0.5	0.187	0.203	0.047	<b>P</b> Vc: 1120sfm (920-1440) fz: 0.001in/z (0.004-0.020)	
424-1290	DNMG-441-DM	DNMG150604DM	0.61	0.5	0.25	0.203	0.016	<b>P</b> Vc: 980sfm (850-1250) fz: 0.006in/z (0.002-0.012)	
424-1291	DNMG-442-DM	DNMG150608DM	0.61	0.5	0.25	0.203	0.031	<b>P</b> Vc: 920sfm (790-1180) fz: 0.008in/z (0.004-0.020)	
424-1292	DNMG-443-DM	DNMG150612DM	0.61	0.5	0.25	0.203	0.047	<b>P</b> Vc: 850sfm (720-1120) fz: 0.010in/z (0.006-0.024)	

P Steel	Coated cemented carbide																Cermet	Coated Cermet	Cemented Carbide							
	+	+	○	○	-	-	+	○	○	+	○	○	○	+	○	○				-	-	+	+	○	-	
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	
424-1285				●																						
424-1286				●																						
424-1287				●																						
424-1288				●																						
424-1289				●																						
424-1290				●																						
424-1291				●																						
424-1292				●																						

**+** Good Working Conditions

**○** General Working Conditions

**-** Adverse Working Conditions



## DM CHIP BREAKER

The DM chip breaker is the preferred choice chip breaker on P category material semi-finish M Class tolerance double sided chip breaker, light cutting force with wide chipping range, can achieve better result on high adhesive alloy steels.



# DNMG

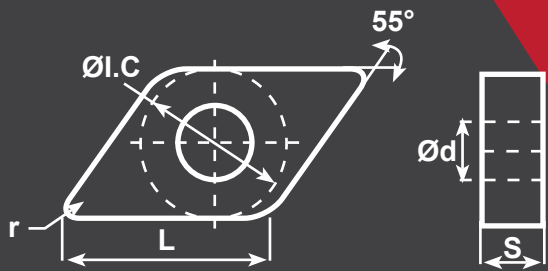
Compatible  
Workpiece Materials



Steel



Stainless Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1321	DNMG-331-EF	DNMG110404EF	0.457	0.375	0.187	0.15	0.016	<b>P</b> Vc: 890sfm (590-1180) fz: 0.008in/z (0.004-0.012)	<b>M</b> Vc: 660sfm (460-850) fz: 0.004in/z (0.002-0.008)
424-1322	DNMG-332-EF	DNMG110408EF	0.457	0.375	0.187	0.15	0.031	<b>P</b> Vc: 890sfm (590-1180) fz: 0.004in/z (0.002-0.008)	<b>M</b> Vc: 590sfm (390-790) fz: 0.004in/z (0.002-0.008)
424-1323	DNMG-431-EF	DNMG150404EF	0.61	0.5	0.187	0.203	0.016	<b>P</b> Vc: 660sfm (530-790) fz: 0.004in/z (0.002-0.008)	<b>M</b> Vc: 660sfm (460-850) fz: 0.004in/z (0.002-0.008)
424-1324	DNMG-432-EF	DNMG150408EF	0.61	0.5	0.187	0.203	0.031	<b>P</b> Vc: 890sfm (590-1180) fz: 0.004in/z (0.002-0.008)	<b>M</b> Vc: 590sfm (390-790) fz: 0.006in/z (0.004-0.012)
424-1328	DNMG-432-EF	DNMG150408EF	0.61	0.5	0.187	0.203	0.031	<b>M</b> Vc: 660sfm (460-850) fz: 0.006in/z (0.004-0.012)	
424-1330	DNMG-441-EF	DNMG150604EF	0.61	0.5	0.25	0.203	0.016	<b>P</b> Vc: 890sfm (590-1180) fz: 0.004in/z (0.002-0.008)	<b>M</b> Vc: 620sfm (360-890) fz: 0.004in/z (0.002-0.008)
424-1331	DNMG-442-EF	DNMG150608EF	0.61	0.5	0.25	0.203	0.031	<b>P</b> Vc: 890sfm (590-1180) fz: 0.004in/z (0.002-0.008)	<b>M</b> Vc: 620sfm (360-890) fz: 0.004in/z (0.002-0.008)

