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General product information

Please refer to general catalog.

Negative

Inserts - 25° Rhombic

- YNMG□□ ZF B109
- YNMG□□ ZM B109

External Toolholders

- AVJNR/L... C057, C062
- AVQNR/L... C131, C132
- AVVNN... C072, C073

Internal Toolholders

- A□□□-AVUNR/L3-... D082

Positive

Insert 25° Rhombic,

- YWMT□□-ZF B163
- YWMT□□-ZM B163

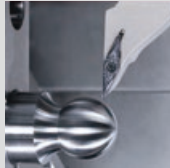
External Toolholders

- SYHBR/L□□□... C136
- SYIBN□□□... C139
- SYJBR/L□□□... C069
- SYQBR/L□□□... C136

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- A□□□-SYUBR/L□ D084
- E□□□-SYQBR/L□-... D092
- E□□□-SYUBR/L□-... D084

Added products



AH8015

Expansion of Y-Pro inserts series with AH8015 grade

[View](#)

Expansion of Y-Pro insert series with AH8015 grade





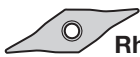
With a new grade in the range, Y-Pro series further expands the workpiece material coverage

Grade	Recommended workpiece material	Feature
PREMIUMTEC New AH8015	M S	- PVD coated grade with a balanced resistance to wear and fracture - First choice for stainless steel and heat-resistant superalloys
PREMIUMTEC T9225	P K	- CVD coating grade - First choice for steel and cast iron - Excellent crater wear resistance and flank wear resistance
PREMIUMTEC T9235	P	- CVD coating grade - High fracture resistance provides stable tool life
PREMIUMTEC GT9530	P	- Coated cermet grade with PremiumTec treatment for exceptional wear resistance - Provides remarkable performance in high-speed finishing of steel
NS9530	P	- General-purpose cermet grade with incredible fracture and wear resistance - Ensures long tool life and excellent surface finishing of steel

INSERT NEGATIVE TYPE

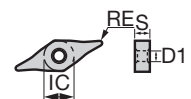
- : Continuous cutting
- ◐ : Light interrupted cutting
- ◑ : Heavy interrupted cutting

YN



Rhombic, 25° with hole

	P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material
●	●	●	●	●	●	●
◐	◐	◐	◐	◐	◐	◐
◑	◑	◑	◑	◑	◑	◑



Application	Chipbreaker	Designation	Coated			Coated Cermet		Cermet		Dimension (in)			
			T9225	T9235	AH8015	GT9530	NS9530	RE	IC	S	D1		
Finishing		Inch YNMG 331 ZF	●	●	●	●	●	0.016	0.375	0.187	0.150		
		Metric YNMG160404-ZF	●	●	●	●	●	0.031	0.375	0.187	0.150		
Finishing to medium cutting		Inch YNMG 331 ZM	●	●	●	●	●	0.016	0.375	0.187	0.150		
		Metric YNMG160408-ZM	●	●	●	●	●	0.031	0.375	0.187	0.150		

● : New

INSERT POSITIVE TYPE

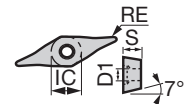
- : Continuous cutting
- c : Light interrupted cutting
- * : Heavy interrupted cutting

YW



Rhombic, 25°
with hole
Positive 7°

P	Steel	●*		●c															
M	Stainless		●c																
K	Cast iron			●c															
N	Non-ferrous																		
S	Superalloy		●c																
H	Hard material																		



Application	Chipbreaker	Designation	Coated		Coated Cermet		Dimension (in)								
			T9225	AH8015	GT9530		RE	IC	S	D1					
Finishing to medium cutting	ZF	-	YWMT11T202-ZF	●	●c	●					0.008	0.184	0.109	0.091	
		-	YWMT11T204-ZF	●	●c	●						0.016	0.184	0.109	0.091
		-	YWMT16T302-ZF	●	●c	●						0.008	0.276	0.156	0.113
		-	YWMT16T304-ZF	●	●c	●						0.016	0.276	0.156	0.113
		-	YWMT16T308-ZF	●	●c	●						0.031	0.276	0.156	0.113
	ZM	-	YWMT11T204-ZM	●	●c	●						0.016	0.184	0.109	0.091
		-	YWMT16T304-ZM	●	●c	●						0.016	0.276	0.156	0.113
		-	YWMT16T308-ZM	●	●c	●						0.031	0.276	0.156	0.113
		-													

