



# **PARTING & GROOVING**

**Parting & Grooving Overview**

**Parting & Grooving Inserts (TD.)**

Parting & Grooving

# 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>YG602</b></p> <p>P20 - P35   M20 - M40</p> <p>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 TiAlN PVD Coating with optimal thermal resistance &amp; strength</li> <li>• Sub-Micron substrate designed for demanding application</li> <li>• First Choice for General Application</li> </ul>
<p><b>YG602G</b></p> <p>P20 - P35   M20 - M40</p> <p>K20 - K40   S15 - S25</p>	<p>PVD - TiAlN - TiN</p>	<p><b>Universal grade for Parting &amp; Groove Turn</b></p> <ul style="list-style-type: none"> <li>• Ultra Dense TiAlN / TiN PVD Coating with optimal thermal resistance &amp; strength</li> <li>• Sub-Micron substrate designed for demanding application</li> <li>• Good wear resistance at high cutting</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

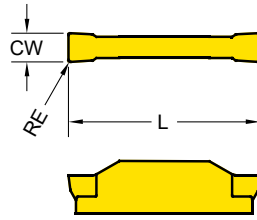
	TD. Series	<p><b>Inserts</b></p> <p>TDN TDP TDY</p>	2, 3, 4, 6
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## Parting & Grooving Chip breakers

<p><b>-P</b> TDP</p>		<ul style="list-style-type: none"> <li>• Parting &amp; Grooving</li> <li>• Low Feed for stainless steel and sticky material</li> </ul>
<p><b>-N</b> TDN</p>		<ul style="list-style-type: none"> <li>• Parting &amp; Grooving</li> <li>• Medium Feed for general application</li> </ul>
<p><b>-Y</b> TDY</p>		<ul style="list-style-type: none"> <li>• Turning &amp; Grooving</li> </ul>

# Parting & Grooving - Inserts




## Parting & Grooving Inserts



Series	L	CW
TD * 2	.787	.079
TD * 3	.787	.118
TD * 4	.787	.157
TD * 5	.787	.197
TD * 6	.787	.236

\* CDX : Cutting Depth Maximum

● : Stock item ○ : Order made item

TD.	Designation	RE	Parting & Grooving		Turning		EDP 5200..		
			Fn (in/rev.)	CDX (in)	Fn (in/rev.)	Ap (in)	YG602	YG602G	YG603
-P  Parting & Grooving (Positive)	TDP2002	.008	.002~.005	.748	-	-	● 0012	○ 0036	● 0078
	TDP3002	.008	.002~.006	.748	-	-	● 0029	○ 0030	● 0076
	TDP4003	.012	.002~.007	.748	-	-	● 0023	○ 0038	● 0080
	TDPR2002-6	.008	.002~.005	.748			● 0045		● 0085
	TDPR3002-6	.012	.002~.006	.748			● 0048		● 0089
	TDPL2002-6	.008	.002~.005	.748			● 0046		● 0086
	TDPL3002-6	.012	.002~.006	.748			● 0049		● 0090
-N  Parting & Grooving (General)	TDN2002	.008	.002~.005	.748	-	-	● 0010	○ 0035	● 0077
	TDN3002	.008	.003~.009	.748	-	-	● 0024	○ 0025	● 0075
	TDN4003	.012	.003~.010	.748	-	-	● 0022	○ 0037	● 0079
	TDN5003	.012	.004~.014	.984			● 0042		
	TDNR2002-6	.008	.002~.005	.748			● 0043		● 0083
	TDNR3002-6	.012	.003~.008	.748			● 0040		● 0087
	TDNL2002-6	.008	.002~.005	.748			● 0044		● 0084
TDNL3002-6	.012	.003~.008	.748			● 0047		● 0088	
-Y  Groove Turn	TDY3E-0.4	.016	.004~.008	.748	.004~.015	.020~.087		● 0027	
	TDY4E-0.4	.016	.006~.010	.748	.004~.016	.020~.110		● 0020	
	TDY5E-0.4		.008~.013	0.975	.004~.016	.020~.133	○ 0082		

Cutting Speed			Vc (ft/min.)			
ISO	VDI	Sub Group	YG602G (YG602)		YG603	
			Min.	Max.	Min.	Max.
P	1~5	Non-Alloyed Steel	390	590		
	6~9	Low-Alloyed Steel	330	460		
	10~11	High-Alloyed Steel	260	360		
M	12~13	Ferritic & Martensitic	230	520	160	300
	14	Austenitic Stainless Steel	180	460	130	260
K	15~16	Grey Cast Iron	360	610		
	17~18	Nodular Cast Iron	360	460		
N	21~30	Non-Ferrous Metals (Al)	820	1440		
S	31~37	Superalloys & Titanium	80	150		
H	38~41	Hard Materials	80	160		