SKU#	Coated cemented carbide																		Cermet	Coated Cermet	Cemented Carbide							
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102				YBD151	YBD152	YBD252				
424-1321	+	+	○	○	-	-	+		○	○															+	+		
424-1322							+		○	○		+	○	○	○										+	+		
424-1323																												
424-1324																												
424-1330																												
424-1331																												

424-1328: YBG203

**+** Good Working Conditions

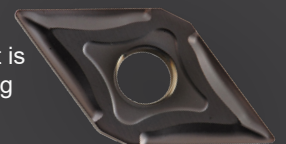
**○** General Working Conditions

**-** Adverse Working Conditions



## EF CHIP BREAKER

With a specially design rake angle and an inclined edge angle aimed at machining material that is highly adhesive and plasticity, such as stainless steel, EF chip breaker has a sharp edge making the cutting light and smooth, stability control chip flows and maintain surface finish, making it suitable for ultra fine and fine machining of stainless steel.



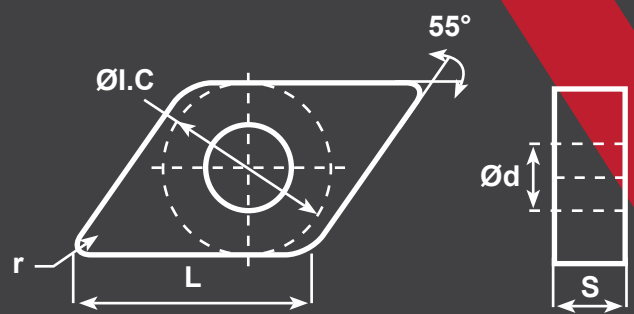
# DNMG



Steel



Stainless Steel



## Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1332	DNMG-431-EM	DNMG150404EM	0.61	0.5	0.187	0.203	0.016	<b>M</b> Vc: 660sfm (460-850) fz: 0.006in/z (0.004-0.012)	
424-1338	DNMG-331-EM	DNMG110404EM	0.457	0.375	0.187	0.15	0.016	<b>P</b> Vc: 890sfm (590-1180) fz: 0.004in/z (0.002-0.008)	
								<b>M</b> Vc: 590sfm (390-790) fz: 0.006in/z (0.004-0.012)	
424-1339	DNMG-332-EM	DNMG110408EM	0.457	0.375	0.187	0.15	0.031	<b>P</b> Vc: 890sfm (590-1180) fz: 0.004in/z (0.004-0.012)	
								<b>M</b> Vc: 530sfm (260-720) fz: 0.008in/z (0.002-0.008)	
424-1340	DNMG-431-EM	DNMG150404EM	0.61	0.5	0.187	0.203	0.016	<b>P</b> Vc: 660sfm (530-790) fz: 0.004in/z (0.002-0.008)	
								<b>M</b> Vc: 590sfm (390-790) fz: 0.006in/z (0.002-0.012)	
424-1341	DNMG-432-EM	DNMG150408EM	0.61	0.5	0.187	0.203	0.031	<b>P</b> Vc: 890sfm (590-1180) fz: 0.004in/z (0.002-0.008)	
								<b>M</b> Vc: 530sfm (260-720) fz: 0.008in/z (0.004-0.012)	
424-1343	DNMG-442-EM	DNMG150608EM	0.61	0.5	0.25	0.203	0.031	<b>P</b> Vc: 890sfm (590-1180) fz: 0.004in/z (0.002-0.008)	
								<b>M</b> Vc: 530sfm (260-720) fz: 0.008in/z (0.004-0.012)	

SKU#	Coated cemented carbide																			Cermet	Coated Cermet	Cemented Carbide		
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBC102	YBC105	YBC202	YBC205	YBC212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102	YBD151				YBD152	YBD252
424-1332	YBG203																							
424-1338									●															
424-1339									●															
424-1340									●															
424-1341									●															
424-1343									●															

**+** Good Working Conditions

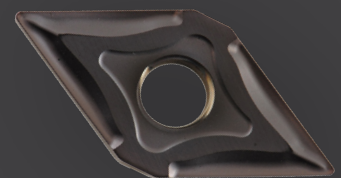
**○** General Working Conditions

**—** Adverse Working Conditions



## EM CHIP BREAKER

The EM chip breaker is the preferred choice chip breaker on M category material Medium. EM chip breaker is designed with sharp cutting edge which is required for machining highly adhesive material such as stainless steel while reinforced the impact resistance on the edge, which makes it suitable for semi-finishing and intermittent machining of adhesive materials.



