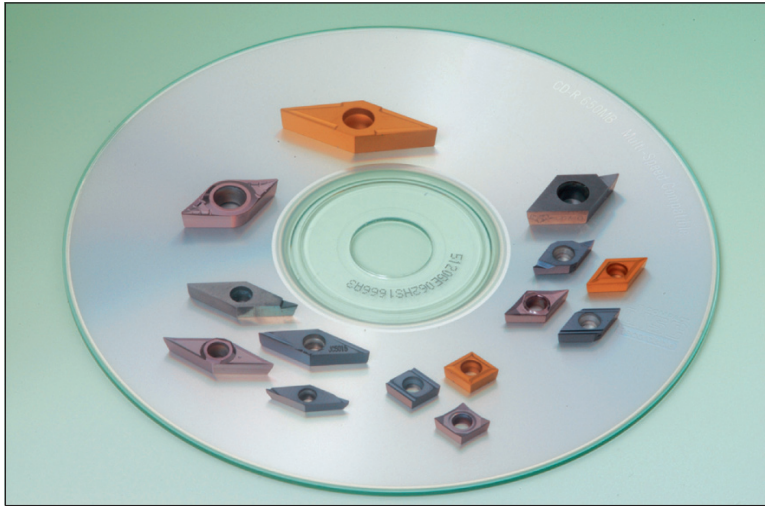
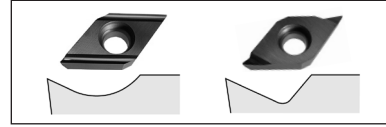


# Turning Inserts for Small Components

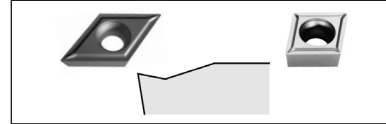


## Chipbreakers: MF, MF2, MM, MM1, MM2



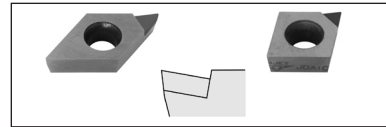
The combination of mirror surface finish and our JC5000 series carbide grades improve surface finish and tool life.

## FT



M-class inserts with optimum chipbreaker geometry are applicable to both semi and rough machining.

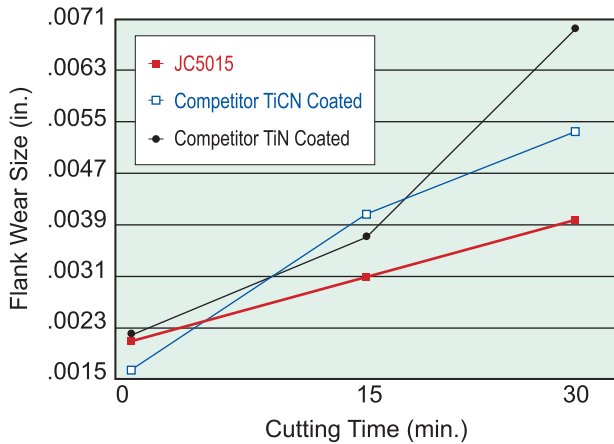
## Diamond



Micro grain sintered diamond provides sharp cutting edge and obtains a fine surface finish.

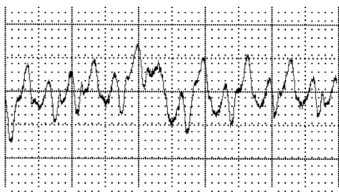
### Insert Flank Wear Comparison

- Work Material: SUS420J2
- Insert: DCET070202R JC5015
- Cutting Condition: SFM=984, IPR+.001, DOC=.002" with coolant.



