



# **PARTING & GROOVING**

**Parting & Grooving Inserts Overview**

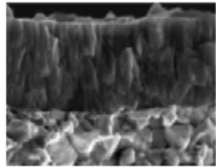
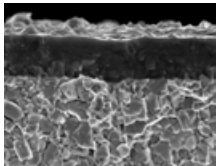
**Parting & Grooving Inserts**

**Parting & Grooving Holders**

## Parting & Grooving Overview

### Parting & Groove Turn Grades








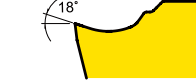

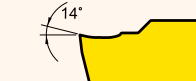

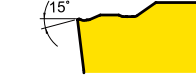
Parting and Grooving Grades		P Steel				M Stainless steel				K Cast iron			N Non Ferrous		S Super Alloy	
		P10	P20	P30	P40	M10	M20	M30	M40	K10	K20	K30	N10	N20	S10	S20
PVD	YG602G (YG602)		602G				602G				602G					602G
	YG603						603									

<p><b>YG602G</b> (YG602)</p> <p>P20 - P35    M20 - M40 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 PVD Coating with optimal thermal resistance &amp; strength</li> <li>Sub-Micron substrate designed for demanding application</li> <li>YG602G : First Choice for Low Cutting Speed, Soft and Sticky Material with Low Hardness (Gold Color)</li> <li>YG602 : First Choice for General Application (Violet Color)</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, 5
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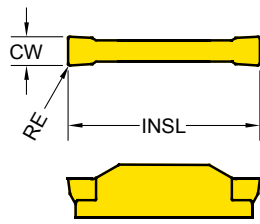
### Parting & Grooving Chipbreakers

Parting & Grooving	-P			<ul style="list-style-type: none"> <li>For Parting &amp; Deep Grooving</li> <li>For Low Feed Rate and Difficult to Cut Materials</li> </ul>
	-N			<ul style="list-style-type: none"> <li>For External Parting And Grooving</li> <li>For General Use</li> </ul>
Turning & Grooving	-Y			<ul style="list-style-type: none"> <li>For External Turning &amp; Grooving</li> <li>For Medium feed rate</li> </ul>
	<b>NEW</b> GL			<ul style="list-style-type: none"> <li>For External, Internal turning and Grooving</li> <li>Face grooving and Face turning</li> <li>For low feed rate</li> </ul>
	<b>NEW</b> GM			<ul style="list-style-type: none"> <li>For External, Internal turning and Grooving</li> <li>First choice Face Grooving and Face turning</li> <li>For Medium feed rate</li> </ul>
	<b>NEW</b> RG			<ul style="list-style-type: none"> <li>For External, Internal turning and Grooving</li> <li>Full radius Insert for Profiling</li> </ul>

Parting & Grooving

# Parting & Grooving Inserts









Recommended Cutting Conditions : p.222



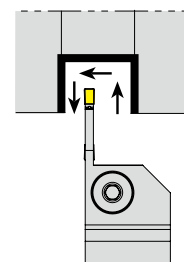
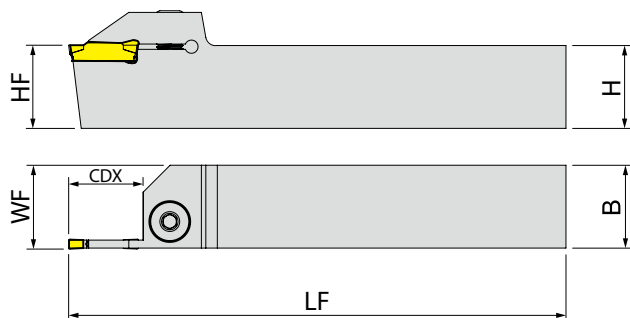
Series	INSL	CW
TD* 2	20	2
TD* 3	20	3
TD* 4	20	4
TD* 5	25	5

