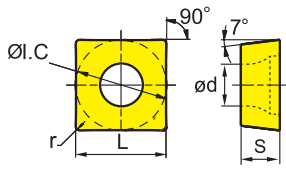




SC (Positive inserts)



😊 Good working condition    😐 Normal working condition    😞 Bad working condition

Workpiece material	YBC151	YBC152	YBC251	YBC252	YBC351	YBC352	YBG102	YBG105	YBG202	YBG205	YBG212	YBG302	YBM151	YBM153	YBM215	YBM251	YBM253	YBS103	YBD052	YBD102	YBD152	YBD252	YNG151	YNG151C	YD101	YD201
P Steel	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊
M Stainless steel							😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊	😊
K Cast iron																				😊	😊	😊	😊	😊	😊	😊
N Non-ferrous metal																										
S Heat resistant alloy, Ti alloy							😊	😊												😊						

Inserts shape	Type	Dimensions(mm)					Coated cemented carbide																	Cermet Coated 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	YNG151	YNG151C	YD101	YD201		
For AI machining	SCGX09T304-LC	9.525	9.525	3.97	4.4	0.4																												★		
	SCGX09T308-LC	9.525	9.525	3.97	4.4	0.8																												★		
	SCGX120408-LC	12.7	12.7	4.76	5.5	0.8																													★	
For AI machining	SCGX09T302-LH	9.525	9.525	3.97	4.4	0.2																												○		
	SCGX09T304-LH	9.525	9.525	3.97	4.4	0.4																												○		
	SCGX09T308-LH	9.525	9.525	3.97	4.4	0.8																												★		
	SCGX120404-LH	12.7	12.7	4.76	5.56	0.4																												○		
	SCGX120408-LH	12.7	12.7	4.76	5.56	0.8																													★	
For roughing	SCMT09T304-HR	9.525	9.525	3.97	4.4	0.4	★	●	●					●																				○		
	SCMT09T308-HR	9.525	9.525	3.97	4.4	0.8	★	○	●																										○	
	SCMT09T312-HR	9.525	9.525	3.97	4.4	1.2	★																												○	
	SCMT120404-HR	12.7	12.7	4.76	5.56	0.4	○	●	○																										○	
	SCMT120408-HR	12.7	12.7	4.76	5.56	0.8	★	●	○	●																										○
	SCMT120412-HR	12.7	12.7	4.76	5.56	1.2	○	○	●																											○
All round	SCMT09T304	9.525	9.525	3.97	4.4	0.4	○	●																											○	
	SCMT120404	12.7	12.7	4.76	5.56	0.4		○	○																										○	
	SCMT120408	12.7	12.7	4.76	5.56	0.8	○	●																											○	
Without chipbreaker	SCMW060204	6.35	6.35	2.38	2.8	0.4																													○	
	SCMW09T304	9.525	9.525	3.97	4.4	0.4																													○	
	SCMW09T308	9.525	9.525	3.97	4.4	0.8	○																												○	
	SCMW120408	12.7	12.7	4.76	5.56	0.8	●																												○	

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

Applicable tool



Page A194    A195    A196    A197    A222

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