

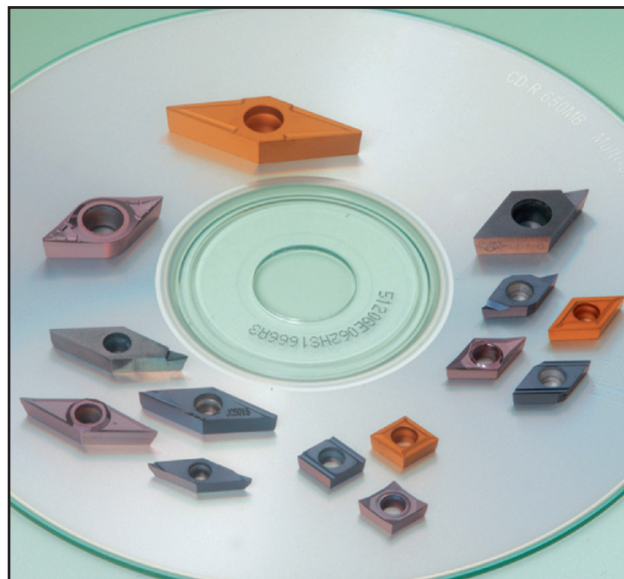
DIJET CARBIDE TOOLS

Turning Inserts

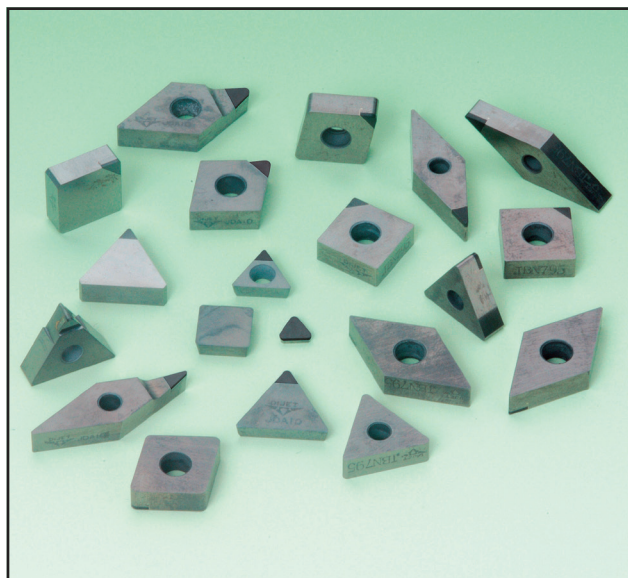
Turning Inserts



Standard ISO Inserts



Inserts for Small Components



Diamond & CBN Inserts

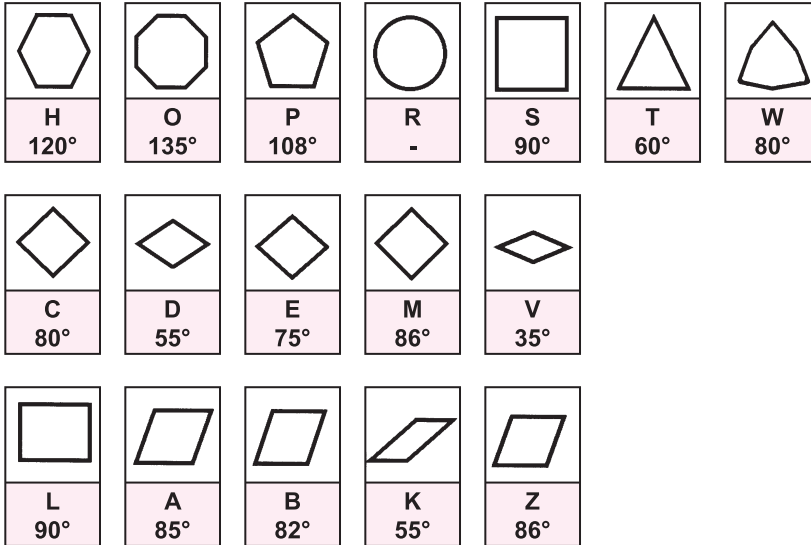


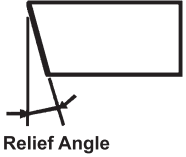
Arno Inserts

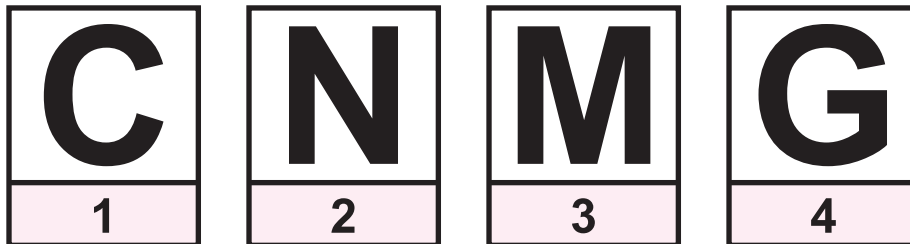
Turning Inserts

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Standard ISO Inserts	
80° Diamond	E-5 ~ E-7
55° Diamond	E-8 ~ E-10
Round	E-10
Square	E-11 ~ E-13
Triangular	E-14 ~ E-16
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Turning Inserts

1
Insert Shape

2
Relief Angle

Symbol	Relief Angle	
A	3°	
B	5°	
C	7°	
D	15°	
E	20°	
F	25°	
G	30°	
N	0°	
P	11°	


3
Tolerance

Symbol	Nose Height	Thickness	Inscribed Circle
A	±.0002	±.001	±.001
F	±.0002	±.001	±.0005
C	±.0005	±.001	±.001
H	±.0005	±.001	±.0005
E	±.001	±.001	±.001
G	±.001	±.005	±.001
J	±.0002	±.001	±.002 ~ ±.005
K*	±.0005	±.001	±.002 ~ ±.005
L*	±.001	±.001	±.002 ~ ±.005
M*	±.003 ~ ±.007	±.005	±.002 ~ ±.005
U*	±.005 ~ ±.015	±.005	±.003 ~ ±.010

4
Type of Insert

Symbol	Shape	Symbol	Shape
A		N	
B		R	
F		T	
G		W	
H		X	Special Design
M			

Turning Inserts

5
Sizes (I.C.)

I.C.	Symbol	
	Normal	Small
5/32	-	5
3/16	-	6
7/32	-	7
1/4	2	8
5/16	-	0
3/8	3	-
1/2	4	-
5/8	5	-
3/4	6	-
7/8	7	-
1	8	-
1 1/4	0	-

6
Thickness

Thickness	Symbol	
	Normal	Small
1/16	-	2
3/32	-	3
1/8	2	4
5/32	-	5
3/16	3	6
1/4	4	-
5/16	5	-
3/8	6	-

7
Radius

Radius	Symbol
-	0
1/64	1
1/32	2
3/64	3
1/16	4
5/64	5
3/32	6
7/64	7
1/8	8

8
Feed Direction

Symbol	Feed Direction
R	Right Hand
L	Left Hand
N	Neutral

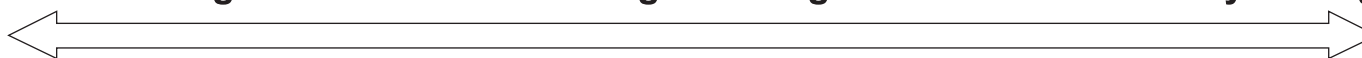
4
5

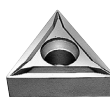
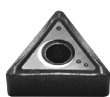
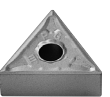
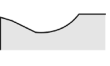
3
6

2
7

R
8

GG
9

9
Chip Breakers
For finishing
For light cutting
For heavy cutting


										
PF	UA	FT	SF	SG	UR	UT	PG	UB	GG	UD
										

Turning Inserts

Recommended Cutting Data

MATERIAL DESCRIPTION	AISI	ISO	APPLICATION	SFM (ft / mn)												CHIP BREAKER
				100	200	300	400	500	600	700	800	900	1000	1100	1200	
Very Soft Steel Low-Carbon Steel Mild Steel (< 0.3% C) (100 ~ 220 BHM)	1010	S10C	Tough					JC450V								UD or UB
	1015	S15C	Rough					JC325V								UB or GG
	1020	S20C	Medium							JC215V						UR or PG
	1023	S22C	Light									JC110V				UT or PF
	1025	S25C	Finish									JC110V				FT or UA
	1030	S30C														
Medium-Carbon Steel High-Carbon Steel Mild Steel (> 0.3% C) (140 ~ 320 BHM)	1035	S35C	Tough				JC450V									UD or UB
	1040	S40C	Rough				JC325V									UB or GG
	1045	S45C	Medium						JC215V							UR or PG
	1050	S50C	Light								JC110V					UT or PF
	1055	S55C	Finish								JC110V					FT or UA
	1060	S60C														
Alloy Steel Tool Steel (~35 HRc)	4130	SCM430	Tough				JC450V									UD or UB
	4140	SCM440	Rough				JC450V									UB or GG
	5130	SCr430	Medium					JC325V								UR or PG
	5140	SCr440	Light							JC215V						UT or PF
	M2	SKH51	Finish							JC110V						FT or UA
	H13	SKD61														
Alloy Steel Tool Steel (36 ~ 48 HRc)	4130	SCM430	Tough	JC450V												UD or UB
	4140	SCM440	Rough		JC450V											UB or GG
	5130	SCr430	Medium			JC325V										UR or PG
	5140	SCr440	Light				JC215V									UT or PF
	M2	SKH51	Finish					JC110V								FT or UA
	H13	SKD61														

Turning Inserts

Recommended Cutting Data

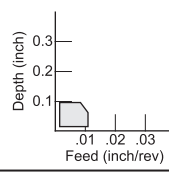
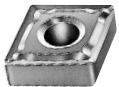
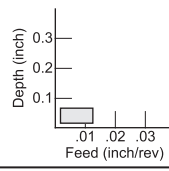
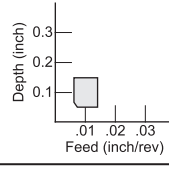
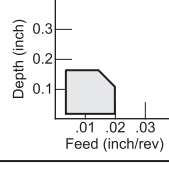
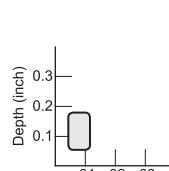
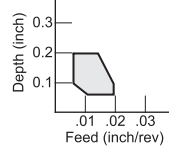
MATERIAL DESCRIPTION	AISI	ISO	APPLICATION	SFM (ft / mn)												CHIP BREAKER
				100	200	300	400	500	600	700	800	900	1000	1100	1200	
Austenitic Stainless Steel (<28 HRc)	304	SUS304	Medium		JC215V											UR or GG
	304L	SUS304L	Light			JC5015										SG
	316	SUS316	Finish				JC110V									SF
	316L	SUS316L														
Ferritic & Martensitic Stainless Steel (<40 HRc)	410	SUS410	Medium		JC215V											UR or GG
	410L	SUS410L	Light			JC5015										SG
	440	SUS440	Finish				JC110V									SF
	630	SUS630														

MATERIAL DESCRIPTION	AISI	ISO	APPLICATION	SFM (ft / mn)						CHIP BREAKER
				500		1000		1500		
Nodular Cast Iron High-Alloy Cast Iron (120 ~ 320 BHM)	A48-50B	FCD	Tough	JC325V					UD or UB	
	A48-60B	FCD	Rough	JC215V					UB or GG	
	A220-7	FCM	Medium	JC110V					UR or PG	
	A220-8	FCM	Light		JC105V				UT or PF	
	A2209	FCM	Finish		JC105V	JBN795			FT or UA	
Cast Iron Gray Cast Iron (120 ~ 320 BHM)	A48-20B 60/40/18	FC FC	Tough	JC325V					UD or UB	
			Rough	JC215V					UB or GG	
			Medium	JC110V					UR or PG	
			Light		JC105V				UT or PF	
			Finish		JC105V	JBN795			FT or UA	

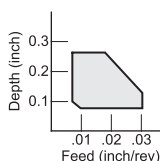
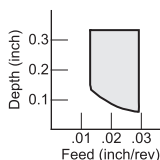
MATERIAL DESCRIPTION	AISI	ISO	APPLICATION	SFM (ft / mn)												CHIP BREAKER
				100	200	300	400	500	600	700	800					
Hardened Steel Hardened Cast Iron (50 ~ HRc)	4340	SNCM430	Medium		JBN245											-
	H-13	SKD61	Light			JBN795										-
	A48-20B A1220-	FC FCM	Finish				JBN795									-