\* CDX : Cutting Depth Maximum

● : Stock item ○ : Order made item

TD.	Designation	RE	Parting & Grooving		Turning		EDP 5200..		
			Fn (mm/rev.)	CDX (mm)	Fn (mm/rev.)	Ap (mm)	YG602	YG602G	YG603
<b>-P</b>  Parting & Grooving (Sharp edge)   * 6° Angled Parting	TDP 2002	0.2	0.04 ~ 0.12	19	-	-	● 0012	○ 0036	● 0078
	TDP 3002	0.2	0.05 ~ 0.16	19	-	-	● 0029	○ 0030	● 0076
	TDP 4003	0.3	0.06 ~ 0.18	19	-	-	● 0023	○ 0038	● 0080
	* TDPR 2002 - 6	0.2	0.03 ~ 0.08	19	-	-	● 0045		● 0085
	* TDPR 3002 - 6	0.2	0.04 ~ 0.12	19	-	-	● 0048		● 0089
	* TDPL 2002 - 6	0.2	0.03 ~ 0.08	19	-	-	● 0046		● 0086
	* TDPL 3002 - 6	0.2	0.04 ~ 0.12	19	-	-	● 0049		● 0090
<b>-N</b>  Parting & Grooving (General)   * 6° Angled Parting	TDN 2002	0.2	0.05 ~ 0.18	19	-	-	● 0010	○ 0035	● 0077
	TDN 3002	0.2	0.07 ~ 0.23	19	-	-	● 0024	○ 0025	● 0075
	TDN 4003	0.3	0.08 ~ 0.28	19	-	-	● 0022	○ 0037	● 0079
	TDN 5003	0.3	0.09 ~ 0.35	24	-	-	● 0042		
	* TDNR 2002 - 6	0.2	0.04 ~ 0.14	19	-	-	● 0043		● 0083
	* TDNR 3002 - 6	0.2	0.06 ~ 0.18	19	-	-	● 0040		● 0087
	* TDNL 2002 - 6	0.2	0.04 ~ 0.14	19	-	-	● 0044		● 0084
* TDNL 3002 - 6	0.2	0.06 ~ 0.18	19	-	-	● 0047		● 0088	
* TDNL 4003 - 4	0.3	0.06 ~ 0.24	19			● 0096			
<b>-Y</b>  Turn Groove	TDY3E - 0.4	0.4	0.06 ~ 0.24	10	0.12 ~ 0.22	0.5 ~ 2.4		● 0027	
	TDY4E - 0.4	0.4	0.08 ~ 0.27	10	0.15 ~ 0.30	0.5 ~ 2.8		● 0020	
	TDY5E - 0.4	0.4	0.08 ~ 0.23	10	0.15 ~ 0.30	0.5 ~ 3.2		● 0082	
<b>-Y</b>  NEW GL  NEW GM  NEW RG	TDY2E - 0.3 - GL	0.3	0.04 ~ 0.20	10	0.06 ~ 0.18	0.4 ~ 1.5		● 0123	● 0124
	TDY3E - 0.3 - GL	0.3	0.05 ~ 0.23	10	0.08 ~ 0.20	0.4 ~ 2.0		● 0125	● 0126
	TDY4E - 0.4 - GL	0.4	0.06 ~ 0.26	10	0.10 ~ 0.25	0.5 ~ 2.3		● 0112	● 0127
	TDY3E - 0.4 - GM	0.4	0.06 ~ 0.24	10	0.12 ~ 0.22	0.5 ~ 2.4		● 0118	● 0119
TDY4E - 0.4 - GM	0.4	0.08 ~ 0.27	10	0.15 ~ 0.30	0.5 ~ 2.8		● 0113	● 0120	
TDY4E - 0.8 - GM	0.8	0.10 ~ 0.27	10	0.18 ~ 0.32	0.8 ~ 2.8		● 0114	● 0122	
TDY2E - 1.0 - RG	1.0	0.05 ~ 0.15	10	0.10 ~ 0.30	0.1 ~ 0.8		● 0111	● 0115	
TDY3E - 1.5 - RG	1.5	0.08 ~ 0.18	10	0.15 ~ 0.35	0.1 ~ 1.2		● 0108	● 0116	
TDY4E - 2.0 - RG	2.0	0.10 ~ 0.20	10	0.18 ~ 0.45	0.1 ~ 1.6		● 0109	● 0117	

