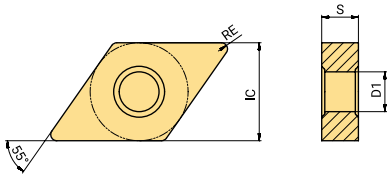



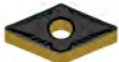

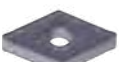


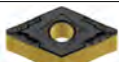
Negative 55° (D)

(mm)



Product code	IC	S	D1
DN_1104_	9.525	4.76	3.81
DN_1504_	12.70	4.76	5.16
DN_1506_	12.70	6.35	5.16

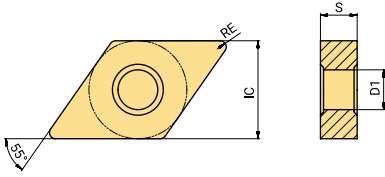
ISO Turning Inserts

Inserts	Product code	RE (mm)	Recommended parameters		Machining conditions																		
					● Good Conditions ● General Conditions ✖ Bad Conditions																		
			f (mm/rev)	ap (mm)	P			M			K			N	S								
					AT202	AT210A	AC052P	AC152P	AC252P	AC350P	AC100M	AC200M	AP200U	AP301M	AC100K	AC102K	AC202K	AW100K	AP010S	AP100S			
Finishing		DNGG 150401FP-UF	0.10	0.02-0.12	0.50-2.50																		
		150402FP-UF	0.20	0.02-0.12	0.50-2.50										○	●							
		150404FP-UF	0.40	0.02-0.12	0.50-2.50										○	●							
		DNMG 150402E-PA1	0.20	0.04-0.25	0.20-1.50	●	●		○														
		150404E-PA1	0.40	0.04-0.28	0.20-1.50	●	●	●	●														
		150408E-PA1	0.80	0.05-0.35	0.20-1.50	●	●	●	●														
		150412E-PA1	1.20	0.05-0.42	0.20-1.50	●	●	○	○														
		150602E-PA1	0.20	0.04-0.25	0.20-1.50	●	●		○														
		150604E-PA1	0.40	0.04-0.28	0.20-1.50	●	●	○	○														
		150608E-PA1	0.80	0.05-0.35	0.20-1.50	●	●	●	●														
	150612E-PA1	1.20	0.05-0.42	0.20-1.50	●	●																	
		DNMG 110404E-PB1	0.40	0.05-0.15	0.26-2.30	●	●	○	●	○													
		150404E-PB1	0.40	0.05-0.15	0.26-3.10	●	●	○	●	○													
		150408E-PB1	0.80	0.10-0.30	0.52-3.10	●	●	○	●	●													
		150604E-PB1	0.40	0.05-0.15	0.26-3.10	●	●		●	●													
		150608E-PB1	0.80	0.10-0.30	0.52-3.10	●	●	○	●	○													
		150612E-PB1	0.80	0.10-0.30	0.52-3.10				●	○													
		DNMG 150404E-SC1	0.40	0.07-0.18	0.20-0.80										●						●		
		150408E-SC1	0.80	0.10-0.25	0.20-0.80										●							●	
		150604E-SC1	0.40	0.07-0.18	0.20-0.80										●							●	
150608E-SC1		0.80	0.10-0.25	0.20-0.80										●							●		
	DNMG 150404E-MB2	0.40	0.05-0.15	0.26-2.90							●		●								●		
	150408E-MB2	0.80	0.10-0.30	0.52-2.90							●		●									●	
	150604E-MB2	0.40	0.05-0.15	0.26-2.90							●		●									●	
	150608E-MB2	0.80	0.10-0.30	0.52-2.90							●		●									●	
Semi-finishing		DNMG 110408E-SL3	0.80	0.12-0.30	0.80-2.50									●						●	●		
		150404E-SL3	0.40	0.12-0.25	0.60-2.50										●						●	●	
		150408E-SL3	0.80	0.12-0.30	0.80-2.50										●						●	●	
		150604E-SL3	0.40	0.12-0.25	0.60-2.50										●						●	●	
	150608E-SL3	0.80	0.12-0.30	0.80-2.50										●						●	●		
		DNMG 110408E-BS	0.80	0.10-0.25	0.70-2.00			●	○														


