

CDV coated grade for stainless steel turning

US7020 · US735

Excellent toughness in relation to notch wear resistance.

Highly efficient machining of difficult-to-cut materials, such as stainless steel and superalloy.



■ Minimizing welding of a mild steel or low carbon steel workpiece.

CDV coated grade for stainless steel turning

US7020 • US735

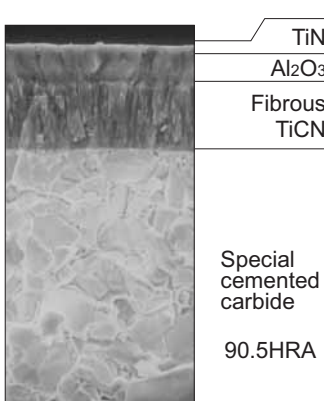
Features

Best for machining of stainless steel

In stainless steel cutting, damages left at the boundary of cut often become a problem. CVD coated carbide grade US7020 and US735 displays stable cutting performance, maintaining damages at the boundary of cut minimum.

Combination with MS/MA breaker achieving low cutting resistance

MS and MA breakers display excellent cutting performance with their low cutting resistance. The combination of MS/ MA breaker and highly wear resistant US7020 or very strong and highly fracture resistant US735 further improves the cutting performance.



Micro-structure of **US7020**

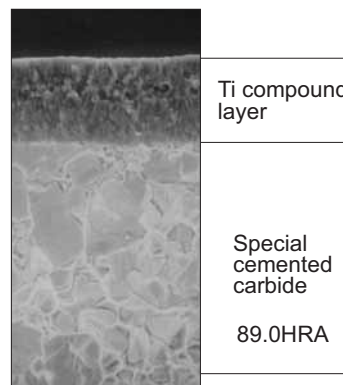
- **Thin layer coating of fibrous TiCN + fine grained Al₂O₃**
Employing thin layer coating with high adhesion strength to the substrate, US7020 is more spalling resistant than other grades designed for steel cutting.
- **Cemented carbide substrate with slanted**
Structure (hard substrate with very tough surface) US7020 displays excellent plastic deformation resistance in high speed machining of stainless steel.
- **Small honing design**
Due to the small honing design, US7020 achieves better cutting performance than other grades designed for steel cutting, displaying high welding resistance.

Best for machining of super alloys

CVD coated carbide grade US7020 and US735 are suitable not only for stainless steel but also for nickel (Ni) based super alloys, which are among the hardest of difficult-to-cut materials.

Solves problems in (low speed, interrupted) machining of steels

US7020 and US735 solves welding problems in low speed cutting of mild steel and abnormal wear problems such as fracturing of cutting edge in medium to low speed, interrupted machining.



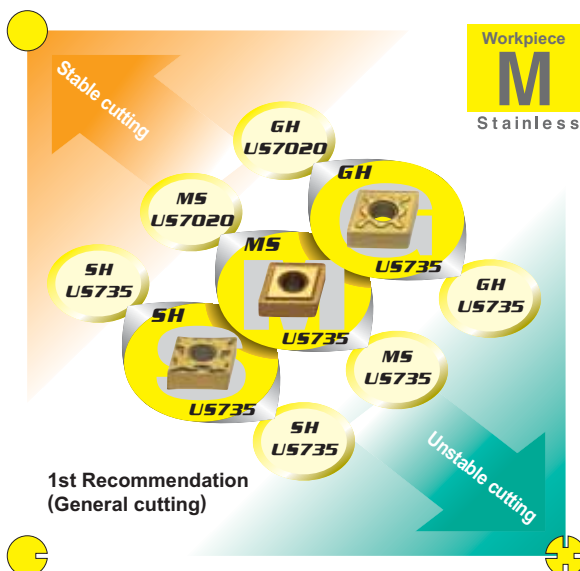
Micro-structure of **US735**

- **Thin layer coating of micrograined Ti compound (Thin multi-layer micrograin coating achieving highest adhesion strength to the substrate)**
Highly welding and wear resistant coating prevents spalling during cutting operations.
- **Extremely tough special cemented carbide substrate**
Specially designed carbide substrate with very high fracture resistance and thermal shock resistance hardly fracture.

Application range and recommended cutting conditions

TOOL NAVI SYSTEM

NEGATIVE INSERTS FOR STAINLESS STEEL



Cutting conditions

- Stable cutting**
Continuous cutting
Constant depth of cutting
Pre-machined
Securely clamped component cutting
- General cutting**
- Unstable cutting**
Heavy interrupted cutting
Irregular depth of cutting
Low clamping rigidity cutting

Cutting area

- S** Light cutting (ap=0.5–1.5mm)
- M** Medium cutting (ap=1.5–4.0mm)
- G** Semi-heavy cutting (ap=4.0–7.0mm)

