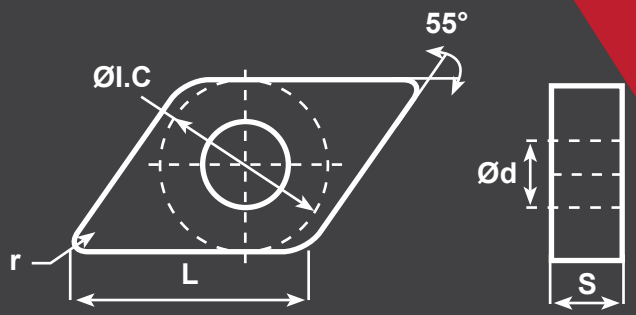
DNMG

Compatible Workpiece Materials

M
Stainless Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
427-2705	DNMG431-ADF	DNMG150404ADF	0.457	0.5	0.187	0.203	0.016	M Vc: 720sfm (460-980)	fz: 0.004in/z (0.002-0.008)

		YB9320	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
P	Steel	+	+	+	o	o	−	−	+		o	o												+	+		
M	Stainless Steel	o							+		o	o		+	o	o	o							+	+		
K	Cast Iron																		+	o	o	−	−				−
N	Ferrite Materials																									o	−
S	Heat-resistant steel								+	+			+					+								+	
		Coated cemented carbide																						Cermet	Coated Cermet	Cemented Carbide	
SKU#																											
427-2705		●																									

+ Good Working Conditions o General Working Conditions − Adverse Working Conditions

ADF CHIP BREAKER

Excellent geometry for general-purpose finishing. Single-sided chip breaker with good chip control that is suitable for alloy steel, stainless steel, and high speed steel

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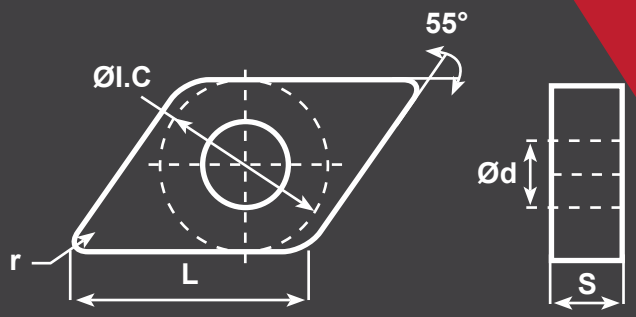
DNMG

Compatible Workpiece Materials

P
Steel



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	P	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	P	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	P	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	P	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	P	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	P	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	P	Vc: 1310sfm (980-1640) fz: 0.008in/z (0.004-0.016)

		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
P	Steel	+	+	o	o	−	−	+		o	o												+	+		
M	Stainless Steel							+		o	o		+	o	o	o							+	+		
K	Cast Iron																	+	o	o	−	−				−
N	Ferrite Materials																								o	−
S	Heat-resistant steel							+	+			+					+								+	
	424-1249				●																					
	424-1250				●																					
	424-1251				●																					
	424-1252				●																					
	424-1259		●																							
	424-1260		●																							
	424-1261		●																							

\+ Good Working Conditions o 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.

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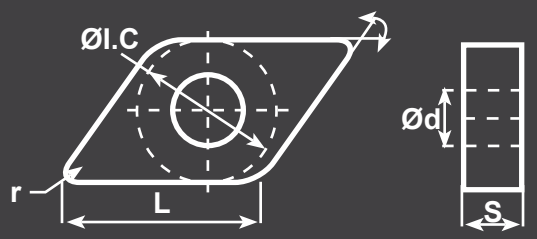
DNMG

Compatible Workpiece Materials

P Steel



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	P 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	P 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	P 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	P 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	P 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	P 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	P 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	P Vc: 850sfm (720-1120)	fz: 0.010in/z (0.006-0.024)

	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
424-1285				●																					
424-1286				●																					
424-1287				●																					
424-1288				●																					
424-1289				●																					
424-1290				●																					
424-1291				●																					
424-1292				●																					

+ Good Working Conditions **O** General Working Conditions **–** Adverse Working Conditions

DM CHIP BREAKER

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

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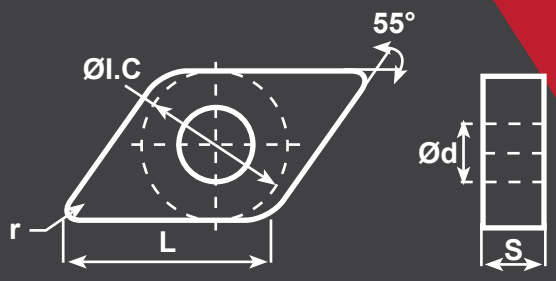
DNMG