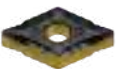
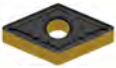


● : Standard stock ○ : Made-to-Order

Negative 55° (D)

(mm)



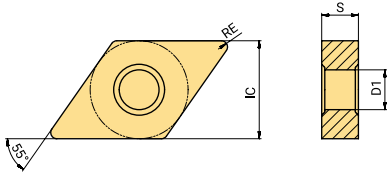
Product code	IC	S	D1
DN_1104_	9.525	4.76	3.81
DN_1504_	12.70	4.76	5.16
DN_1506_	12.70	6.35	5.16

Inserts	Product code	RE (mm)	Recommended parameters		Machining conditions															
					● Good Conditions ● General Conditions ✖ Bad Conditions															
					P						M				K		N		S	
f (mm/rev)	ap (mm)	AT202	AT210A	AC052P	AC152P	AC252P	AC350P	AC100M	AC200M	AP200U	AP301M	AC100K	AC102K	AC202K	AW100K	AP010S	AP100S			
Semi-finishing		DNMG 150404R-M1T	0.40	0.10-0.35	0.70-4.50	●	●													
	150404L-M1T	0.40	0.10-0.35	0.70-4.50	●	●														
		DNMG 150404E-PB3	0.40	0.06-0.18	0.30-3.10	●	●	●	●	○										
		150408E-PB3	0.80	0.12-0.36	0.60-3.10	●	●	●	●	○										
		150412E-PB3	1.20	0.18-0.54	0.90-3.10	●	●	○	●	○										
		150604E-PB3	0.40	0.06-0.18	0.30-3.10	●	●		●	●										
		150608E-PB3	0.80	0.12-0.36	0.60-3.10	●	●	●	●	○										
		150612E-PB3	1.20	0.18-0.54	0.90-3.10	●	●	○	●	●										
		DNMG 110408E-PC3	0.80	0.14-0.40	0.68-2.60				○											
		110412E-PC3	1.20	0.20-0.60	1.02-2.60				●											
		150404E-PC3	0.40	0.07-0.20	0.34-3.50	●	●		○											
		150408E-PC3	0.80	0.14-0.40	0.68-3.50	●	●	○	○											
		150412E-PC3	1.20	0.20-0.60	1.02-3.50	●	●		○											
		150604E-PC3	0.40	0.07-0.20	0.34-3.50	●	●		○											
		150608E-PC3	0.80	0.14-0.40	0.68-3.50	●	●		●	○										
		150612E-PC3	1.20	0.20-0.60	1.02-3.50	●	●		●											
		DNMG 150404E-SC3	0.40	0.08-0.22	0.40-3.90						●			●					●	●
		150408E-SC3	0.80	0.15-0.44	0.80-3.90						●			●					●	●
		150412E-SC3	1.20	0.23-0.66	1.20-3.90						●			●					●	●
		150604E-SC3	0.40	0.08-0.22	0.40-3.90						●			●					●	●
		150608E-SC3	0.80	0.15-0.44	0.80-3.90						●			●					●	●
		150612E-SC3	1.20	0.23-0.66	1.20-3.90						●			●					●	●
		DNMG 110404E-MC3	0.40	0.08-0.22	0.32-2.90						●		●	●						
		110408E-MC3	0.80	0.15-0.44	0.64-2.90						●		●	●						
		150404E-MC3	0.40	0.08-0.22	0.32-3.90						●	●		●	●					
		150408E-MC3	0.80	0.15-0.44	0.64-3.90						●		●	●						
		150412E-MC3	1.20	0.23-0.66	0.96-3.90						●		●	●						
		150604E-MC3	0.40	0.08-0.22	0.32-3.90						●		●	●						
150608E-MC3		0.80	0.15-0.44	0.64-3.90						●		●	●							
150612E-MC3		1.20	0.23-0.66	0.96-3.90						●		●	●							

● : Standard stock ○ : Made-to-Order

Negative 55° (D)