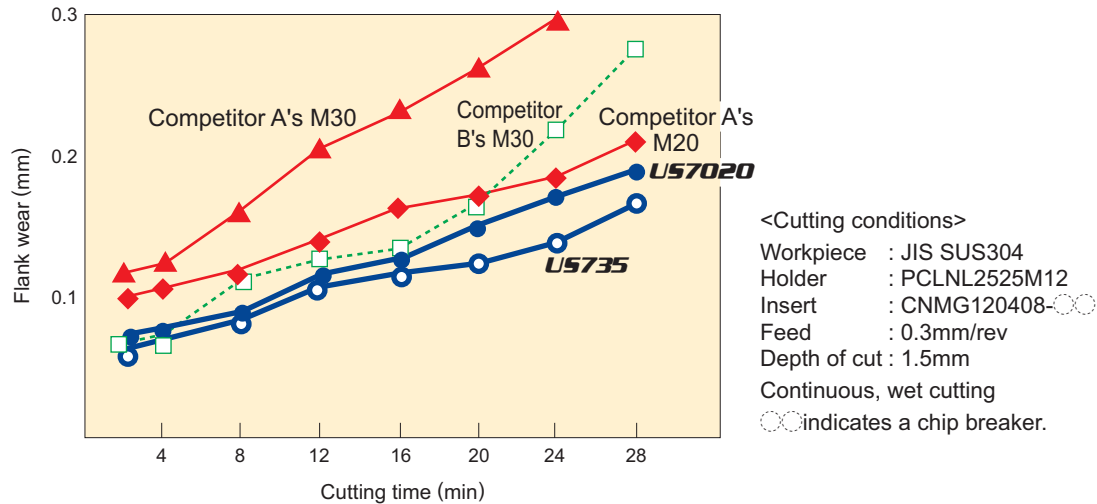
Cutting performance

● High efficiency machining of stainless steel

US7020 displays its best cutting performance in high speed cutting. For medium to low speed cutting, US735 is recommended.

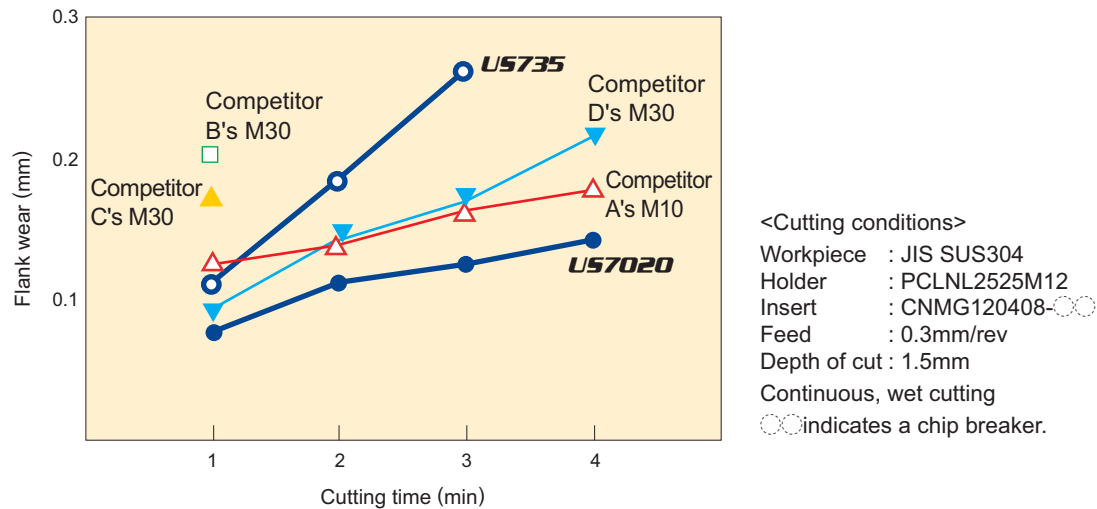
■ Regular speed cutting (Cutting speed : 120m/min)

US735 is recommended for regular speed cutting as it achieves strong cutting edge and thus is suitable for general purposes.



■ High speed cutting (Cutting speed : 300m/min)

US7020 is recommended for high speed, stable cutting as it is highly wear resistant and thus enables high efficiency machining.



Recommended cutting conditions

Recommended cutting conditions

Workpiece	Cutting speed (m/min)	
	US7020	US735
Stainless steel	170 (120-220)	100 (70-120)
Ni (nickel) based heat-resistant alloy	40 (30-50)	30 (20-40)
Mild steel (≤180HB)	200 (150-250)	150 (100-200)

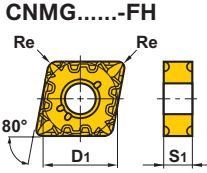
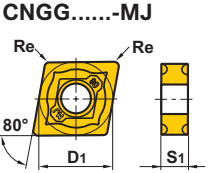
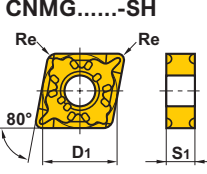
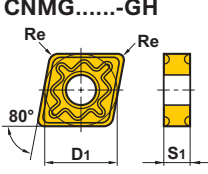
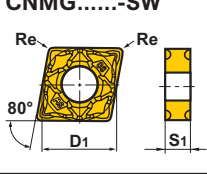
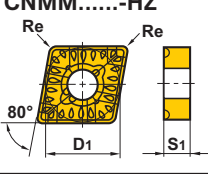
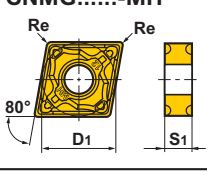
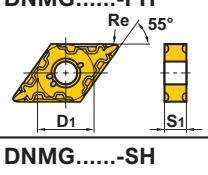
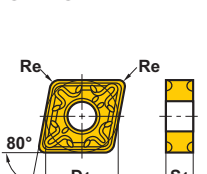
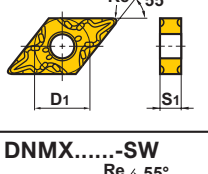

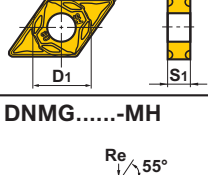
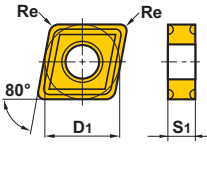
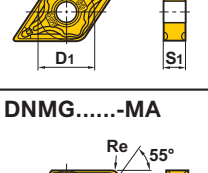
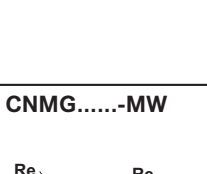
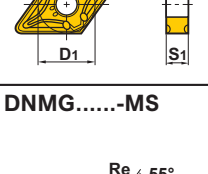
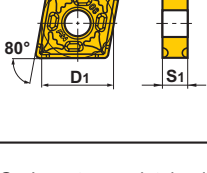
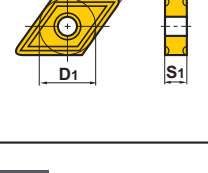
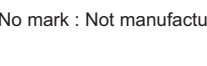
Application range