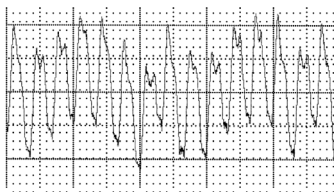
### Comparison of Work Surface Finish

DCET070202R-MF, JC5015



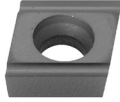
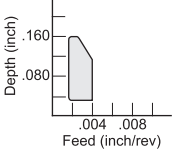

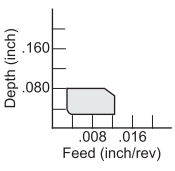
Ra : 0.25  $\mu\text{m}$   
Rmax : 1.85  $\mu\text{m}$

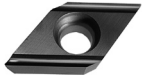
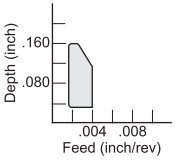
DIJET'S STANDARD CHIPBREAKER




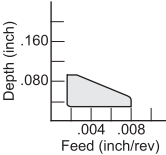

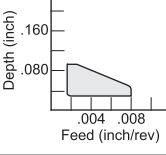

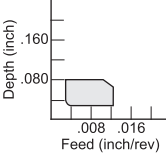
Ra : 0.49  $\mu\text{m}$   
Rmax : 2.58  $\mu\text{m}$


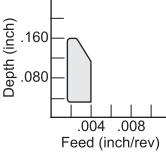
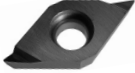
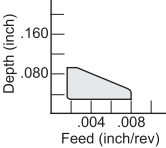
## Turning Inserts for Small Components

80° Diamond	PART ID	COATED							UNCOATED					DESCRIPTION							
		ISO CODE							CERMET												
	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter	
<b>CCET</b> <b>MF</b> for Fine Finishing  	CCET 060201L-MF																.250	.093	.004	.110	
	CCET 060201R-MF																	.250	.093	.004	.110
	CCET 060202L-MF																	.250	.093	.008	.110
	CCET 060202R-MF																	.250	.093	.008	.110
	CCET 09T301L-MF																	.375	.156	.004	.173
	CCET 09T301R-MF																	.375	.156	.004	.173
	CCET 09T302L-MF																	.375	.156	.008	.173
	CCET 09T302R-MF																	.375	.156	.008	.173
<b>CCMT</b> <b>FT</b> for Light to Medium  	CCMT 060202-FT		•	•													.250	.093	.008	.114	
	CCMT 060204-FT			•	•													.250	.093	.016	.114
	CCMT 09T302-FT			•	•													.375	.156	.008	.173
	CCMT 09T304-FT			•	•													.375	.156	.016	.173

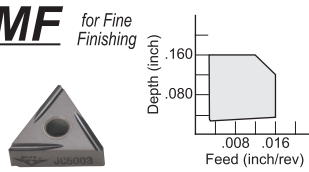
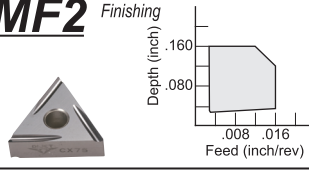
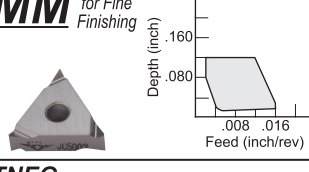
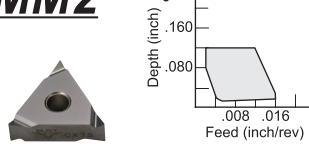
55° Diamond	PART ID	COATED							UNCOATED					DESCRIPTION							
		ISO CODE							CERMET												
	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS	I.C.	Thickness	Nose Radius	Hole Diameter	
<b>DCET</b> <b>MF</b> for Fine Finishing  	DCET 0702005R-MF																.250	.093	.002	.110	
	DCET 070201L-MF																	.250	.093	.004	.110
	DCET 070201R-MF																	.250	.093	.004	.110
	DCET 070202L-MF																	.250	.093	.008	.110
	DCET 070202R-MF																	.250	.093	.008	.110
	DCET 070204L-MF																	.250	.093	.016	.110
	DCET 070204R-MF																	.250	.093	.016	.110
	DCET 11T3005R-MF																	.375	.156	.002	.173
	DCET 11T301L-MF																	.375	.156	.004	.173
	DCET 11T301R-MF																	.375	.156	.004	.173
	DCET 11T302L-MF																	.375	.156	.008	.173
	DCET 11T302R-MF																	.375	.156	.008	.173
	DCET 11T304L-MF																	.375	.156	.016	.173
	DCET 11T304R-MF																	.375	.156	.016	.173