MATERIAL DESCRIPTION	AISI	ISO	APPLICATION	SFM (ft / mn)				CHIP BREAKER
				1000	2000	3000	4000	
Aluminum Aluminum Alloy Hi-Si Aluminum Alloy (>12% Si)			Medium		JDA10			-
			Light		JDA10		-	
			Finish			JDA715	-	

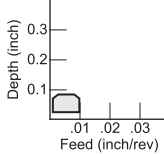
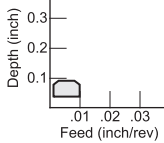
Turning Inserts

80° Diamond	PART ID		COATED								UNCOATED					DESCRIPTION						
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Negative																						
CNMG UA for Finishing to Light 	CNMG 431-UA CNMG 432-UA	CNMG 120404-UA CNMG 120408-UA		• •	• •	• •					•		•						.500 .500	.187 .187	.016 .031	.203 .203
CNMG PF for Finishing to Light 	CNMG 321-PF CNMG 322-PF	CNMG 090304-PF CNMG 090308-PF		• •															.375 .375	.125 .125	.016 .031	.150 .150
CNMG SF for Finishing to Light 	CNMG 431-SF CNMG 432-SF	CNMG 120404-SF CNMG 120408-SF		• •					• •	• •									.500 .500	.187 .187	.016 .031	.203 .203
CNMG UT for Light to Medium 	CNMG 431-UT CNMG 432-UT CNMG 433-UT	CNMG 120404-UT CNMG 120408-UT CNMG 120412-UT		• •	• •	• •					•		• •						.500 .500 .500	.187 .187 .187	.016 .031 .047	.203 .203 .203
CNMG SG for Light to Medium 	CNMG 431L-SG CNMG 431R-SG CNMG 432L-SG CNMG 432R-SG CNMG 433L-SG CNMG 433R-SG	CNMG 120404L-SG CNMG 120404R-SG CNMG 120408L-SG CNMG 120408R-SG CNMG 120412L-SG CNMG 120412R-SG						• • • • • •	• • • • • •									.500 .500 .500 .500 .500 .500	.187 .187 .187 .187 .187 .187	.016 .016 .031 .031 .047 .047	.203 .203 .203 .203 .203 .203	
CNMG PG for Light to Medium 	CNMG 321-PG CNMG 322-PG CNMG 431-PG CNMG 432-PG CNMG 433-PG CNMG 434-PG CNMG 542-PG CNMG 543-PG	CNMG 090304-PG CNMG 090308-PG CNMG 120404-PG CNMG 120408-PG CNMG 120412-PG CNMG 120416-PG CNMG 160608-PG CNMG 160612-PG	• • • • • • • •	• • • • • • • •	• • • • • • • •	• • • • • • • •												.375 .375 .500 .500 .500 .500 .625 .625	.125 .125 .187 .187 .187 .187 .250 .250	.016 .031 .016 .031 .047 .063 .031 .047	.150 .150 .203 .203 .203 .203 .250 .250	
CNMG UR for Light to Medium 	CNMG 322-UR CNMG 431-UR CNMG 432-UR CNMG 433-UR	CNMG 090308-UR CNMG 120404-UR CNMG 120408-UR CNMG 120412-UR			•								• • •		• • •			.375 .500 .500 .500	.125 .187 .187 .187	.031 .016 .031 .047	.150 .203 .203 .203	

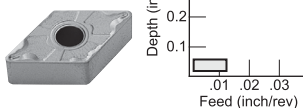
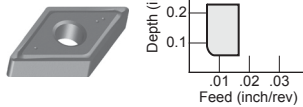
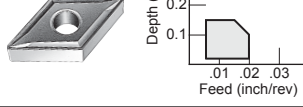
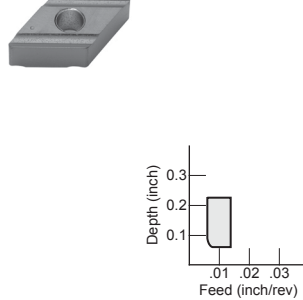
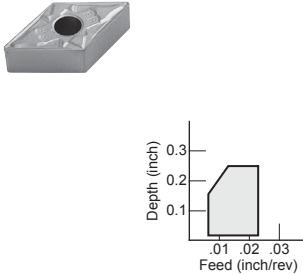
Turning Inserts

80° Diamond	PART ID		COATED								UNCOATED					DESCRIPTION							
											CERMET												
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter	
M class - Negative																							
CNMG GG for Medium  	CNMG 431-GG	CNMG 120404-GG	•	•	•	•	•												.500	.187	.016	.203	
	CNMG 432-GG	CNMG 120408-GG	•	•	•	•	•													.500	.187	.031	.203
	CNMG 433-GG	CNMG 120412-GG	•	•	•	•	•													.500	.187	.047	.203
	CNMG 434-GG	CNMG 120416-GG					•	•												.500	.187	.063	.203
	CNMG 542-GG	CNMG 160608-GG		•	•															.625	.250	.031	.250
	CNMG 543-GG	CNMG 160612-GG			•	•	•													.625	.250	.047	.250
	CNMG 642-GG	CNMG 190608-GG		•	•	•	•													.750	.250	.031	.312
	CNMG 643-GG	CNMG 190612-GG		•	•	•	•													.750	.250	.047	.312
	CNMG 644-GG	CNMG 190616-GG		•	•	•	•													.750	.250	.063	.312
	CNMG 431-UB	CNMG 120404-UB		•	•															.500	.187	.016	.203
	CNMG 432-UB	CNMG 120408-UB		•	•															.500	.187	.031	.203
	CNMG 433-UB	CNMG 120412-UB		•	•															.500	.187	.047	.203
CNMG 543-UB	CNMG 160612-UB		•	•															.625	.250	.047	.250	
CNMG UD for Medium to Heavy  	CNMG 432-UD	CNMG 120408-UD	•	•	•	•	•												.500	.187	.031	.203	
	CNMG 433-UD	CNMG 120412-UD		•	•	•	•													.500	.187	.047	.203
	CNMG 434-UD	CNMG 120416-UD					•													.500	.187	.063	.203
	CNMG 543-UD	CNMG 160612-UD		•	•															.625	.250	.047	.250
	CNMG 643-UD	CNMG 190612-UD		•	•	•	•													.750	.250	.047	.312
	CNMG 644-UD	CNMG 190616-UD					•													.750	.250	.063	.312
CNMA 	CNMA 431	CNMA 120404	•	•												•			.500	.187	.016	.203	
	CNMA 432	CNMA 120408	•	•												•			.500	.187	.031	.203	
	CNMA 433	CNMA 120412	•	•															.500	.187	.047	.203	

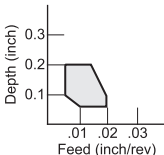
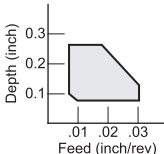
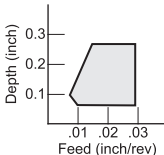
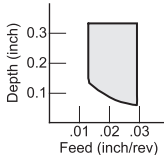
Turning Inserts

80° Diamond	PART ID		COATED								UNCOATED						DESCRIPTION			
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	CERMET						I.C.	Thickness	Nose Radius	Hole Diameter
CCMT FT for Finishing  	CCMT 2(1.5)0-FT	CCMT 060202-FT	•	•							•						.250	.093	.008	.114
	CCMT 2(1.5)1-FT	CCMT 060204 FT	•	•							•						.250	.093	.016	.114
	CCMT 2(1.5)2-FT	CCMT 060208-FT	•	•													.250	.093	.031	.114
	CCMT 3(2.5)0-FT	CCMT 09T302-FT	•	•							•						.375	.156	.008	.173
	CCMT 3(2.5)1-FT	CCMT 09T304-FT	•	•							•						.375	.156	.016	.173
	CCMT 3(2.5)2-FT	CCMT 09T308-FT	•	•							•						.375	.156	.031	.173
	CCMT 431-FT	CCMT 120404-FT	•	•													.500	.187	.016	.203
	CCMT 432-FT	CCMT 120408-FT	•	•													.500	.187	.031	.203
CPMT FT for Finishing  	CPMT 3(2.5)1-FT	CPMT 09T304-FT									•						.375	.156	.016	.173

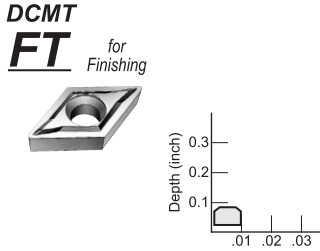
Turning Inserts

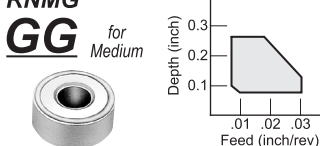
55° Diamond	PART ID		COATED								UNCOATED					DESCRIPTION						
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Negative																						
DNMG PF for Finishing to Light 	DNMG 331-PF DNMG 332-PF	DNMG 110404-PF DNMG 110408-PF		• •															.375 .375	.187 .187	.016 .031	.150 .150
DNMG SF for Finishing to Light 	DNMG 431-SF DNMG 432-SF	DNMG 150404-SF DNMG 150408-SF							• •	• •									.500 .500	.187 .187	.016 .031	.203 .203
	DNMG 441-SF DNMG 442-SF	DNMG 150604-SF DNMG 150608-SF							• •	• •									.500 .500	.250 .250	.016 .031	.203 .203
DNMG UT for Light to Medium 	DNMG 431-UT	DNMG 150404-UT		•									•						.500	.187	.016	.203
DNMG SG for Light to Medium 	DNMG 431L-SG DNMG 431R-SG	DNMG 150404L-SG DNMG 150404R-SG							• •	• •									.500 .500	.187 .187	.016 .016	.203 .203
	DNMG 432L-SG DNMG 432R-SG	DNMG 150408L-SG DNMG 150408R-SG							• •	• •									.500 .500	.187 .187	.031 .031	.203 .203
	DNMG 441L-SG DNMG 441R-SG	DNMG 150604L-SG DNMG 150604R-SG							• •	• •									.500 .500	.250 .250	.016 .016	.203 .203
	DNMG 442L-SG DNMG 442R-SG	DNMG 150608L-SG DNMG 150608R-SG							• •	• •									.500 .500	.250 .250	.031 .031	.203 .203
DNMG PG for Light to Medium 	DNMG 331-PG DNMG 332-PG	DNMG 110404-PG DNMG 110408-PG	• •	• •	• •	• •													.375 .375	.187 .187	.016 .031	.150 .150
	DNMG 431-PG DNMG 432-PG DNMG 433-PG	DNMG 150404-PG DNMG 150408-PG DNMG 150412-PG	• • •	• • •	• • •	• • •	• • •												.500 .500 .500	.187 .187 .187	.016 .031 .047	.203 .203 .203
	DNMG 441-PG DNMG 442-PG DNMG 443-PG	DNMG 150604-PG DNMG 150608-PG DNMG 150612-PG	• • •	• • •	• • •	• • •	• • •												.500 .500 .500	.250 .250 .250	.016 .031 .047	.203 .203 .203