Workpiece material	Properties	Recommended grade
Austenitic materials (JIS SUS304, 316, etc.)	<ul style="list-style-type: none"> Strong work hardening tendency. Low heat conductivity leading to raised temperature. Unstable cutting resistance leading to vibration. Generated chips tend to spread and lengthen. 	US7020 for high speed, stable cutting US735 for medium to low speed, unstable cutting
Ferritic materials (JIS SUS405, 430, etc.)	<ul style="list-style-type: none"> Lower work hardening tendency and lower cutting resistance when compared with austenitic materials. Fairly good chip disposability. 	US7020
Martensitic materials (JIS SUS403, 410, etc.)	<ul style="list-style-type: none"> Although work hardening tendency is low, cutting resistance is high due to their high hardness. Fairly good chip disposability. 	US7020

US7020·US735

Standard inserts

● Negative inserts

Geometry	Order number	US7020	US735	Dimensions (mm)			Geometry	Order number	US7020	US735	Dimensions (mm)			
				D1	S1	Re					D1	S1	Re	
	CNMG120404-FH	●		12.7	4.76	0.4		CNGG120404-MJ			12.7	4.76	0.4	
	120408-FH			12.7	4.76	0.8		CNGG120408-MJ			12.7	4.76	0.8	
	CNMG090304-SH	□		9.525	3.18	0.4		CNMG120408-GH	●	●	12.7	4.76	0.8	
	090308-SH	□		9.525	3.18	0.8		120412-GH	●	●	12.7	4.76	1.2	
	09T304-SH	●		9.525	3.97	0.4		160612-GH	●	●	15.875	6.35	1.2	
	09T308-SH	●		9.525	3.97	0.8		190612-GH	●	●	19.05	6.35	1.2	
	120404-SH	●		12.7	4.76	0.4		190616-GH	●	●	19.05	6.35	1.6	
	120408-SH	●		12.7	4.76	0.8								
	CNMG120404-SW	●		12.7	4.76	0.4		CNMM120408-HZ	□	□	12.7	4.76	0.8	
	120408-SW	●		12.7	4.76	0.8		120412-HZ	□	□	12.7	4.76	1.2	
	CNMG120404-MH	●		12.7	4.76	0.4			DNMG150404-FH	●		12.7	4.76	0.4
	120408-MH	●		12.7	4.76	0.8			150408-FH	●		12.7	4.76	0.8
	120412-MH	●		12.7	4.76	1.2								
	120416-MH	●		12.7	4.76	1.6								
	160612-MH	●		15.875	6.35	1.2								
	190612-MH	●		19.05	6.35	1.2								
	CNMG120404-MA	●	●	12.7	4.76	0.4		DNMG110404-SH		●	9.525	4.76	0.4	
	120408-MA	●	●	12.7	4.76	0.8		110408-SH	●	●	9.525	4.76	0.8	
	120412-MA	●	●	12.7	4.76	1.2		150404-SH	●	●	12.7	4.76	0.4	
	120416-MA	□	●	12.7	4.76	1.6		150408-SH	●	●	12.7	4.76	0.8	
	160608-MA	□	●	15.875	6.35	0.8		150412-SH	●	●	12.7	4.76	1.2	
		160612-MA	□	●	15.875	6.35	1.2		DNMX150404-SW	●		12.7	4.76	0.4
		160616-MA	□	●	15.875	6.35	1.6		150408-SW	●		12.7	4.76	0.8
		190612-MA	□	●	19.05	6.35	1.2		150604-SW	●		12.7	6.35	0.4
		190616-MA	□	●	19.05	6.35	1.6		150608-SW	●		12.7	6.35	0.8
		CNMG090304-MS	□	●	9.525	3.18	0.4		DNMG150404-MH	●		12.7	4.76	0.4
		090308-MS	□	●	9.525	3.18	0.8		150408-MH	●		12.7	4.76	0.8
		09T304-MS	□	●	9.525	3.97	0.4		150412-MH	●		12.7	4.76	1.2
		09T308-MS	□	●	9.525	3.97	0.8		150604-MH	●		12.7	6.35	0.4
		120404-MS	●	●	12.7	4.76	0.4		150608-MH	●		12.7	6.35	0.8
	120408-MS	●	●	12.7	4.76	0.8	150612-MH		●		12.7	6.35	1.2	
		120412-MS	●	●	12.7	4.76	1.2		DNMG150404-MA	●	●	12.7	4.76	0.4
		120416-MS	□	□	12.7	4.76	1.6		150408-MA	●	●	12.7	4.76	0.8
		160604-MS	□	□	15.875	6.35	0.4		150412-MA	●	●	12.7	4.76	1.2
		160608-MS	□	□	15.875	6.35	0.8		150604-MA	●	●	12.7	6.35	0.4
160612-MS		□	□	15.875	6.35	1.2	150608-MA		●	●	12.7	6.35	0.8	
		190612-MS	□	●	19.05	6.35	1.2		150612-MA	●	●	12.7	6.35	1.2
		190616-MS	□	●	19.05	6.35	1.6		DNMG110408-MS	●	●	9.525	4.76	0.8
									150404-MS	●	●	12.7	4.76	0.4
									150408-MS	●	●	12.7	4.76	0.8
									150412-MS	●	●	12.7	4.76	1.2
								150604-MS	●	●	12.7	6.35	0.4	
								150608-MS	●	●	12.7	6.35	0.8	

● : Inventory maintained. □ : Non stock, produced to order only.

No mark : Not manufactured.

