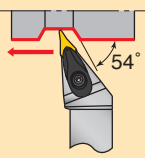
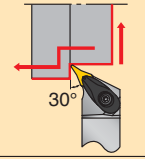
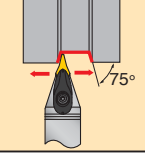
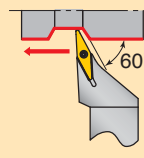
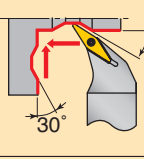
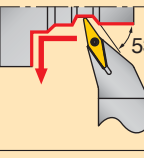
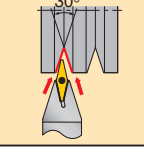


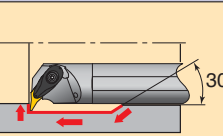
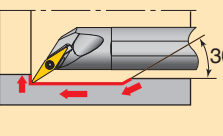
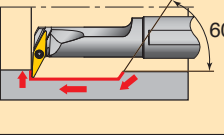
Y Pro Series Product Range

External turning

Toolholder type	
Negative rake	 <p>AVJN R/L Profiling Insert: YNMG1604□□ →P. 8</p>
	 <p>AVQN R/L Profiling Insert: YNMG1604□□ →P. 8</p>
	 <p>AVVN N Profiling Insert: YNMG1604□□ →P. 9</p>

Toolholder type	
Positive rake	 <p>SYJB R/L Spherical surface and taper cutting Insert: YWMT16T3□□ →P. 10</p>
	 <p>SYQB R/L Undercutting Insert: YWMT16T3□□ →P. 10</p>
	 <p>SYHB R/L Retracting Insert: YWMT16T3□□ →P. 11</p>
	 <p>SYIB N "V" grooving Insert: YWMT16T3□□ →P. 11</p>

Internal turning

	Toolholder type	Shank	Shank dia. øDs	Min. bore diameter (mm)					
				0	10	20	30	40	50
Negative rake	 <p>AVUN R/L Profiling Insert: YNMG1604□□ →P. 9</p>	Steel	ø32, ø40					ø40	ø50
	 <p>SYQB R/L Undercutting Insert: YWMT11T2□□ →P. 11</p>	Steel	ø12, ø16			ø17	ø21.5		
	 <p>SYUB R/L Spherical surface and taper cutting Insert: YWMT11T2□□ →P. 12</p>	Steel	ø16			ø20	ø20		
Positive rake		Carbide	ø12, ø16			ø17	ø21.5		
		Carbide	ø12, ø16			ø20	ø24.5		

Standard cutting conditions

Cutting speed by grade and work material

Grades	Cutting speed: Vc (m/min)		
	Low carbon steels and alloy steels (< 180HB)	Medium carbon steels and alloy steels (< 240HB)	High carbon steels and alloy steels (< 300HB)
T9125 Coated carbide	220 (150 ~ 300)	180 (120 ~ 250)	150 (100 ~ 180)
GT730 Coated cermet	250 (150 ~ 300)	200 (80 ~ 250)	150 (80 ~ 200)