Turning Inserts

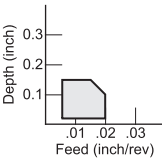
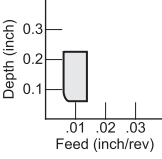
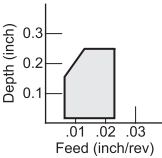
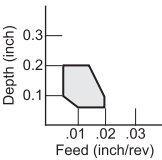
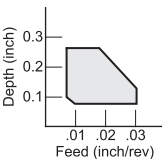
55° Diamond	PART ID		COATED							UNCOATED							DESCRIPTION					
										CERMET												
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Negative																						
DNMG UR for Light to Medium  	DNMG 331-UR	DNMG 110404-UR	•	•	•													.375	.187	.016	.150	
	DNMG 332-UR	DNMG 110408-UR	•	•	•														.375	.187	.031	.150
	DNMG 431-UR	DNMG 150404-UR	•	•	•	•						•		•				.500	.187	.016	.203	
	DNMG 432-UR	DNMG 150408-UR	•	•	•	•						•		•				.500	.187	.031	.203	
	DNMG 433-UR	DNMG 150412-UR												•				.500	.187	.047	.203	
	DNMG 441-UR	DNMG 150604-UR			•	•												.500	.250	.016	.203	
DNMG 442-UR	DNMG 150608-UR			•	•												.500	.250	.031	.203		
DNMG GG for Medium  	DNMG 431-GG	DNMG 150404-GG	•	•	•	•												.500	.187	.016	.203	
	DNMG 432-GG	DNMG 150408-GG	•	•	•	•												.500	.187	.031	.203	
	DNMG 433-GG	DNMG 150412-GG	•	•	•	•												.500	.187	.047	.203	
	DNMG 441-GG	DNMG 150604-GG		•	•	•	•											.500	.250	.016	.203	
	DNMG 442-GG	DNMG 150608-GG		•	•	•	•											.500	.250	.031	.203	
	DNMG 443-GG	DNMG 150612-GG		•	•	•	•											.500	.250	.047	.203	
DNMG UB for Medium  	DNMG 431-UB	DNMG 150404-UB	•	•														.500	.187	.016	.203	
	DNMG 432-UB	DNMG 150408-UB	•	•								•						.500	.187	.031	.203	
	DNMG 433-UB	DNMG 150412-UB		•														.500	.187	.047	.203	
	DNMG 441-UB	DNMG 150604-UB		•	•													.500	.250	.016	.203	
	DNMG 442-UB	DNMG 150608-UB		•	•													.500	.250	.031	.203	
DNMG UD for Medium to Heavy  	DNMG 431-UD	DNMG 150404-UD			•													.500	.187	.016	.203	
	DNMG 432-UD	DNMG 150408-UD			•													.500	.187	.031	.203	
	DNMG 433-UD	DNMG 150412-UD			•													.500	.187	.047	.203	
	DNMG 442-UD	DNMG 150608-UD		•	•	•												.500	.250	.031	.203	
	DNMG 443-UD	DNMG 150612-UD			•													.500	.250	.047	.203	
DNMA 	DNMA 431	DNMA 150404	•	•														.500	.187	.016	.203	
	DNMA 432	DNMA 150408	•	•											•			.500	.187	.031	.203	
	DNMA 433	DNMA 150412	•	•														.500	.187	.047	.203	

Turning Inserts

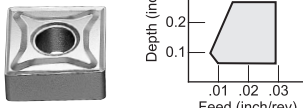
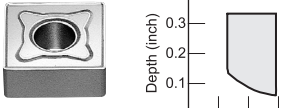
55° Diamond	PART ID		COATED								UNCOATED					DESCRIPTION							
											CERMET												
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter	
M class - Positive																							
DCMT FT for Finishing 	DCMT 2(1.5)0-FT	DCMT 070202-FT	•	•						•									.250	.093	.008	.114	
	DCMT 2(1.5)1-FT	DCMT 070204-FT	•	•						•										.250	.093	.016	.114
	DCMT 2(1.5)2-FT	DCMT 070208-FT	•	•																.250	.093	.031	.114
	DCMT 3(2.5)0-FT	DCMT 11T302-FT	•	•						•										.375	.156	.008	.173
	DCMT 3(2.5)1-FT	DCMT 11T304-FT	•	•						•										.375	.156	.016	.173
	DCMT 3(2.5)2-FT	DCMT 11T308-FT	•	•																.375	.156	.031	.173

Round	PART ID		COATED								UNCOATED				DESCRIPTION							
											CERMET											
M class - Negative	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
RNMG GG for Medium 	RNMG 43-GG	RNMG 120400-GG			•	•	•												.500	.187		.203

Turning Inserts

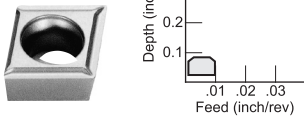
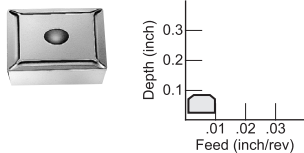
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	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Negative																						
SNMG UT for Light to Medium  	SNMG 432-UT	SNMG 120408-UT			•														.500	.187	.031	.203
SNMG SG for Light to Medium  	SNMG 431L-SG SNMG 431R-SG SNMG 432L-SG SNMG 432R-SG SNMG 433L-SG SNMG 433R-SG	SNMG 120404L-SG SNMG 120404R-SG SNMG 120408L-SG SNMG 120408R-SG SNMG 120412L-SG SNMG 120412R-SG						•	•	•									.500 .500 .500 .500 .500 .500	.187 .187 .187 .187 .187 .187	.016 .016 .031 .031 .047 .047	.203 .203 .203 .203 .203 .203
SNMG PG for Light to Medium  	SNMG 431-PG SNMG 432-PG SNMG 433-PG SNMG 434-PG	SNMG 120404-PG SNMG 120408-PG SNMG 120412-PG SNMG 120416-PG	•	•	•	•	•												.500 .500 .500 .500	.187 .187 .187 .187	.016 .031 .047 .063	.203 .203 .203 .203
SNMG UR for Light to Medium  	SNMG 431-UR SNMG 432-UR SNMG 433-UR	SNMG 120404-UR SNMG 120408-UR SNMG 120412-UR		•	•	•													.500 .500 .500	.187 .187 .187	.016 .031 .047	.203 .203 .203
SNMG GG for Medium  	SNMG 321-GG SNMG 322-GG SNMG 323-GG SNMG 431-GG SNMG 432-GG SNMG 433-GG SNMG 434-GG SNMG 543-GG SNMG 544-GG SNMG 643-GG SNMG 644-GG SNMG 856-GG	SNMG 090304-GG SNMG 090308-GG SNMG 090312-GG SNMG 120404-GG SNMG 120408-GG SNMG 120412-GG SNMG 120416-GG SNMG 150612-GG SNMG 150616-GG SNMG 190612-GG SNMG 190616-GG SNMG 250724-GG		•	•	•													.375 .375 .375 .500 .500 .500 .500 .625 .625 .750 .750 1.00	.125 .125 .125 .187 .187 .187 .187 .250 .250 .250 .250 .312	.016 .031 .047 .016 .031 .047 .063 .047 .063 .094	.150 .150 .150 .203 .203 .203 .203 .250 .250 .312 .312 .359

Turning Inserts

Square	PART ID		COATED								UNCOATED					DESCRIPTION						
											CERMET											
M class - Negative	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
SNMG UB for Medium 	SNMG 431-UB SNMG 432-UB	SNMG 120404-UB SNMG 120408-UB		• •	• •														.500 .500	.187 .187	.016 .031	.203 .203
SNMG UD for Medium to Heavy 	SNMG 432-UD SNMG 433-UD SNMG 434-UD	SNMG 120408-UD SNMG 120412-UD SNMG 120416-UD	• •	• •	• • •	• • •													.500 .500 .500	.187 .187 .187	.031 .047 .063	.203 .203 .203
	SNMG 643-UD SNMG 644-UD	SNMG 190612-UD SNMG 190616-UD			• •	• •													.750 .750	.250 .250	.047 .063	.312 .312

Square	PART ID		COATED								UNCOATED					DESCRIPTION						
											CERMET											
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC730U	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Negative																						
SNMA 	SNMA 433 SNMA 433 SNMA 434	SNMA 120408 SNMA 120412 SNMA 120416	• • •	• • •	 	 	 	 	 	 	 	 	 	 	 	 • 	 	 	.500 .500 .500	.187 .187 .187	.031 .047 .063	.203 .203 .203
SNMN 	SNMN 321	SNMN 090304	 	 	 	 	 	 	 	 	 	 	 	 	 	• 	 	 	.375 .500 .500	.125 .187 .187	.016 .016 .031	
	SNMN 431 SNMN 432 SNMN 433T	SNMN 120404 SNMN 120408 SNMN 120412T	 	 	 	 	 	 	 • 	 	 	 	 	 	 	• • 	 	 	.750 .500 .500	.187 .187 .187	.031 .031 .047	
	SNMN 632	SNMN 190408	 	 	 	 	 	 	 	 	 	 	 	 	 	• 	 	 	.750 .500 .500	.187 .187 .187	.031 .031 .047	

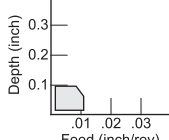
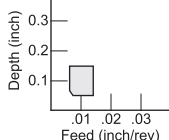
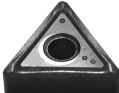
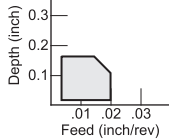
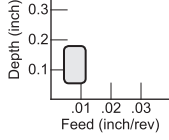
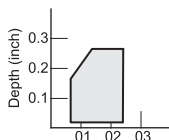
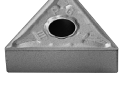
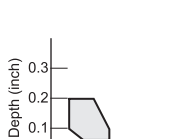
Turning Inserts

Square	PART ID		COATED								UNCOATED					DESCRIPTION						
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Positive																						
SCMT FT for Finishing 	SCMT 3(2.5)1-FT	SCMT 09T304-FT		•	•														.375	.156	.016	.173
	SCMT 3(2.5)2-FT	SCMT 09T308-FT		•	•														.375	.156	.031	.173
	SCMT 431-FT	SCMT 120404-FT		•	•														.500	.187	.016	.203
	SCMT 432-FT	SCMT 120408-FT		•	•														.500	.187	.031	.203
SPMR FT for Finishing 	SPMR 321-FT	SPMR 090304-FT			•	•	•				•								.375	.125	.016	
	SPMR 322-FT	SPMR 090308-FT			•	•	•				•								.375	.125	.031	
	SPMR 421-FT	SPMR 120304-FT			•	•	•												.500	.125	.016	
	SPMR 422-FT	SPMR 120308-FT			•	•	•												.500	.125	.031	
SPMN 	SPMN 421	SPMN 120304					•												.500	.125	.016	
	SPMN 422	SPMN 120308					•												.500	.125	.031	
	SPMN 423	SPMN 120312	•																.500	.125	.047	
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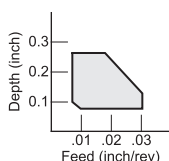
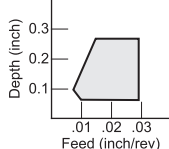
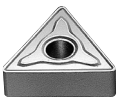
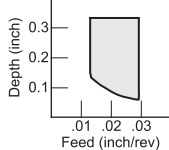
Square	PART ID		COATED								UNCOATED				DESCRIPTION							
											CERMET											
G class - Negative	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
SNGN 	SNGN 422	SNGN 120308														•			.500	.125	.031	
	SNGN 431	SNGN 120404															•			.500	.187	.016

Square	PART ID		COATED								UNCOATED					DESCRIPTION						
											CERMET											
G class - Positive	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	NAT	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
SPGN 	SPGN 322	SPGN 090308										•				•			.375	.125	.031	
	SPGN 421	SPGN 120304													•	•			.500	.125	.016	
	SPGN 422	SPGN 120308														•	•	•	.500	.125	.031	
	SPGN 432	SPGN 120408														•			.500	.187	.031	

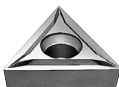
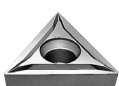
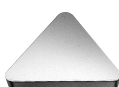
Turning Inserts