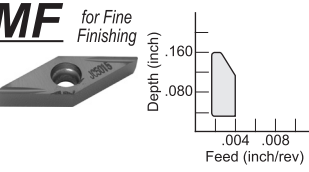
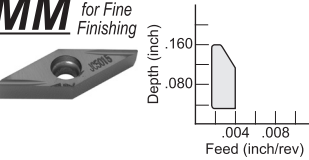
# Turning Inserts for Small Components

55° Diamond	PART ID	COATED											UNCOATED			DESCRIPTION					
		ISO CODE											CERMET			I.C.	Thickness	Nose Radius	Hole Diameter		
	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25					UMS	
<b>DCET</b> <b>MM</b> for Fine Finishing  	DCET 0702005R-MM						•	•										.250	.093	.002	.110
	DCET 070201L-MM						•	•										.250	.093	.004	.110
	DCET 070201R-MM						•	•										.250	.093	.004	.110
	DCET 070202L-MM						•	•										.250	.093	.008	.110
	DCET 070202R-MM						•	•										.250	.093	.008	.110
	DCET 070204L-MM						•	•										.250	.093	.016	.110
	DCET 070204R-MM						•	•										.250	.093	.016	.110
	DCET 11T3005R-MM						•	•										.375	.156	.002	.173
	DCET 11T301L-MM						•	•										.375	.156	.004	.173
	DCET 11T301R-MM						•	•										.375	.156	.004	.173
	DCET 11T302L-MM						•	•										.375	.156	.008	.173
	DCET 11T302R-MM						•	•										.375	.156	.008	.173
	DCET 11T304L-MM						•	•										.375	.156	.016	.173
	DCET 11T304R-MM						•	•										.375	.156	.016	.173
<b>DCET</b> <b>MM1</b> for Finishing  	DCET 070201L-MM1						•										.250	.093	.004	.110	
	DCET 070201R-MM1						•											.250	.093	.004	.110
	DCET 070202L-MM1						•											.250	.093	.008	.110
	DCET 070202R-MM1						•											.250	.093	.008	.110
	DCET 11T301L-MM1						•											.375	.156	.004	.173
	DCET 11T301R-MM1						•											.375	.156	.004	.173
<b>DCMT</b> <b>FT</b> for Finishing  	DCMT 070202-FT	•	•					•									.250	.093	.008	.110	
	DCMT 070204-FT	•	•					•										.250	.093	.016	.110
	DCMT 11T302-FT	•	•					•										.375	.156	.008	.173
	DCMT 11T304-FT	•	•					•										.375	.156	.016	.173


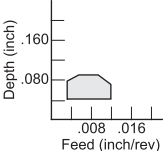
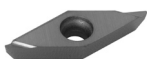
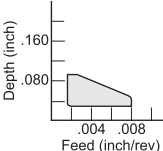
55° Diamond	PART ID	COATED											UNCOATED			DESCRIPTION					
		ISO CODE											CERMET			I.C.	Thickness	Nose Radius	Hole Diameter		
	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25					UMS	
<b>DPET</b> <b>MF</b> for Fine Finishing  	DPET 070201R-MF						•										.250	.093	.004	.110	
	DPET 11T301R-MF						•											.375	.156	.004	.173
	DPET 11T302R-MF						•											.375	.156	.008	.173
<b>DPET</b> <b>MM</b> for Fine Finishing  	DPET 0702005R-MM						•	•									.250	.093	.002	.110	
	DPET 070201R-MM						•	•										.250	.093	.004	.110
	DPET 070202R-MM						•	•										.250	.093	.008	.110