Compatible Workpiece Materials

P Steel

M 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	P Vc: 890sfm (590-1180)	fz: 0.008in/z (0.004-0.012)
								M 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	P Vc: 890sfm (590-1180)	fz: 0.004in/z (0.002-0.008)
								M 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	P Vc: 660sfm (530-790)	fz: 0.004in/z (0.002-0.008)
								M 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	P Vc: 890sfm (590-1180)	fz: 0.004in/z (0.002-0.008)
								M 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	M 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	P Vc: 890sfm (590-1180)	fz: 0.004in/z (0.002-0.008)
								M 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	P Vc: 890sfm (590-1180)	fz: 0.004in/z (0.002-0.008)
								M Vc: 620sfm (360-890)	fz: 0.004in/z (0.002-0.008)

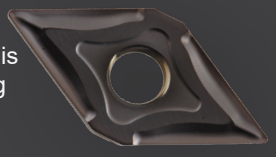
	Coated cemented carbide																				Cermet	Coated Cermet	Cemented Carbide	
SKU#	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052	YBD102	YBD151	YBD152	YBD252	YNG151	YNG151C	YD101	YD201
P Steel	+	+	o	o	−	−	+		o	o												+	+		
M Stainless Steel							+		o	o		+	o	o	o							+	+		
K Cast Iron																	+	o	o	−	−				−
N Ferrite Materials																								o	−
S Heat-resistant steel							+	+			+					+								+	
424-1321									●																
424-1322									●																
424-1323									●																
424-1324									●																
424-1330									●																
424-1331									●																

424-1328: YBG203

+ Good Working Conditions o 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.



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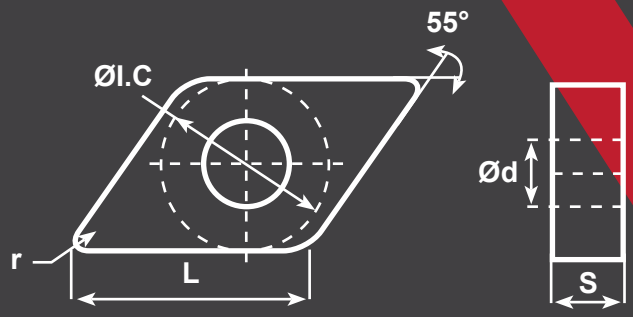
DNMG

P Steel

M Stainless Steel



Compatible Workpiece Materials

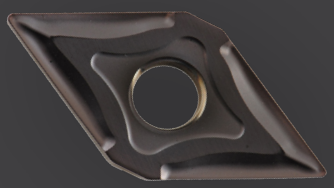
SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r		START SPEED	START FEED
424-1332	DNMG-431-EM	DNMG150404EM	0.61	0.5	0.187	0.203	0.016	M	Vc: 660sfm (460-850)	fz: 0.006in/z (0.004-0.012)
424-1338	DNMG-331-EM	DNMG110404EM	0.457	0.375	0.187	0.15	0.016	P	Vc: 890sfm (590-1180)	fz: 0.004in/z (0.002-0.008)
								M	Vc: 590sfm (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	P	Vc: 890sfm (590-1180)	fz: 0.004in/z (0.004-0.012)
								M	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	P	Vc: 660sfm (530-790)	fz: 0.004in/z (0.002-0.008)
								M	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	P	Vc: 890sfm (590-1180)	fz: 0.004in/z (0.002-0.008)
								M	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	P	Vc: 890sfm (590-1180)	fz: 0.004in/z (0.002-0.008)
								M	Vc: 530sfm (260-720)	fz: 0.008in/z (0.004-0.012)

		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
		Coated cemented carbide																					Cermet	Coated Cermet	Cemented Carbide	
P	Steel	+	+	○	○	−	−	+		○	○												+	+		
M	Stainless Steel							+		○	○		+	○	○	○							+	+		
K	Cast Iron																	+	○	○	−	−				−
N	Ferrite Materials																								○	−
S	Heat-resistant steel							+	+			+					+								+	
SKU#																										
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.



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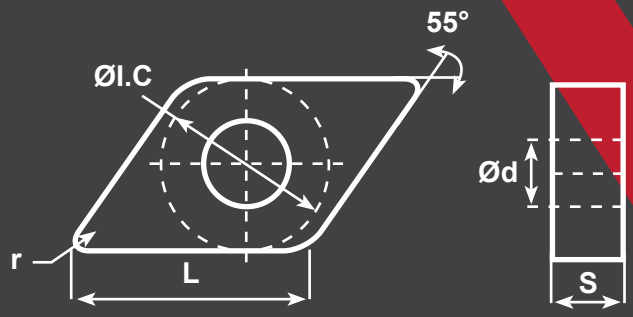
DNMG

P Steel

M Stainless Steel



Compatible Workpiece Materials

SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r
427-2332	DNMG-442-NM	DNMG150608NM	0.61	0.5	0.25	0.203	0.031
427-2333	DNMG-443-NM	DNMG150612NM	0.61	0.5	0.187	0.203	0.047