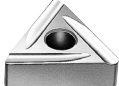
Triangular	PART ID		COATED								UNCOATED					DESCRIPTION						
											CERMET											
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Negative																						
TNMG UA for Finishing to Light 	TNMG 331-UA TNMG 332-UA TNMG 333-UA	TNMG 160404-UA TNMG 160408-UA TNMG 160412-UA		•	•	•													.375 .375 .375	.187 .187 .187	.016 .031 .047	.150 .150 .150
TNMG SF for Finishing to Light 	TNMG 331-SF TNMG 332-SF	TNMG 160404-SF TNMG 160408-SF							•	•									.375 .375	.187 .187	.016 .031	.150 .150
TNMG UT for Light to Medium 	TNMG 331-UT TNMG 332-UT TNMG 333-UT TNMG 432-UT	TNMG 160404-UT TNMG 160408-UT TNMG 160412-UT TNMG 220408-UT		•	•	•	•					•							.375 .375 .375 .500	.187 .187 .187 .187	.016 .031 .047 .031	.150 .150 .150 .203
TNMG SG for Light to Medium 	TNMG 331R-SG TNMG 331L-SG TNMG 332R-SG TNMG 332L-SG	TNMG 160404R-SG TNMG 160404L-SG TNMG 160408R-SG TNMG 160408L-SG							•	•									.375 .375 .375 .375	.187 .187 .187 .187	.016 .016 .031 .031	.150 .150 .150 .150
TNMG PG for Light to Medium 	TNMG 331-PG TNMG 332-PG TNMG 333-PG TNMG 432-PG TNMG 433-PG	TNMG 160404-PG TNMG 160408-PG TNMG 160412-PG TNMG 220408-PG TNMG 220412-PG	•	•	•	•	•												.375 .375 .375 .500 .500	.187 .187 .187 .187 .187	.016 .031 .047 .031 .047	.150 .150 .150 .203 .203
TNMG UR for Light to Medium 	TNMG 331-UR TNMG 332-UR TNMG 333-UR TNMG 432-UR TNMG 433-UR	TNMG 160404-UR TNMG 160408-UR TNMG 160412-UR TNMG 220408-UR TNMG 220412-UR		•	•	•	•					•	•						.375 .375 .375 .500 .500	.187 .187 .187 .187 .187	.016 .031 .047 .031 .047	.150 .150 .150 .203 .203

Turning Inserts

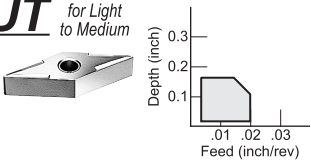
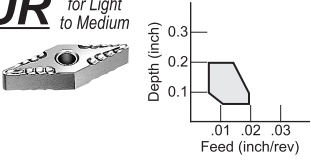
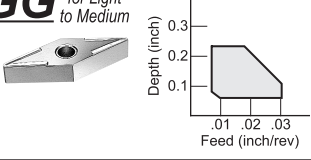
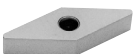
Triangular	PART ID		COATED								UNCOATED					DESCRIPTION						
											CERMET											
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Negative																						
TNMG GG for Medium  	TNMG 331-GG	TNMG 160404-GG	•	•	•	•	•												.375	.187	.016	.150
	TNMG 332-GG	TNMG 160408-GG	•	•	•	•	•												.375	.187	.031	.150
	TNMG 333-GG	TNMG 160412-GG	•	•	•	•	•												.375	.187	.047	.150
	TNMG 431-GG	TNMG 220404-GG		•		•	•												.500	.187	.016	.203
	TNMG 432-GG	TNMG 220408-GG		•	•	•	•												.500	.187	.031	.203
	TNMG 433-GG	TNMG 220412-GG		•	•	•	•												.500	.187	.047	.203
	TNMG 434-GG	TNMG 220416-GG		•			•												.500	.187	.063	.203
	TNMG 543-GG	TNMG 270612-GG		•															.625	.250	.047	.250
	TNMG 544-GG	TNMG 270616-GG		•															.625	.250	.063	.250
	TNMG UB for Medium  	TNMG 331-UB	TNMG 160404-UB		•	•														.375	.187	.016
TNMG 332-UB		TNMG 160408-UB		•	•							•							.375	.187	.031	.150
TNMG 333-UB		TNMG 160412-UB		•	•														.375	.187	.047	.150
TNMG 432-UB		TNMG 220408-UB		•	•														.500	.187	.031	.203
TNMG 433-UB		TNMG 220412-UB		•	•														.500	.187	.047	.203
TNMG UD for Medium to Heavy  		TNMG 332-UD	TNMG 160408-UD	•	•	•	•	•												.375	.187	.031
	TNMG 333-UD	TNMG 160412-UD	•	•	•	•	•												.375	.187	.047	.150
	TNMG 334-UD	TNMG 160416-UD				•													.375	.187	.063	.150
	TNMG 432-UD	TNMG 220408-UD	•	•	•	•	•												.500	.187	.031	.203
	TNMG 433-UD	TNMG 220412-UD	•	•	•	•	•												.500	.187	.047	.203
	TNMA 	TNMA 331	TNMA 160404	•	•											•				.375	.187	.016
TNMA 332		TNMA 160408	•	•	•										•				.375	.187	.031	.150
TNMA 333		TNMA 160412	•	•											•				.375	.187	.047	.150
TNMA 431		TNMA 220404													•				.500	.187	.016	.203
TNMA 432		TNMA 220408	•												•				.500	.187	.031	.203
TNMA 433		TNMA 220412	•												•				.500	.187	.047	.203

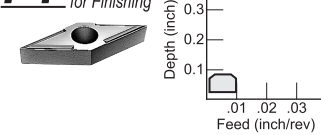
Turning Inserts

Triangular	PART ID		COATED								UNCOATED							DESCRIPTION			
											CERMET										
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius
M class - Positive																					
TCMT FT for Finishing  Depth (inch) 0.3 0.2 0.1 0.01 0.02 0.03 Feed (inch/rev)	TCMT 2(1.5)0-FT	TCMT 110202-FT	•	•						•								.250	.093	.008	.114
	TCMT 2(1.5)1-FT	TCMT 110204-FT	•	•						•								.250	.093	.016	.114
	TCMT 2(1.5)2-FT	TCMT 110208-FT	•	•						•								.250	.093	.031	.114
	TCMT 3(2.5)1-FT	TCMT 16T304-FT	•	•														.375	.156	.016	.173
TCMT 3(2.5)2-FT	TCMT 16T308-FT	•	•															.375	.156	.031	.173
TPMT FT for Finishing  Depth (inch) 0.3 0.2 0.1 0.01 0.02 0.03 Feed (inch/rev)	TPMT 2(1.5)1-FT	TPMT 110204-FT								•								.250	.093	.016	.114
TPMR FT for Finishing  Depth (inch) 0.3 0.2 0.1 0.01 0.02 0.03 Feed (inch/rev)	TPMR 221-FT	TPMR 110304-FT	•	•	•	•				•								.250	.125	.016	
	TPMR 222-FT	TPMR 110308-FT	•	•	•	•				•								.250	.125	.031	
	TPMR 321-FT	TPMR 160304-FT	•	•	•	•				•								.375	.125	.016	
	TPMR 322-FT	TPMR 160308-FT	•	•	•	•				•								.375	.125	.031	
	TPMR 323-FT	TPMR 160312-FT								•								.375	.125	.047	
TPMN 	TPMN 221	TPMN 110304	•	•	•					•					•			.250	.125	.016	
	TPMN 222	TPMN 110308		•	•										•			.250	.125	.031	
	TPMN 321	TPMN 160304			•	•									•			.375	.125	.016	
	TPMN 322	TPMN 160308	•	•	•	•									•	•		.375	.125	.031	
	TPMN 323	TPMN 160312														•		.375	.125	.047	
	TPMN 432	TPMN 220408		•	•					•					•			.500	.187	.031	
	TPMN 433	TPMN 220412		•	•										•			.500	.187	.047	
	TPMN 434	TPMN 220416													•			.500	.187	.063	

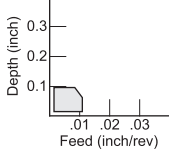
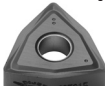
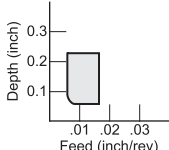
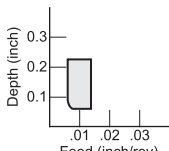
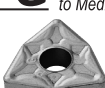
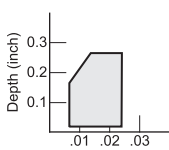
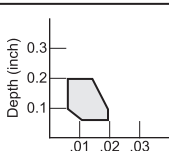
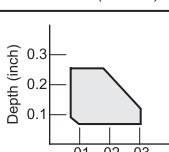
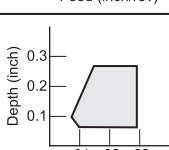
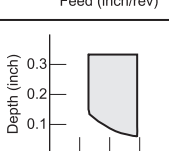
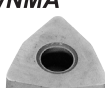
Triangular	PART ID		COATED								UNCOATED						DESCRIPTION						
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter	
																							CERMET
G class - Negative																							
TNGG GN for Light to Medium  Depth (inch) .01 .02 .03 Feed (inch/rev)	TNGG 331R-GN	TNGG 160404R-GN										•		•					.375	.187	.016	.150	
	TNGG 331L-GN	TNGG 160404L-GN											•		•					.375	.187	.016	.150
	TNGG 332R-GN	TNGG 160408R-GN											•		•					.375	.187	.031	.150
	TNGG 332L-GN	TNGG 160408L-GN											•		•					.375	.187	.031	.150
	TNGG 431R-GN	TNGG 220404R-GN											•							.500	.187	.016	.203
	TNGG 431L-GN	TNGG 220404L-GN											•							.500	.187	.016	.203

Turning Inserts

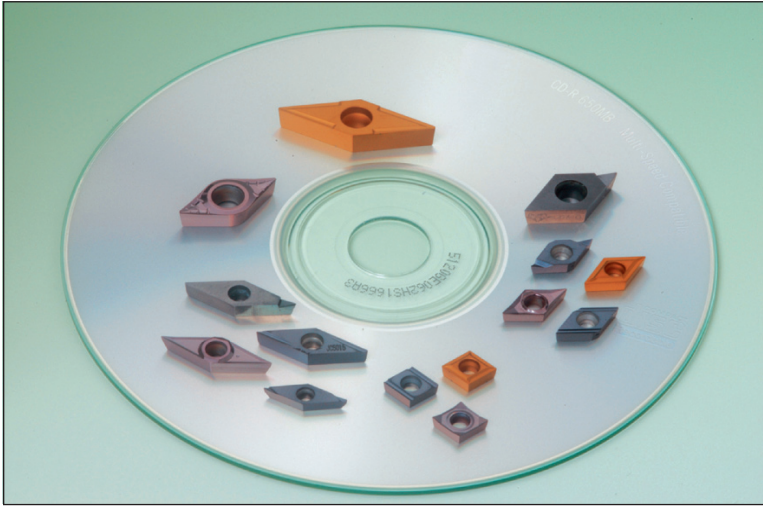
35° Diamond	PART ID		COATED								UNCOATED						DESCRIPTION						
											CERMET												
M class - Negative	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter	
VNMG UT for Light to Medium 	VNMG 331-UT	VNMG 160404-UT		•	•								•						.375	.187	.016	.150	
	VNMG 332-UT	VNMG 160408-UT		•	•	•					•		•							.375	.187	.031	.150
VNMG UR for Light to Medium 	VNMG 331-UR	VNMG 160404-UR		•	•		•						•						.375	.187	.016	.150	
	VNMG 332-UR	VNMG 160408-UR		•	•	•	•						•							.375	.187	.031	.150
VNMG GG for Light to Medium 	VNMG 331-GG	VNMG 160404-GG	•	•	•	•	•												.375	.187	.016	.150	
	VNMG 332-GG	VNMG 160408-GG	•	•	•	•	•													.375	.187	.031	.150
VNMA 	VNMA 331	VNMA 160404	•																.375	.187	.016	.150	
	VNMA 332	VNMA 160408	•																	.375	.187	.031	.150

35° Diamond	PART ID		COATED								UNCOATED						DESCRIPTION					
											CERMET											
M class - Positive	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
VBMT FT for Finishing 	VBMT 331-FT	VBMT 160404-FT		•	•														.375	.187	.016	.173
	VBMT 332-FT	VBMT 160408-FT		•	•															.375	.187	.031

