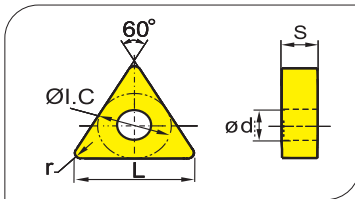


TN** Negative Insert · Negative WSP



		Ideal Machining Condition Gute Bearbeitungsbedingungen	Normal Machining Condition Normale Bearbeitungsbedingungen	Unfavorable Machining Condition Ungünstige Bearbeitungsbedingungen
P Steel / Stahl		●	●	●
M Stainless Steel / Rostfreier Stahl		●	●	●
K Cast iron / Gusseisen		●	●	●
N Non-ferrous material / Ne Metalle		●	●	●
S Heat-resistant steel / Warmfester Stahl		●	●	●

Insert Shape Schneid- plattenform	Type · Typ	Dimension (mm) Abmessung					Coated Carbide Beschichtetes Hartmetall																Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall				
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG202	YBG205	YBG302	YBM151	YBM251	YBM351	YBD052	YBD102	YBD151	YBD152			YBD252	YNG151	YNG151C	YC10	YC40
 DR Roughing/ Schruppen	TNMM160408-DR	16.5	9.525	4.76	3.81	0.8		●		●																			
	TNMM160412-DR	16.5	9.525	4.76	3.81	1.2		●																					
	TNMM220408-DR	22	12.7	4.76	5.16	0.8		●		●																			
	TNMM220412-DR	22	12.7	4.76	5.16	1.2		●		●																			
	TNMM220416-DR	22	12.7	4.76	5.16	1.6		○		○																			
	TNMM270612-DR	27.5	15.875	4.76	5.16	1.2					○																		
	TNMM270616-DR	27.5	15.875	4.76	5.16	1.6					○																		
 ER Roughing/ Schruppen	TNMG160408-ER	16.5	9.525	4.76	3.81	0.8									○														
	TNMG160412-ER	16.5	9.525	4.76	3.81	1.2									○														
	TNMG220408-ER	22	12.7	4.76	5.16	0.8									○														
	TNMG220412-ER	22	12.7	4.76	5.16	1.2									○														

Tool holder / Klemmhalter

DTGNR/L Kr:91° 	PTFNR/L Kr:90° 	PTTNR/L Kr:60° 	PTGNR/L Kr:90° 	MTGNR/L Kr:90° 	MTJNR/L Kr:93° 	MTFNR/L Kr:90°
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Insert code key
ISO Code

A50-A51

Grade selection reference
Sortenauswahl

A16/A37-A47

chip breaker selection reference
Spanbrecherauswahl

A28-A36

Recommended cutting parameters
Empfohlene Schnittparameter

A261-A263