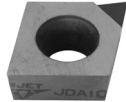
## Turning Inserts for Small Components

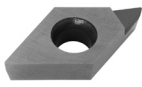
<b>Triangular</b>	PART ID	COATED								UNCOATED					DESCRIPTION			
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	CERMET					I.C.	Thickness	Nose Radius	Hole Diameter
		LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS									
<b>TNEG MF</b> for Fine Finishing 	TNEG 160401L-MF TNEG 160401R-MF TNEG 160402L-MF TNEG 160402R-MF TNEG 160404L-MF TNEG 160404R-MF						•								.375	.187	.004	.150
<b>TNEG MF2</b> for Semi-Finishing 	TNEG 160401L-MF2 TNEG 160401R-MF2 TNEG 160402L-MF2 TNEG 160402R-MF2 TNEG 160404L-MF2 TNEG 160404R-MF2														.375	.187	.004	.150
<b>TNEG MM</b> for Fine Finishing 	TNEG 160401L-MM TNEG 160401R-MM TNEG 160402L-MM TNEG 160402R-MM TNEG 160404L-MM TNEG 160404R-MM						•								.375	.187	.004	.150
<b>TNEG MM2</b> for Semi-Finishing 	TNEG 160401L-MM2 TNEG 160401R-MM2 TNEG 160402L-MM2 TNEG 160402R-MM2 TNEG 160404L-MM2 TNEG 160404R-MM2														.375	.187	.004	.150

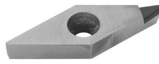
<b>35° Diamond</b>	PART ID	COATED								UNCOATED					DESCRIPTION			
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	CERMET					I.C.	Thickness	Nose Radius	Hole Diameter
		LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS									
<b>VBET MF</b> for Fine Finishing 	VBET 110301R-MF VBET 110302R-MF						•	•							.250	.125	.004	.110
<b>VBET MM</b> for Fine Finishing 	VBET 110301R-MM VBET 110302R-MM						•	•							.250	.125	.008	.110

# Turning Inserts for Small Components

35° Diamond	PART ID	COATED													UNCOATED			DESCRIPTION				
															CERMET			I.C.	Thickness	Nose Radius	Hole Diameter	
	ISO CODE	JC105V	JC110V	JC215V	JC325V	JC450V	JC5003	JC5015	JC8015	LN10	NIT	CX50	CX75	PX90	KT9	DX25	UMS					
 <p><b>VBMT FT</b> for Light to Medium</p> 	VBMT 160404-FT																		.375	.187	.016	.173
 <p><b>VPET MM</b> for Fine Finishing</p> 	VPET 080201L-MM VPET 080201R-MM VPET 080202L-MM VPET 080202R-MM																	.187	.093	.004	.090	

80° Diamond	PART ID	POLYCRYSTALLINE													DESCRIPTION						
															I.C.	Thickness	Nose Radius	Hole Diameter			
	ISO CODE	JDA10	JDA715																		
 <p><b>JDA-CCGT</b> for Fine Finishing</p>	JDA-CCGT060201 JDA-CCGT060202 JDA-CCGT09T301 JDA-CCGT09T302																	.250	.093	.004	.110

55° Diamond	PART ID	POLYCRYSTALLINE													DESCRIPTION					
															I.C.	Thickness	Nose Radius	Hole Diameter		
	ISO CODE	JDA10	JDA715																	
 <p><b>JDA-DCGT</b> for Fine Finishing</p>	JDA-DCGT070201 JDA-DCGT070202 JDA-DCGT11T301 JDA-DCGT11T302																.250	.093	.004	.110

35° Diamond	PART ID	POLYCRYSTALLINE													DESCRIPTION					
															I.C.	Thickness	Nose Radius	Hole Diameter		
	ISO CODE	JDA10	JDA715																	
 <p><b>JDA-VBGT</b> for Fine Finishing</p>	JDA-VBGT110301 JDA-VBGT110302																.250	.125	.004	.110