

TURNING

THREADING

GROOVING

MILLING

DRILLING

ACCESSORIES

CC	CARBIDE Positive					ISO513	HC-CVD						HC-PVD		HW		HT				
	Size	IC	S	D1	AN		P	JC7010	JC7020	JC8005	JC8015	JC8025	JC9010	JC9025	JPS015	JPS025	JPS010	JUG010	JUG020	JU4015	JP4020
	MICRO CC	3.50	1.40	1.90	7°		M			200 380	180 360	140 300	150 280	120 240	80 220	60 180					200 380
	0602□	6.35	2.38	2.80	7°	K	180 380	150 300						80 170					160 280	160 300	
	09T3□	9.525	3.97	4.40	7°	N										600 2200	600 2000	500 1500			
	1204□	12.70	4.76	5.50	7°	S								40 80							
						H															
GRADE APPLICATION AREA	Stable machining, continuous cut					+															
main application	General machining, light interruption					-															
applicable	Unstable machining, interrupted cut					+															
FINISHING	GB	MICRO CC.R01-GBL	RE 0.1	a_p 0.05 f_n 0.02	0.20 0.04	0.35 0.06									○						
		CC.R02-GBL	RE 0.2	a_p 0.05 f_n 0.03	0.20 0.05	0.35 0.07										●		●	○		
		CC.R04-GBL	RE 0.4	a_p 0.05 f_n 0.04	0.20 0.06	0.35 0.08										●		●	○		
	PPF	CCET 060202 ⁹⁰ /L-PPF	RE 0.2	a_p 0.10 f_n 0.04	0.40 0.07	0.70 0.10										●				●	
		060204 ⁹⁰ /L-PPF	RE 0.4	a_p 0.10 f_n 0.04	0.40 0.08	0.70 0.12										●				●	
		CCET 09T302 ⁹⁰ /L-PPF	RE 0.2	a_p 0.10 f_n 0.04	0.50 0.08	0.90 0.12										●				●	
		09T304 ⁹⁰ /L-PPF	RE 0.4	a_p 0.10 f_n 0.04	0.50 0.09	0.90 0.14										●				●	
	PFU	CCMT 060202-PFU	RE 0.2	a_p 0.20 f_n 0.04	0.80 0.08	1.40 0.12				●	●		●	●	●	●				●	○
		060204-PFU	RE 0.4	a_p 0.20 f_n 0.05	0.80 0.11	1.40 0.17			●	●	●		●	●	●	●				●	●
		CCMT 09T302-PFU	RE 0.2	a_p 0.30 f_n 0.05	1.00 0.10	1.70 0.15				●	●		●	●	●	●				●	○
		09T304-PFU	RE 0.4	a_p 0.30 f_n 0.06	1.00 0.14	1.70 0.22			●	●	●		●	●	●	●				●	●
		09T308-PFU	RE 0.8	a_p 0.30 f_n 0.08	1.00 0.16	1.70 0.24				●	●		●	●	●					●	○
MEDIUM	PPM	CCET 09T304 ⁹⁰ /L-PPM	RE 0.4	a_p 0.50 f_n 0.04	1.50 0.07	2.50 0.10									●				●		
	PMU	CCMT 060202-PMU	RE 0.2	a_p 0.50 f_n 0.05	1.50 0.10	2.50 0.15				○	●		●	●						●	○
		060204-PMU	RE 0.4	a_p 0.50 f_n 0.06	1.50 0.13	2.50 0.20		●		●	●	●	●	●	●					●	●
		060208-PMU	RE 0.8	a_p 0.50 f_n 0.08	1.50 0.16	2.50 0.24		●		○	●		●	●	●					●	
		CCMT 09T302-PMU	RE 0.2	a_p 0.60 f_n 0.06	1.80 0.13	3.00 0.20					●	●	●	●	●					●	○
		09T304-PMU	RE 0.4	a_p 0.60 f_n 0.07	1.80 0.16	3.00 0.25					●	●	●	●	●	●				●	●
		09T308-PMU	RE 0.8	a_p 0.60 f_n 0.08	1.80 0.19	3.00 0.30		●	●		●	●	●	●	●	●				●	○
		CCMT 120404-PMU	RE 0.4	a_p 0.80 f_n 0.08	2.20 0.17	3.60 0.26		●			●	●	●	●	●					●	
		120408-PMU	RE 0.8	a_p 0.80 f_n 0.10	2.20 0.22	3.60 0.32		●	○		●	●	●	●	●					●	
120412-PMU	RE 1.2	a_p 0.80 f_n 0.12	2.20 0.24	3.60 0.36		●			○	○		○	○					●			