**External holders**



: p. 119 Unit :mm

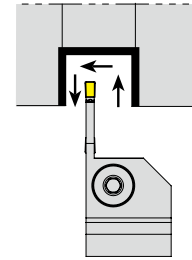
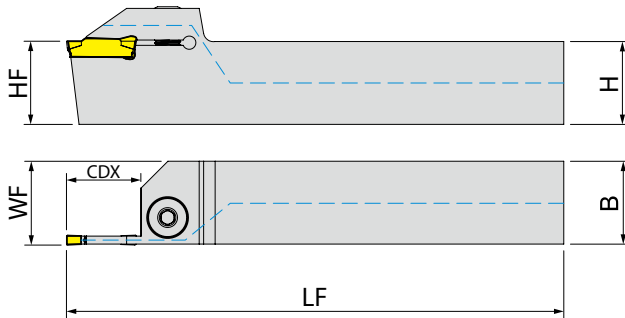
Designation	EDP 5700..		CW	CDX	H (= HF)	B	LF	WF	Insert
	R	L							
YTER/L 1212 - 2T15	0025	0024	2	15	12	12	100	12.3	TD.2..
YTER/L 1616 - 2T15	0027	0026	2	15	16	16	125	16.3	
YTER/L 2020 - 2T15	0030	0029	2	15	20	20	125	20.3	
YTER/L 2020 - 2T20	0032	0031	2	20	20	20	125	20.3	
YTER/L 2020 - 2T9	0028	-	2	9	20	20	125	20.3	
YTER/L 2525 - 2T17	0034	0033	2	17	25	25	150	25.3	
YTER/L 1212 - 3T15	0036	0035	3	15	12	12	100	12.4	TD.3..
YTER/L 1616 - 3T15	0038	0037	3	15	16	16	125	16.4	
YTER/L 2020 - 3T20	0040	0039	3	20	20	20	125	20.4	
YTER/L 2525 - 3T20	0044	0043	3	20	25	25	150	25.4	
YTER/L 2525 - 3T9	0042	0041	3	9	25	25	150	25.4	
YTER/L 3232 - 3T20	0045	-	3	20	32	32	170	32.4	TD.4..
YTER/L 2525 - 4T20	0047	0046	4	20	25	25	150	25.5	

▶ NEXT PAGE

Series	Designation	Information	Screw	Ring	Wrench
YTER/L	..2..	Description	YAKV-02-M6x22	YABPL-01	YAAL-03-3
		EDP	18000195	18000058	18000061
	..3../..4../..5..	Description	Y2004-M8x1x20	-	YAAL-05-4
		EDP	18000196	-	18000062

Parting & Grooving - Holder - External

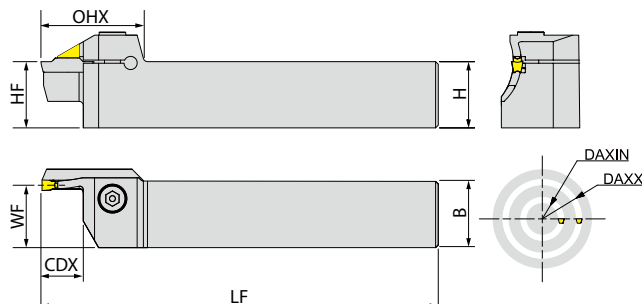
# External holders




: p. 119 Unit : mm

Designation	●	EDP 5700.. R L	CW	CDX	H (= HF)	B	LF	WF	Insert
YTER/L 1212-2T15-C	●	0194 0171	2	15	12	12	100	12.3	TD.2..
YTER/L 1616-2T15-C	●	0197 0174	2	15	16	16	125	16.3	
YTER/L 2020-2T15-C	●	0201 0178	2	15	20	20	125	20.3	
YTER/L 2020-2T17-C	●	0202	2	17	20	20	125	20.3	
YTER/L 2020-2T20-C	●	0203 0179	2	20	20	20	125	20.3	
YTER/L 2020-2T09-C	●	0204 0180	2	09	20	20	125	20.3	
YTER/L 2525-2T17-C	●	0208 0184	2	17	25	25	150	25.3	
YTER/L 1212-3T15-C	●	0196 0173	3	15	12	12	100	12.4	TD.3..
YTER/L 1616-3T15-C	●	0199 0176	3	15	16	16	125	16.4	
YTER/L 2020-3T20-C	●	0205 0181	3	20	20	20	125	20.4	
YTER/L 2020-3T25-C	●	0206 0182	3	25	20	20	125	20.4	
YTER/L 2020-3T30-C	●	0207 0183	3	30	20	20	125	20.4	
YTER/L 2525-3T22-C	●	0209 0185	3	22	25	25	150	25.4	
YTER/L 2525-3T25-C	●	0210 0186	3	25	25	25	150	25.4	
YTER/L 2525-3T30-C	●	0211 0187	3	30	25	25	150	25.4	TD.4..
YTER/L 2525-3T09-C	●	0212 0188	3	09	25	25	150	25.4	
YTER/L 3232-3T25-C	●	0217 0192	3	25	32	32	170	32.4	
YTER/L 2525-4T22-C	●	0213 0189	4	22	25	25	150	25.5	TD.5..
YTER/L 2525-4T25-C	●	0214	4	25	25	25	150	25.5	
YTER/L 2525-4T30-C	●	0215 0190	4	30	25	25	150	25.5	
YTER/L 2525-5T25-C	●	0216 0191	5	25	25	25	150	25.5	