● Negative inserts

Geometry	Order number	LJ57020	LJ5735	Dimensions (mm)			Geometry	Order number	LJ57020	LJ5735	Dimensions (mm)		
				D1	S1	Re					D1	S1	Re
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	150412-MW	<input type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	1.2		120412-HZ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	1.2
	150608-MW	<input type="checkbox"/>	<input type="checkbox"/>	12.7	6.35	0.8		150612-HZ	<input type="checkbox"/>	<input type="checkbox"/>	15.875	6.35	1.2
	150612-MW	<input type="checkbox"/>	<input type="checkbox"/>	12.7	6.35	1.2		190612-HZ	<input type="checkbox"/>	<input type="checkbox"/>	19.05	6.35	1.2
							190616-HZ	<input type="checkbox"/>	<input type="checkbox"/>	19.05	6.35	1.6	
	DNGM150404-MJ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.4		TNMG160404-FH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.4
	150408-MJ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8		160408-FH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.8
	DNMG150408-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	0.8		TNMG160404-SH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.4
	150412-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	1.2		160408-SH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.8
	150608-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	6.35	0.8		220408-SH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8
	150612-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	6.35	1.2							
	DNMM150408-HZ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8		TNMX160404-SW	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.4
	150412-HZ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	1.2		160408-SW	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.8
	150416-HZ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	1.6							
	150608-HZ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	6.35	0.8							
	150612-HZ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	6.35	1.2							
150616-HZ	<input type="checkbox"/>	<input type="checkbox"/>	12.7	6.35	1.6								
	SNMG120408-MH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8		TNMG160404-MH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.4
	120412-MH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	1.2		160408-MH	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.8
						160412-MH		<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	1.2	
						220408-MH		<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8	
						220412-MH		<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	1.2	
	SNMG120404-MA	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.4		TNMG160404-MA	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	0.4
	120408-MA	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	0.8		160408-MA	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	0.8
	120412-MA	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	1.2		160412-MA	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	1.2
	150608-MA	<input checked="" type="checkbox"/>	<input type="checkbox"/>	15.875	6.35	0.8		220408-MA	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	0.8
	150612-MA	<input checked="" type="checkbox"/>	<input type="checkbox"/>	15.875	6.35	1.2		220412-MA	<input type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	1.2
	190616-MA	<input checked="" type="checkbox"/>	<input type="checkbox"/>	19.05	6.35	1.6		270608-MA	<input type="checkbox"/>	<input checked="" type="checkbox"/>	15.875	4.76	0.8
						270612-MA	<input type="checkbox"/>	<input checked="" type="checkbox"/>	15.875	4.76	1.2		
	SNMG090304-MS	<input type="checkbox"/>	<input type="checkbox"/>	9.525	3.18	0.4		TNMG160404-MS	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	0.4
	090308-MS	<input checked="" type="checkbox"/>	<input type="checkbox"/>	9.525	3.18	0.8		160408-MS	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	0.8
	120404-MS	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.4		160412-MS	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	1.2
	120408-MS	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8		220408-MS	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8
	120412-MS	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	1.2		220412-MS	<input type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	1.2
	120416-MS	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	1.6							
	150608-MS	<input type="checkbox"/>	<input type="checkbox"/>	15.875	6.35	0.8							
	150612-MS	<input type="checkbox"/>	<input type="checkbox"/>	15.875	6.35	1.2							
190616-MS	<input type="checkbox"/>	<input type="checkbox"/>	19.05	6.35	1.6								
	SNMG120408-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	0.8		TNMG160404R-ES	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	0.4
	120412-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	1.2		160404L-ES	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	0.4
	120416-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	1.6		160408R-ES	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	0.8
	150612-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	15.875	6.35	1.2		160408L-ES	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	9.525	4.76	0.8
	190612-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	19.05	6.35	1.2		220408R-ES	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8
190616-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	19.05	6.35	1.6	220408L-ES	<input checked="" type="checkbox"/>	<input type="checkbox"/>	12.7	4.76	0.8		
	SNMG120408-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	12.7	4.76	0.8		TNMX160408-MW	<input type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	0.8
	190612-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	19.05	6.35	1.2		160412-MW	<input type="checkbox"/>	<input type="checkbox"/>	9.525	4.76	1.2
190616-GH	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	19.05	6.35	1.6								