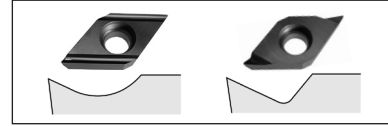
Turning Inserts

80° Trigon	PART ID		COATED								UNCOATED					DESCRIPTION						
											CERMET											
	INCH CODE	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
M class - Negative																						
WNMG UA for Finishing to Light  	WNMG 431-UA WNMG 432-UA	WNMG 080404-UA WNMG 080408-UA	• •																.500 .500	.187 .187	.016 .031	.203 .203
WNMG SF for Finishing to Light  	WNMG 431-SF WNMG 432-SF	WNMG 080404-SF WNMG 080408-SF						• •	• •										.500 .500	.187 .187	.016 .031	.203 .203
WNMG SG for Light to Medium  	WNMG 431R-SG WNMG 431L-SG WNMG 432R-SG WNMG 432L-SG	WNMG 080404R-SG WNMG 080404L-SG WNMG 080408R-SG WNMG 080408L-SG	• • • •					• • • •	• • • •										.500 .500 .500 .500	.187 .187 .187 .187	.016 .016 .031 .031	.203 .203 .203 .203
WNMG PG for Light to Medium  	WNMG 431-PG WNMG 432-PG WNMG 433-PG	WNMG 080404-PG WNMG 080408-PG WNMG 080412-PG	• • •	• • •	• • •	• • •													.500 .500 .500	.187 .187 .187	.016 .031 .047	.203 .203 .203
WNMG UR for Light to Medium  	WNMG 431-UR WNMG 432-UR WNMG 433-UR	WNMG 080404-UR WNMG 080408-UR WNMG 080412-UR	• • •	• • •	• • •									• •					.500 .500 .500	.187 .187 .187	.016 .031 .047	.203 .203 .203
WNMG GG for Medium  	WNMG 431-GG WNMG 432-GG WNMG 433-GG	WNMG 080404-GG WNMG 080408-GG WNMG 080412-GG	• • •	• • •	• • •	• •													.500 .500 .500	.187 .187 .187	.016 .031 .047	.203 .203 .203
WNMG UB for Medium  	WNMG 431-UB WNMG 432-UB WNMG 433-UB	WNMG 080404-UB WNMG 080408-UB WNMG 080412-UB	• • •	• • •		• • •													.500 .500 .500	.187 .187 .187	.016 .031 .047	.203 .203 .203
WNMG UD for Medium to Heavy  	WNMG 432-UD WNMG 433-UD WNMG 434-UD	WNMG 080408-UD WNMG 080412-UD WNMG 080416-UD	• • •	• • •	• • •	• • •													.500 .500 .500	.187 .187 .187	.031 .047 .063	.203 .203 .203
WNMA 	WNMA 431 WNMA 432 WNMA 433	WNMA 080404 WNMA 080408 WNMA 080412	• • •	• • •															.500 .500 .500	.187 .187 .187	.016 .031 .047	.203 .203 .203

Turning Inserts for Small Components

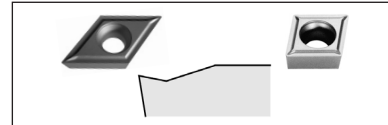


Chipbreakers: MF, MF2, MM, MM1, MM2



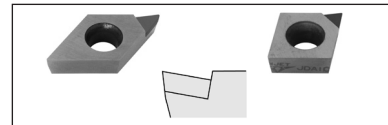
The combination of mirror surface finish and our JC5000 series carbide grades improve surface finish and tool life.

FT



M-class inserts with optimum chipbreaker geometry are applicable to both semi and rough machining.

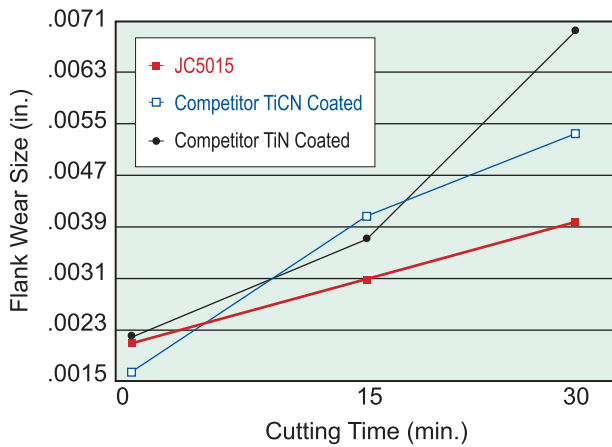
Diamond



Micro grain sintered diamond provides sharp cutting edge and obtains a fine surface finish.

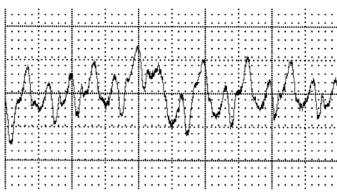
Insert Flank Wear Comparison

- Work Material: SUS420J2
- Insert: DCET070202R JC5015
- Cutting Condition: SFM=984, IPR+.001, DOC=.002" with coolant.



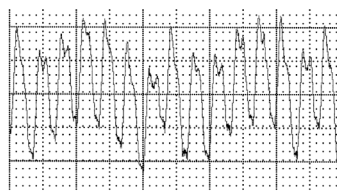
Comparison of Work Surface Finish

DCET070202R-MF, JC5015



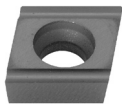
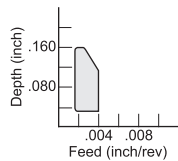
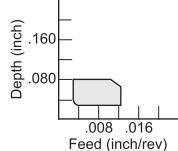
Ra : 0.25 μm
Rmax : 1.85 μm

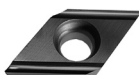
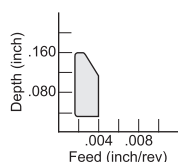
DIJET'S STANDARD CHIPBREAKER



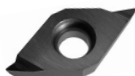
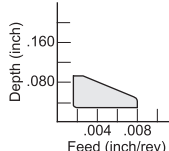
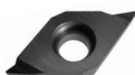
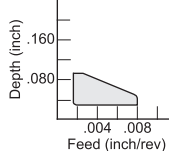
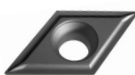
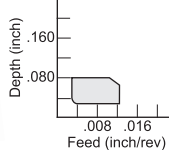
Ra : 0.49 μm
Rmax : 2.58 μm

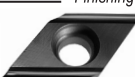
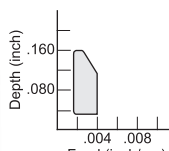
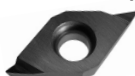
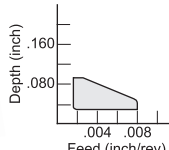
Turning Inserts for Small Components

80° Diamond	PART ID	COATED							UNCOATED				DESCRIPTION				
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	CERMET				I.C.	Thickness	Nose Radius	Hole Diameter
										LN10	NIT	CX50	CX75				
CCET MF for Fine Finishing  	CCET 060201L-MF						•	•						.250	.093	.004	.110
	CCET 060201R-MF						•	•						.250	.093	.004	.110
	CCET 060202L-MF						•	•						.250	.093	.008	.110
	CCET 060202R-MF						•	•						.250	.093	.008	.110
	CCET 09T301L-MF						•	•						.375	.156	.004	.173
	CCET 09T301R-MF						•	•						.375	.156	.004	.173
	CCET 09T302L-MF						•	•						.375	.156	.008	.173
	CCET 09T302R-MF						•	•						.375	.156	.008	.173
CCMT FT for Light to Medium  	CCMT 060202-FT		•	•						•				.250	.093	.008	.114
	CCMT 060204-FT		•	•						•				.250	.093	.016	.114
	CCMT 09T302-FT		•	•						•				.375	.156	.008	.173
	CCMT 09T304-FT		•	•						•				.375	.156	.016	.173

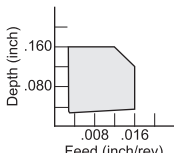
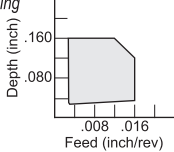
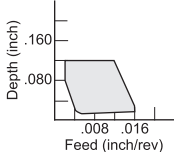
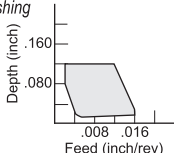
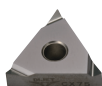
55° Diamond	PART ID	COATED							UNCOATED				DESCRIPTION					
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	CERMET				I.C.	Thickness	Nose Radius	Hole Diameter	
										LN10	NIT	CX50	CX75					PX90
DCET MF for Fine Finishing  	DCET 0702005R-MF						•	•							.250	.093	.002	.110
	DCET 070201L-MF						•	•							.250	.093	.004	.110
	DCET 070201R-MF						•	•							.250	.093	.004	.110
	DCET 070202L-MF						•	•							.250	.093	.008	.110
	DCET 070202R-MF						•	•							.250	.093	.008	.110
	DCET 070204L-MF						•	•							.250	.093	.016	.110
	DCET 070204R-MF						•	•							.250	.093	.016	.110
	DCET 11T3005R-MF						•	•							.375	.156	.002	.173
	DCET 11T301L-MF						•	•							.375	.156	.004	.173
	DCET 11T301R-MF						•	•							.375	.156	.004	.173
	DCET 11T302L-MF						•	•							.375	.156	.008	.173
	DCET 11T302R-MF						•	•							.375	.156	.008	.173
	DCET 11T304L-MF						•	•							.375	.156	.016	.173
	DCET 11T304R-MF						•	•							.375	.156	.016	.173

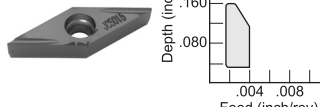
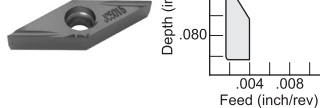
Turning Inserts for Small Components

55° Diamond	PART ID	COATED								UNCOATED				DESCRIPTION								
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter	
																						CERMET
DCET MM for Fine Finishing  	DCET 0702005R-MM						•	•										.250	.093	.002	.110	
	DCET 070201L-MM						•	•										.250	.093	.004	.110	
	DCET 070201R-MM						•	•										.250	.093	.004	.110	
	DCET 070202L-MM						•	•										.250	.093	.008	.110	
	DCET 070202R-MM						•	•										.250	.093	.008	.110	
	DCET 070204L-MM						•	•										.250	.093	.016	.110	
	DCET 070204R-MM						•	•										.250	.093	.016	.110	
	DCET 11T3005R-MM						•	•										.375	.156	.002	.173	
	DCET 11T301L-MM						•	•										.375	.156	.004	.173	
	DCET 11T301R-MM						•	•										.375	.156	.004	.173	
	DCET 11T302L-MM						•	•										.375	.156	.008	.173	
	DCET 11T302R-MM						•	•										.375	.156	.008	.173	
	DCET 11T304L-MM						•	•										.375	.156	.016	.173	
	DCET 11T304R-MM						•	•										.375	.156	.016	.173	
DCET MM1 for Finishing  	DCET 070201L-MM1						•	•										.250	.093	.004	.110	
	DCET 070201R-MM1						•	•										.250	.093	.004	.110	
	DCET 070202L-MM1						•	•										.250	.093	.008	.110	
	DCET 070202R-MM1						•	•										.250	.093	.008	.110	
	DCET 11T301L-MM1						•	•										.375	.156	.004	.173	
	DCET 11T301R-MM1						•	•										.375	.156	.004	.173	
	DCET 11T302L-MM1						•	•										.375	.156	.008	.173	
	DCET 11T302R-MM1						•	•										.375	.156	.008	.173	
	DCMT FT for Finishing  	DCMT 070202-FT	•	•					•										.250	.093	.008	.110
		DCMT 070204-FT	•	•					•											.250	.093	.016
DCMT 11T302-FT		•	•					•											.375	.156	.008	.173
DCMT 11T304-FT		•	•					•											.375	.156	.016	.173

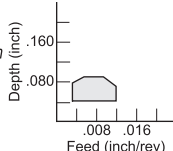
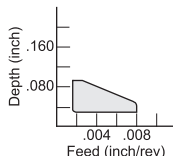
55° Diamond	PART ID	COATED								UNCOATED				DESCRIPTION							
	CERMET																				
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
DPET MF for Fine Finishing  	DPET 070201R-MF							•										.250	.093	.004	.110
	DPET 11T301R-MF							•										.375	.156	.004	.173
	DPET 11T302R-MF							•										.375	.156	.008	.173
DPET MM for Fine Finishing  	DPET 0702005R-MM						•	•										.250	.093	.002	.110
	DPET 070201R-MM						•	•										.250	.093	.004	.110
	DPET 070202R-MM						•	•										.250	.093	.008	.110

