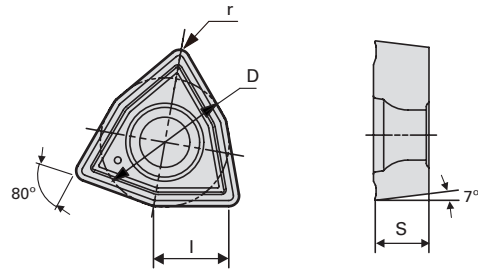
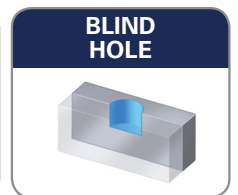
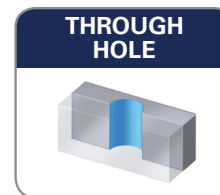


WCMX



Designation	Grade	Dimensions			
		l	D	S	r
WCMX 040208	YG602	3.33	6.35	2.38	0.8
WCMX 050308	YG602	3.39	7.94	3.18	0.8
WCMX 06T308	YG602	4.48	9.53	3.97	0.8
WCMX 080412	YG602	7.26	12.7	4.76	1.2



WCMX 0402
Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.05	0.10	0.08	180	270	225
	Low Alloys	200	0.05	0.10	0.08	120	230	175
	High Alloys	220	0.07	0.10	0.09	70	170	120
M	Austenitic	190	0.05	0.10	0.08	170	230	200
K	Grey Cast Iron	140	0.10	0.11	0.11	150	230	190

WCMX 0503
Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.06	0.11	0.09	180	270	225
	Low Alloys	200	0.06	0.11	0.09	120	230	175
	High Alloys	220	0.09	0.11	0.10	70	170	120
M	Austenitic	190	0.06	0.11	0.09	170	230	200
K	Grey Cast Iron	140	0.13	0.12	0.13	150	230	190

WCMX 06T3
Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.06	0.12	0.07	180	270	230
	Low Alloys	200	0.06	0.12	0.06	120	230	180
	High Alloys	220	0.08	0.12	0.10	70	170	120
M	Austenitic	190	0.06	0.12	0.09	170	230	200
K	Grey Cast Iron	140	0.12	0.13	0.13	150	230	190

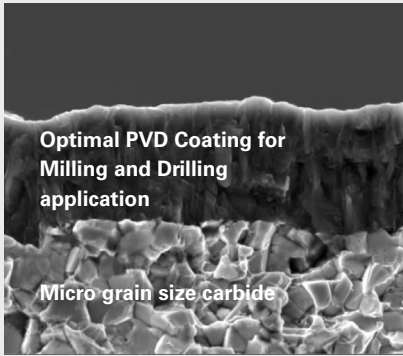
WCMX 0804
Recommended Cutting Condition

Material			Cutting Conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev.)			Vc (m/min.)		
			Min.	Max.	Recommend	Min.	Max.	Recommend
P	Non Alloys	120	0.06	0.16	0.11	180	270	225
	Low Alloys	200	0.06	0.16	0.11	120	230	175
	High Alloys	220	0.09	0.16	0.13	70	170	120
M	Austenitic	190	0.06	0.15	0.11	170	230	200
K	Grey Cast Iron	140	0.10	0.18	0.14	150	230	190

Features of Grades :

YG-1 Universal grades, designs for multi-purpose application and extremely efficient in covering materials including Steels, Stainless Steels and Cast Iron.

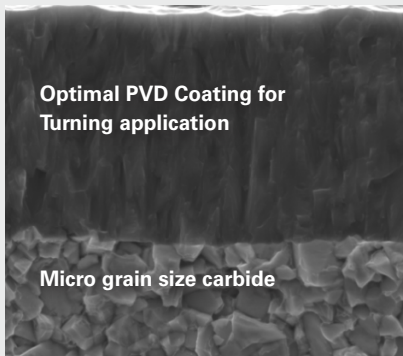
YG602



Exclusive PVD coating / Unique Substrate for MILLING and DRILLING Application

- Ultra dense PVD coating with optimal thermal resistance & added strength
- Sub-micron substrate designed for demanding application

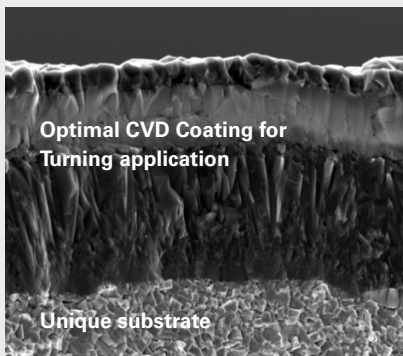
YG801



Exclusive PVD coating / Unique Substrate for TURNING Application

- Unique PVD coating and substrate designed to balance edge strength & wear resistance for continuous machining.
- Excellent cutting performance under harsh machining condition.

YG1001



Unique Substrate / CVD coating for TURNING Application

- Thick coating optimized for Cast iron applications and harsh machining condition.
- Advanced CVD coating with optimal thermal & wear resistance for turning applications.
- Exceptional cutting performance attributed to combination of carbide substrate and coating.

Grade	P	M	K	S
YG602	P30-40	M20-30	K20-30	S10-20
YG801	P20-40	M20-40	K10-25	S05-25
YG1001	-	-	K10-25	-