Series	Designation	Infomation	Screw	Ring	Wrench
YTER/L	..2..	Description	YAKV-02-M6X22	YABPL-01	YAAL-03-3
		EDP	18000195	18000058	18000061
	..3../..4../..5..	Description	Y2004-M8X1X20	-	YAAL-05-4
		EDP	18000196	-	18000062



 : p. 119 Unit :mm

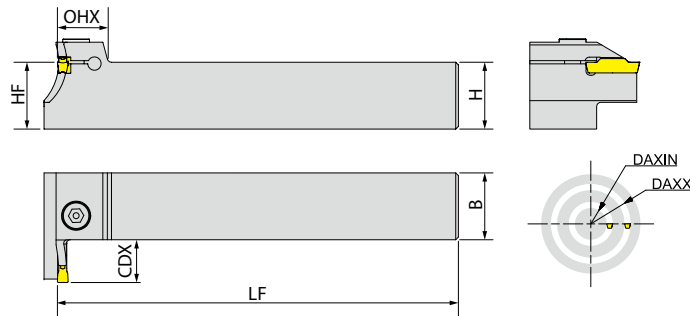
Designation	EDP 5700.. R L	CW	DAXIN	DAXX	CDX	H (= HF)	B	LF	WF	Insert
YTFR 25M-D034050-3T10A	0599 -	3	34	50	10	25	25	150	24	TD3..
YTFR 25M-D044060-3T15A	0600 -	3	44	60	15	25	25	150	24	
YTFR 25M-D054085-3T15A	0601 -	3	54	85	15	25	25	150	24	
YTFR 25M-D034050-4T15A	0602 -	4	34	50	15	25	25	150	23.6	TD4..
YTFR 25M-D042060-4T15A	0603 -	4	42	60	15	25	25	150	23.6	
YTFR 25M-D052072-4T20A	0604 -	4	52	72	20	25	25	150	23.6	
YTFR 25M-D064120-4T20A	0605 -	4	64	120	20	25	25	150	23.6	
YTFR 25M-D112200-4T20A	0606 -	4	112	200	20	25	25	150	23.6	
YTFR 25M-D200-4T20A	0607 -	4	200	-	20	25	25	150	23.6	

Series	Designation	Information	Screw	Ring	Wrench
YTFR	..S	Description	SHB-M6x1.0x25L	-	HL-05
		EDP	58000039	-	58000041

Parting & Grooving - Holder - External

**External holders - Perpendicular Face grooving**

NEW

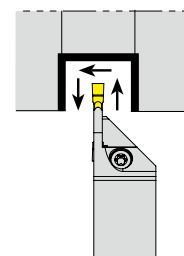
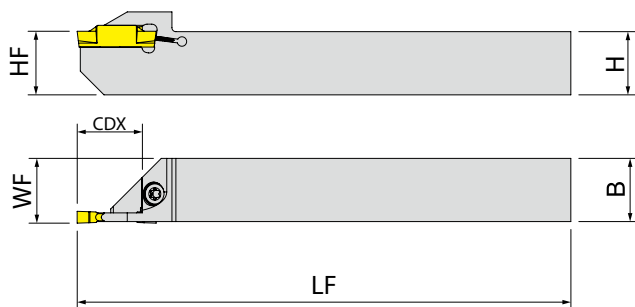