US7020·US735

Standard inserts

● Negative inserts

Geometry	Order number	US7020	US735	Dimensions (mm)		
				D1	S1	Re
	TNMG160408-GH	●	●	9.525	4.76	0.8
	160412-GH	●	●	9.525	4.76	1.2
	220408-GH	●	●	12.7	4.76	0.8
	220412-GH	●	●	12.7	4.76	1.2
	220416-GH	●	●	12.7	4.76	1.6
	270612-GH	●	●	19.05	6.35	1.2
	TNMM160408-HZ	□	□	9.525	4.76	0.8
	220408-HZ	□	□	12.7	4.76	0.8
	220412-HZ	□	□	12.7	4.76	1.2
	220416-HZ	□	□	12.7	4.76	1.6
	VNMG160404-MH	●	●	9.525	4.76	0.4
	160408-MH	●	●	9.525	4.76	0.8
	VNMG160404-MA	●	●	9.525	4.76	0.4
	160408-MA	●	●	9.525	4.76	0.8
	VNMG160404-MS	●	●	9.525	4.76	0.4
	160408-MS	●	●	9.525	4.76	0.8
	WNMG080404-FH	●	●	12.7	4.76	0.4
	080408-FH	●	●	12.7	4.76	0.8
	WNMG06T304-SH	●	●	9.525	3.97	0.4
	06T308-SH	●	●	9.525	3.97	0.8
	060404-SH	●	●	9.525	4.76	0.4
	060408-SH	●	●	9.525	4.76	0.8
	060412-SH	●	●	9.525	4.76	1.2
	080404-SH	●	●	12.7	4.76	0.4
	080408-SH	●	●	12.7	4.76	0.8
	080412-SH	●	●	12.7	4.76	1.2
	WNMG060404-SW	●	●	9.525	4.76	0.4
	060408-SW	●	●	9.525	4.76	0.8
	080404-SW	●	●	12.7	4.76	0.4
	080408-SW	●	●	12.7	4.76	0.8
	WNMG080404-MH	●	●	12.7	4.76	0.4
	080408-MH	●	●	12.7	4.76	0.8
	080412-MH	●	●	12.7	4.76	1.2
	WNMG06T304-MA	●	●	9.525	3.97	0.4
	06T308-MA	●	●	9.525	3.97	0.8
	06T312-MA	●	●	9.525	3.97	1.2
	060404-MA	●	●	9.525	4.76	0.4
	060408-MA	●	●	9.525	4.76	0.8
	060412-MA	●	●	9.525	4.76	1.2
	080404-MA	●	●	12.7	4.76	0.4
	080408-MA	●	●	12.7	4.76	0.8
	080412-MA	●	●	12.7	4.76	1.2
	100612-MA	□	□	15.875	6.35	1.2
100616-MA	□	□	15.875	6.35	1.6	
	WNMG06T304-MS	●	●	9.525	3.97	0.4
	06T308-MS	●	●	9.525	3.97	0.8
	060404-MS	●	●	9.525	4.76	0.4
	060408-MS	●	●	9.525	4.76	0.8
	080404-MS	●	●	12.7	4.76	0.4
	080408-MS	●	●	12.7	4.76	0.8
	WNMG060408-MW	□	□	9.525	4.76	0.8
	060412-MW	□	□	9.525	4.76	1.2
	080408-MW	●	●	12.7	4.76	0.8
	080412-MW	●	●	12.7	4.76	1.2
	WNMG080408-GH	●	●	12.7	4.76	0.8
	080412-GH	●	●	12.7	4.76	1.2
	RNGJ190600	●	●	19.05	6.35	-

● : Inventory maintained. □ : Non stock, produced to order only.

No mark : Not manufactured.

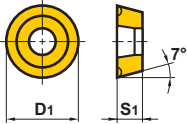
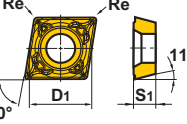
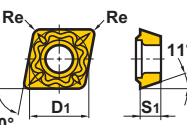
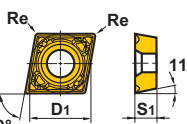
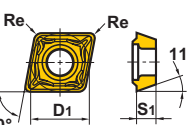
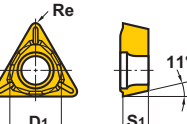
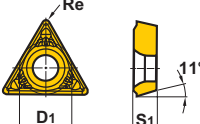
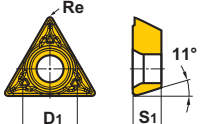
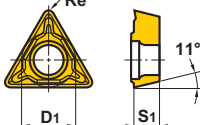
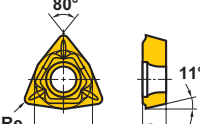
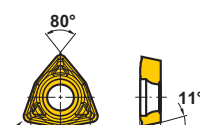
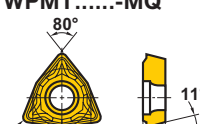
● Positive inserts

Geometry	Order number	LJ57020	LJ5735	Dimensions (mm)		
				D1	S1	Re
	VBMT110304-MV	●	●	6.35	3.18	0.4
	110308-MV	●	●	6.35	3.18	0.8
	160404-MV	●	●	9.525	4.76	0.4
	160408-MV	●	●	9.525	4.76	0.8
	WBMTL30202R-MV	●	●	4.76	2.38	0.2
	30202L-MV	●	●	4.76	2.38	0.2
	30204R-MV	●	●	4.76	2.38	0.4
	30204L-MV	●	●	4.76	2.38	0.4
	CCMT060202-SW	●		6.35	2.38	0.2
	060204-SW	●		6.35	2.38	0.4
	09T302-SW	●		9.525	3.97	0.2
	09T304-SW	●		9.525	3.97	0.4
	CCMH060202-SV	●	●	6.35	2.38	0.2
	060204-SV	●	●	6.35	2.38	0.4
	CCMT060204-MW	●		6.35	2.38	0.4
	060208-MW	●		6.35	2.38	0.8
	09T304-MW	●		9.525	3.97	0.4
	09T308-MW	●		9.525	3.97	0.8
	120404-MW	●		12.7	4.76	0.4
	120408-MW	●		12.7	4.76	0.8
	CCMH060202-MV	●	●	6.35	2.38	0.2
	060204-MV	●	●	6.35	2.38	0.4
	CCMT060202	●		6.35	2.38	0.2
	060204	●		6.35	2.38	0.4
	060208	●		6.35	2.38	0.8
	080304	●		7.94	3.18	0.4
	080308	●		7.94	3.18	0.8
	09T302	●		9.525	3.97	0.2
	09T304	●		9.525	3.97	0.4
	09T308	●		9.525	3.97	0.8
	120404	●		12.7	4.76	0.4
	120408	●		12.7	4.76	0.8
120412	●		12.7	4.76	1.2	
	DCMT070202-SV	●	●	6.35	2.38	0.2
	070204-SV	●	●	6.35	2.38	0.4
	070208-SV	●	●	6.35	2.38	0.8
	11T302-SV	●	●	9.525	3.97	0.2
	11T304-SV	●	●	9.525	3.97	0.4
11T308-SV	●	●	9.525	3.97	0.8	
	DCMT070202-MV	●	●	6.35	2.38	0.2
	070204-MV	●	●	6.35	2.38	0.4
	070208-MV	●	●	6.35	2.38	0.8
	11T302-MV	●	●	9.525	3.97	0.2
	11T304-MV	●	●	9.525	3.97	0.4
	11T308-MV	●	●	9.525	3.97	0.8
	DCMT070202		●	6.35	2.38	0.2
	070204		●	6.35	2.38	0.4
	070208		●	6.35	2.38	0.8
	11T302		●	9.525	3.97	0.2
	11T304		●	9.525	3.97	0.4
	11T308		●	9.525	3.97	0.8
	150404		●	12.7	4.76	0.4
	150408		●	12.7	4.76	0.8
	150412		●	12.7	4.76	1.2
	SCMT09T304		●	9.525	3.97	0.4
	09T308		●	9.525	3.97	0.8
	120404		●	12.7	4.76	0.4
	120408		●	12.7	4.76	0.8
	TCMT080204		□	4.76	2.38	0.4
	090204		□	5.56	2.38	0.4
	110202		●	6.35	2.38	0.2
	110204		●	6.35	2.38	0.4
	130302		□	7.94	3.18	0.2
	130304		●	7.94	3.18	0.4
	16T304		●	9.525	3.97	0.4
	16T308		●	9.525	3.97	0.8
	VCMT080202-MV	●	●	4.76	2.38	0.2
	080204-MV	●	●	4.76	2.38	0.4
	VCMT110304		●	6.35	3.18	0.4
	160404		●	9.525	4.76	0.4
	160408		●	9.525	4.76	0.8
	160412		●	9.525	4.76	1.2
	WCMT020102		●	3.97	1.59	0.2
	020104		●	3.97	1.59	0.4
	L30202		●	4.76	2.38	0.2
	L30204		●	4.76	2.38	0.4
	040202		●	6.35	2.38	0.2
	040204		●	6.35	2.38	0.4
	040208		●	6.35	2.38	0.8
	06T304		●	9.525	4.76	0.4
06T308		●	9.525	4.76	0.8	
	RCMT0803M0		●	8	3.18	—

