для заказа - kyocera@kyocera-tools.ru

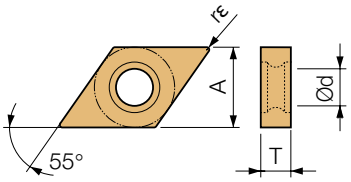
How to read this page B13

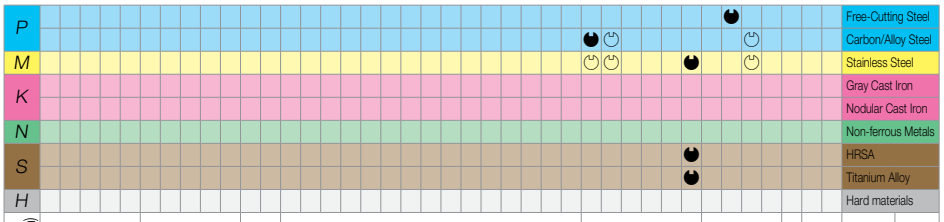
Small Double-Sided
Turning Inserts

(in)

Part Number	A	T	Ød
DN_222_	0.276	1/8	0.142

NEGATIVE C D R S T V W CERAMIC

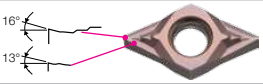
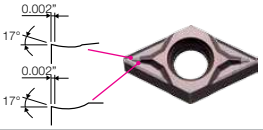




		ANSI Part Number	ISO Part Number	rε	Cermet TN610	Cermet TN620	Cermet TN6010	Cermet TN6020	Cermet TN60	MEGA COAT Cermet PV710	MEGA COAT Cermet PV720	MEGA COAT Cermet PV7010	MEGA COAT Cermet PV7025	MEGA COAT Cermet PV7005	PVD Cermet PV90	PVD Cermet PV7020	CVD Coated Carbide CA510	CVD Coated Carbide CA515	CVD Coated Carbide CA525	CVD Coated Carbide CA530	CVD Coated Carbide CA5505	CVD Coated Carbide CA5515	CVD Coated Carbide CA5525	CVD Coated Carbide CA5535	CVD Coated Carbide CA6515	CVD Coated Carbide CA6525	CVD Coated Carbide CA4505	CVD Coated Carbide CA4515	CVD Coated Carbide CA4010	CVD Coated Carbide CA4115	CVD Coated Carbide CA4120	MEGACOAT / MEGACOAT NANO PR1425	MEGACOAT / MEGACOAT NANO PR1225	MEGACOAT / MEGACOAT NANO PR1305	MEGACOAT / MEGACOAT NANO PR1310	MEGACOAT / MEGACOAT NANO PR1325	MEGACOAT / MEGACOAT NANO PR1535	PVD Coated Carbide PR930	PVD Coated Carbide PR1005	PVD Coated Carbide PR1025	DLC PR1125	DLC PDL025	Carbide KW10	Carbide SW05	Toolholder Page	Chipbreaker Range
Finishing-Medium Sharp Edge	DNGU	22202MF-SK	080301MF-SK	<0.004																																	●						E38	B51 2
		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$^{R}_{L}$-F	0803005MF$^{R}_{L}$-F	<0.002																														Ⓡ						Ⓡ				
		22202MF$^{R}_{L}$-F	080301MF$^{R}_{L}$-F	<0.004																													Ⓡ	Ⓡ			Ⓡ		Ⓡ	Ⓡ				
		22205MF$^{R}_{L}$-F	080302MF$^{R}_{L}$-F	<0.008																													Ⓡ	Ⓡ			Ⓡ		Ⓡ	Ⓡ				
		2221MF$^{R}_{L}$-F	080304MF$^{R}_{L}$-F	<1/64																													Ⓡ	Ⓡ			Ⓡ		Ⓡ	Ⓡ				
Low Feed Sharp Edge	DNGU	222013MF$^{R}_{L}$-U	0803005MF$^{R}_{L}$-U	<0.002																														Ⓡ						Ⓡ				
		22202MF$^{R}_{L}$-U	080301MF$^{R}_{L}$-U	<0.004																													Ⓡ	Ⓡ			Ⓡ		Ⓡ	Ⓡ				
		22205MF$^{R}_{L}$-U	080302MF$^{R}_{L}$-U	<0.008																													Ⓡ	Ⓡ			Ⓡ		Ⓡ	Ⓡ				
		2221MF$^{R}_{L}$-U	080304MF$^{R}_{L}$-U	<1/64																													Ⓡ	Ⓡ			Ⓡ		Ⓡ	Ⓡ				
Low Feed Honed Edge	DNGU	22202ME$^{R}_{L}$-U	080301ME$^{R}_{L}$-U	<0.004																																			Ⓡ	Ⓡ				
		22205ME$^{R}_{L}$-U	080302ME$^{R}_{L}$-U	<0.008																																			Ⓡ	Ⓡ				
		2221ME$^{R}_{L}$-U	080304ME$^{R}_{L}$-U	<1/64																																			Ⓡ	Ⓡ				

• 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).

Chipbreaker Selection (Negative Inserts)

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.

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