

# Turning Indexable Inserts

## Small Double Sided Tools

(mm)

Description	A	T	ød
CN_U0703_	7.5	3.18	3.6

B



Negative



Insert (Turning)

Insert	Description	Dim. (mm)	Material											PVD Coated Carbide	Carbide	Ref. Page for Toolholder	Applicable Chipbreaker Range										
			Cermet	PVD Cermet	CVD Coated Carbide						PVD Coated Carbide																
		rε	TN6010	TN6020	TN60	PV7005	PV7010	PV7020	CA5505	CA5515	CA5525	CA5535	CA6515	CA6525	CA4010	CA4115	CA4120	CA4505	CA4515	PR930	PR1005	PR1025	PR1125	KW10			
Finishing-Medium Sharp Edge	CNGU 070301MF-SK	< 0.1																								E4	
	CNGU 070302MF-SK	< 0.2																									
Medium-Roughing With Honing	CNMU 070302E-GK	0.2																									
	CNMU 070304E-GK	0.4																									
Finishing Sharp Edge	CNGU 0703005MF <sup>β</sup> /L-F	< 0.05																			R	R					
	CNGU 070301MF <sup>β</sup> /L-F	< 0.1																			R	R					
	CNGU 070302MF <sup>β</sup> /L-F	< 0.2																			R	R					
	CNGU 070304MF <sup>β</sup> /L-F	< 0.4																			R	R					
Low Feed Sharp Edge	CNGU 0703005MF <sup>β</sup> /L-U	< 0.05																			R	R					
	CNGU 070301MF <sup>β</sup> /L-U	< 0.1																			R	R					
	CNGU 070302MF <sup>β</sup> /L-U	< 0.2																			R	R					
	CNGU 070304MF <sup>β</sup> /L-U	< 0.4																			R	R					
Low Feed With Honing	CNGU 070301ME <sup>β</sup> /L-U	< 0.1																			R	R					
	CNGU 070302ME <sup>β</sup> /L-U	< 0.2																			R	R					
	CNGU 070304ME <sup>β</sup> /L-U	< 0.4																			R	R					

\* Insert whose corner R(rε) dimension expressed with less than sign (e.g. <0.05, <0.1, <0.2 etc.) indicate models with minus tolerance for corner R(rε).

## Chipbreaker Selection

Cutting Range	Name	Design	Advantages
Finishing-Medium	SK		A low cutting force chipbreaker designed for chip control in stainless steel. Cutting performance is similar to comparable sized positive inserts.
Medium-Roughing	GK		Chip breaker "dot" and pocket design provide chip control at multiple depths of cut and feed rates.
Finishing	F		Good chip control for finishing to light cutting with low cutting force.
Low Feed	U		Good chip control at low feed rate and varied ap with low cutting force.