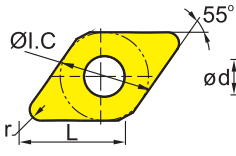


## Cemented carbide and cermet inserts

### DN □ □ (Negative inserts)



😊 Good working condition    😐 Normal working condition    ☹️ Bad working condition

Workpiece material	Steel (P)	Stainless steel (M)	Cast iron (K)	Non-ferrous metal (N)	Heat resistant alloy, Ti alloy (S)
Steel	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊
Stainless steel	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊
Cast iron	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊
Non-ferrous metal	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊
Heat resistant alloy, Ti alloy	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊😊😊😊😊😊😊

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet Coated cermet	Cermet							
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBG302	YBM151	YBM153	YBM215	YBM251			YBM253	YBS103	YBD052	YBD102	YBD152	YBD252	YNG151
<b>DF</b>   For finishing	DNMG110404-DF	11.6	9.525	4.76	3.81	0.4	○	●	○																						○
	DNMG110408-DF	11.6	9.525	4.76	3.81	0.8	○	○	○																						
	DNMG110412-DF	11.6	9.525	4.76	3.81	1.2	○	○																							
	DNMG150404-DF	15.5	12.7	4.76	5.16	0.4	★	●	★																						
	DNMG150408-DF	15.5	12.7	4.76	5.16	0.8	★	●	★																						
	DNMG150412-DF	15.5	12.7	4.76	5.16	1.2	○	○																							
	DNMG150604-DF	15.5	12.7	6.35	5.16	0.4	●	★	●	★													○								
	DNMG150608-DF	15.5	12.7	6.35	5.16	0.8	★	●	○																						
	DNMG150612-DF	15.5	12.7	6.35	5.16	1.2			○																						
<b>WGF</b>   For finishing Wiper	DNMX110404-WGF	11.6	9.525	4.76	3.81	0.4	★															★									
	DNMX110408-WGF	11.6	9.525	4.76	3.81	0.8	★																★								
	DNMX150404-WGF	15.5	12.7	4.76	5.16	0.4	★																★								
	DNMX150408-WGF	15.5	12.7	4.76	5.16	0.8	★																	★							
	DNMX150604-WGF	15.5	12.7	6.35	5.16	0.4	★																	★							
	DNMX150608-WGF	15.5	12.7	6.35	5.16	0.8	★																	★							

★Recommended grade (always stock available)    ●Available grade (always stock available)    ○Make-to-order

#### Applicable tool



Page    A167                      A174                      A175                      A213                      A214

Insert code key    A50-A51    Grade selection reference    A19/A36-A48    Chipbreaker selection reference    A22-A35    Recommended cutting parameters    A241-A244

General turning

Cemented carbide and cermet inserts





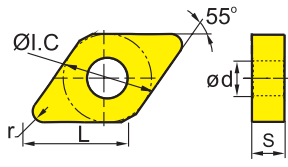


# General Turning Inserts

Cemented carbide and cermet inserts

## DN (Negative inserts)

😊 Good working condition   😐 Normal working condition   ☹️ Bad working condition



Workpiece material	Symbol
Steel	P
Stainless steel	M
Cast iron	K
Non-ferrous metal	N
Heat resistant alloy, Ti alloy	S

Workpiece material	Steel (P)	Stainless steel (M)	Cast iron (K)	Non-ferrous metal (N)	Heat resistant alloy, Ti alloy (S)
Steel (P)	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊
Stainless steel (M)	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊
Cast iron (K)	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊
Non-ferrous metal (N)	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊
Heat resistant alloy, Ti alloy (S)	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊	😊😊😊😊😊😊😊😊

