

Parting & Groove Turn

Parting & Groove Turn 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 Universal Grade for Parting & Groove Turn
- YG602 : Black version upon request

Parting & Groove Turn Inserts

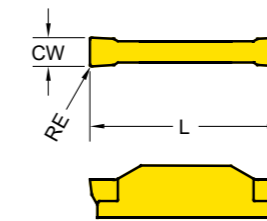
Inserts	TD. Series	2, 3, 4

Parting & Groove Turn Chipbreakers

-P TDP			• Parting & Grooving (Positive)
-N TDN			• Parting & Grooving (General)
-Y TDY			• Groove Turn

Parting & Groove Turn - Inserts

Parting & Groove Turn Inserts (TD.)



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

● : Stock item ○ : Order made item

TD.	Designation	RE	Parting & Grooving		Groove Turn		YG602	YG602G
			Fn (mm/rev.)	Tmax (mm)	Fn (mm/rev.)	Ap (mm)		
TDP Parting & Grooving (Positive)	TDP 2002	0.2	0.04~0.12	19	-	-	○	●
	TDP 3002	0.2	0.05~0.16	19	-	-	○	●
	TDP 4003	0.3	0.06~0.18	19	-	-	○	●
TDN Parting & Grooving (General)	TDN 2002	0.2	0.06~0.18	19	-	-	○	●
	TDN 3002	0.2	0.07~0.22	19	-	-	○	●
	TDN 4003	0.3	0.08~0.25	19	-	-	○	●
TDY Groove Turn	TDY 3 E - 0.4	0.4	0.10~0.20	19	0.10~0.38	0.5~2.2		●
	TDY 4 E - 0.4	0.4	0.15~0.26	19	0.10~0.40	0.5~2.8		●

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