US7020·US735

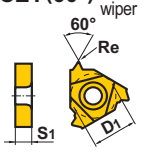
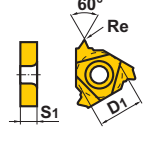
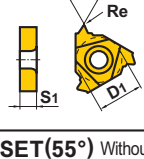
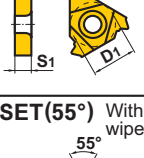
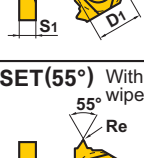

Standard inserts

● Positive inserts

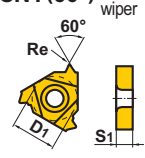
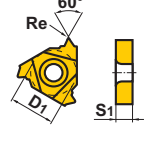
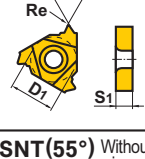
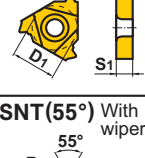
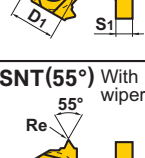

Geometry	Order number	US7020	US735	Dimensions (mm)		
				D1	S1	Re
	RCMX1003M0	●	●	10	3.18	—
	1204M0	●	●	12	4.76	—
	1606M0	●	●	16	6.35	—
	2006M0	●	●	20	6.35	—
RDGH.....-M4	RDGH120400-M4		●	12.7	4.76	—
	CPMH080202-SV	●	●	7.94	2.38	0.2
	080204-SV	●	●	7.94	2.38	0.4
	090302-SV	●	●	9.525	3.18	0.2
	090304-SV	●	●	9.525	3.18	0.4
	090308-SV	●	●	9.525	3.18	0.8
	CPMT080204-SQ	●	●	7.94	2.38	0.4
	080208-SQ	●	●	7.94	2.38	0.8
	090304-SQ	●	●	9.525	3.18	0.4
	090308-SQ	●	●	9.525	3.18	0.8
	CPMH080204-MV	●	●	7.94	2.38	0.4
	080208-MV	●	●	7.94	2.38	0.8
	090304-MV	●	●	9.525	3.18	0.4
	090308-MV	●	●	9.525	3.18	0.8
	CPMT080204-MQ	●	●	7.94	2.38	0.4
	080208-MQ	●	●	7.94	2.38	0.8
	090304-MQ	●	●	9.525	3.18	0.4
	090308-MQ	●	●	9.525	3.18	0.8
	TPMV090204-SQ	●	●	5.56	2.38	0.4
	110304-SQ	●	●	6.35	3.18	0.4
	160304-SQ	●	●	9.525	3.18	0.4
	TPMH080202-MV	●	●	4.76	2.38	0.2
	080204-MV	●	●	4.76	2.38	0.4
	090202-MV	●	●	5.56	2.38	0.2
	090204-MV	●	●	5.56	2.38	0.4
	110302-MV	●	●	6.35	3.18	0.2
	110304-MV	●	●	6.35	3.18	0.4
	110308-MV	●	●	6.35	3.18	0.8
	160304-MV	●	●	9.525	3.18	0.4
	160308-MV	●	●	9.525	3.18	0.8
	TPMH080202-SV	●	●	4.76	2.38	0.2
	080204-SV	●	●	4.76	2.38	0.4
	090202-SV	●	●	5.56	2.38	0.2
	090204-SV	●	●	5.56	2.38	0.4
	110302-SV	●	●	6.35	3.18	0.2
	110304-SV	●	●	6.35	3.18	0.4
	110308-SV	●	●	6.35	3.18	0.8
	160302-SV	●	●	9.525	3.18	0.2
	160304-SV	●	●	9.525	3.18	0.4
160308-SV	●	●	9.525	3.18	0.8	
	TPMV/T090204-MQ		●	5.56	2.38	0.4
	090208-MQ		●	5.56	2.38	0.8
	110304-MQ		●	6.35	3.18	0.4
	110308-MQ		●	6.35	3.18	0.8
	160304-MQ		●	9.525	3.18	0.4
160308-MQ		●	9.525	3.18	0.8	
	WPMT040204-SQ		●	6.35	2.38	0.4
	060304-SQ		●	9.525	3.18	0.4
	060308-SQ		●	9.525	3.18	0.8
	WPMT040202-MV	●	●	6.35	2.38	0.2
	040204-MV	●	●	6.35	2.38	0.4
	060304-MV	●	●	9.525	3.18	0.4
	060308-MV	●	●	9.525	3.18	0.8
	WPMT040204-MQ	●	●	6.35	2.38	0.4
	040208-MQ	●	●	6.35	2.38	0.8
	060304-MQ	●	●	9.525	3.18	0.4
	060308-MQ	●	●	9.525	3.18	0.8