● stock standard, ○ non-standard stock



CC	CARBIDE Positive					ISO513	HC-CVD						HC-PVD		HW		HT			
	Size	IC	S	D1	AN		JP7010	JP7020	JP8005	JP8015	JP8025	JP9010	JP9025	JP5015	JP5025	JP6010	JU6010	JU6020	JU4015	JP4020
<p>2 edges</p>	MICRO CC	3.50	1.40	1.90	7°	P			200 380	180 360	140 300		80 220	60 180					200 380 400	200 400
	0602□□	6.35	2.38	2.80	7°	M					150 280	120 240	80 160	60 120					160 280 300	160 300
	09T3□□	9.525	3.97	4.40	7°	K	180 380	150 300						80 170					200 400	200 420
	1204□□	12.70	4.76	5.50	7°	N									600 2200	600 2000	500 1500			
							S							40 80						
						H														
GRADE APPLICATION AREA	Stable machining, continuous cut					+														
main application	General machining, light interruption					-														
applicable	Unstable machining, interrupted cut					+														
MEDIUM <p>polished surface</p>	CCGX	060202-PMN	RE 0.2	a _p ▶ 0.30 f _n ▶ 0.05	1.50 0.10	2.70 0.15														
		060204-PMN	RE 0.4	a _p ▶ 0.30 f _n ▶ 0.06	1.50 0.13	2.70 0.20										●	●	●		
		060208-PMN	RE 0.8	a _p ▶ 0.30 f _n ▶ 0.08	1.50 0.16	2.70 0.24									○	○	●			
	CCGX	09T302-PMN	RE 0.2	a _p ▶ 0.50 f _n ▶ 0.06	2.00 0.11	3.50 0.16									○	●				
		09T304-PMN	RE 0.4	a _p ▶ 0.50 f _n ▶ 0.08	2.00 0.16	3.50 0.24									●	●	●			
		09T308-PMN	RE 0.8	a _p ▶ 0.50 f _n ▶ 0.10	2.00 0.20	3.50 0.30									○	○	●			
	CCGX	120402-PMN	RE 0.2	a _p ▶ 0.50 f _n ▶ 0.08	3.00 0.14	5.50 0.20									○	●				
		120404-PMN	RE 0.4	a _p ▶ 0.50 f _n ▶ 0.10	3.00 0.20	5.50 0.30									○	●	●			
		120408-PMN	RE 0.8	a _p ▶ 0.50 f _n ▶ 0.15	3.00 0.25	5.50 0.35									○	●	●			
	ROUGHING <p>reinforced edge</p>	CCMT	09T304-PRU	RE 0.4	a _p ▶ 1.50 f _n ▶ 0.10	2.50 0.19	3.50 0.28	●			●									
09T308-PRU			RE 0.8	a _p ▶ 1.50 f _n ▶ 0.12	2.50 0.22	3.50 0.32	●			●										
CCMT		120408-PRU	RE 0.8	a _p ▶ 1.50 f _n ▶ 0.14	3.00 0.26	4.50 0.38	●			●										
		120412-PRU	RE 1.2	a _p ▶ 1.50 f _n ▶ 0.16	3.00 0.28	4.50 0.40	●			●										

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