General turning

Cemented carbide and cermet inserts

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																													
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBG302	YBM151	YBM153	YBM215	YBM251	YBM253	YBS103	YBD052	YBD102	YBD152	YBD252	Cermet Coated cermet	Cemented carbide						
DM For semi-finishing	DNMG110404-DM	11.6	9.525	4.76	3.81	0.4	●	●	○																											
	DNMG110408-DM	11.6	9.525	4.76	3.81	0.8	★	●	★	○													●													
	DNMG110412-DM	11.6	9.525	4.76	3.81	1.2	○		○																											
	DNMG150404-DM	15.5	12.7	4.76	5.16	0.4	○	●	★																								○			
	DNMG150408-DM	15.5	12.7	4.76	5.16	0.8	★	●	★																									●		
	DNMG150412-DM	15.5	12.7	4.76	5.16	1.2	★	○	★																											
	DNMG150416-DM	15.5	12.7	4.76	5.16	1.6				○																										
	DNMG150604-DM	15.5	12.7	6.35	5.16	0.4	★	●	★	○													●												●	
	DNMG150608-DM	15.5	12.7	6.35	5.16	0.8	★	●	★	●													●													
	DNMG150612-DM	15.5	12.7	6.35	5.16	1.2	●	●	★	○																										
DNMG150616-DM	15.5	12.7	6.35	5.16	1.6	○	○	○																												
EM For semi-finishing	DNMG110404-EM	11.6	9.525	4.76	3.81	0.4									○	★					○	★														
	DNMG110408-EM	11.6	9.525	4.76	3.81	0.8									○	★						○	★													
	DNMG110412-EM	11.6	9.525	4.76	3.81	1.2									○	★						○	★													
	DNMG150404-EM	15.5	12.7	4.76	5.16	0.4									●	★						★	★													
	DNMG150408-EM	15.5	12.7	4.76	5.16	0.8									●	★						★	★													
	DNMG150412-EM	15.5	12.7	4.76	5.16	1.2									○	★						★	★													
	DNMG150604-EM	15.5	12.7	6.35	5.16	0.4							○		●	★						○	★													
	DNMG150608-EM	15.5	12.7	6.35	5.16	0.8									●	★						○	★													
	DNMG150612-EM	15.5	12.7	6.35	5.16	1.2									○	★						○	★													
NM For semi-finishing	DNMG150412-NM	15.5	12.7	4.76	5.16	1.2							○	★												○									○	
	DNMG150612-NM	15.5	12.7	6.35	5.16	1.2							●	★												○									○	

★Recommended grade (always stock available)   ●Available grade (always stock available)   ○Make-to-order

### Applicable tool

DDJNR/L  
Kr:93°



Page A167

PDJNR/L  
Kr:93°



A174

PDPNN  
Kr:62°30'



A175

PDPNR/L  
Kr:62°30'



A213

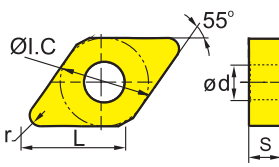
PDUNR/L  
Kr:93°



A214

### DN       (Negative inserts)

☺ Good working condition    😐 Normal working condition    ☹ Bad working condition



<b>P</b> Steel
<b>M</b> Stainless steel
<b>K</b> Cast iron
<b>N</b> Non-ferrous metal
<b>S</b> Heat resistant alloy, Ti alloy

Material	P	M	K	N	S	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBG302	YBM151	YBM153	YBM215	YBM251	YBM253	YBS103	YBD052	YBD102	YBD152	YBD252
Steel	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
Stainless steel	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
Cast iron	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
Non-ferrous metal	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺
Heat resistant alloy, Ti alloy	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺

General turning

Cemented carbide and cermet inserts

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																Cermet Coated Cermet	Cermet	Cemented carbide											
		L	ØI.C	S	ød	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBG302	YBM151	YBM153	YBM215	YBM251				YBM253	YBS103	YBD052	YBD102	YBD152	YBD252					
 Light-load roughing	DNMM150608-LR	15.5	12.7	6.35	5.16	0.8				★																										
	DNMM150612-LR	15.5	12.7	6.35	5.16	1.2				★																										
	DNMM150616-LR	15.5	12.7	6.35	5.16	1.6				★																										
 For light roughing	DNMG150408-DR	15.5	12.7	4.76	5.16	0.8				○																										
	DNMG150412-DR	15.5	12.7	4.76	5.16	1.2				○																										
	DNMG150416-DR	15.5	12.7	4.76	5.16	1.6				○	○																									
	DNMG150608-DR	15.5	12.7	6.35	5.16	0.8	★	○	○	○																●	●									
	DNMG150612-DR	15.5	12.7	6.35	5.16	1.2	○	●	★	○																○	●									
	DNMG150616-DR	15.5	12.7	6.35	5.16	1.6				○																	○									
 For roughing	DNMM150608-DR	15.5	12.7	6.35	5.16	0.8	○	○																												
	DNMM150612-DR	15.5	12.7	6.35	5.16	1.2	○	●																												
	DNMM150616-DR	15.5	12.7	6.35	5.16	1.6				○																										
 For roughing	DNMG150608-ER	15.5	12.7	6.35	5.16	0.8																	★													
	DNMG150612-ER	15.5	12.7	6.35	5.16	1.2																	★													
 For roughing	DNMM150608-ER	15.5	12.7	6.35	5.16	0.8																	★													
	DNMM150612-ER	15.5	12.7	6.35	5.16	1.2																	★													
 For roughing	DNMG150608-SNR	15.5	12.7	6.35	5.16	0.8							○	●		○								●												
	DNMG150612-SNR	15.5	12.7	6.35	5.16	1.2							○	●		○								●												

★ Recommended grade (always stock available)    ● Available grade (always stock available)    ○ Make-to-order

### Applicable tool



Page **A167**

**A174**

**A175**

**A213**

**A214**

Insert code key

**A50-A51**

Grade selection reference

**A19/A36-A48**

Chipbreaker selection reference

**A22-A35**

Recommended cutting parameters

**A241-A244**