(mm)



Product code	IC	S	D1
DN_1104_	9.525	4.76	3.81
DN_1504_	12.70	4.76	5.16
DN_1506_	12.70	6.35	5.16

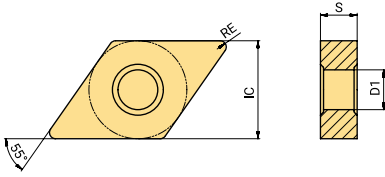
ISO Turning Inserts

Inserts	Product code	RE (mm)	Recommended parameters		Machining conditions															
					● Good Conditions ● General Conditions ✖ Bad Conditions															
					P						M				K		N		S	
f (mm/rev)	ap (mm)	AT202	AT210A	AC052P	AC152P	AC252P	AC350P	AC100M	AC200M	AP200U	AP301M	AC100K	AC102K	AC202K	AW100K	AP010S	AP100S			
Medium	DNMG 110404E-PD3	0.40	0.08-0.22	0.40-2.90	●	●		●	○											
	110408E-PD3	0.80	0.15-0.44	0.80-2.90	●	●	●	●	●											
	110412E-PD3	1.20	1.20-2.90	0.23-0.66				○												
	150404E-PD3	0.40	0.08-0.22	0.40-3.90	●	●		●	○											
	150408E-PD3	0.80	0.15-0.44	0.80-3.90	●	●	○	●	○	●										
	150412E-PD3	1.20	0.23-0.66	1.20-3.90			○	●	●	●										
	150604E-PD3	0.40	0.08-0.22	0.40-3.90				●	●	●										
	150608E-PD3	0.80	0.15-0.44	0.80-3.90			●	●	●	●										
	150612E-PD3	1.20	0.23-0.66	1.20-3.90			●	●	●	●										
	DNMG 150408E-UC4	0.80	0.15-0.48	0.80-4.50			●	●	●											
	150608E-UC4	0.80	0.15-0.48	0.80-4.50			●	●	●											
	150612E-UC4	1.20	0.23-0.72	1.20-4.50			●	●	●											
	DNMG 150404E-PC4	0.40	0.08-0.22	0.40-3.90	●	●		○	○					●	●					
	150408E-PC4	0.80	0.15-0.44	0.80-3.90	●	●	○	○	○					●	●					
	150412E-PC4	1.20	0.23-0.66	1.20-3.90			○	○	○					●	●					
	150604E-PC4	0.40	0.08-0.22	0.40-3.90	●	●		○	○					●	●					
	150608E-PC4	0.80	0.15-0.44	0.80-3.90	●	●	●	●	●					●	●					
	150612E-PC4	1.20	0.23-0.66	1.20-3.90			●	●	○					●	●					
DNMG 150608R-PL5	0.80	0.15-0.44	0.80-3.90				●	●												

● : Standard stock ○ : Made-to-Order

Negative 55° (D)

(mm)

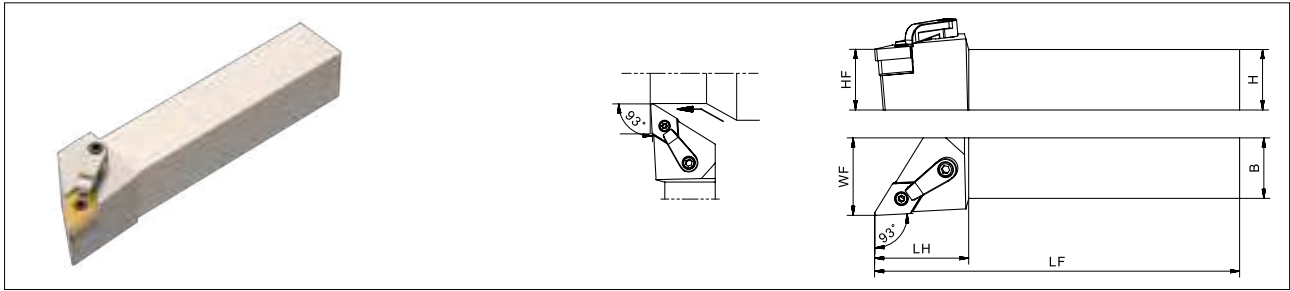


Product code	IC	S	D1
DN_1104_	9.525	4.76	3.81
DN_1504_	12.70	4.76	5.16
DN_1506_	12.70	6.35	5.16