Threading inserts

● Inserts for SET type holders

Application	Geometry	Pitch mm (threads/inch)	Order number	L5735	Dimensions (mm)		
					D1	S1	Re
General 60°	 SET(60°) Without wiper	0.5-1.5 (48-16)	SET6006R3XMM	●	9.525	3.65	0.06
		1.75-3.0 (14-8)	6022R3XMM	●	9.525	3.65	0.22
Metric screw thread ISO	 SET(60°) With wiper	1.0	SET100R3XMM	●	9.525	3.65	0.13
		1.25	125R3XMM	●	9.525	3.65	0.16
		1.5	150R3XMM	●	9.525	3.65	0.20
		1.75	175R3XMM	●	9.525	3.65	0.22
		2.0	200R3XMM	●	9.525	3.65	0.25
		2.5	250R3XMM	●	9.525	3.65	0.31
Unified coarse screw thread UN	 SET(60°) With wiper	(24)	SET240R3XMUN	●	9.525	3.65	0.13
		(20)	200R3XMUN	●	9.525	3.65	0.16
		(16)	160R3XMUN	●	9.525	3.65	0.20
		(14)	140R3XMUN	●	9.525	3.65	0.23
		(12)	120R3XMUN	●	9.525	3.65	0.27
General 55°	 SET(55°) Without wiper	(48-16)	SET5507R3XMP	●	9.525	3.65	0.07
		(14-8)	5525R3XMP	●	9.525	3.65	0.25
With coarse screw thread, Parallel pipe thread W	 SET(55°) With wiper	(19)	SET190R3XMP	●	9.525	3.65	0.17
		(14)	140R3XMP	●	9.525	3.65	0.25
		(12)	120R3XMP	●	9.525	3.65	0.29
		(11)	110R3XMP	●	9.525	3.65	0.30
Taper pipe thread	 SET(55°) With wiper	(19)	SET190R3XMPT	●	9.525	3.65	0.16
		(14)	140R3XMPT	●	9.525	3.65	0.25
		(11)	110R3XMPT	●	9.525	3.65	0.32

● Inserts for SNT type boring bars

Application	Geometry	Pitch mm (threads/inch)	Order number	L5735	Dimensions (mm)		
					D1	S1	Re
General 60°	 SNT(60°) Without wiper	0.5-1.5 (48-16)	SNT6004R22MM	●	6.35	3.18	0.04
		0.5-1.5 (48-16)	6004R3XMM	●	9.525	3.65	0.04
		1.75-3.0 (14-8)	6012R3XMM	●	9.525	3.65	0.12
Metric screw thread ISO	 SNT(60°) With wiper	1.0	SNT100R3XMM	●	9.525	3.65	0.07
		1.25	125R3XMM	●	9.525	3.65	0.09
		1.5	150R3XMM	●	9.525	3.65	0.12
		1.75	175R3XMM	●	9.525	3.65	0.12
		2.0	200R3XMM	●	9.525	3.65	0.14
		2.5	250R3XMM	●	9.525	3.65	0.18
Unified coarse screw thread UN	 SNT(60°) With wiper	(24)	SNT240R3XMUN	●	9.525	3.65	0.07
		(20)	200R3XMUN	●	9.525	3.65	0.09
		(16)	160R3XMUN	●	9.525	3.65	0.11
		(14)	140R3XMUN	●	9.525	3.65	0.13
		(12)	120R3XMUN	●	9.525	3.65	0.15
General 55°	 SNT(55°) Without wiper	(48-16)	SNT5507R22MP	●	6.35	3.18	0.07
		(48-16)	5507R3XMP	●	9.525	3.65	0.07
		(14-8)	5525R3XMP	●	9.525	3.65	0.25
With coarse screw thread, Parallel pipe thread W	 SNT(55°) With wiper	(19)	SNT190R3XMP	●	9.525	3.65	0.17
		(14)	140R3XMP	●	9.525	3.65	0.25
		(12)	120R3XMP	●	9.525	3.65	0.29
		(11)	110R3XMP	●	9.525	3.65	0.30
Taper pipe thread	 SNT(55°) With wiper	(19)	SNT190R3XMPT	●	9.525	3.65	0.18
		(14)	140R3XMPT	●	9.525	3.65	0.25
		(11)	110R3XMPT	●	9.525	3.65	0.32

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Threading inserts

● Inserts for DG type holder

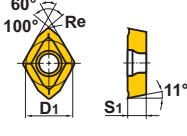
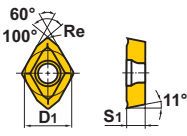
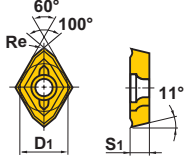
Geometry	Order number	US735	Insert width W ₃	Dimensions (mm)		
				L ₁	S ₁	Re
DGM.....CT 	DGM30CT	●	3	20	5	0.4
	40CT	●	4	20	5	0.4
	50CT	●	5	25	6	0.4
DGM.....CTB 	DGM40CTB	●	4	20	5	2
	50CTB	●	5	25	6	2.5
	60CTB	●	6	25	6	3
DGM.....CTD 	DGM50CTD04	●	5	25	6	0.4
	50CTD08	●	5	25	6	0.8
DGM.....CTR/L 	DGM50CTR04	●	5	25	6	0.4
	50CTL04	●	5	25	6	0.4
DGM.....CTF 	DGM30CTF	●	3	20	3	0.4
	40CTF	●	4	20	3	0.4
	50CTF	●	5	25	5	0.4
	60CTF	●	6	25	5	0.4

