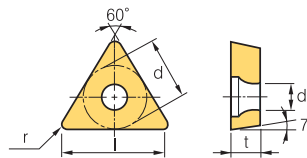


## B Turning Insert (Positive)

TC ○○



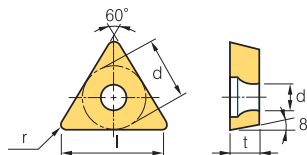
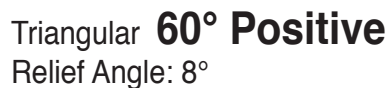
| Dimensions (mm) |       |      |                |
|-----------------|-------|------|----------------|
| Size            | d     | t    | d <sub>1</sub> |
| 09              | 5.56  | 2.38 | 2.5            |
| 11              | 6.35  | 2.38 | 2.8            |
| 16              | 9.523 | 3.97 | 4.4            |

[illegible]

| Inserts             |                                                                                                    | Designation | Cermet     |        | Coated | Coated |        |        |        |        |        |        |        |        |        |        |        |        | Uncoated |        | Cutting Condition |        |        |     |           |                |            |           |           |
|---------------------|----------------------------------------------------------------------------------------------------|-------------|------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|----------|--------|-------------------|--------|--------|-----|-----------|----------------|------------|-----------|-----------|
|                     |                                                                                                    |             | CN1500     | CN2000 | CN2500 | CC1500 | CC2500 | NC3215 | NC3120 | NC3225 | NC3030 | NC5330 | NC6310 | NC6315 | NC9115 | NC9125 | NC9135 | PC5300 | PC5400   | PC8105 | PC8110            | PC8115 | PC9030 | H01 | H05       | fn<br>(mm/rev) | ap<br>(mm) |           |           |
| Medium to finishing | <div>MP</div>     | TCMT        | 090204-MP  |        |        |        |        |        |        |        |        |        |        |        | ●      | ●      | ●      |        |          |        |                   |        |        |     |           |                | 0.05~0.18  | 0.10~1.00 |           |
|                     |                                                                                                    |             | 090208-MP  |        |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |     |           |                |            | 0.08~0.20 | 0.10~1.20 |
|                     |                                                                                                    |             | 110202-MP  |        |        |        |        |        | ●      |        | ●      |        | ●      |        |        | ●      | ●      | ●      |          |        |                   | ●      | ●      |     |           |                |            | 0.03~0.12 | 0.20~1.50 |
|                     |                                                                                                    |             | 110204-MP  |        |        |        |        |        | ●      |        | ●      |        | ●      |        |        | ●      | ●      | ●      |          |        |                   | ●      | ●      |     |           |                |            | 0.05~0.15 | 0.20~15.0 |
|                     |                                                                                                    |             | 110208-MP  |        |        |        |        |        | ●      |        | ●      |        | ●      |        |        | ●      | ●      | ●      | ●        |        |                   | ●      | ●      |     |           |                |            | 0.10~0.28 | 0.25~2.00 |
|                     |                                                                                                    |             | 16T302-MP  |        |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |     |           |                |            | 0.08~0.25 | 0.20~1.50 |
|                     |                                                                                                    |             | 16T304-MP  | ●      |        | ●      |        | ●      | ●      |        | ●      |        | ●      |        | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●   |           |                |            | 0.08~0.20 | 0.30~2.50 |
|                     |                                                                                                    |             | 16T308-MP  | ●      |        | ●      |        | ●      | ●      |        | ●      |        | ●      |        | ●      | ●      | ●      | ●      | ●        | ●      | ●                 | ●      | ●      | ●   |           |                |            | 0.10~0.30 | 0.50~2.50 |
|                     |                                                                                                    |             | 16T312-MP  |        |        |        |        |        |        | ●      |        | ●      |        | ●      |        |        | ●      | ●      | ●        |        |                   | ●      | ●      | ●   |           |                |            | 0.20~0.40 | 0.50~2.50 |
| 220408-MP           |                                                                                                    |             |            |        |        |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |     | 0.20~0.40 | 0.50~3.50      |            |           |           |
| Medium cutting      | <div>C25</div>  | TCMT        | 090204-C25 | ●      |        | ●      | ●      | ●      | ●      |        | ●      |        | ●      |        |        |        |        | ●      | ●        |        | ●                 |        |        |     |           |                | 0.06~0.18  | 0.40~2.50 |           |
|                     |                                                                                                    |             | 090208-C25 | ●      |        | ●      | ●      | ●      | ●      |        | ●      |        | ●      |        |        |        |        |        | ●        | ●      |                   |        |        |     |           |                | 0.08~0.25  | 0.80~2.50 |           |
|                     |                                                                                                    |             | 110202-C25 | ●      |        | ●      | ●      | ●      | ●      |        | ●      |        | ●      |        |        |        |        |        |          | ●      | ●                 |        | ●      |     |           |                | 0.04~0.12  | 0.40~2.00 |           |
|                     |                                                                                                    |             | 110204-C25 | ●      | ●      | ●      | ●      | ●      | ●      |        | ●      |        | ●      |        |        |        |        |        | ●        | ●      |                   | ●      |        |     |           |                | 0.06~0.20  | 0.60~2.50 |           |
|                     |                                                                                                    |             | 110208-C25 | ●      |        | ●      | ●      | ●      | ●      |        | ●      |        | ●      |        | ●      |        |        |        | ●        | ●      |                   | ●      |        | ●   |           |                | 0.08~0.25  | 0.80~2.50 |           |
|                     |                                                                                                    |             | 16T304-C25 | ●      |        | ●      | ●      | ●      | ●      | ●      |        | ●      |        | ●      |        | ●      |        |        | ●        | ●      |                   | ●      |        | ●   |           |                | 0.08~0.28  | 0.80~3.00 |           |
|                     |                                                                                                    |             | 16T308-C25 | ●      |        | ●      | ●      | ●      | ●      | ●      | ●      |        | ●      |        |        |        |        |        | ●        | ●      |                   | ●      |        | ●   |           |                | 0.10~0.30  | 1.00~3.00 |           |

● : Stock item

TO ☐ ☐



| Dimensions (mm) |      |      |                |
|-----------------|------|------|----------------|
| Size            | d    | t    | d <sub>i</sub> |
| 06              | 3.97 | 1.59 | 2.15           |
| 09              | 5.56 | 2.38 | 2.8            |
| 14              | 8.2  | 3.0  | 3.8            |

| Workpiece | Steel                                | P |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  | Machining types |
|-----------|--------------------------------------|---|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|--|-----------------|
|           | Stainless steel                      | M |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |                 |
|           | Cast iron                            | K |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |                 |
|           | Non-ferrous metal                    | N |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |                 |
|           | Heat resistant alloy, Titanium alloy | S |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |                 |
|           | Hardened steel                       | H |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |                 |
|           |                                      |   |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |                 |

[illegible]

● : Stock item

