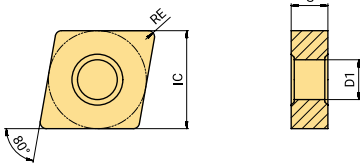


Negative 80° (C)

(mm)



Product code	IC	S	D1
CN_1204_	12.70	4.76	5.16
CN_1606_	15.875	6.35	6.35
CN_1906_	19.05	6.35	7.94

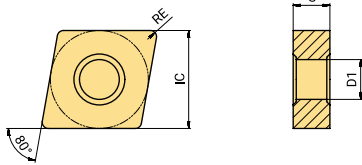
ISO Turning Inserts

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		
Finishing	 CNGG 120401FP-UF 120402FP-UF 120404FP-UF	0.10	0.02-0.12	0.50-2.50															
		0.20	0.02-0.12	0.50-2.50							○	●						●	○
		0.40	0.02-0.12	0.50-2.50							○	●						●	○
	 CNMG 120402E-PA1 120404E-PA1 120408E-PA1 120412E-PA1	0.20	0.04-0.25	0.20-1.50	●	●	●	●											
		0.40	0.04-0.28	0.20-1.50	●	●	●	●											
		0.80	0.05-0.35	0.20-1.50	●	●	●	●											
		1.20	0.05-0.42	0.20-1.50	●	●		●											
	 CNMG 120404E-PB1 120408E-PB1 120412E-PB1	0.40	0.05-0.15	0.26-3.20	●	●	●	●	○										
		0.80	0.10-0.30	0.52-3.20	●	●	○	●	○										
		1.20	0.15-0.45	0.78-3.20	○	○	●	●	●										
	 CNMG 120404E-SC1 120408E-SC1	0.40	0.07-0.18	0.20-0.80							●							●	
		0.80	0.10-0.25	0.20-0.80							●							●	
 CNMG 120404E-MB2 120408E-MB2	0.40	0.05-0.15	0.26-3.20						●	●	●	●							
	0.80	0.10-0.30	0.52-3.20						●	●	●	●							
Semi-finishing	 CNMG 120404E-SL3 120408E-SL3	0.40	0.12-0.25	0.60-3.00						●							●	●	
		0.80	0.15-0.30	0.80-3.00							●							●	●
	 CNMG 120404E-F2K 120408E-F2K	0.40	0.12-0.24	0.50-2.50	●														
		0.80	0.15-0.30	0.50-2.50	●														
	 CNMG 120404E-PB3 120408E-PB3 120412E-PB3	0.40	0.06-0.18	0.30-3.50	●	●	●	●	○										
		0.80	0.12-0.36	0.60-3.50	●	●	●	●	○										
		1.20	0.18-0.54	0.90-3.50	●	●	○	●	○										
	 CNMG 120404E-PC3 120408E-PC3 120412E-PC3	0.40	0.07-0.20	0.34-3.90	●	●		○											
		0.80	0.14-0.40	0.68-3.90	●	●	●	●											
		1.20	0.20-0.60	1.02-3.90	●	●		○	○										
	 CNMG 120404E-SC3 120408E-SC3 120412E-SC3 160612E-SC3	0.40	0.08-0.22	0.40-4.30						●	●	●						●	●
0.80		0.15-0.44	0.80-4.30						●	●	●	●					●	●	
1.20		0.23-0.66	1.20-4.30						●	●	●						●	●	
1.20		0.23-0.66	1.20-5.30						●	●	●						●	●	

● : Standard stock ○ : Made-to-Order

Negative 80° (C)

(mm)



Product code	IC	S	D1
CN_0903_	9.525	3.18	3.81
CN_1204_	12.70	4.76	5.16
CN_1606_	15.875	6.35	6.35
CN_1906_	19.05	6.35	7.94

