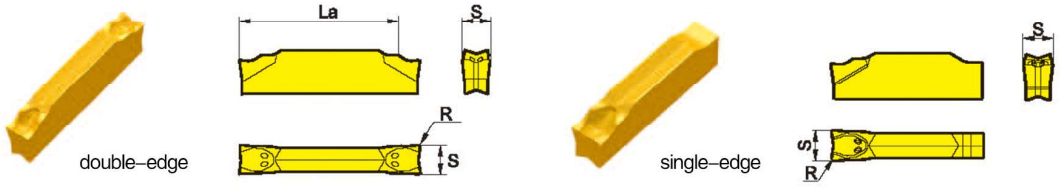
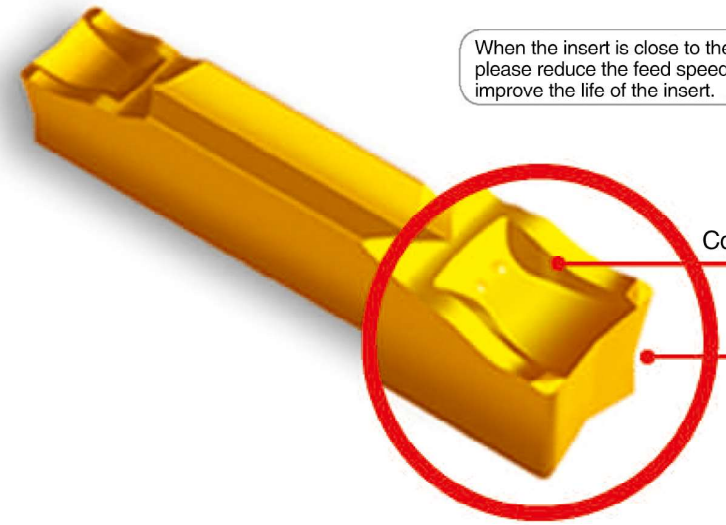
Cutting off inserts



Type		Dimension(mm)			Grade				
					Coated carbide CVD		Coated carbide PVD		Non–coated carbide
		$S^{+0.1}_{0}$	R±0.1	La_{max}	YBC151	YBC251	YBG205	YBG302	YD101
double–edge	ZPED02502-MG	2.5	0.2	17		○	★	★	
	ZPFD0302-MG	3.0	0.2	17		○	★	○	
	ZPGD0402-MG	4.0	0.2	22		○	★	○	
	ZPHD0503-MG	5.0	0.3	22		○	★	○	
	ZPKD0604-MG	6.0	0.4	22		○	★	○	
single–edge	ZPES02502-MG	2.5	0.2			○	★	★	
	ZPFS0302-MG	3.0	0.2			○	★	○	
	ZPGS0402-MG	4.0	0.2			○	★	○	
	ZPHS0503-MG	5.0	0.3			○	★	○	
	ZPKS0604-MG	6.0	0.4			○	★	○	

single–edge only for the parting blade holder

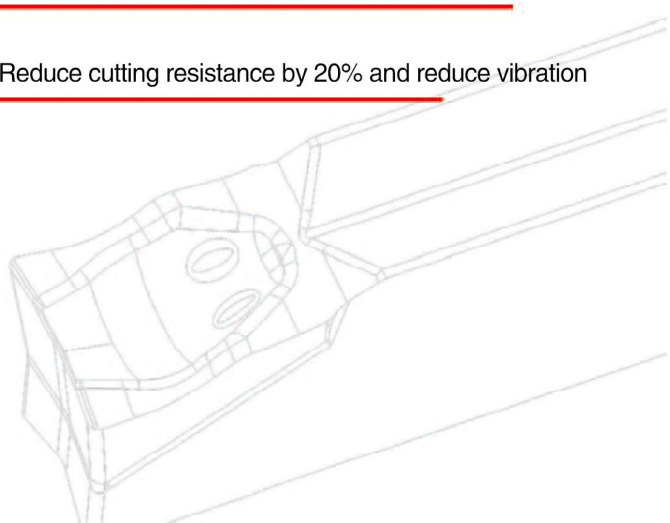
★ Recommended grade (always stock available) ☆ Available grade ○ Make–to–order



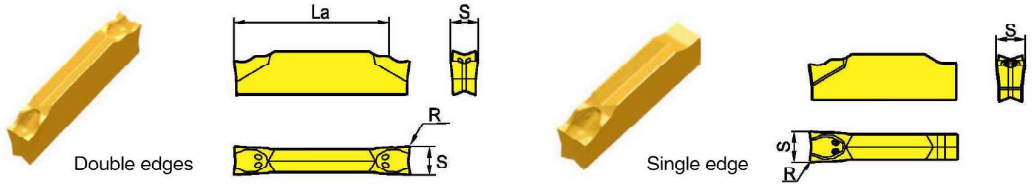
When the insert is close to the center of the workpiece, please reduce the feed speed by 30%, which will improve the life of the insert.