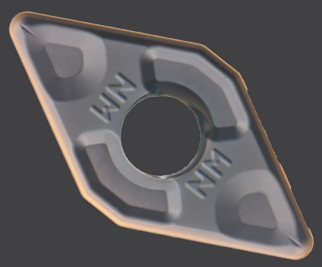
	START SPEED	START FEED
P	Vc: 980sfm (820-1150)	fz: 0.004in/z (0.002-0.008)
M	Vc: 720sfm (530-920)	fz: 0.008in/z (0.004-0.012)
P	Vc: 980sfm (820-1150)	fz: 0.008in/z (0.004-0.012)
M	Vc: 720sfm (530-920)	fz: 0.012in/z (0.008-0.016)

	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
P Steel	+	+	o	o	−	−	+		o	o												+	+		
M Stainless Steel							+		o	o		+	o	o	o							+	+		
K Cast Iron																	+	o	o	−	−				−
N Ferrite Materials																								o	−
S Heat-resistant steel							+	+			+					+								+	
427-2332								●																	
427-2333								●																	

+ Good Working Conditions o 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.



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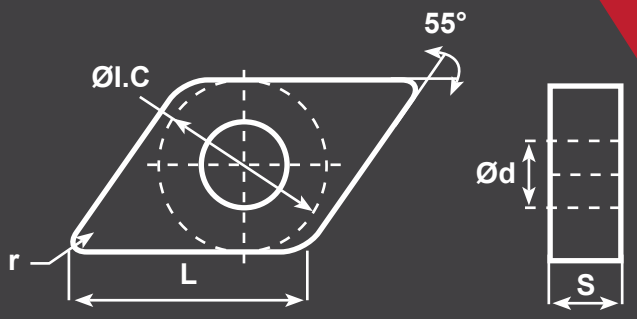
DNMG

Compatible Workpiece Materials

K Cast Iron



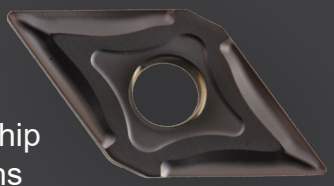
SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1313	DNMG-432-PM	DNMG150408PM	0.61	0.5	0.187	0.203	0.031	K	Vc: 980sfm (720-1180) fz: 0.010in/z (0.006-0.016)

	Coated cemented carbide																				Cermet	Coated Cermet	Cemented Carbide	
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
P Steel	+	+	o	o	−	−	+		o	o												+	+		
M Stainless Steel							+		o	o		+	o	o	o							+	+		
K Cast Iron																	+	o	o	−	−				−
N Ferrite Materials																								o	−
S Heat-resistant steel							+	+			+					+								+	
424-1313																				●					

+ Good Working Conditions o 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.



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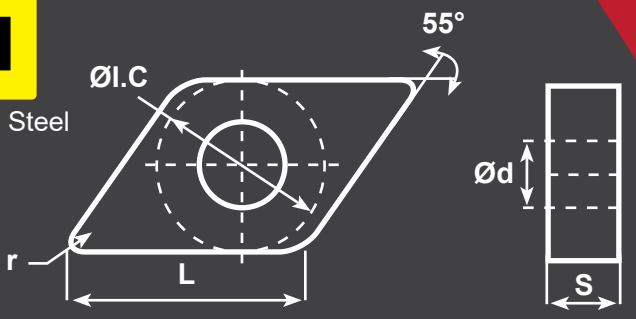
DNMG

P Steel

M Stainless Steel

K Cast Iron

Compatible Workpiece Materials



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r
427-3067	DNMG-442-SF	DNMG150608SF	0.61	0.5	0.25	0.203	0.031

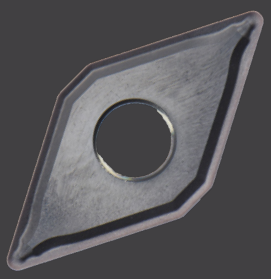
	START SPEED	START FEED
P	Vc:1310sfm(1050-1580)	fz: 0.008in/z (0.002-0.014)
M	Vc: 720sfm(530-920)	fz: 0.008in/z (0.002-0.014)
K	Vc: 690sfm(530-850)	fz: 0.008in/z (0.002-0.014)

	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
P Steel	+	+	o	o	−	−	+		o	o												+	+		
M Stainless Steel							+		o	o		+	o	o	o							+	+		
K Cast Iron																	+	o	o	−	−				−
N Ferrite Materials																								o	−
S Heat-resistant steel							+	+			+					+								+	
427-3067																							●		

+ Good Working Conditions o General Working Conditions − Adverse Working Conditions

SF CHIP BREAKER

The SF chip breaker is Extra Fine Finishing on P soft steel. Unique nose design and sharp cutting edge lead to small cutting resistance and reduce vibration. Outstanding performance of chip breaking and chip flowing on machining P soft steel and medium carbon steel to ensure high quality surface finish



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