● Inserts for UG type holder

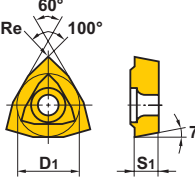
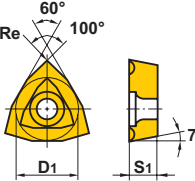
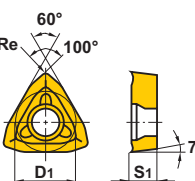
Geometry	Order number	US735	Insert width W ₃	Dimensions (mm)		
				L ₁	S ₁	Re
KGT.N 	KGT3N	●	3.1	—	—	0.2
	4N	●	4.1	—	—	0.2
	5N	●	5.1	—	—	0.2

Inserts for drills

● Inserts for TAF type drill

Geometry	Order number	US735	Dimensions (mm)		
			D1	S1	Re
U1 breaker GPMT 	GPMT060204-U1	●	5.56	2.38	0.4
	070204-U1	●	6.35	2.38	0.4
	090304-U1	●	7.94	3.18	0.4
	11T308-U1	●	9.525	3.97	0.8
	140408-U1	●	12.7	4.76	0.8
U2 breaker GPMT 	GPMT060204-U2	●	5.56	2.38	0.4
	070204-U2	●	6.35	2.38	0.4
	090304-U2	●	7.94	3.18	0.4
	11T308-U2	●	9.525	3.97	0.8
	140408-U2	●	12.7	4.76	0.8
U3 breaker GPMT 	GPMT060204-U3	●	5.56	2.38	0.4
	070204-U3	●	6.35	2.38	0.4
	090304-U3	●	7.94	3.18	0.4
	11T308-U3	●	9.525	3.97	0.8
	140408-U3	●	12.7	4.76	0.8

● Inserts for TAG · TAS type drill

Geometry	Order number	US735	Dimensions (mm)		
			D1	S1	Re
U1 breaker NCMT 	NCMT080204-U1	●	4.76	2.38	0.4
	090204-U1	●	5.56	2.38	0.4
	110208-U1	●	6.35	2.38	0.8
	130308-U1	●	7.94	3.18	0.8
	16T308-U1	●	9.525	3.97	0.8
	220412-U1	●	12.7	4.76	1.2
U2 breaker NCMT 	NCMT080204-U2	●	4.76	2.38	0.4
	090204-U2	●	5.56	2.38	0.4
	110208-U2	●	6.35	2.38	0.8
	130308-U2	●	7.94	3.18	0.8
	16T308-U2	●	9.525	3.97	0.8
	220412-U2	●	12.7	4.76	1.2
U3 breaker NCMT 	NCMT080204-U3	●	4.76	2.38	0.4
	090204-U3	●	5.56	2.38	0.4
	110208-U3	●	6.35	2.38	0.8
	130308-U3	●	7.94	3.18	0.8
	16T308-U3	●	9.525	3.97	0.8
	220412-U3	●	12.7	4.76	1.2

US7020·US735

Application examples

Insert (Grade)	CNMG120408-MA(US735)	CNMG120408-MS(US735)	CNMG120408-MS(US735)	CNMG120408-GH(US7020)	
Workpiece	Stainless steel (JIS SUS304) 	Stainless steel (JIS SUS420) 	Stainless steel (JIS SUS304) 	Stainless steel (JIS SUS303) 	
Cutting conditions	Cutting speed (m/min)	120	100	70	300
	Feed (mm/rev)	0.3	0.3	0.15	0.25
	Depth of cut (mm)	2	2.5	1	1.5
Coolant	Wet cutting	Dry cutting	Wet cutting	Wet cutting	
Result	 US735 Conventional coated grade	 US735 Conventional coated grade	 US735 Conventional coated grade	 US7020 Conventional coated grade US7020 achieved 3 times as long tool life as the conventional grade in high speed cutting.	

Insert (Grade)	CNMG120408-MS(US7020)	CNMG120408-MS(US7020)	CNMG120408-MA(US7020)	CNMG120408-MA(US7020)	
Workpiece	Stainless steel (JIS SUS316) 	Stainless steel (JIS SUS304) 	Alloy steel (JIS SCM420) 	Bearing steel (JIS SUJ2) 	
Cutting conditions	Cutting speed (m/min)	Conventional coated grade =100, US7020=200	Conventional coated grade =100, US7020=200	180	Conventional coated grade =120, US7020=150
	Feed (mm/rev)	0.15-0.2	0.22	0.33	Conventional coated grade =0.3, US7020=0.4
	Depth of cut (mm)	2	1.5-2	2.5	2
Coolant	Wet cutting	Wet cutting	Wet cutting	Wet cutting	
Result	 US7020 Conventional coated grade UC7020 doubled cutting speed and achieved 2 times as long tool life as the conventional grade.	 US7020 Conventional coated grade UC7020 achieved 2 times as high cutting speed and 1.5 times as long tool life as the conventional grade.	 US7020 Conventional coated grade Due to its high welding resistance, UC7020 achieved 10 times as long tool life as the conventional grade.	 US7020 Conventional coated grade UC7020 achieved 1.7 times as high cutting speed and 1.5 times as long tool life as the conventional grade.	

For your safety

●Do not touch cutting or chips without wearing gloves. ●Use tools under recommended cutting conditions, and exchange tools before excessive wear occurs. ●Chips become extremely hot, scattered over and may be stretched. Ensure safety guards and goggles are used. ●In case of using non-water soluble oil, make sure to have a fire prevention countermeasure. ●Use the provided wrench spanner, and ensure the inserts and spare parts are damped securely.

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(Tools specifications subject to change without notice.)