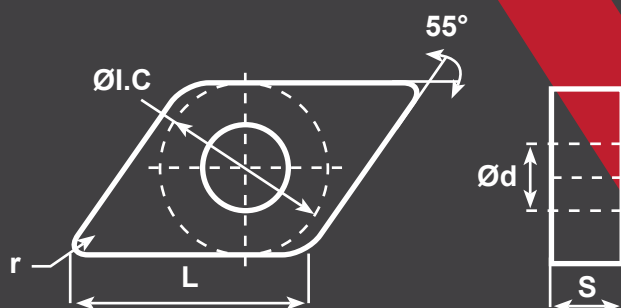
# DNMG



Steel



Stainless Steel



Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
427-2332	DNMG-442-NM	DNMG150608NM	0.61	0.5	0.25	0.203	0.031	<b>P</b> Vc: 980sfm (820-1150) fz: 0.004in/z (0.002-0.008)	
								<b>M</b> Vc: 720sfm (530-920) fz: 0.008in/z (0.004-0.012)	
427-2333	DNMG-443-NM	DNMG150612NM	0.61	0.5	0.187	0.203	0.047	<b>P</b> Vc: 980sfm (820-1150) fz: 0.008in/z (0.004-0.012)	
								<b>M</b> Vc: 720sfm (530-920) fz: 0.012in/z (0.008-0.016)	

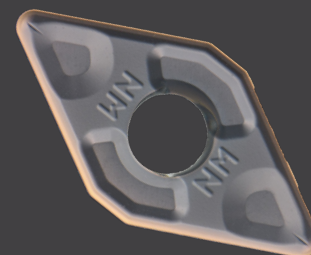
	Coated cemented carbide																Cermet	Coated Cermet	Cemented Carbide						
SKU#	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YD101	YD201
427-2332								●																	
427-2333								●																	

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



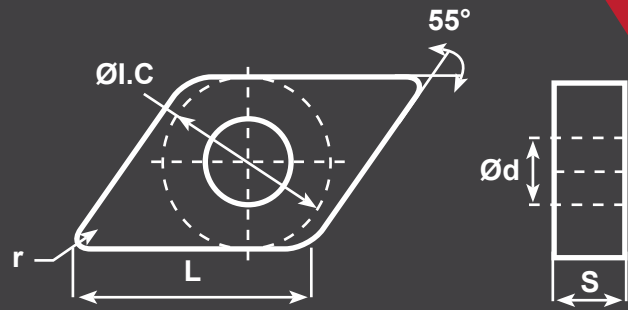
## NM CHIP BREAKER

The NM Chipbreaker with high cutting edge strength is designed to semi-finish machining on Ni-based super alloy. Smooth surface of chipbreaker ensures unobstructed chip flow and high wear resistance of cutting edge after treatment.



# DNMG

Compatible  
Workpiece Materials



**SKU# ANSI# ISO# L ØI.C S Ød r START SPEED START FEED**  
 424-1313 DNMG-432-PM DNMG150408PM 0.61 0.5 0.187 0.203 0.031 **K** Vc: 980sfm (720-1180) fz: 0.010in/z (0.006-0.016)

	Coated cemented carbide																Cermet	Coated Cermet	Cemented Carbide							
Material	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	
<b>P</b> Steel	+	+	○	○	-	-	+		○	○													+	+		
<b>M</b> Stainless Steel							+		○	○		+	○	○	○								+	+		
<b>K</b> Cast Iron																	+	○	○	-	-					-
<b>N</b> Ferrite Materials																								○	-	
<b>S</b> Heat-resistant steel							+	+			+				+									+		
<b>SKU#</b>	424-1313																				●					

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

## PM CHIP BREAKER

The PM chip breaker is the preferred choice chip breaker on P category material semi-finish. M Class tolerance double sided chip breaker, with higher toughness on cutting edge than DM chip breaker. Suitable for semi-finishing under unfavorable conditions and machining cast iron with low cutting force.