Turning Inserts for Small Components

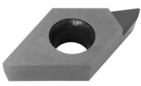
Triangular	PART ID	COATED								UNCOATED				DESCRIPTION					
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CERMET		I.C.	Thickness	Nose Radius	Hole Diameter	
													CX75	PX90					KT9
TNEG MF for Fine Finishing 	TNEG 160401L-MF TNEG 160401R-MF TNEG 160402L-MF TNEG 160402R-MF TNEG 160404L-MF TNEG 160404R-MF						• • • • • •									.375 .375 .375 .375 .375 .375	.187 .187 .187 .187 .187 .187	.004 .004 .008 .008 .016 .016	.150 .150 .150 .150 .150 .150
TNEG MF2 for Semi-Finishing 	TNEG 160401L-MF2 TNEG 160401R-MF2 TNEG 160402L-MF2 TNEG 160402R-MF2 TNEG 160404L-MF2 TNEG 160404R-MF2											• • • • • •				.375 .375 .375 .375 .375 .375	.187 .187 .187 .187 .187 .187	.004 .004 .008 .008 .016 .016	.150 .150 .150 .150 .150 .150
TNEG MM for Fine Finishing 	TNEG 160401L-MM TNEG 160401R-MM TNEG 160402L-MM TNEG 160402R-MM TNEG 160404L-MM TNEG 160404R-MM						• • • • • •									.375 .375 .375 .375 .375 .375	.187 .187 .187 .187 .187 .187	.004 .004 .008 .008 .016 .016	.150 .150 .150 .150 .150 .150
TNEG MM2 for Semi-Finishing 	TNEG 160401L-MM2 TNEG 160401R-MM2 TNEG 160402L-MM2 TNEG 160402R-MM2 TNEG 160404L-MM2 TNEG 160404R-MM2											• • • • • •				.375 .375 .375 .375 .375 .375	.187 .187 .187 .187 .187 .187	.004 .004 .008 .008 .016 .016	.150 .150 .150 .150 .150 .150

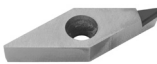
35° Diamond	PART ID	COATED								UNCOATED				DESCRIPTION						
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CERMET		KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
												CX50	CX75							
VBET MF for Fine Finishing 	VBET 110301R-MF VBET 110302R-MF						•	•									.250 .250	.125 .125	.004 .008	.110 .110
VBET MM for Fine Finishing 	VBET 110301R-MM VBET 110302R-MM						•	•									.250 .250	.125 .125	.004 .008	.110 .110

Turning Inserts for Small Components

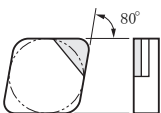
35° Diamond	PART ID	COATED								UNCOATED				DESCRIPTION							
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter
VBMT FT for Light to Medium 	VBMT 160404-FT		•	•														.375	.187	.016	.173
VPET MM for Fine Finishing 	VPET 080201L-MM VPET 080201R-MM VPET 080202L-MM VPET 080202R-MM						•	•										.187 .187 .187 .187	.093 .093 .093 .093	.004 .004 .008 .008	.090 .090 .090 .090

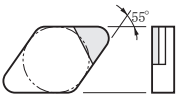
80° Diamond	PART ID	POLYCRYSTALLINE											DESCRIPTION			
	ISO CODE	JDA10	JDA715										I.C.	Thickness	Nose Radius	Hole Diameter
Polycrystalline JDA-CCGT for Fine Finishing 	JDA-CCGT060201	•											.250	.093	.004	.110
	JDA-CCGT060202	•											.250	.093	.008	.110
	JDA-CCGT09T301	•											.375	.156	.004	.173
	JDA-CCGT09T302	•											.375	.156	.008	.173

55° Diamond	PART ID	POLYCRYSTALLINE											DESCRIPTION			
	ISO CODE	JDA10	JDA715										I.C.	Thickness	Nose Radius	Hole Diameter
Polycrystalline JDA-DCGT for Fine Finishing 	JDA-DCGT070201	•											.250	.093	.004	.110
	JDA-DCGT070202	•											.250	.093	.008	.110
	JDA-DCGT11T301	•											.375	.156	.004	.173
	JDA-DCGT11T302	•											.375	.156	.008	.173

35° Diamond	PART ID	POLYCRYSTALLINE											DESCRIPTION			
	ISO CODE	JDA10	JDA715										I.C.	Thickness	Nose Radius	Hole Diameter
Polycrystalline JDA-VBGT for Fine Finishing 	JDA-VBGT110301	•											.250	.125	.004	.110
	JDA-VBGT110302	•											.250	.125	.008	.110

Polycrystalline Inserts

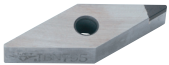
80° Diamond	PART ID		DIAMOND		DESCRIPTION			
	INCH CODE	ISO CODE	JBN795	JBN245	I.C.	Thickness	Nose Radius	Hole Diameter
 	JBN1-CNMA431	JBN1-CNMA120404	•	•	.500	.187	.016	.203
	JBN1-CNMA432	JBN1-CNMA120408	•	•	.500	.187	.031	.203
	JBN1-CNMA433	JBN1-CNMA120412	•	•	.500	.187	.047	.203

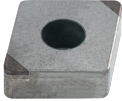
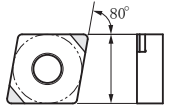
55° Diamond	PART ID		DIAMOND		DESCRIPTION			
	INCH CODE	ISO CODE	JBN795	JBN245	I.C.	Thickness	Nose Radius	Hole Diameter
 	JBN1-DNMA431	JBN1-DNMA150404	•	•	.500	.187	.016	.203
	JBN1-DNMA432	JBN1-DNMA150408	•	•	.500	.187	.031	.203
	JBN1-DNMA433	JBN1-DNMA150412	•	•	.500	.187	.047	.203

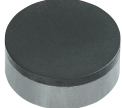
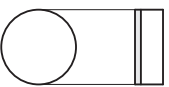
60° Triangular	PART ID		DIAMOND		DESCRIPTION			
	INCH CODE	ISO CODE	JBN795	JBN245	I.C.	Thickness	Nose Radius	Hole Diameter
 	JBN1-TNMA331	JBN1-TNMA160404	•	•	.375	.187	.016	.150
	JBN1-TNMA332	JBN1-TNMA160408	•	•	.375	.187	.031	.150
	JBN1-TNMA333	JBN1-TNMA160412	•	•	.375	.187	.047	.150

90° Square	PART ID		DIAMOND		DESCRIPTION			
	INCH CODE	ISO CODE	JBN795	JBN245	I.C.	Thickness	Nose Radius	Hole Diameter
 	JBN1-SNMA431	JBN1-SNMA120404	•	•	.500	.187	.016	.203
	JBN1-SNMA432	JBN1-SNMA120408	•	•	.500	.187	.031	.203
	JBN1-SNMA433	JBN1-SNMA120412	•	•	.500	.187	.047	.203

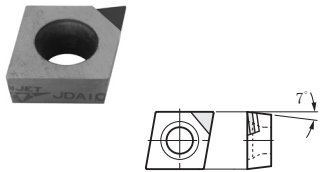
Polycrystalline Inserts

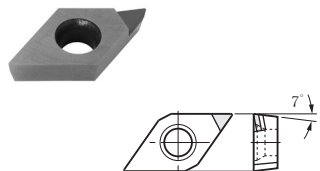
35° Diamond	PART ID		DIAMOND		DESCRIPTION			
	INCH CODE	ISO CODE	JBN795	JBN245	I.C.	Thickness	Nose Radius	Hole Diameter
 	JBN1-VNMA331	JBN1-VNMA160404	•	•	.375	.187	.016	.150
	JBN1-VNMA332	JBN1-VNMA160408	•	•	.375	.187	.031	.150

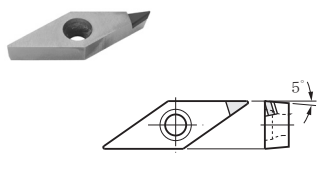
80° Diamond	PART ID		DIAMOND		DESCRIPTION			
	INCH CODE	ISO CODE	JBN795	JBN245	I.C.	Thickness	Nose Radius	Hole Diameter
 	JBN2-CNMA433	JBN2-CNMA120412	•	•	.500	.187	.047	.203

Round	PART ID		DIAMOND		DESCRIPTION			
	INCH CODE	ISO CODE	JBN795	JBN245	I.C.	Thickness	Nose Radius	Hole Diameter
 	JBN-RNGN43	JBN-RNGN120400	•	•	.500	.187	-	-

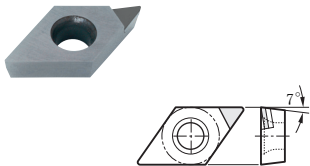
Polycrystalline Inserts

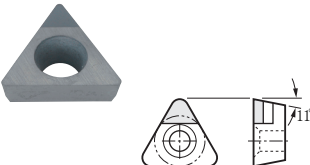
80° Diamond	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA175	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-CCGT060201		•	.250	.093	.004	.110
	JDA-CCGT060202		•	.250	.093	.008	.110
	JDA-CCGT09T301		•	.375	.156	.004	.173
	JDA-CCGT09T302		•	.375	.156	.008	.173

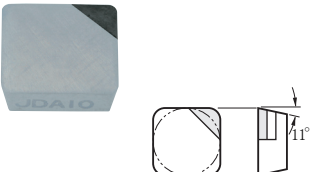
55° Diamond	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA175	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-DCGT070201		•	.250	.093	.004	.110
	JDA-DCGT070202		•	.250	.093	.008	.110
	JDA-DCGT11T301		•	.375	.156	.004	.173
	JDA-DCGT11T302		•	.375	.156	.008	.173

35° Diamond	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA175	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-VBGT110301		•	.250	.125	.004	.110
	JDA-VBGT110302		•	.250	.125	.008	.110

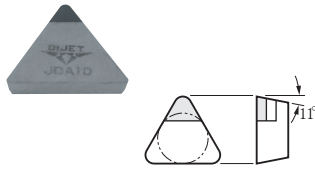
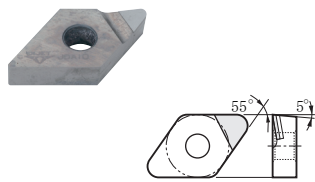
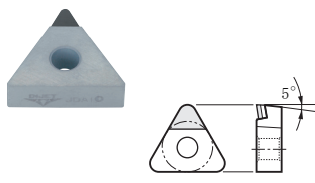
Polycrystalline Inserts

55° Diamond	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA10	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-DCMT11T302		•	.375	.156	.008	.173

60° Triangular	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA10	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-TPGW110202		•	.250	.093	.008	.110
	JDA-TPGW110304		•	.250	.125	.016	.137

90° Square	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA10	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-SPGN090304		•	.375	.125	.016	-

Polycrystalline Inserts

60° Triangular	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA10	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-TPGN090204		•	.218	.093	.016	-
	JDA-TPGN110304		•	.250	.125	.016	-
	JDA-TPGN160304		•	.375	.125	.016	-
55° Diamond	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA10	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-DNMM150404		•	.500	.187	.016	.203
60° Triangular	PART ID	DIAMOND		DESCRIPTION			
	ISO CODE		JDA10	I.C.	Thickness	Nose Radius	Hole Diameter
	JDA-TNMM160404		•	.375	.187	.016	.150
	JDA-TNMM160408		•	.375	.187	.031	.150

Arno Turning Inserts

High Efficiency of Turning and Milling on Aluminum and Non-Ferrous Materials



Dijet has expanded its line of turning inserts to encompass the machining of aluminum and non-ferrous materials. The inserts in this section have a polished surface for optimum chip-flow.

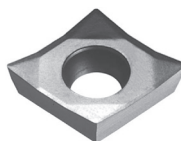
CHIPBREAKERS

ASF



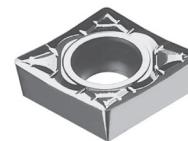
Finishing geometry for machining aluminum, aluminum alloys and non-ferrous materials, also suitable for finishing stainless steel. Very low cutting forces due to sharp cutting edges and special chip-breaker. Completely ground insert.

ALU



Geometry for machining aluminum, aluminum alloys and non-ferrous materials, also suitable for finishing molybdenum, sintered steel or stainless steel. Very low cutting forces due to sharp cutting edges and special chip-breaker. Excellent for machining of unstable and thin-walled work pieces. Completely ground insert.

ACB



Same application as the ALU chip-breaker, however this chip-breaker is optimized for small chips.

