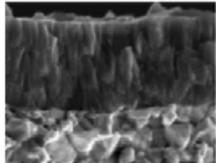
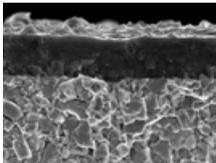


## Parting & Grooving Overview

### Parting & Groove Turn Grades

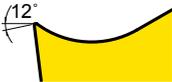
Parting and Grooving Grades		P Steel				M Stainless steel				K Cast iron			N Non Ferrous		S Super Alloy	
		P10	P20	P30	P40	M10	M20	M30	M40	K10	K20	K30	N10	N20	S10	S20
PVD	YG602G (YG602)		602G				602G				602G					602G
	YG603						603									

<p><b>YG602G</b> (YG602)</p> <p>P20 - P35   M20 - M40 K20 - K40   S15 - S25</p>	<p>PVD - TiAlN</p> 	<p><b>Universal grade for Parting &amp; Groove Turn</b></p> <ul style="list-style-type: none"> <li>Ultra Dense PVD Coating with optimal thermal resistance &amp; strength</li> <li>Sub-Micron substrate designed for demanding application</li> <li>YG602G : First Choice for Low Cutting Speed, Soft and Sticky Material with Low Hardness (Gold Color)</li> <li>YG602 : First Choice for General Application (Violet Color)</li> </ul>
<p><b>YG603</b></p> <p>M30 - M50</p>	<p>PVD - TiAlN</p> 	<p><b>PVD Parting &amp; Grooving Grade for Stainless Steel</b></p> <ul style="list-style-type: none"> <li>Ultra high toughness substrate and strong adhesion</li> <li>Excellent cutting edge strength and chipping resistance</li> <li>Stable machinability and tool life for stainless steel</li> </ul>

### Parting & Grooving Inserts

	TD. Series	<p><b>Inserts</b></p> <p>TDN, TDP, TDY</p>	2, 3, 4, 5, 6, 8
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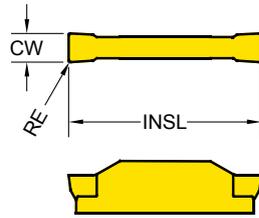
### Parting & Grooving Chipbreakers

Parting & Grooving	-P			<ul style="list-style-type: none"> <li>For Parting &amp; Grooving</li> <li>For Low Feed Rate and Difficult to Cut Materials</li> </ul>
	-N			<ul style="list-style-type: none"> <li>For External Parting And Grooving</li> <li>For General Use</li> </ul>
Turning & Grooving	-Y			<ul style="list-style-type: none"> <li>For External Turning &amp; Grooving</li> <li>For Medium feed rate</li> </ul>
	GL			<ul style="list-style-type: none"> <li>For External, Internal turning and Grooving</li> <li>Face grooving and Face turning</li> <li>For low feed rate</li> </ul>
	GM			<ul style="list-style-type: none"> <li>For External, Internal turning and Grooving</li> <li>First choice Face Grooving and Face turning</li> <li>For Medium feed rate</li> </ul>
	RG			<ul style="list-style-type: none"> <li>For External, Internal turning and Grooving</li> <li>Full radius Insert for Profiling</li> </ul>

Parting & Grooving

# Parting & Grooving Inserts

Recommended Cutting Conditions : p.258



Series	INSL	CW	Series	INSL	CW
TD* 2	20.00	2.00	TD* 5	25.00	5.00
TD* 3	20.00	3.00	TD* 6	25.00	6.00
TD* 4	20.00	4.00	TD* 8	30.00	8.00

\* 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	YG603
-P  Parting & Grooving (Sharp edge)	TDP 2002	0.2	0.04-0.12	19	-	-	● 0012	○ 0036	● 0078
	TDP 3002	0.2	0.05-0.16	19	-	-	● 0029	○ 0030	● 0076
	TDP 4003	0.3	0.06-0.18	19	-	-	● 0023	○ 0038	● 0080
	TDP5003	0.3	0.06-0.20	24	-	-	● 0142	○ 0143	● 0144
	TDP6003	0.3	0.06-0.22	24	-	-	● 0145	○ 0146	● 0147
	*T DPR 2002 - 6	0.2	0.03-0.08	19	-	-	● 0045		● 0085
	*T DPR 3002 - 6	0.2	0.04-0.12	19	-	-	● 0048		● 0089
	*T DPL 2002 - 6	0.2	0.03-0.08	19	-	-	● 0046		● 0086
	*T DPL 3002 - 6	0.2	0.04-0.12	19	-	-	● 0049		● 0090
	-N  Parting & Grooving Right Hand Shown (Sharp edge) *  6° Angled Parting	TDN 2002	0.2	0.05-0.18	19	-	-	● 0010	○ 0035
TDN 3002		0.2	0.07-0.23	19	-	-	● 0024	○ 0025	● 0075
TDN 4003		0.3	0.08-0.28	19	-	-	● 0022	○ 0037	● 0079
TDN 5003		0.3	0.09-0.30	24	-	-	● 0042	○ 0136	● 0130
TDN6003		0.3	0.10-0.35	24	-	-	● 0132	○ 0137	● 0133
TDN8004		0.4	0.12-0.40	29	-	-	● 0138	○ 0139	● 0140
*T DNR 2002 - 6		0.2	0.04-0.14	19	-	-	● 0043		● 0083
*T DNR 3002 - 6		0.2	0.06-0.18	19	-	-	● 0040		● 0087
*T DNL 2002 - 6		0.2	0.04-0.14	19	-	-	● 0044		● 0084
*T DNL 3002 - 6		0.2	0.06-0.18	19	-	-	● 0047		● 0088
*T DNL 4003 - 6	0.3	0.06-0.24	19	-	-	● 0096			