Inserts	Product code	RE (mm)	Recommended parameters		Machining conditions														
					● Good Conditions ● General Conditions ✖ Bad Conditions														
					P						M			K			N		S
f (mm/rev)	ap (mm)	AT202	AT210A	AC052P	AC152P	AC252P	AC350P	AC100M	AC200M	AP200U	AP301M	AC100K	AC102K	AC202K	AW100K	AP010S	AP100S		
Roughing		DNMG 150408E-MC4	0.80	0.20-0.60	1.20-5.40														
		150412E-MC4	1.20	0.30-0.90	1.80-5.40														
		150608E-MC4	0.80	0.20-0.60	1.20-5.40														●
		150612E-MC4	1.20	0.30-0.90	1.80-5.40														●
		DNMG 110404E-KC4	0.40	0.09-0.24	0.48-3.50														
		110408E-KC4	0.80	0.18-0.48	0.96-3.50														
		150404E-KC4	0.40	0.09-0.24	0.48-4.60														
		150408E-KC4	0.80	0.18-0.48	0.96-4.60														
		150412E-KC4	1.20	0.26-0.72	1.44-4.60														
		150604E-KC4	0.40	0.09-0.24	0.48-4.60														
		150608E-KC4	0.80	0.18-0.48	0.96-4.60														
		150612E-KC4	1.20	0.26-0.72	1.44-4.60														
		DNMG 150408E-PD5	0.80	0.20-0.60	1.20-5.40			○	○	○									
		150412E-PD5	1.20	0.30-0.90	1.80-5.40			●	○	○									
		150416E-PD5	1.60	0.40-1.20	2.40-5.40			○	○	●									
		150608E-PD5	0.80	0.20-0.60	1.20-5.40			○	○	●	●								
		150612E-PD5	1.20	0.30-0.90	1.80-5.40			○	●	●	●								
		150616E-PD5	1.60	0.40-1.20	2.40-5.40			●	●	○									
		DNMA 150404E-KD5	0.40	0.10-0.30	0.60-5.40														
		150408E-KD5	0.80	0.20-0.60	1.20-5.40														
		150412E-KD5	1.20	0.30-0.90	1.80-5.40														
		150604E-KD5	0.40	0.10-0.30	0.60-5.40														
		150608E-KD5	0.80	0.20-0.60	1.20-5.40														
		150612E-KD5	1.20	0.30-0.90	1.80-5.40														

● : Standard stock ○ : Made-to-Order

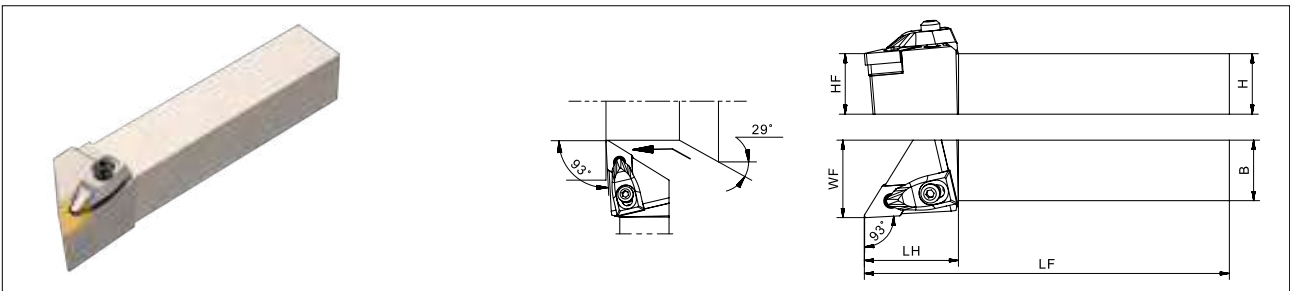
MDJN (External/Profile Turning)



