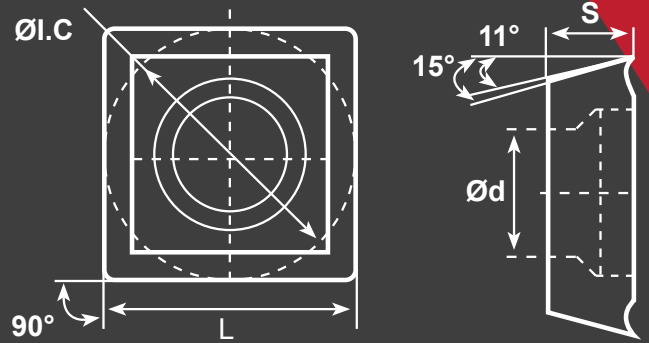


SNMG

Compatible
Workpiece Materials



Steel



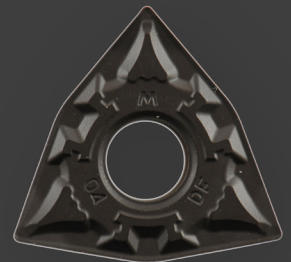
SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1538	SNMG432-DF	SNMG120408DF	0.5	0.5	0.187	0.203	0.031	P Vc: 1310sfm (980-1640) fz: 0.006in/z (0.002-0.012)	

Material	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				
P Steel	+	+	○	○	-	-	+		○	○														+	+			
M Stainless Steel							+		○	○			+	○	○	○									+	+		
K Cast Iron																		+	○	○	-	-					-	
N Ferrite Materials																										○	-	
S Heat-resistant steel							+	+				+					+								+			

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

DF CHIP BREAKER

The preferred choice chip breaker on P category material finish M Class tolerance with double-sided chip breaker gives excellent chip flow in finishing cut range while producing an excellent surface finish on the workpiece.

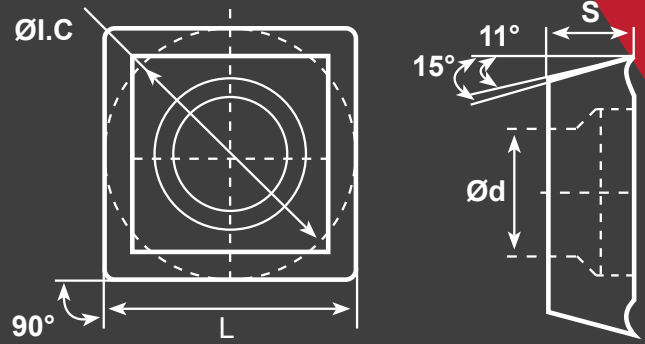


SNMG



Steel

Compatible Workpiece Materials



SKU#	ANSI#	ISO#	L	$\varnothing I.C$	S	$\varnothing d$	r	START SPEED	START FEED
424-1563	SNMG-322-DM	SNMG090308DM	0.375	0.375	0.125	0.15	0.031	P Vc: 920sfm (720-1180)	fz: 0.008in/z (0.004-0.012)
424-1564	SNMG-431-DM	SNMG120404DM	0.5	0.5	0.187	0.203	0.016	P Vc: 980sfm (850-1250)	fz: 0.006in/z (0.002-0.012)
424-1565	SNMG-432-DM	SNMG120408DM	0.5	0.5	0.187	0.203	0.031	P Vc: 920sfm (790-1180)	fz: 0.008in/z (0.004-0.020)
424-1566	SNMG-433-DM	SNMG120412DM	0.5	0.5	0.187	0.203	0.047	P Vc: 1120sfm (920-1440)	fz: 0.010in/z (0.004-0.020)
424-1567	SNMG-543-DM	SNMG150612DM	0.625	0.625	0.25	0.25	0.047	P Vc: 850sfm (720-1120)	fz: 0.010in/z (0.006-0.024)
424-1568	SNMG-643-DM	SNMB190612DM	0.75	0.75	0.25	0.313	0.047	P Vc: 850sfm (720-1120)	fz: 0.010in/z (0.006-0.024)
424-1569	SNMG-644-DM	SNMG190616DM	0.75	0.75	0.25	0.313	0.063	P Vc: 790sfm (660-1050)	fz: 0.012in/z (0.008-0.026)

Material	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				
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			
424-1563				●																								
424-1564				●																								
424-1565				●																								
424-1566				●																								
424-1567				●																								
424-1568				●																								
424-1569				●																								

+ 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.