Control chip flow and crimp with good groove structure

Reduce cutting resistance by 20% and reduce vibration



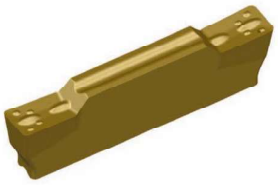
Grooving and turning inserts

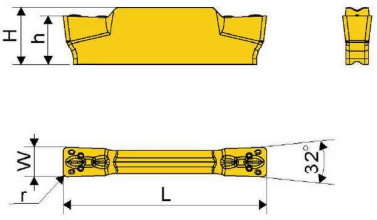


Type		Basic dimensions(mm)			Grade				
					CVD Coating		PVD Coating		Cemented Non Carbide
		$S^{+0.1}_{0}$	R±0.1	La_{max}	SD4025	SD4125	SD1015	SD1025	SK101
Double edges	ZPED02502-MG	2.5	0.2	17	●	★	●	★	○
	ZPFD0302-MG	3.0	0.2	17	●	★	●	★	○
	ZPGD0402-MG	4.0	0.2	22	●	★	●	★	○
	ZPHD0503-MG	5.0	0.3	22	●	★	●	★	○
	ZPKD0604-MG	6.0	0.4	22	●	★	●	★	○
Single edge	ZPES02502-MG	2.5	0.2		●	★	●	★	○
	ZPFS0302-MG	3.0	0.2		●	★	●	★	○
	ZPGS0402-MG	4.0	0.2		●	★	●	★	○
	ZPHS0503-MG	5.0	0.3		●	★	●	★	○
	ZPKS0604-MG	6.0	0.4		●	★	●	★	○

The single-edge insert is only mounted on parting blade.

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

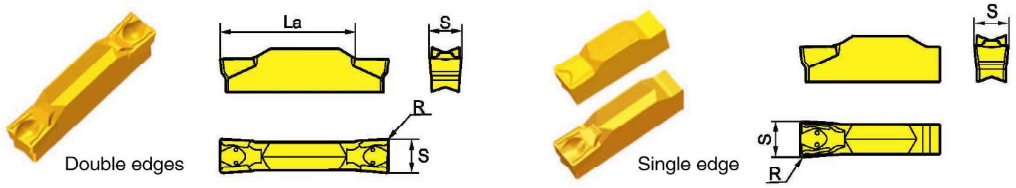




Type	Basic dimensions(mm)					Coated cemented carbide																Cemented carbide				
						P						M							K								
	L	W	r	h	H	SD4015	SD4115	SD4025	SD4125	SD4035	SD4135	SD1015	SD1025	SD1035	SD1045	SD4330	SD4340	SD4350	SD3105	SD3205	SD3115	SD3215	SD3125	SD3225	SP302	SP402	SK002	SK102	SK202
MGMN200-M	16.0	2.00	0.20	3.50	3.98			☆	★					★								★		☆		☆			
MGMN300-M	21.0	3.00	0.40	4.80	5.63			☆	★					★								★		☆		☆			
MGMN400-M	21.0	4.00	0.40	4.80	5.88			☆	★					★								★		☆					
MGMN500-M	26.00	5.00	0.80	5.85	7.05			☆	★					★								★		☆					
MGMN600-M	26.00	6.00	0.80	5.85																									

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

Grooving and turning inserts



Type		Basic dimensions(mm)			Grade				
					CVD Coating		PVD Coating		Cemented Non Carbide
		$S^{+0.1}_{0}$	R±0.10	La_{max}	SD4025	SD4225	SD1215	SD1125	SK101
Double edges	ZTED02503-MG	2.5	0.3	17	○	○	●	★	
	ZTFD0303-MG	3.0	0.3	17	○	○	●	★	
	ZTGD0404-MG	4.0	0.4	22	●	○	●	★	
	ZTHD0504-MG	5.0	0.4	22		○	●	★	
	ZTKD0608-MG	6.0	0.8	22		○	●	★	
Single edge	ZTHS0504-MG	5.0	0.4			○	○	○	
	ZTKS0608-MG	6.0	0.8			○	○	○	

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