

PARTING & GROOVING

Parting & Grooving Overview

Parting & Grooving Inserts (TD.)

Parting & Grooving Overview

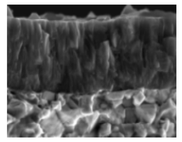
Parting & Groove Turn Grades

Parting and Grooving Grades		P Steel				M Stainless steel			K Cast iron			N Non Ferrous		S Super Alloy	
		P10	P20	P30	P40	M10	M20	M30	K10	K20	K30	N10	N20	S10	S20
PVD	YG602G (YG602)		602G				602G			602G					602G

YG602G
(YG602)

P20 - P35 | M20 - M40
K20 - K40 | S15 - S25

PVD - TiAlN



Universal grade for Parting & Groove Turn

- Ultra Dense PVD Coating with optimal thermal resistance & strength
- Sub-Micron substrate designed for demanding application
- YG602G : First Choice for Low Cutting Speed, Soft and Sticky Material with Low Hardness
- YG602 : First Choice for General Application

Parting & Grooving Inserts



TD. Series

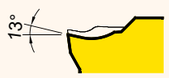
Inserts
TDN
TDP
TDY

2, 3, 4

Parting & Grooving Chipbreakers

-P TDP

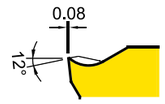




• Parting & Grooving (Positive)

-N TDN





• Parting & Grooving (General)

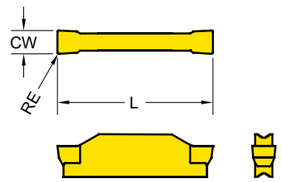
-Y TDY





• Turning, Parting & Grooving

Parting & Grooving Inserts (TD.)



Series	L	CW
TD*2	20	2
TD*3	20	3
TD*4	20	4

* CDX : Cutting Depth Maximum

● : Stock item ○ : Order made item

TD.		Designation	RE	Parting & Grooving Fn (mm/rev.)	Parting & Grooving CDX (mm)	Side Turning Fn (mm/rev.)	Side Turning Ap (mm)	EDP 5200.. YG602	EDP 5200.. YG602G
TDP	 Parting & Grooving (Positive)	TDP2002	0.2	0.04~0.12	19			● 0012	○ 0036
		TDP3002	0.2	0.05~0.16	19			● 0029	○ 0030
		TDP4003	0.3	0.06~0.18	19			● 0023	○ 0038
TDN	 Parting & Grooving (General)	TDN2002	0.2	0.06~0.18	19			● 0010	○ 0035
		TDN3002	0.2	0.07~0.22	19			● 0024	○ 0025
		TDN4003	0.3	0.08~0.25	19			● 0022	○ 0037
TDY	 Groove Turn	TDY3E - 0.4	0.4	0.10~0.20	19	0.10~0.38	0.50~2.20	○ 0019	● 0027
		TDY4E - 0.4	0.4	0.15~0.26	19	0.10~0.40	0.50~2.80		● 0020

Cutting Speed			Vc (m/min.)	
ISO	VDI	Sub Group	YG602G (YG602) Min.	Max.
P	1~5	Non-alloyed steel	90	180
	6~9	Low-alloyed steel	80	120
	10~11	High-alloyed steel	80	110
M	12~13	Ferritic & martensitic stainless steel	70	160
	14	Austenitic stainless steel	55	140
K	15~16	Grey cast iron	110	185
	17~18	Nodular cast iron	110	140
N	21~30	Non-ferrous metals (al)	250	440
S	31~37	Superalloys & Titanium	25	45
H	38~41	Hard materials	25	50