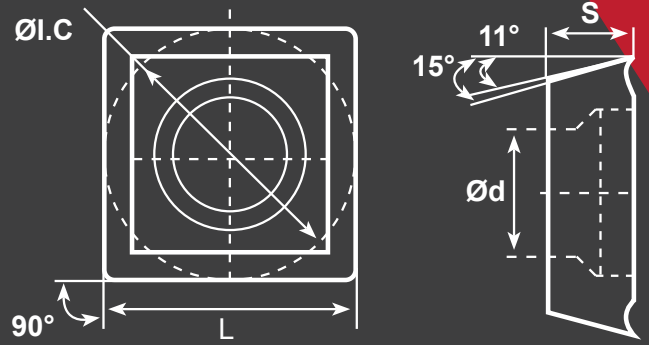


SNMG

Compatible
Workpiece Materials



Steel



SKU# ANSI# ISO# L ØI.C S Ød r START SPEED START FEED
 424-1580 SNMG433-DR SNMG120412DR 0.5 0.5 0.187 0.203 0.047 **P** Vc: 920sfm (720-1180) fz: 0.014in/z (0.010-0.028)

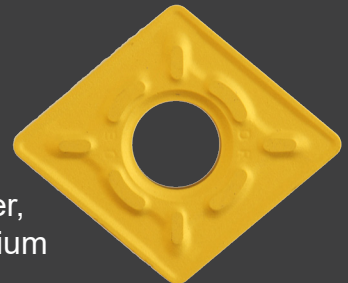
Material	Coated cemented carbide																	Cermet	Coated Cermet	Cemented Carbide									
	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBM215	YBM151	YBM251	YBM253	YBS103	YBD052				YBD102	YBD151	YBD152	YBD252					
P Steel	+	+	○	○	-	-	+		○	○															+	+			
M 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				
424-1580					●																								

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



DR CHIP BREAKER

The HR chip breaker is the preferred choice chip breaker for General Purpose M Class tolerance double sided chip breaker, suitable for inside boring and outside turning semi-finish/medium on alloy steel and cast iron.



SNMG

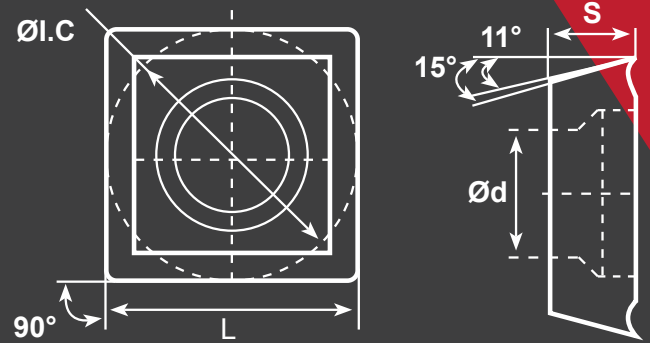
Compatible
Workpiece Materials



Steel



Stainless Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1582	SNMG-322-EF	SNMG090308EF	0.375	0.375	0.125	0.15	0.031	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)
424-1583	SNMG-432-EF	SNMG120408EF	0.5	0.5	0.187	0.203	0.031	P Vc: 890sfm (590-1180) fz: 0.008in/z (0.004-0.012)	M Vc: 620sfm (360-890) fz: 0.008in/z (0.004-0.012)

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							+	+			+					+								+		

+ Good Working Conditions

○ General Working Conditions

- Adverse Working Conditions



EF CHIP BREAKER

The EF chip breaker is the preferred choice chip breaker on M category material finishM Class tolerance double sided 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.