Product code	Stock		Dimension						Insert corner radius (RE)	Spare parts					Insert					
	R	L	H	HF	B	LF	LH	WF		Wrench	Clamp screw	Clamp	Lock pin	Shim						
MDJN ^{R/L} 2020K-1504	○	○	20	20	20	125	39	25	0.8	LT-H3	CD060255X	CLM210140	CS060190	S-MDN15064	DN*A 1504... DN*G 1504... DN*M 1504...					
	●	○	25	25	25	150		32												
MDJN ^{R/L} 2020K-1506	○	○	20	20	20	125	39	25						0.8	LT-H3	CD060255X	CLM210140	CS060190	S-MDN15048	DN*A 1506... DN*G 1506... DN*M 1506...
	○	○	25	25	25	150		32												

● : Standard stock ○ : Made-to-Order

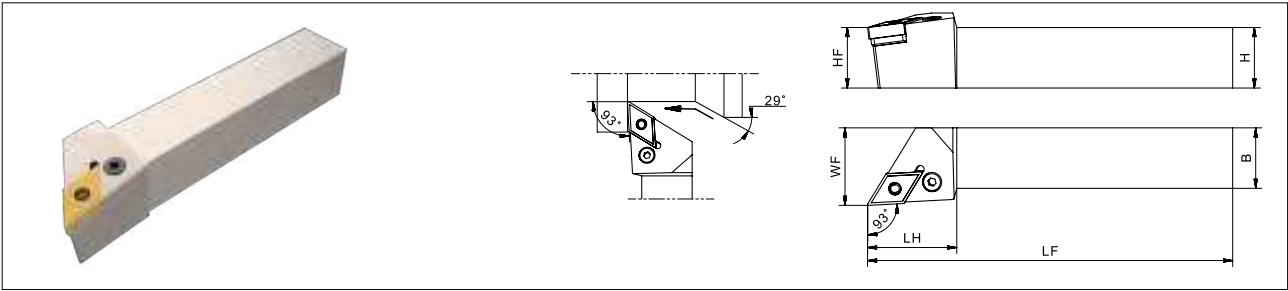
DDJN (External/Profile Turning)


















Product code	Stock		Dimension						Insert corner radius (RE)	Spare parts						Insert						
	R	L	H	HF	B	LF	LH	WF		Wrench	Clamp screw	Clamp	Spring	Shim screw	Shim							
DDJN ^{R/L} 2020K-1504	○	○	20	20	20	125	39	25	0.8	LT-H3	CH050215	CLD283090	YB0.20-2.50-12-5.5	SH060100X	S-DDN15064	DN*A 1504... DN*G 1504... DN*M 1504...						
	●	○	25	25	25	150		32														
DDJN ^{R/L} 2020K-1506	○	○	20	20	20	125	39	25							0.8	LT-H3	CH050215	CLD283090	YB0.20-2.50-12-5.5	SH060100X	S-DDN15048	DN*A 1506... DN*G 1506... DN*M 1506...
	○	○	25	25	25	150		32														

● : Standard stock ○ : Made-to-Order

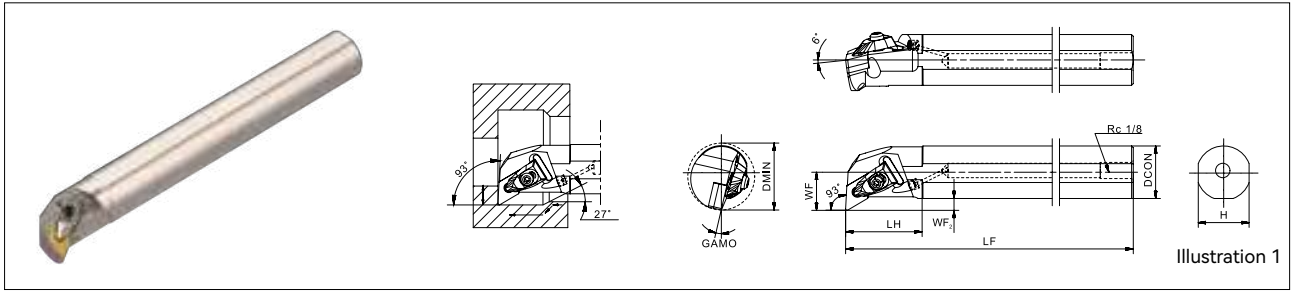
PDJN (External/Profile Turning)