Arno Carbides For Turning

GRADE	FEATURES and APPLICATIONS
AM15C	<i>CVD-multilayer coating substrate + TiN - TiCN - TiN. This grade in combination with ALU-geometry is recommended for finishing alloyed and stainless steel, as well as cast steel at high cutting speeds under stable machining conditions.</i>
PVD1	<i>PVD-multilayer coating, substrate + TiN. Submicron carbide grade with high wear-resistance and resistance against crater wear. Light to medium cutting. Excellent for machining non-ferrous products, e.g. Al and Al-alloys, copper, brass and refractory metals (e.g. niob, tantalum, molybdenum, tungsten).</i>
PVD2	<i>PVD-multilayer coating, substrate + TiN. Wear resistant grade with good cutting edge stability for machining non-ferrous materials, e.g. Al and Al-alloys, copper, brass and refractory metals (e.g. niob, tantalum, molybdenum, tungsten) under unfavorable machining conditions. Also suitable for finishing steel and stainless steel under favorable machining conditions.</i>
AK10	<i>Submicron carbide grade for machining Al and Al-alloys, copper, brass, non-ferrous and refractory metals (e.g. niob, tantalum, titanium, molybdenum, tungsten) with medium chip cross sections under favorable machining conditions.</i>
AK20	<i>A grade with great resilience for machining Al and Al-alloys, copper, brass, non-ferrous and refractory metals (e.g. niob, tantalum, molybdenum, tungsten) with medium chip cross sections under unfavorable machining conditions and interrupted cuts.</i>
AT10	<i>PVD-multilayer coating, substrate + TiCN. Grade for machining aluminum and aluminum alloys, copper, brass, non-ferrous materials and refractory metals (e.g. niob, tantalum, molybdenum, tungsten) at medium cutting with favorable cutting conditions. For higher cutting speeds use grade PVD1.</i>
AT20	<i>PVD-multilayer coating, substrate + TiCN. Grade with higher toughness for machining aluminum and aluminum alloys, copper, brass, non-ferrous materials and refractory metals (e.g. niob, tantalum, molybdenum, tungsten) at medium cutting with unfavorable cutting conditions. For higher cutting speeds use grade PVD2.</i>
AL10	<i>PVD-multilayer coating, substrate + AlTiN. Extremely wear resistant grade for machining steel materials, cast iron and non-ferrous products. Due to high hardness in coating, high wear-resistance can be achieved. Specially suitable for high cutting speeds.</i>
AL20	<i>PVD-multilayer coating, substrate + AlTiN. Wear resistant grade with good cutting edge stability for machining steel materials, cast iron and non-ferrous products. Due to the high hardness in coating, good wear resistance can be achieved.</i>

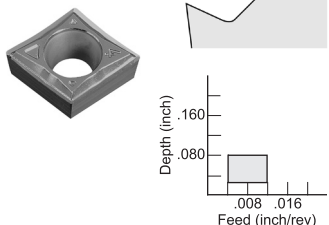
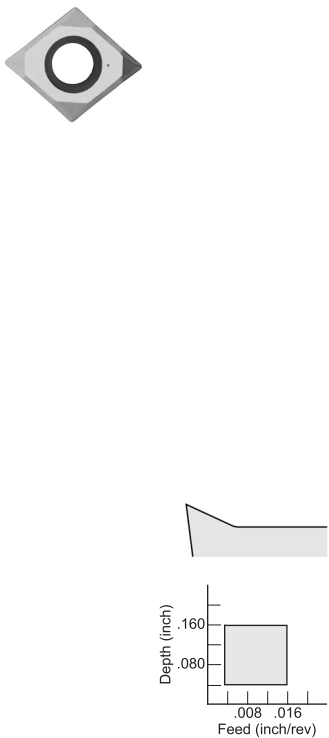
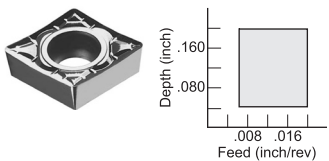
Arno Carbide Grades for Turning

Application Range

TURNING APPLICATION													
	finish ← → rough					finish ← → rough				finish ← → rough			
ISO	P01	P10	P20	P30	P40	M10	M20	M30	M40	K01	K10	K20	K30
AISI	C8	C7	C6		C5	C7	C6		C5	C4	C3	C2	C1
	STEEL					STAINLESS STEEL				CAST IRON			
COATED SERIES	AM15C					AM15C				PVD1			
	PVD1					AT20				PVD2			
	PVD2					AL20				AT10			
	AT10									AT20			
	AT20									AL10			
	AL10									AL20			
	AL20												
UNCOATED SERIES										AK10			
										AK20			

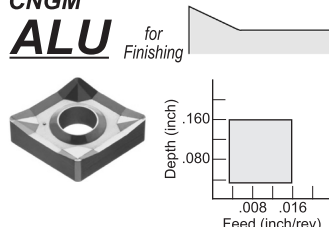
-  CVD Coated
-  PVD Coated
-  Uncoated

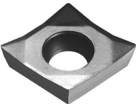
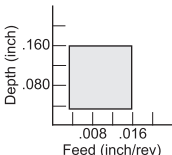
Arno Turning Inserts

80° Diamond	PART ID	COATED							UNCOATED			DESCRIPTION			
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20				I.C.	Thickness	Nose Radius	Hole Diameter
CCGT ASF for Finishing 	CCGT 0602005FN-ASF				•	•	•	•				.250	.093	.002	.110
	CCGT 060201FN-ASF				•	•	•	•				.250	.093	.004	.110
	CCGT 060202FN-ASF				•	•	•	•				.250	.093	.008	.110
	CCGT 060204FN-ASF				•	•	•	•				.250	.093	.016	.110
	CCGT 09T3005FN-ASF				•	•	•	•				.375	.156	.002	.173
	CCGT 09T301FN-ASF				•	•	•	•				.375	.156	.004	.173
	CCGT 09T302FN-ASF				•	•	•	•				.375	.156	.008	.173
	CCGT 09T304FN-ASF				•	•	•	•				.375	.156	.016	.173
	CCGT 0602005FN-ALU		•	•	•	•	•	•				.250	.093	.002	.110
	CCGT 060201FN-ALU		•	•	•	•	•	•				.250	.093	.004	.110
CCGT ALU for Finishing 	CCGT 060201EN-ALU	•										.250	.093	.004	.110
	CCGT 060202FN-ALU		•	•	•	•	•	•				.250	.093	.008	.110
	CCGT 060202EN-ALU	•										.250	.093	.008	.110
	CCGT 060204FN-ALU		•	•	•	•	•	•				.250	.093	.016	.110
	CCGT 060204EN-ALU	•										.250	.093	.016	.110
	CCGT 09T301FN-ALU		•	•	•	•	•	•				.375	.156	.004	.173
	CCGT 09T301EN-ALU	•										.375	.156	.004	.173
	CCGT 09T302FN-ALU		•	•	•	•	•	•				.375	.156	.008	.173
	CCGT 09T302EN-ALU	•										.375	.156	.008	.173
	CCGT 09T304FN-ALU		•	•	•	•	•	•				.375	.156	.016	.173
	CCGT 09T304EN-ALU	•										.375	.156	.016	.173
	CCGT 09T308FN-ALU		•	•	•	•	•	•				.375	.156	.031	.173
	CCGT 09T308EN-ALU	•										.375	.156	.031	.173
	CCGT 120401FN-ALU		•	•	•	•	•	•				.500	.187	.004	.216
	CCGT 120401EN-ALU	•										.500	.187	.004	.216
	CCGT 120402FN-ALU		•	•	•	•	•	•				.500	.187	.008	.216
	CCGT 120402EN-ALU	•										.500	.187	.008	.216
	CCGT 120404FN-ALU		•	•	•	•	•	•				.500	.187	.016	.216
	CCGT 120404EN-ALU	•										.500	.187	.016	.216
	CCGT 120408FN-ALU		•	•	•	•	•	•				.500	.187	.031	.216
	CCGT 120408EN-ALU	•										.500	.187	.031	.216
CCGT ACB for Finishing 	CCGT 060204FN-ACB		•	•	•	•	•	•				.250	.093	.016	.110
	CCGT 09T304FN-ACB		•	•	•	•	•	•				.375	.156	.016	.173
	CCGT 09T308FN-ACB		•	•	•	•	•	•				.375	.156	.031	.173
	CCGT 120404FN-ACB		•	•	•	•	•	•				.500	.187	.016	.216
	CCGT 120408FN-ACB		•	•	•	•	•	•				.500	.187	.031	.216
	CCGT 120408EN-ACB	•										.500	.187	.031	.216

FN - cutting edge up sharp
 EN - cutting edge has hone

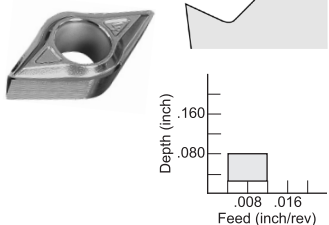
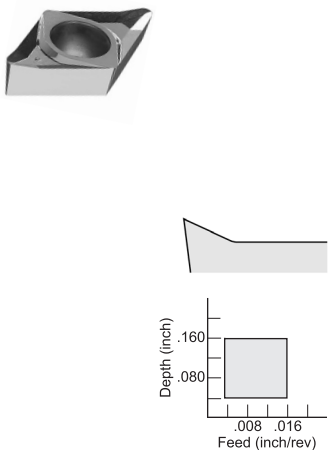
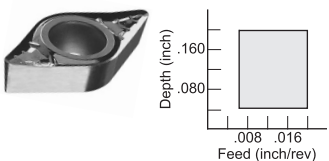
Arno Turning Inserts

80° Diamond	PART ID	COATED								UNCOATED			DESCRIPTION						
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20			AK10	AK20				I.C.	Thickness	Nose Radius	Hole Diameter
CNGM ALU for Finishing 	CNGM 160612FN-ALU			•		•		•				•				.625	.250	.047	.250
	CNGM 190612FN-ALU			•		•		•				•				.750	.250	.047	.312

80° Diamond	PART ID	COATED								UNCOATED			DESCRIPTION					
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20			AK10	AK20			I.C.	Thickness	Nose Radius	Hole Diameter
CPGT ALU for Finishing  	CPGT 05T1005FN-ALU			•	•	•	•	•			•	•			.218	.078	.002	.098
	CPGT 05T101FN-ALU			•	•	•	•	•			•	•			.218	.078	.004	.098
	CPGT 05T102FN-ALU			•	•	•	•	•			•	•			.218	.078	.008	.098
	CPGT 05T104FN-ALU			•	•	•	•	•			•	•			.218	.078	.016	.098

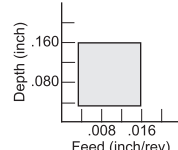
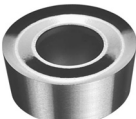
FN - cutting edge up sharp
 EN - cutting edge has hone

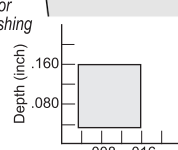
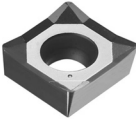
Arno Turning Inserts

