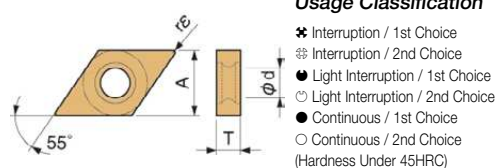








Double-Sided

Turning Inserts



Part Number	A	T	Ød
DN_222_	0.276	1/8	0.142

				Corner Radius (in)	Cermet			MEGA COAT Cermet	PVD Cermet	CVD Coated Carbide					MEGACOAT / MEGACOAT NANO				PVD Coated Carbide		Carbide	Toolholder Page	Chipbreaker Range																		
ANSI		ISO			rε	TN620	TN6010	TN6020	TN60	PV720	PV7010	PV7025	PV90	CA510	CA515	CA525	CA530	CA5505	CA5515	CA5525	CA5535			CA6515	CA6525	PR1425	PR1225	PR1305	PR1310	PR1325	PR930	PR1005	PR1025	PR1125	KW10	SW05					
Part Number		Part Number																																							
 Finishing-Medium Sharp Edge	DNGU	22202MF-SK	080301MF-SK	<0.004																																					
		22205MF-SK	080302MF-SK	<0.008																																					
		2221MF-SK	080304MF-SK	<1/64																																					
 Finishing-Medium Sharp Edge / Polished	DNGU	22202MFP-SK	080301MFP-SK	<0.004																				●	●																
		22205MFP-SK	080302MFP-SK	<0.008																				●	●																
		2221MFP-SK	080304MFP-SK	<1/64																				●	●																
 Medium-Roughing Honed Edge	DNMU	22205E-GK	080302E-GK	0.008																				●	●																
		2221E-GK	080304E-GK	1/64																				●	●																
 Finishing Sharp Edge	DNGU	222013MF%-F	0803005MF%-F	<0.002																					R																
		22202MF%-F	080301MF%-F	<0.004																					R	R															
		22205MF%-F	080302MF%-F	<0.008																					R	R															
		2221MF%-F	080304MF%-F	<1/64																					R	R															
 Low Feed Sharp Edge	DNGU	222013MF%-U	0803005MF%-U	<0.002																					R																
		22202MF%-U	080301MF%-U	<0.004																					R	R															
		22205MF%-U	080302MF%-U	<0.008																					R	R															
		2221MF%-U	080304MF%-U	<1/64																					R	R															
 Low Feed Honed Edge	DNGU	22202ME%-U	080301ME%-U	<0.004																																					
		22205ME%-U	080302ME%-U	<0.008																																					
		2221ME%-U	080304ME%-U	<1/64																																					

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• Insert whose corner R(rε) dimension expressed with less than sign (e.g. <0.002, <0.004, <0.008 etc.) indicate models with minus tolerance for corner R (rε).

Cutting Range	Name	Cross-Section	Advantages
Finishing-Medium	SK		A low cutting force chipbreaker designed for chip control in steel and stainless steel. Cutting performance is similar to comparably sized positive inserts.
Medium-Roughing	GK		Chipbreaker "dot" and pocket design provide chip control at multiple depths of cut and feed rates.
Finishing	F		Controlled chip evacuation direction with low cutting forces.
Low Feed	U		Good chip control at low feed rates and varied depths of cut with low cutting forces.