Product code	Stock		Dimension						Insert corner radius (RE)	Spare parts					Insert
	R	L	H	HF	B	LF	LH	WF		Wrench	Lever screw	Lever	Shim	Shim pin	
															
PDJN^{R/L} 1616H-11	○	○	16	16	16	100	28	20	0.4						DN*G 1104...
2020K-11	●	●	20	20	20	125	25								
2525M-11	●	●	25	25	25	150	36	32							
PDJN^{R/L} 2020K-1504	●	○	20	20	20	125	36	25	0.8						DN*A 1504... DN*G 1504... DN*M 1504...
2525M-1504	●	●	25	25	25	150		32							
3232P-1504	○	○	32	32	32	170		40							
PDJN^{R/L} 2020K-1506	○	○	20	20	20	125	25								
2525M-1506	○	○	25	25	25	150	32	40	LT-H3	LH080200	LV4B	S-PDN15032	SP4N	DN*A 1506... DN*G 1506... DN*M 1506...	
3232P-1506	○	○	32	32	32	170									

● : Standard stock ○ : Made-to-Order

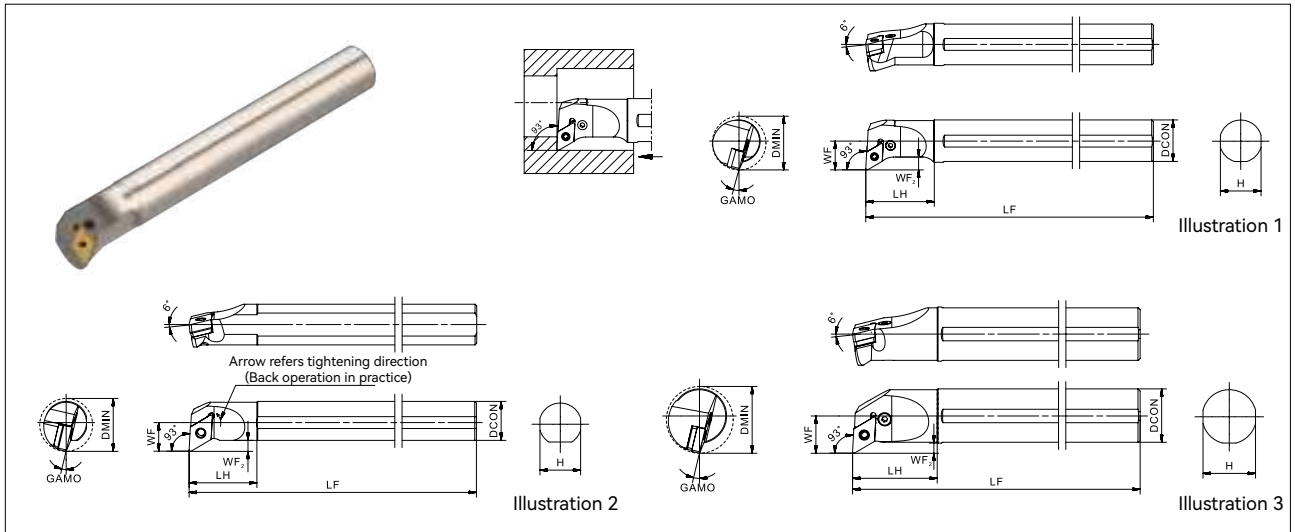
A-DDUN Steel Boring Bar(Internal/Internal Profile Boring)