SNMG

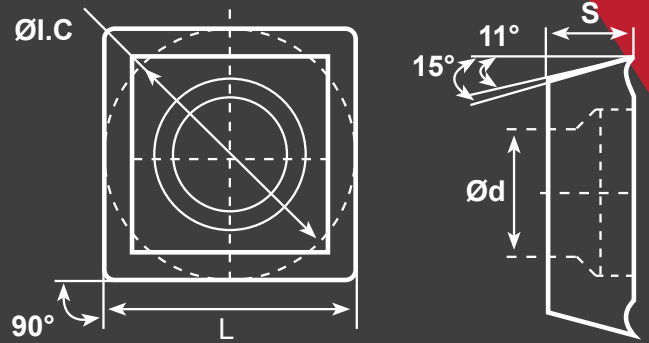
Compatible
Workpiece Materials



Steel



Stainless Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1592	SNMG-432-EM	SNMG120408EM	0.5	0.5	0.187	0.203	0.031	P Vc: 890sfm (590-1180) fz: 0.008in/z (0.004-0.012)	M Vc: 530sfm (260-720) fz: 0.008in/z (0.004-0.012)
424-1593	SNMG-433-EM	SNMG120412EM	0.5	0.5	0.187	0.203	0.047	P Vc: 890sfm (590-1180) fz: 0.008in/z (0.004-0.012)	M Vc: 460sfm (200-660) fz: 0.012in/z (0.008-0.016)
424-1594	SNMG-434-EM	SNMG120416EM	0.5	0.5	0.187	0.203	0.063	M Vc: 530sfm (260-720) fz: 0.010in/z (0.006-0.016)	P Vc: 890sfm (590-1180) fz: 0.008in/z (0.004-0.012)
424-1595	SNMG-543-EM	SNMG150612EM	0.625	0.625	0.25	0.25	0.047	P Vc: 890sfm (590-1180) fz: 0.008in/z (0.004-0.012)	M Vc: 390sfm (200-590) fz: 0.012in/z (0.008-0.020)

Material	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			
P Steel	+	+	○	○	-	-	+		○	○														+	+		
M Stainless Steel							+		○	○		+	○	○	○									+	+		
K Cast Iron																	+	○	○	-	-						
N Ferrite Materials																										○	-
S Heat-resistant steel							+	+			+					+									+		
SKU#	424-1592	424-1593	424-1594	424-1595																							

+ 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, such as austenitic stainless steel.



SNMG

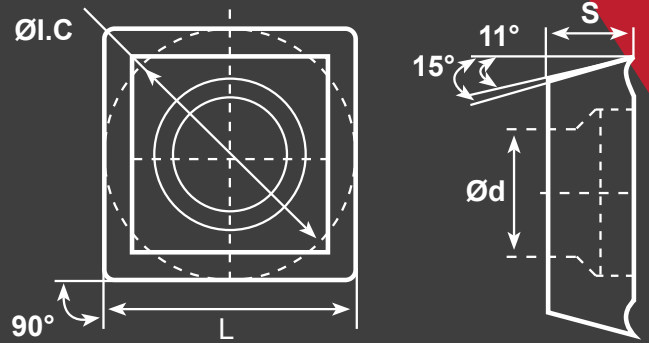
Compatible Workpiece Materials



Steel



Stainless Steel



SKU#	ANSI#	ISO#	L	ØI.C	S	Ød	r	START SPEED	START FEED
424-1550	SNMG432-PM	SNMG120408PM	0.5	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
424-1550																					●				

+ Good Working Conditions
○ General Working Conditions
 Adverse Working Conditions

PM CHIP BREAKER

The preferred choice chip breaker on P category material semi-finish M Class tolerance double sided chip breaker has a stronger cutting edge than DM chip breaker. This insert is suitable for turning semi-finish/medium on alloy steel under unstable cutting conditions and is also the preferred choice on cast iron.