: p. 119 Unit : mm

Designation	EDP 5700.. R L	CW	DAXIN	DAXX	CDX	H (= HF)	B	LF	Insert
YTFPR25M - D034050 - 3T12A	0608 -	3	34	50	12	25	25	150	TD.3..
YTFPR25M - D044060 - 3T15A	0609 -	3	44	60	15	25	25	150	
YTFPR25M - D054085 - 3T15A	0610 -	3	54	85	15	25	25	150	
YTFPR25M - D034050 - 4T15A	0611 -	4	34	50	15	25	25	150	TD.4..
YTFPR25M - D042060 - 4T15A	0612 -	4	42	60	15	25	25	150	
YTFPR25M - D052072 - 4T20A	0613 -	4	52	72	20	25	25	150	
YTFPR25M - D064120 - 4T20A	0614 -	4	64	120	20	25	25	150	
YTFPR25M - D112200 - 4T20A	0615 -	4	112	200	20	25	25	150	

Series	Designation	Information	Screw	Ring	Wrench
YTFPR	16-2T..	Description	SHB-M6x1.0x25L	-	HL-05
		EDP	58000039	-	58000041
	20~25-3T..	Description	SHB-M6x1.0x25L	-	HL-05
		EDP	58000039	-	58000041
	32-3T..	Description	SHB-M6x1.0x25L	-	HL-05
		EDP	58000039	-	58000041

Parting & Grooving - Holder - External  
**External holders (Swiss Lathe)**



: p. 119 Unit : mm

Designation	EDP 5700..		CW	CDX	H (= HF)	B	LF	WF	Insert
	R	L							
YTER/L 1212-2T12-S	0048	-	2	12	12	12	125	12.2	TD.2..
YTER/L 1616-2T16-S	0049	-	2	16	16	16	125	16.2	
YTER/L 1212-3T12-S	0051	0050	3	12	12	12	125	12.3	TD.3..
YTER/L 1616-3T16-S	0053	0052	3	16	16	16	125	16.3	
YTER/L 1212-2T12-S-C	● 0193	0170	2	12	12	12	125	12.2	TD.2..
YTER/L 1616-2T16-S-C	● 0198	0175	2	16	16	16	125	16.2	
YTER/L 1212-3T12-S-C	● 0195	0172	3	12	12	12	125	12.3	TD.3..
YTER/L 1616-3T16-S-C	● 0200	0177	3	16	16	16	125	16.3	

TURNING

PARTING & GROOVING

MILLING

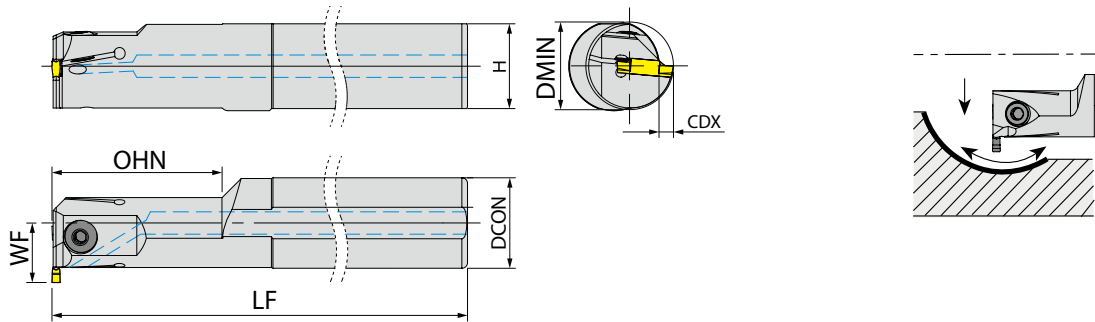
DRILLING

TECHNICAL INFORMATION

Series	Designation	Information	Screw	Ring	Wrench
YTER/L	..S	Description	Y4015-M4x11	-	Y80-T15
		EDP	18000119	-	18000167



## Parting &amp; Grooving - Holder - Internal

**Internal holders with Coolant supply**


: p. 119

Unit : mm

Designation		EDP 5700.. R	L	CW	DMIN	CDX	DCON	H (= HF)	OHN	LF	WF	Insert
YTIR/L 16 - 2T8.5 - C	●	0222	0218	2	25	8.5	16	14.8	28	150	16.5	TD.2..
YTIR/L 20 - 3T06 - C	●	0223	0219	3	25	6	20	18.3	40	170	16	
YTIR/L 25 - 3T06 - C	●	0224	0220	3	25	6	25	23	40	200	18.5	TD.3..
YTIR/L 32 - 3T05 - C	●	0225	0221	3	31	5	32	30	60	250	21	