Product code	Stock		Minimum boring hole diameter (mm)	Dimension								Insert corner radius (RE)	Internal coolant	Illustration	Spare parts							Insert
	R	L		DCON	H	LF	LH	WF	WF2	GAMO	Wrench				Lever screw	Clamp	Spring	Shim	Shim screw	Nozzle		
											DMIN											
A32S-DDUNR/L15-40	●	●	40	32	30	250	45	22	8	13°	0.8	With	1	LT-H3	CH 050215	CLD 255090	YB0.20-2.50-12-5.5	S-DDN 15032	SH 060100X	NZ 060020	DN*A 1504... DN*G 1504... DN*M 1504...	
A40T-DDUNR/L15-50	○	○	50	40	37	300	55	27	8.5	12°												
A50U-DDUNR/L15-63	○	○	63	50	47	350	65	35	10.5	12°												

● : Standard stock ○ : Made-to-Order

S-PDUN Steel Boring Bar(Internal/Internal Profile Boring)

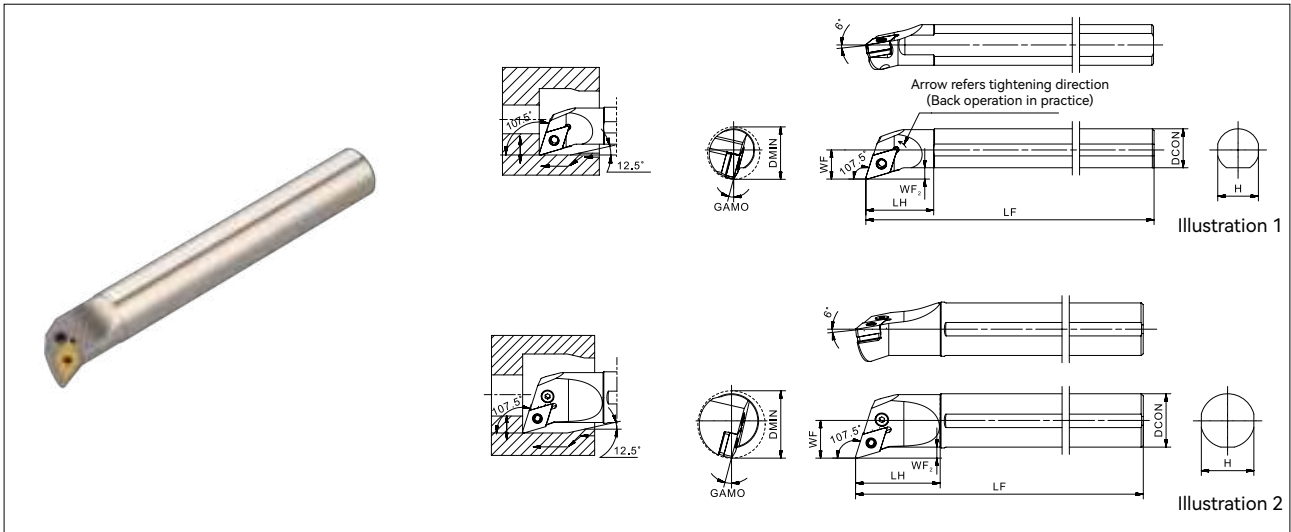


Product code	Stock		Minimum boring hole diameter (mm)	Dimension							Insert corner radius (RE)	Internal coolant	Spare parts						Insert	
	R	L		DCON	H	LF	LH	WF	WF2	GAMO			Wrench	Lever screw	Lever	Shim	Shim pin	Eccentric pin		
			DMIN																	
S20Q-PDUNR/L11-27	○	○	27	20	19	180	35	16	7.6	17°	0.8	Without	1	LT-H2.5	LH060142	LV3	S-PDN11027	SP3	-	DN*G 1104...
S25R-PDUNR/L11-32	○	○	32	25	24	200	40	17												
S32S-PDUNR/L11-40	○	○	40	32	31	250	45	22	8.5	12°										
S25R-PDUNR/L15-32	○	○	32	25	24	200	40	17	6.5	13°			3	LT-H3	-	-	S-PDN15032X	-	EP046140	DN*A 1504... DN*G 1504... DN*M 1504...
S32S-PDUNR/L15-44	○	○	44	32	31	250	50	22												
S40T-PDUNR/L15-54	○	○	54	40	39	300	65	27	7.5	12°										

