


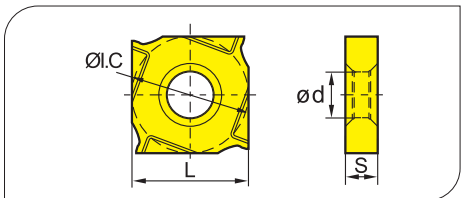


### Spare parts · Ersatzteile


| Diameter<br>Durchmesser<br>Ø D | Cutting width<br>a <sub>p</sub> | Screw<br>Schraube   | Wrench<br>Schlüssel  |  |
|--------------------------------|---------------------------------|---|--|---|
|                                |                                 |  |  |   |
| Ø63-Ø160                       | 4                               | I91M4×3.2X  | WT10S  |   |
| Ø63-Ø160                       | 5                               | I91M4×4.2X  |  |   |
| Ø63-Ø250                       | 6                               | I91M4×5.1X  |  |   |
| Ø63-Ø250                       | 7                               | I91M4×6.1X  |  |   |
| Ø63-Ø250                       | 8                               | I91M4×7.1X  |  |   |

### Applicable inserts · Wendschneidplatten



● Ideal Machining Condition / Gute Bearbeitungsbedingungen  
● Normal Machining Condition / Normale Bearbeitungsbedingungen  
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

| Workpiece Material / Werkstoffe           | P | M | K | N | S | YBC301 | YBC401 | YBM251 | YBM253 | YBM351 | YBD152 | YBD252 | YBG102 | YBG202 | YBG205 | YBG302 | YBG152 | YBG252 | YNG151 | YNG151C | YC305 | YD051 | YD101 | YD201 |
|---|---|---|---|---|---|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|---------|-------|-------|-------|-------|
| P Steel / Stahl                           | ● | ● | ● | ● | ● | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●       | ●     | ●     | ●     | ●     |
| M Stainless Steel / Rostfreier Stahl      | ● | ● | ● | ● | ● | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●       | ●     | ●     | ●     | ●     |
| K Cast iron / Gusseisen                   | ● | ● | ● | ● | ● | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●       | ●     | ●     | ●     | ●     |
| N Non-ferrite material / Ne Metalle       | ● | ● | ● | ● | ● | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●       | ●     | ●     | ●     | ●     |
| S Heat-resistant steel / Warmfester Stahl | ● | ● | ● | ● | ● | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●      | ●       | ●     | ●     | ●     | ●     |

| Insert<br>WSP   | Type · Typ | Dimensions (mm) · Abmessungen |      |     |     | CVD Coating<br>CVD Beschicht. |        |        |        | PVD Coating<br>PVD Beschicht. |        |        |        | Cermet |        | Carbide uncoat.<br>unbe. Hartmetall |        |        |        |         |       |       |       |       |
|---|------------|-------------------------------|------|-----|-----|-------------------------------|--------|--------|--------|-------------------------------|--------|--------|--------|--------|--------|-------------------------------------|--------|--------|--------|---------|-------|-------|-------|-------|
|   |            | I.C                           | L    | S   | d   | YBC301                        | YBC401 | YBM251 | YBM253 | YBM351                        | YBD152 | YBD252 | YBG102 | YBG202 | YBG205 | YBG302                              | YBG152 | YBG252 | YNG151 | YNG151C | YC305 | YD051 | YD101 | YD201 |
|  | XSEQ1202   | 12.7                          | 12.7 | 2.3 | 5.0 |                               |        |        |        |                               |        |        |        |        |        | ●                                   |        |        |        |         |       |       |       |       |
|   | XSEQ1203   | 12.7                          | 12.7 | 3.0 | 5.0 |                               |        |        | ○      |                               |        |        |        |        |        | ●                                   |        |        |        |         |       |       |       |       |
|   | XSEQ12T3   | 12.7                          | 12.7 | 3.5 | 5.0 | ○                             |        |        |        |                               |        |        |        |        |        | ●                                   |        |        |        |         |       |       |       |       |
|   | XSEQ1204   | 12.7                          | 12.7 | 4.0 | 5.0 |                               |        |        |        |                               |        |        |        |        |        | ●                                   |        |        |        |         |       |       |       |       |
|   | XSEQ12T4   | 12.7                          | 12.7 | 4.5 | 5.0 |                               |        |        |        |                               |        |        |        |        |        | ●                                   |        |        |        |         |       |       |       |       |

### Recommended Cutting data · Schnittdaten

|          | Workpiece material<br>Werkstück-<br>stoff                                     | Hardness HB<br>Härte | Grade<br>Sorte | Cutting data · Schnittdaten |                 |
|----------|---|----------------------|----------------|-----------------------------|-----------------|
|          |   |                      |                | V(m/min)                    | f(mm/z)         |
| <b>P</b> | Low-carbon steel Soft steel<br>Niedrig legierter Kohlenstoffstahl<br>Baustahl | ≤180                 | YBG202         | 180 (100-250)               | 0.1(0.08-0.25)  |
|          |   |                      | YBG302         | 150 (100-200)               | 0.15(0.1-0.3)   |
|          | High-carbon steel Alloy steel<br>Hoch Leg. Kohlenstoffstahl<br>Leg. Stahl     | 180-280              | YBG202         | 150 (80-250)                | 0.1(0.08-0.25)  |
|          |   |                      | YBG302         | 120 (80-200)                | 0.15(0.1-0.3)   |
| <b>M</b> | Alloy tool steel<br>Leg. Werkzeugstahl  | 280-350              | YBG202         | 120 (80-250)                | 0.1(0.08-0.25)  |
|          |   |                      | YBG302         | 100 (80-200)                | 0.15(0.1-0.3)   |
| <b>K</b> | Stainless steel<br>Rostfreier Stahl   | ≤270                 | YBG202         | 120 (80-250)                | 0.1(0.05-0.15)  |
|          |   |                      | YBG302         | 100 (80-200)                | 0.08(0.05-0.15) |
| <b>K</b> | Cast iron<br>Gusseisen  | 180-250              | YBG152         | 120 (80-250)                | 0.1(0.05-0.15)  |
|          |   |                      | YBG302         | 150 (100-250)               | 0.08(0.05-0.15) |

Applicable tool **B9-B15**  
Werkzeug

Tools code key **B22-B23**  
Werkzeug ISO

Grade selection guide **B16-B20**  
Sortenauswahl

Technical data **B183-B188**  
Technische Daten