TURNING

PARTING &amp; GROOVING

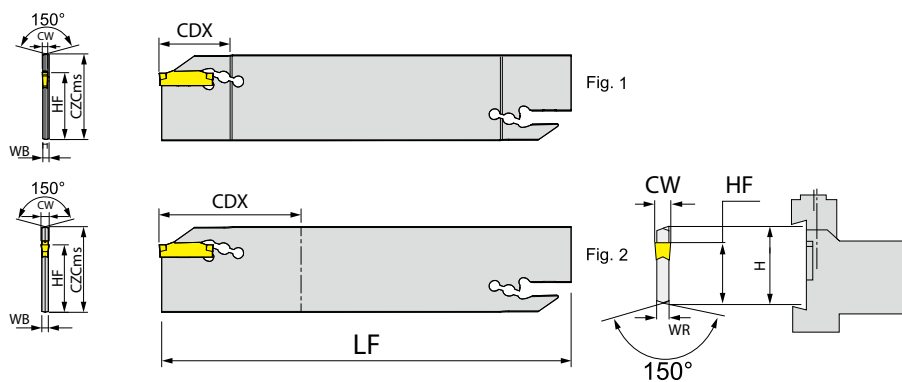
MILLING

DRILLING

TECHNICAL INFORMATION

Series	Designation	Information	Screw	Ring	Wrench
YTIR/L	16-2T..	Description	Y2503-M4X10	-	YAAL-03-3
		EDP	18000197	-	18000061
	20-3T..	Description	Y2504-M5X12	-	YAAL-05-4
		EDP	18000198	-	18000062
	25-3T..	Description	Y2504-M5X16	-	YAAL-05-4
		EDP	58000028	-	18000062
32-3T..	Description	Y2004-M8X1X20	-	YAAL-05-4	
	EDP	18000196	-	18000062	

Parting & Grooving - Holder  
**Blade**



: p. 119 Unit:mm

Designation	EDP 5700..	CZCms	CW	CDX	HF	LF	WB	Insert	Fig
YGB 32 - 2	0058	32	2	25	25	150	2.4	TD.2..	1
YGB 32 - 3	0059	32	3	50	25	150	2.4	TD.3..	2
YGB 32 - 2 - C	● 0226	32	2	25	25	150	2.4	TD.2..	1
YGB 32 - 3 - C	● 0227	32	3	50	25	150	2.4	TD.3..	2

TURNING

PARTING & GROOVING

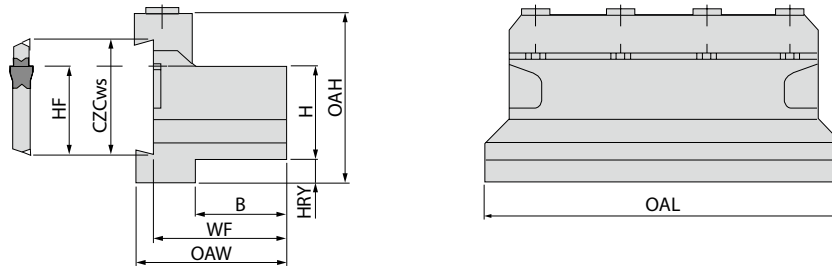
MILLING

DRILLING

TECHNICAL INFORMATION

Series	Designation	Information	Screw	Ring	Wrench
YGB..	..-32..	Description	-	-	YALA-02
		EDP	-	-	58000027

# Parting & Grooving - Holder Blade Block



: p.119 Unit:mm

Designation	EDP 5700..	CZCws	H	B	HF	WF	HRY	OAL	OAH	OAW
YGBU 20 - 32	0060	32	20	19	25	32.7	13	100	50	38
YGBU 25 - 32	0061	32	25	23	25	36.7	8	110	50	42
YGBU 32 - 32	0062	32	32	29	25	42.7	5	110	54	48
YGBU 20 - 32 - C	● 0228	32	20	19	25	32.7	13	100	50	38
YGBU 25 - 32 - C	● 0229	32	25	23	25	36.7	8	110	50	42
YGBU 32 - 32 - C	● 0230	32	32	29	25	42.7	5	110	54	48

Series	Designation	Infomation	Screw	Ring	Wrench
YGBU	20-32	Description	YABK-03	Y2505-M6X30	YAAL-07-5
		EDP	18000204	18000199	18000203
	25~32-32	Description	YABK-04	Y2505-M6X30	YAAL-07-5
		EDP	18000205	18000199	18000203