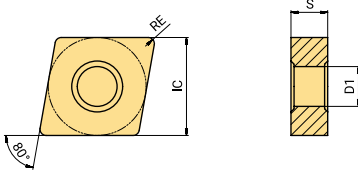
ISO Turning Inserts

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			
Roughing	CNMG 120408E-MC4	0.80	0.20-0.60	1.20-6.40								●	●	●	●				●	
	120412E-MC4	1.20	0.30-0.90	1.80-6.40								●	●	●	●				●	
	160612E-MC4	1.20	0.30-0.90	1.80-8.10								●	●	●	●				●	
	160616E-MC4	1.60	0.40-1.20	2.40-8.10								●	●	●	●					
	190612E-MC4	1.20	0.30-0.90	1.80-9.70								●	●	●	●					
	190616E-MC4	1.60	0.40-1.20	2.40-9.70								●	●	●	●					
	CNMG 090308E-KC4	0.80	0.18-0.48	0.96-3.90												●	●			
	120404E-KC4	0.40	0.09-0.24	0.48-5.20												●	●			
	120408E-KC4	0.80	0.18-0.48	0.96-5.20										●	●	●				
	120412E-KC4	1.20	0.26-0.72	1.44-5.20										●	●	●				
	120416E-KC4	1.60	0.35-0.96	1.92-5.20											●	●				
	160608E-KC4	0.80	0.18-0.48	0.96-6.40											●	●				
160612E-KC4	1.20	0.26-0.72	1.44-6.40											●	●					
160616E-KC4	1.60	0.35-0.96	1.92-6.40											●	●					
190608E-KC4	0.80	0.18-0.48	0.96-7.70											●	●					
190612E-KC4	1.20	0.26-0.72	1.44-7.70											●	●					
190616E-KC4	1.60	0.35-0.96	1.92-7.70											●	●					
190624E-KC4	2.40	0.53-1.44	2.88-7.70											●	●					
	CNMG 120408E-PD5	0.80	0.20-0.60	1.20-6.40			●	●	●	●										
	120412E-PD5	1.20	0.30-0.90	1.80-6.40			○	●	●	●										
	160608E-PD5	0.80	0.20-0.60	1.20-8.10			●	○												
	160612E-PD5	1.20	0.30-0.90	1.80-8.10			●	●	●	●										
	160616E-PD5	1.60	0.40-1.20	2.40-8.10			○	○	○	●										
	160624E-PD5	2.40	0.60-1.80	3.60-8.10			○	●	○											
	190612E-PD5	1.20	0.30-0.90	1.80-9.70			●	●	●	●										
	190616E-PD5	1.60	0.40-1.20	2.40-9.70			○	●	●											

● : Standard stock ○ : Made-to-Order

Negative 80° (C)

(mm)

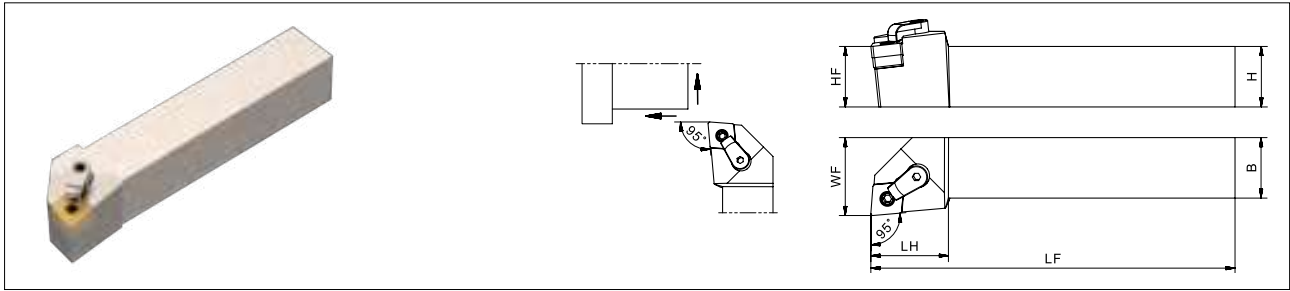


Product code	IC	S	D1
CN_1204_	12.70	4.76	5.16
CN_1606_	15.875	6.35	6.35
CN_1906_	19.05	6.35	7.94
CN_2507_	25.40	7.94	9.12
CN_2509_	25.40	9.52	9.12

