



PARTING & GROOVING

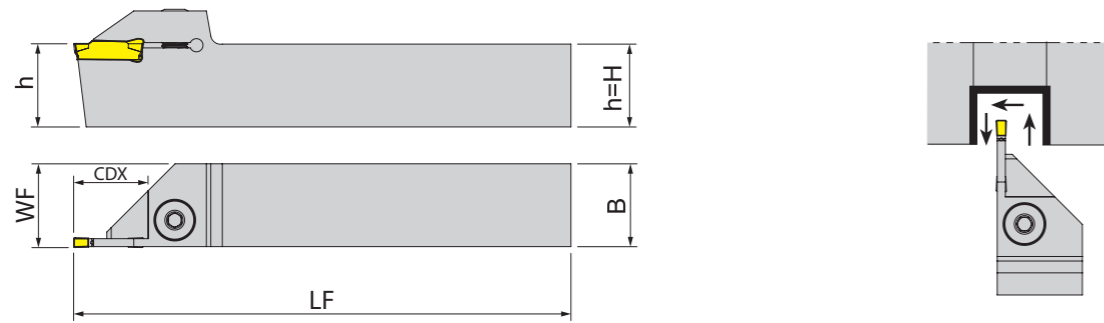
Parting & Grooving Holders

Parting & Grooving Inserts Overview

Parting & Grooving Inserts (TD.)

Parting & Grooving - Holder - External

External holders for TD. insert



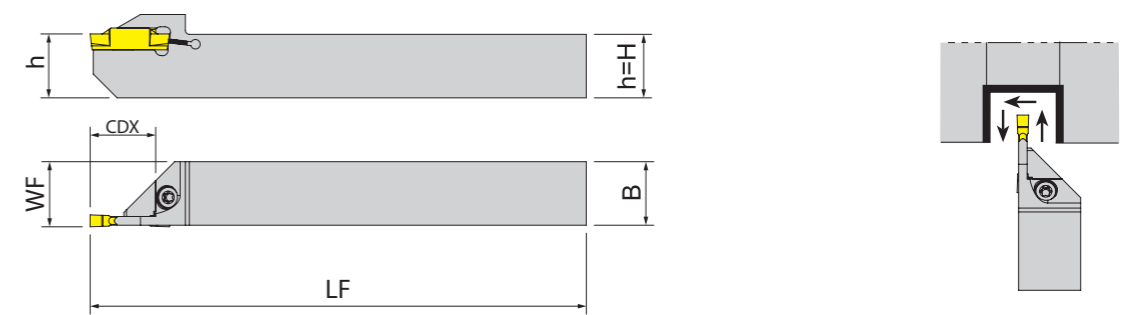
: p. 99 Unit : mm

Designation	EDP 5700.. R	L	CW	CDX	H	B	LF	WF	Insert
YTER/L 1212-2T15	0025	0024	2	15	12	12	100	12.3	TD.2..
YTER/L 1616-2T15	0027	0026	2	15	16	16	125	16.3	
YTER/L 2020-2T15	0030	0029	2	15	20	20	125	20.3	
YTER/L 2020-2T20	0032	0031	2	20	20	20	125	20.3	
YTER/L 2020-2T9	0028	-	2	9	20	20	125	20.3	
YTER/L 2525-2T17	0034	0033	2	17	25	25	150	25.3	
YTER/L 1212-3T15	0036	0035	3	15	12	12	100	12.4	TD.3..
YTER/L 1616-3T15	0038	0037	3	15	16	16	125	16.4	
YTER/L 2020-3T20	0040	0039	3	20	20	20	125	20.4	
YTER/L 2525-3T20	0044	0043	3	20	25	25	150	25.4	
YTER/L 2525-3T9	0042	0041	3	9	25	25	150	25.4	
YTER/L 3232-3T20	0045	-	3	20	32	32	170	32.4	TD.4..
YTER/L 2525-4T20	0047	0046	4	20	25	25	150	25.5	

: p. 99 Unit : mm

Parting & Grooving - Holder - External

External holders (Swiss Lathe) for TD. insert



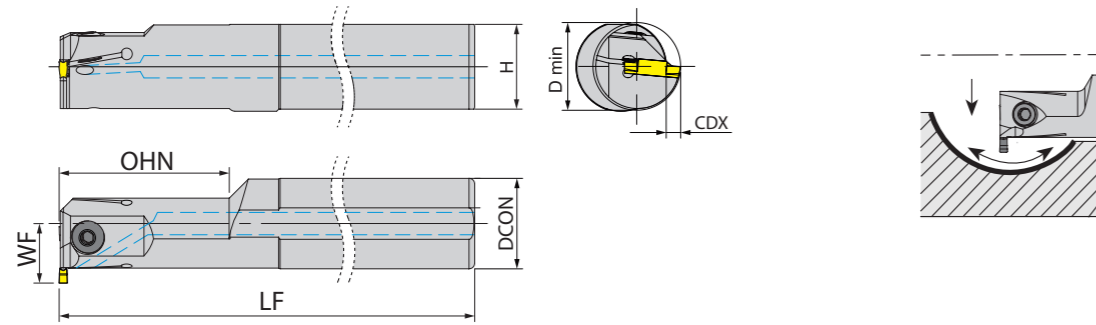
: p. 99 Unit : mm

Designation	EDP 5700.. R	L	CW	CDX	H	B	LF	WF	Insert
YTER/L 1212-2T12-S	0048	-	2	12	12	12	125	12.2	TD.2..
YTER/L 1616-2T16-S	0049	-	2	16	16	16	125	16.2	
YTER/L 1212-3T12-S	0051	0050	3	12	12	12	125	12.3	TD.3..
YTER/L 1616-3T16-S	0053	0052	3	16	16	16	125	16.3	