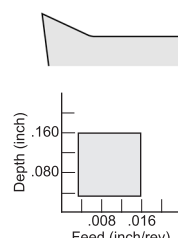
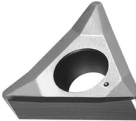
55° Diamond	PART ID	COATED								UNCOATED		DESCRIPTION			
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20		AK10	AK20	I.C.	Thickness	Nose Radius	Hole Diameter
DCGT ASF for Finishing 	DCGT 0702005FN-ASF				•	•	•	•		•	•	.250	.093	.002	.110
	DCGT 070201FN-ASF				•	•	•	•		•	•	.250	.093	.004	.110
	DCGT 070202FN-ASF				•	•	•	•		•	•	.250	.093	.008	.110
	DCGT 070204FN-ASF				•	•	•	•		•	•	.250	.093	.016	.110
	DCGT 11T3005FN-ASF				•	•	•	•		•	•	.375	.156	.002	.173
	DCGT 11T301FN-ASF				•	•	•	•		•	•	.375	.156	.004	.173
	DCGT 11T302FN-ASF				•	•	•	•		•	•	.375	.156	.008	.173
	DCGT 11T304FN-ASF				•	•	•	•		•	•	.375	.156	.016	.173
	DCGT 0702005FN-ALU		•	•	•	•	•	•		•	•	.250	.093	.002	.110
	DCGT 070201FN-ALU		•	•	•	•	•	•		•	•	.250	.093	.004	.110
	DCGT 070201EN-ALU	•										.250	.093	.004	.110
	DCGT 070202FN-ALU		•	•	•	•	•	•		•	•	.250	.093	.008	.110
DCGT ALU for Finishing 	DCGT 070202EN-ALU	•										.250	.093	.008	.110
	DCGT 070204FN-ALU		•	•	•	•	•	•		•	•	.250	.093	.016	.110
	DCGT 070204EN-ALU	•										.250	.093	.016	.110
	DCGT 11T301FN-ALU		•	•	•	•	•	•		•	•	.375	.156	.004	.173
	DCGT 11T301EN-ALU	•										.375	.156	.004	.173
	DCGT 11T302FN-ALU		•	•	•	•	•	•		•	•	.375	.156	.008	.173
	DCGT 11T302EN-ALU	•										.375	.156	.008	.173
	DCGT 11T304FN-ALU		•	•	•	•	•	•		•	•	.375	.156	.016	.173
	DCGT 11T304EN-ALU	•										.375	.156	.016	.173
	DCGT 11T308FN-ALU		•	•	•	•	•	•		•	•	.375	.156	.031	.173
	DCGT 11T308EN-ALU	•										.375	.156	.031	.173
	DCGT 070204FN-ACB		•	•	•	•	•	•		•	•	.250	.093	.016	.110
DCGT ACB for Finishing 	DCGT 11T304FN-ACB		•	•	•	•	•	•		•	•	.375	.156	.016	.173
	DCGT 11T308FN-ACB		•	•	•	•	•	•		•	•	.375	.156	.031	.173

FN - cutting edge up sharp
 EN - cutting edge has hone

Arno Turning Inserts

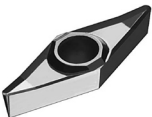
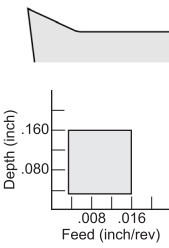
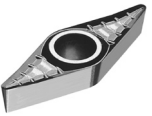
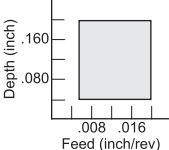
Round	PART ID	COATED								UNCOATED			DESCRIPTION						
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20			AK10	AK20			I.C.	Thickness	Nose Radius	Hole Diameter	
RCGT ALU for Finishing 	RCGT 0602MOFN-ALU RCGT 0602MOEN-ALU	•	•	•	•	•	•	•			•	•			.236 .236	.093 .093		.110 .110	
	RCGT 0803MOFN-ALU RCGT 0803MOEN-ALU	•	•	•	•	•	•	•			•	•			.315 .315	.125 .125		.133 .133	
	RCGT 1003MOFN-ALU RCGT 1003MOEN-ALU	•	•	•	•	•	•	•	•			•	•			.393 .393	.125 .125		.173 .173
	RCGT 1204MOFN-ALU RCGT 1204MOEN-ALU	•	•	•	•	•	•	•	•			•	•			.472 .472	.187 .187		.173 .173

Square	PART ID	COATED								UNCOATED			DESCRIPTION					
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20			AK10	AK20			I.C.	Thickness	Nose Radius	Hole Diameter
SCGT ALU for Finishing 	SCGT 09T304FN-ALU SCGT 09T304EN-ALU SCGT 09T308FN-ALU SCGT 09T308EN-ALU	•	•	•	•	•	•	•			•	•			.375 .375 .375 .375	.156 .156 .156 .156	.016 .016 .031 .031	.173 .173 .173 .173
	SCGT 120408FN-ALU SCGT 120408EN-ALU	•	•	•	•	•	•	•			•	•			.500 .500	.187 .187	.031 .031	.216 .216

Triangular	PART ID	COATED								UNCOATED			DESCRIPTION						
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20			AK10	AK20			I.C.	Thickness	Nose Radius	Hole Diameter	
TCGT ALU for Finishing 	TCGT 06T102FN-ALU		•	•	•	•	•	•			•	•			.156	.077	.008	.090	
	TCGT 090202FN-ALU TCGT 090204FN-ALU		•	•	•	•	•	•	•			•	•			.218 .218	.093 .093	.008 .016	.098 .098
	TCGT 110201FN-ALU TCGT 110201EN-ALU TCGT 110202FN-ALU TCGT 110202EN-ALU TCGT 110204FN-ALU TCGT 110204EN-ALU	•	•	•	•	•	•	•	•			•	•			.250 .250 .250 .250 .250 .250	.093 .093 .093 .093 .093 .093	.004 .004 .008 .008 .016 .016	.110 .110 .110 .110 .110 .110
	TCGT 16T301FN-ALU TCGT 16T301EN-ALU TCGT 16T302FN-ALU TCGT 16T302EN-ALU TCGT 16T304FN-ALU TCGT 16T304EN-ALU TCGT 16T308FN-ALU TCGT 16T308EN-ALU	•	•	•	•	•	•	•	•			•	•			.375 .375 .375 .375 .375 .375 .375 .375	.156 .156 .156 .156 .156 .156 .156 .156	.004 .004 .008 .008 .016 .016 .031 .031	.173 .173 .173 .173 .173 .173 .173 .173

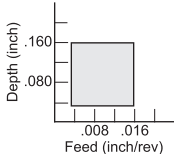
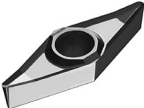
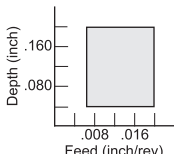
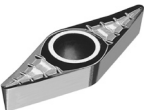
FN - cutting edge up sharp
 EN - cutting edge has hone

Arno Turning Inserts

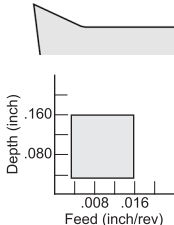
35° Diamond	PART ID	COATED								UNCOATED				DESCRIPTION			
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20			AK10	AK20		I.C.	Thickness	Nose Radius	Hole Diameter
VC GT ALU for Finishing  	VC GT 0702005FN-ALU		•	•	•	•	•	•			•	•		.156	.093	.002	.086
	VC GT 070201FN-ALU		•	•	•	•	•	•			•	•		.156	.093	.004	.086
	VC GT 070202FN-ALU		•	•	•	•	•	•			•	•		.156	.093	.008	.086
	VC GT 070204FN-ALU		•	•	•	•	•	•			•	•		.156	.093	.016	.086
	VC GT 110301FN-ALU		•	•	•	•	•	•			•	•		.250	.125	.004	.114
	VC GT 110301EN-ALU	•												.250	.125	.004	.114
	VC GT 110302FN-ALU		•	•	•	•	•	•			•	•		.250	.125	.008	.114
	VC GT 110302EN-ALU	•												.250	.125	.008	.114
	VC GT 110304FN-ALU		•	•	•	•	•	•			•	•		.250	.125	.016	.114
	VC GT 110304EN-ALU	•												.250	.125	.016	.114
	VC GT 110308FN-ALU		•	•	•	•	•	•			•	•		.250	.125	.031	.114
	VC GT 110308EN-ALU	•												.250	.125	.031	.114
	VC GT 130301FN-ALU		•	•	•	•	•	•			•	•		.312	.125	.004	.125
	VC GT 130302FN-ALU		•	•	•	•	•	•			•	•		.312	.125	.008	.125
	VC GT 130304FN-ALU		•	•	•	•	•	•			•	•		.312	.125	.016	.125
	VC GT 130308FN-ALU		•	•	•	•	•	•			•	•		.312	.125	.031	.125
	VC GT 160401FN-ALU		•	•	•	•	•	•			•	•		.375	.187	.004	.173
	VC GT 160402FN-ALU		•	•	•	•	•	•			•	•		.375	.187	.008	.173
	VC GT 160402EN-ALU	•												.375	.187	.008	.173
	VC GT 160404FN-ALU		•	•	•	•	•	•			•	•		.375	.187	.016	.173
	VC GT 160404EN-ALU	•												.375	.187	.016	.173
	VC GT 160408FN-ALU		•	•	•	•	•	•			•	•		.375	.187	.031	.173
	VC GT 160408EN-ALU	•												.375	.187	.031	.173
	VC GT 160412FN-ALU		•	•	•	•	•	•			•	•		.375	.187	.047	.173
	VC GT 160412EN-ALU	•												.375	.187	.047	.173
VC GT ACB for Finishing  	VC GT 220530FN-ALU		•	•	•	•	•	•			•	•		.500	.187	.118	.216
	VC GT 160408FN-ACB		•	•	•	•	•	•			•	•		.375	.187	.031	.173
	VC GT 160412FN-ACB		•	•	•	•	•	•			•	•		.375	.187	.047	.173
	VC GT 220530FN-ACB		•	•	•	•	•	•			•	•		.500	.218	.118	.216

FN - cutting edge up sharp
 EN - cutting edge has hone

Arno Turning Inserts

35° Diamond	PART ID	COATED								UNCOATED			DESCRIPTION					
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20			AK10	AK20			I.C.	Thickness	Nose Radius	Hole Diameter
VPGT ALU for Finishing 	VPGT 220516FN-ALU		•	•	•	•	•	•			•	•			.500	.218	.062	.216
VPGT ACB for Light to Medium 	VPGT 220516FN-ACB		•	•	•	•	•	•			•	•			.500	.218	.062	.216

FN - cutting edge up sharp
 EN - cutting edge has hone

80° Trigon	PART ID	COATED								UNCOATED			DESCRIPTION					
	ISO CODE	AM15C	PVD1	PVD2	AT10	AT20	AL10	AL20			AK10	AK20			I.C.	Thickness	Nose Radius	Hole Diameter
WCGT <u>ALU</u> for Finishing  	WCGT 030202FN-ALU		•	•	•	•	•	•			•	•			.218	.093	.008	.098
	WCGT 030204FN-ALU		•	•	•	•	•	•			•	•			.218	.093	.016	.098
	WCGT 040201FN-ALU		•	•	•	•	•	•			•	•			.250	.093	.004	.110
	WCGT 040202FN-ALU		•	•	•	•	•	•			•	•			.250	.093	.008	.110
	WCGT 040204FN-ALU		•	•	•	•	•	•			•	•			.250	.093	.016	.110
	WCGT 06T301FN-ALU		•	•	•	•	•	•			•	•			.375	.156	.004	.173
	WCGT 06T302FN-ALU		•	•	•	•	•	•			•	•			.375	.156	.008	.173
	WCGT 06T304FN-ALU		•	•	•	•	•	•			•	•			.375	.156	.016	.173
	WCGT 080404FN-ALU		•	•	•	•	•	•			•	•			.500	.187	.016	.216
	WCGT 080408FN-ALU		•	•	•	•	•	•			•	•			.500	.187	.031	.216

FN - cutting edge up sharp
 EN - cutting edge has hone

Arno Turning Inserts

Recommended Cutting Data - Carbide

		CUTTING SPEED (SFM)		
WORK MATERIAL		AK10, AK20	PVD1, PVD2, AT10, AT20	PVD1, PVD2, AT10, AT20 AL10, AL20
PURE ALUMINUM		2,100 ~ 4,000	2,300 ~ 4,250	
ALUMINUM ALLOY	UN-HEAT TREATED	2,100 ~ 3,300	2,300 ~ 3,600	
	HEAT TREATED	1,000 ~ 2,300	1,100 ~ 2,500	
	Si < 13%	650 ~ 2,000	720 ~ 2,150	
	Si > 13%	500 ~ 1,300	560 ~ 1,500	
STAINLESS STEEL SUS 300 SERIES				~ 650
STAINLESS STEEL SUS 400 SERIES				~ 820
CARBON STEEL ALLOY STEEL				~ 980

Recommended Cutting Data - Diamond

WORK MATERIAL	JDA715	
	SFM	FEED RATE/REVOLUTION
ALUMINUM ALLOY	1,640 ~ 5,000	.002 ~ .008
COPPER ALLOY	3,300	.0009 ~ .008
SYNTHETIC RESIN	3,600	.0009 ~ .008

[illegible]