Inserts	Product code	RE (mm)	Recommended parameters		Machining conditions													
					● Good Conditions ● General Conditions ✖ Bad Conditions													
					P						M				K		N	
f (mm/rev)	ap (mm)	AT202	AT210A	AC052P	AC152P	AC252P	AC350P	AC100M	AC200M	AP200U	AP301M	AC100K	AC102K	AC202K	AW100K	AP010S	AP100S	
Roughing	CNMA 120404E-KD5	0.40	0.10-0.30	0.60-6.40														
	120408E-KD5	0.80	0.20-0.60	1.20-6.40									●	●				
	120412E-KD5	1.20	0.30-0.90	1.80-6.40									●	●	●			
	120416E-KD5	1.60	0.40-1.20	2.40-6.40									●	●	●			
	160608E-KD5	0.80	0.20-0.60	1.20-8.10									●	●	●			
	160612E-KD5	1.20	0.30-0.90	1.80-8.10									●	●	●			
	160616E-KD5	1.60	0.40-1.20	2.40-8.10									●	●	●			
	160620E-KD5	2.00	0.50-1.50	3.00-8.10									●	●	●			
	190608E-KD5	0.80	0.20-0.60	1.20-9.70									●	●	●			
	190612E-KD5	1.20	0.30-0.90	1.80-9.70									●	●	●			
190616E-KD5	1.60	0.40-1.20	2.40-9.70									●	●	●				
Heavy roughing	CNMM 190616E-PC8	1.60	0.32-0.64	2.88-7.70				○	○									
	190624E-PC8	2.40	0.48-0.96	4.32-7.70				○	○									
	CNMM 120408E-PD8	0.80	0.16-0.32	1.44-5.20				○	○									
	120412E-PD8	1.20	0.24-0.48	2.16-5.20				○	○	●								
	160612E-PD8	1.20	0.24-0.48	2.16-6.40				○	●	●								
	160616E-PD8	1.60	0.32-0.64	2.88-6.40				○	●									
	160624E-PD8	2.40	0.48-0.96	4.32-6.40				○	○									
	190612E-PD8	1.20	0.24-0.48	2.16-7.70				○	○	●								
	190616E-PD8	1.60	0.32-0.64	2.88-7.70				○	○	●								
	190624E-PD8	2.40	0.48-0.96	4.32-7.70				○	○	○	●							
	250724E-PD8	2.40	0.48-0.96	4.32-10.30				○	○	○								
	250924E-PD8	2.40	0.48-0.96	4.32-10.30				○	○									
	CNMM 190612S-PC9	1.20	0.26-0.60	2.40-9.70				○	●									
	190616S-PC9	1.60	0.35-0.80	3.20-9.70				●	●	●								
	190624S-PC9	2.40	0.53-1.20	4.80-9.70				●	○									
	250724S-PC9	2.40	0.53-1.20	4.80-12.90				○	○									
	250924S-PC9	2.40	0.53-1.20	4.80-12.90				●	●									
	CNMM 190612S-PD9	1.20	0.30-0.72	2.64-11.60				○	○	●								
	190616S-PD9	1.60	0.40-0.96	3.52-11.60				○	○									
	190624S-PD9	2.40	0.60-1.44	5.28-11.60				●	○									
250724S-PD9	2.40	0.60-1.44	5.28-15.50				○	○										
250924S-PD9	2.40	0.60-1.44	5.28-15.50				○	○	●									

● : Standard stock ○ : Made-to-Order

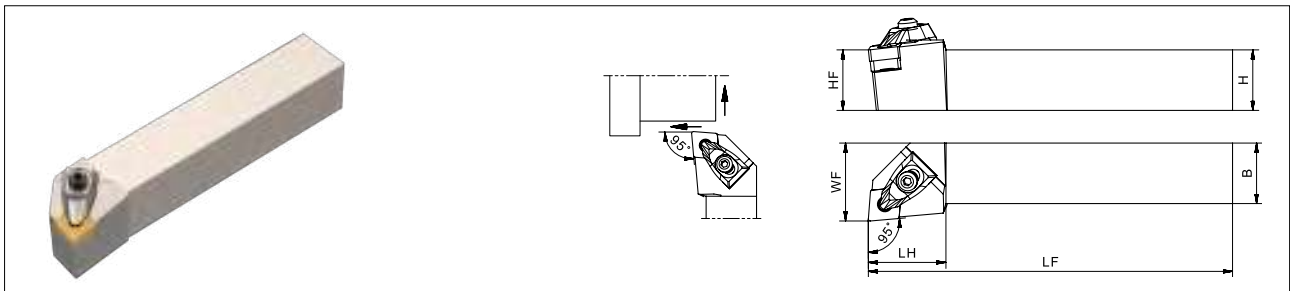
MCLN (External/Face Turning)



