

| TURNING   | SC                     | CARBIDE Positive                      | ISO513 | HC-CVD           |            |            |  |  |              | HC-PVD       |             | HW          |             | HT     |        |                   |                   |   |  |   |  |  |  |
|-----------|------------------------|---------------------------------------|--------|------------------|------------|------------|--|--|--------------|--------------|-------------|-------------|-------------|--------|--------|-------------------|-------------------|---|--|---|--|--|--|
|           |                        |                                       |        | JC7010           | JC7020     | JC8005     | JC8015   | JC8025   | JC9010       | JC9025       | JPS015      | JPS025      | JPS010      | JU6010 | JU6020 | JU4015            | JP4020            |   |  |   |  |  |  |
|           |                        |                                       |        |                  |            | 200<br>380 | 180<br>360                                     | 140<br>300                                     |              |              | 80<br>220   | 60<br>180   |             |        |        | 200<br>380<br>400 | 200<br>380<br>400 |   |  |   |  |  |  |
|           | Size                   | IC                                    | S      | D1               | AN         | P          |  |  |              |              |             |             |             |        |        |                   |                   |   |  |   |  |  |  |
|           | 09T3□                  | 9.525                                 | 3.97   | 4.40             | 7°         | M          |  |  |              |              |             |             |             |        |        |                   |                   |   |  |   |  |  |  |
|           | 1204□                  | 12.70                                 | 4.76   | 5.50             | 7°         | K          | 180<br>380                                     | 150<br>300                                     |              |              |             |             |             |        |        |                   |                   |   |  |   |  |  |  |
|           |                        |                                       |        |                  |            | N          |  |  |              |              | 600<br>2200 | 600<br>2000 | 500<br>1500 |        |        |                   |                   |   |  |   |  |  |  |
|           |                        |                                       |        |                  |            | S          |  |  |              | 40<br>80     |             |             |             |        |        |                   |                   |   |  |   |  |  |  |
|           |                        |                                       |        |                  |            | H          |  |  |              |              |             |             |             |        |        |                   |                   |   |  |   |  |  |  |
| THREADING | GRADE APPLICATION AREA | Stable machining, continuous cut      |        |                  |            |            | + Hardness<br>- Toughness                      |  |              |              |             |             |             |        |        |                   |                   |   |  |   |  |  |  |
|           | main application       | General machining, light interruption |        |                  |            |            |  |  |              |              |             |             |             |        |        |                   |                   |   |  |   |  |  |  |
|           | applicable             | Unstable machining, interrupted cut   |        |                  |            |            |  |  |              |              |             |             |             |        |        |                   |                   |   |  |   |  |  |  |
| GROOVING  | MEDIUM                 | PMU <b>P M K</b>                      |        | general purpose  | SCMT       | 09T304-PMU | RE 0.4   | a <sub>p</sub> ▶ 0.60<br>f <sub>n</sub> ▶ 0.07 | 1.80<br>0.16 | 3.00<br>0.25 | ○           |             |             |        |        |                   | ●                 |   |  |   |  |  |  |
|           |                        |                                       |        |                  |            | 09T308-PMU | RE 0.8   | a <sub>p</sub> ▶ 0.60<br>f <sub>n</sub> ▶ 0.08 | 1.80<br>0.19 | 3.00<br>0.30 | ●           |             |             | ●      |        |                   |                   |   |  | ○ |  |  |  |
|           |                        |                                       |        |                  | SCMT       | 120404-PMU | RE 0.4   | a <sub>p</sub> ▶ 0.80<br>f <sub>n</sub> ▶ 0.08 | 2.20<br>0.17 | 3.60<br>0.26 |             |             |             |        |        | ○                 |                   | ● |  |   |  |  |  |
|           |                        |                                       |        |                  |            | 120408-PMU | RE 0.8   | a <sub>p</sub> ▶ 0.80<br>f <sub>n</sub> ▶ 0.10 | 2.20<br>0.22 | 3.60<br>0.32 | ●           |             |             |        |        |                   |                   |   |  |   |  |  |  |
|           |                        | PMN <b>N</b>                          |        | polished surface | SCGX       | 09T304-PMN | RE 0.4   | a <sub>p</sub> ▶ 0.50<br>f <sub>n</sub> ▶ 0.08 | 2.00<br>0.16 | 3.50<br>0.24 |             |             |             |        | ○      | ○                 | ●                 |   |  |   |  |  |  |
|           |                        |                                       |        |                  | 09T308-PMN | RE 0.8     | a <sub>p</sub> ▶ 0.50<br>f <sub>n</sub> ▶ 0.10 | 2.00<br>0.20                                   | 3.50<br>0.30 |              |             |             |             | ○      | ○      | ●                 |                   |   |  |   |  |  |  |
|           | SCGX                   |                                       |        |                  | 120404-PMN | RE 0.4     | a <sub>p</sub> ▶ 0.50<br>f <sub>n</sub> ▶ 0.10 | 3.00<br>0.20                                   | 5.50<br>0.30 |              |             |             |             |        | ○      | ○                 | ●                 |   |  |   |  |  |  |
|           |                        |                                       |        |                  | 120408-PMN | RE 0.8     | a <sub>p</sub> ▶ 0.50<br>f <sub>n</sub> ▶ 0.15 | 3.00<br>0.25                                   | 5.50<br>0.35 |              |             |             |             |        |        | ○                 | ○                 | ● |  |   |  |  |  |
| MILLING   | ROUGHING               | PRU <b>P K</b>                        |        | reinforced edge  | SCMT       | 09T308-PRU | RE 0.8   | a <sub>p</sub> ▶ 1.50<br>f <sub>n</sub> ▶ 0.12 | 2.50<br>0.22 | 3.50<br>0.32 | ●           |             |             |        |        |                   |                   |   |  |   |  |  |  |
|           |                        |                                       |        |                  | SCMT       | 120408-PRU | RE 0.8   | a <sub>p</sub> ▶ 1.50<br>f <sub>n</sub> ▶ 0.14 | 3.00<br>0.26 | 4.50<br>0.38 | ●           |             |             |        |        |                   |                   |   |  |   |  |  |  |

● stock standard, ○ non-standard stock

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