● : New

STANDARD CUTTING CONDITIONS

For negative insert

ISO	Operation	Chipbreaker	Grades	Depth of cut ap (in)	Feed f (ipr)	Cutting speed: Vc (sfm)		
						Low carbon steels, alloy steels	Medium carbon steels, alloy steels	High carbon steels, alloy steels
P	Finishing	ZF	GT9530	0.008 - 0.059	0.001 - 0.008	490 - 980	490 - 980	490 - 980
			NS9530	0.008 - 0.059	0.001 - 0.008	490 - 980	490 - 980	490 - 984
			T9225	0.008 - 0.059	0.001 - 0.008	390 - 980	390 - 980	330 - 820
			T9235	0.008 - 0.059	0.001 - 0.008	164 - 660	164 - 660	164 - 490
	Finishing to medium	ZM	GT9530	0.028 - 0.079	0.006 - 0.016	490 - 980	490 - 980	490 - 980
			NS9530	0.028 - 0.079	0.006 - 0.016	490 - 980	490 - 980	490 - 980
			T9225	0.028 - 0.079	0.006 - 0.016	390 - 980	390 - 980	330 - 820
			T9235	0.028 - 0.079	0.006 - 0.016	164 - 660	164 - 660	164 - 490
M	Finishing	ZF	AH8015	0.008 - 0.059	0.001 - 0.008	164 - 490	164 - 490	164 - 490
	Finishing to medium	ZM	AH8015	0.028 - 0.079	0.006 - 0.016	164 - 490	164 - 490	164 - 490
K	Finishing	ZF	T9225	0.008 - 0.059	0.001 - 0.008	460 - 1640	460 - 1640	460 - 1640
	Finishing to medium	ZM	T9225	0.028 - 0.079	0.006 - 0.016	460 - 1640	460 - 1640	460 - 1640
S	Finishing	ZF	AH8015	0.008 - 0.059	0.001 - 0.008	66 - 260	66 - 260	66 - 260
	Finishing to medium	ZM	AH8015	0.028 - 0.079	0.006 - 0.016	66 - 260	66 - 260	66 - 260

For positive insert

ISO	Operation	Chipbreaker	Grades	Depth of cut ap (in)	Feed f (ipr)	Cutting speed: Vc (sfm)		
						Low carbon steels, alloy steels	Medium carbon steels, alloy steels	High carbon steels, alloy steels
P	Finishing to medium	ZF	GT9530	0.008 - 0.059	0.002 - 0.010	490 - 980	490 - 980	490 - 980
			T9225	0.008 - 0.059	0.002 - 0.010	330 - 980	260 - 980	260 - 820
		ZM	GT9530	0.020 - 0.079	0.002 - 0.012	490 - 980	490 - 980	490 - 980
			T9225	0.020 - 0.079	0.002 - 0.012	330 - 980	260 - 980	260 - 820
M	Finishing to medium	ZF	AH8015	0.008 - 0.059	0.002 - 0.010	164 - 490	164 - 490	164 - 490
		ZM	AH8015	0.020 - 0.079	0.002 - 0.012	164 - 490	164 - 490	164 - 490
K	Finishing to medium	ZF	T9225	0.008 - 0.059	0.002 - 0.010	460 - 1640	460 - 1640	460 - 1640
		ZM	T9225	0.020 - 0.079	0.002 - 0.012	460 - 1640	460 - 1640	460 - 1640
S	Finishing to medium	ZF	AH8015	0.008 - 0.059	0.002 - 0.010	66 - 260	66 - 260	66 - 260
		ZM	AH8015	0.020 - 0.079	0.002 - 0.012	66 - 260	66 - 260	66 - 260

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