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			
MCLN^{R/L}																	
2020K-12	●	●	20	20	20	125	33	35	0.8	LT-H3	CD060255X	CLM180130	CS060170	S-MCN12048	CN*A 1204...	CN*G 1204...	CN*M 1204...
2525M-12	●	●	25	25	25	150	32	32									

● : Standard stock ○ : Made-to-Order

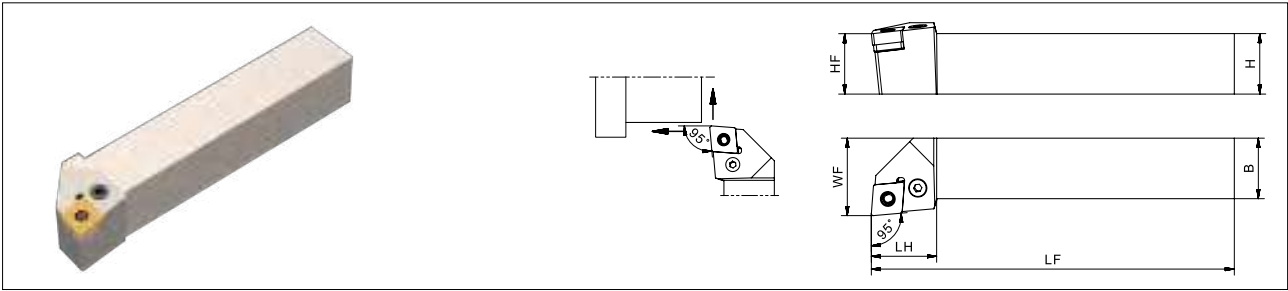
DCLN (External/Face Turning)



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			
DCLN^{R/L}																		
2020K-12	●	●	20	20	20	125	32	25	0.8	LT-H3	CH050215	CLD255090	YB0.20-2.50-12-5.5	SH060100X	S-DCN12048	CN*A 1204...	CN*G 1204...	CN*M 1204...
2525M-12	●	●	25	25	25	150		32										

● : Standard stock ○ : Made-to-Order

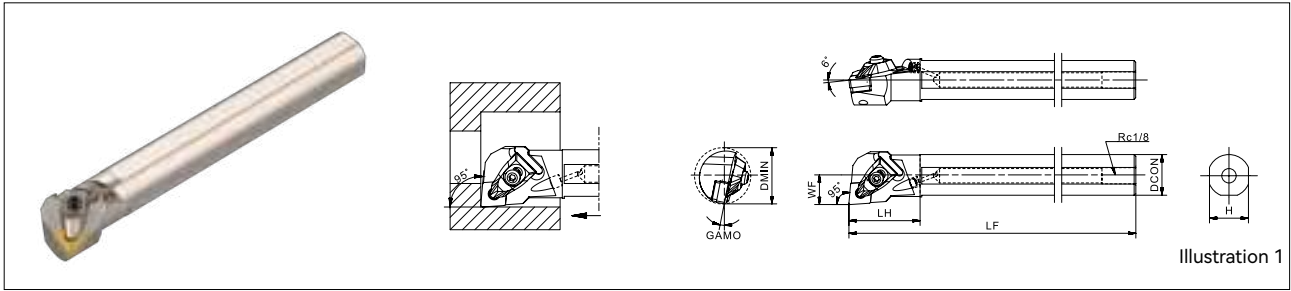
PCLN (External/Face Turning)