● : Standard stock ○ : Made-to-Order

Turning Tools

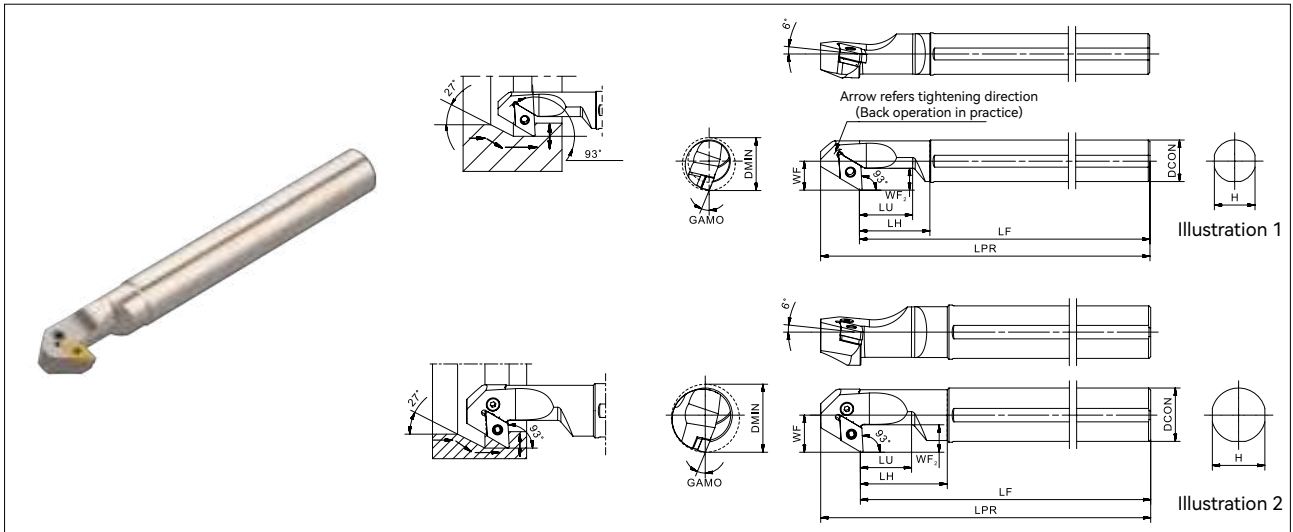
S-PDQN Steel Boring Bar (Internal/Internal Profile Boring)



Product code	Stock		Minimum boring hole diameter (mm)	Dimension							Insert corner radius (RE)	Internal coolant	Illustration	Spare parts						Insert
	R	L		DMIN	DCON	H	LF	LH	WF	WF2				GAMO	Wrench	Lever screw	Lever	Shim	Shim pin	
S25R-PDQNR/L15-32	○	○	32	25	24	200	40	17	6.5	13°	0.8	1	LT-H3	SP020050	-	S-PDN15032X	-	EP046140	DN*A 1504... DN*G 1504... DN*M 1504...	
S32S-PDQNR/L15-44	○	○	44	32	31	250	50	22						12°	2	LH080200	LV4B	S-PDN15032		SP4N
S40T-PDQNR/L15-54	○	○	54	40	39	300	65	27	7.5											

● : Standard stock ○ : Made-to-Order

S-PDZN Steel Boring Bar(Internal Back Boring)



Turning
Tools

Product code	Stock		Minimum boring hole diameter (mm)	Dimension								GAMO	Insert corner radius (RE)	Internal coolant	Illustration	Spare parts						Insert
	R	L		DMIN	DCON	H	LPR	LF	LH	LU	WF					WF2	GAMO	GAMO	Lever screw	Lever	Shim	
S25R-PDZNR/L15-32	○	○	32	25	24	225	200	40	17	13	13°	0.8	Without	1	LT-H3	SP 020050	-	S-PDN 15032X	-	EP 046140	DN*A 1504... DN*G 1504... DN*M 1504...	
S32S-PDZNR/L15-44	○	○	44	32	31	275	250	50	22	16				2	2	LT-H3	LH 080200	LV4B	S-PDN 15032	SP4N		-
S40T-PDZNR/L15-54	○	○	54	40	39	325	300	65	50	27	12°											

● : Standard stock ○ : Made-to-Order