Series	Size	Screw	Ring	Wrench
YTER/L	..2..	YAKV-02-M6x22	YABPL-01	YAAL-03-3
	..3../..4..	Y2004-M8x1x20	-	YAAL-05-4

Series	Size	Screw	Wrench
YTER/L	..S	Y4015-M4x11	Y80-T15

Parting & Grooving - Holder - Internal
Internal holders for TD. insert

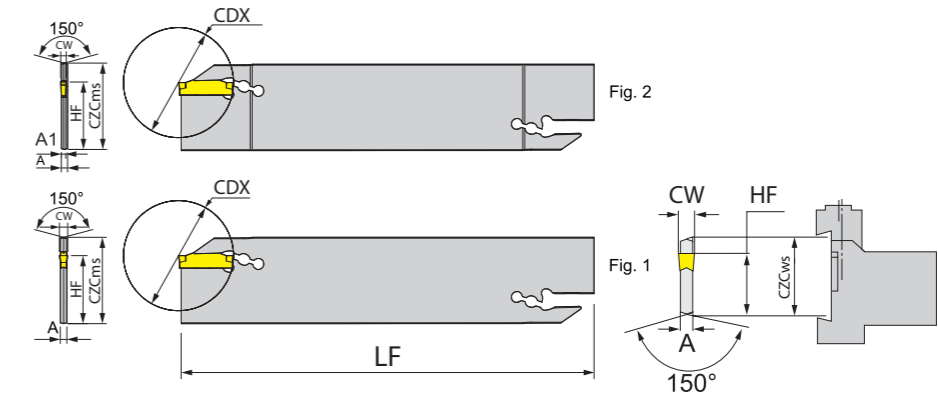


: p. 99 Unit :mm

Designation	EDP 5700.. R L	CW	DMIN	CDX	DCON	H	OHN	LF	WF	Insert
YTIR/L 16-2C-T8.5-C	● 0054 -	2	25	8.5	16	14.8	28	150	16.5	TD.2..
YTIR/L 20-3C-T6-C	● 0055 -	3	25	6	20	18.3	40	170	16	TD.3..
YTIR/L 25-3C-T6-C	● 0056 -	3	25	6	25	23	40	200	18.5	
YTIR/L 32-3C-T5-C	● 0057 -	3	31	5	32	30	60	250	21	

Series	Size	Screw	Wrench
YTIR/L	16-2C..	Y2503-M4x10	YAAL-03-3
	20~25-3C..	Y2504-M5x12	YAAL-05-4
	32-3C..	Y2004-M8x1x20	YAAL-05-4

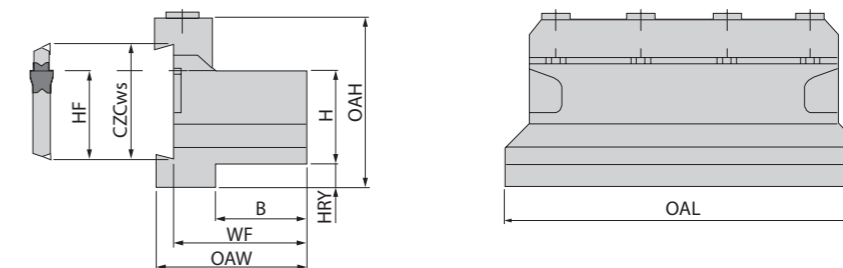
Parting & Grooving - Holder
Blade for TD. insert



: p. 99 Unit:mm

Designation	EDP 5700..	CZCms	CW	CDX	HF	LF	W	Insert
YGB 32-2	0058	32	2	20	25	150	2.4	TD.2..
YGB 32-3	0059	32	3	20	25	150	2.4	TD.3..
Series	Wrench							
YGB..	YALA-01							

Parting & Grooving - Holder
Blade Block for TD. insert



: p. 99 Unit:mm

Designation	EDP 5700..	CZCws	H	B	HF	WF	HRY	OAL	OAH	OAW
YGBU 20-32	0060	32	20	19	25	32.7	13	100	50	38
YGBU 25-32	0061	32	25	23	25	36.7	8	110	50	42
YGBU 32-32	0062	32	32	29	25	42.7	5	110	54	48

Series	Size	Clamp	Screw	Wrench
YGBU	20-32	YABK-03	Y2505-M6x30	YAAL-07-5
	25~32-32	YABK-04	Y2505-M6x30	YAAL-07-5

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

Inserts	TD. Series	2, 3, 4

Parting & Grooving Chipbreakers

-P TDP			• Parting & Grooving (Positive)
-N TDN			• Parting & Grooving (General)
-Y TDY			• Turning, Parting & Grooving

Parting & Grooving - Inserts

Parting & Grooving Inserts

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		Turning		EDP 5200..	
			Fn (mm/rev.)	CDX (mm)	Fn (mm/rev.)	Ap (mm)	YG602	YG602G
-P 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
-N Parting & Grooving (General)	TDN2002	0.2	0.04 ~ 0.12	19			● 0010	● 0035
	TDN3002	0.2	0.07~0.22	19			● 0024	● 0025
	TDN4003	0.3	0.08~0.25	19			● 0022	● 0037
-Y Groove Turn	TDY3E - 0.4	0.4	0.10~0.20	19	0.10~0.38	0.50~2.20		● 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	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