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	
PCLN ^{R/L} 1616H-0903	○	○	16	16	16	100		20	0.8	LT-H2.5	LH060170	LV3	S-PCN09032	SP3	CN*G 0903...
	○	○	20	20	20	125	22	25							
	○	○	25	25	25	150		32							
PCLN ^{R/L} 1616H-12	○	○	16	16	16	100		20	0.8	LT-H3	LH080200	LV4C	S-PCN12032	SP4N	CN*A 1204... CN*G 1204... CN*M 1204...
	○	●	20	20	20	125	27	25							
	●	●	25	25	25	150		32							
	○	○	32	32	32	170		40							
PCLN ^{R/L} 2525M-16	○	○	25	25	25	150		32	1.2	LT-H4	LH100270	LV6	S-PCN19048	SP6	CN*A 1906... CN*G 1906... CN*M 1906...
	○	○	32	32	32	170	32	40							
	○	○	40	40	40	250		50							
PCLN ^{R/L} 3232P-19	○	○	32	32	32	170		40	2.4	LT-H5	LH120360	LV8	S-PCN25080	SP8N	CN*A 2507... CN*G 2507... CN*M 2507...
	○	○	40	40	40	250	45	45							
	○	○	32	32	32	170	45	45							
PCLN ^{R/L} 3232P-2509	○	○	32	32	32	170		45	2.4	LT-H5	LH120360	LV8	S-PCN25064	SP8N	CN*A 2509... CN*G 2509... CN*M 2509...
	○	○	40	40	40	250		45							

● : Standard stock ○ : Made-to-Order

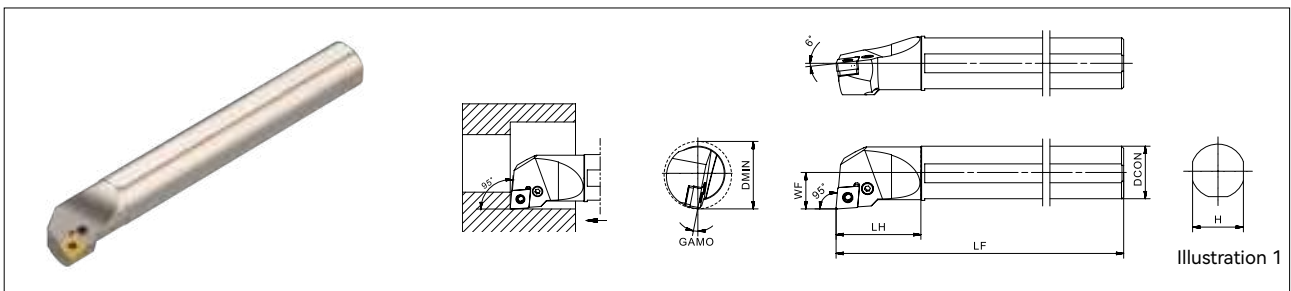
A-DCLN Steel Boring Bar(Internal/Internal Face Boring)



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				GAMO	Wrench	Lever screw	Clamp	Spring	Shim		Shim screw
A25R-DCLNR/L12-32	●	●	32	25	23	200	42	17	11°	0.8	With	1	LT-H3	CH 050215	CLD 255090	YB0.20-2.50-12-5.5	S-DCN 12032	SH 060080X	NZ 060020	CN*A 1204... CN*G 1204... CN*M 1204...
A32S-DCLNR/L12-40	●	●	40	32	30	250	50	22												
A40T-DCLNR/L12-50	○	○	50	40	37	300	60	27												

● : Standard stock ○ : Made-to-Order

S-PCLN Steel Boring Bar(Internal/Internal Face 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				GAMO	Wrench	Lever screw	Lever	Shim	
S25R-PCLNR/L12-32	○	○	32	25	24	200	42	16.3	10°	0.8	Without	1	LT-H3	LH080200	LV4C	S-PCN12032	SP4N	CN*A 1204... CN*G 1204... CN*M 1204...
S32S-PCLNR/L12-40	●	●	40	32	30	250	50	21										
S40T-PCLNR/L12-50	○	○	50	40	37	300	60	25										

● : Standard stock ○ : Made-to-Order