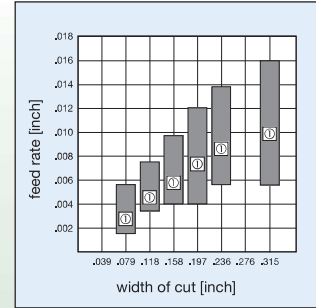


**PGU**



left-hand    neutral    right-hand

For grooving and parting operations, universal use. Positive chipbreaker groove for light cutting action. Right-hand and left-hand styles with 6° front angle.

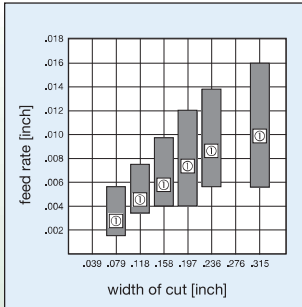


① Recommended Starting Feed

**PGM**



neutral



① Recommended Starting Feed

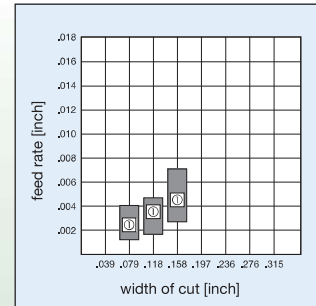
For grooving and parting, also capable of copy and straight turning as well as chamfering. With additional chip forming element for good chip control with varying depths of cut.

**PGS**



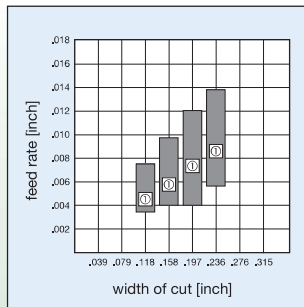
left-hand    neutral    right-hand

For low-bur parting with straight flanks and smooth surface finishes. All inserts are recommended for parting and grooving slender workpieces, part diameter <1.25", and thin-wall tubes.



① Recommended Starting Feed

**PGR**



① Recommended Starting Feed

Full round inserts for profiling, grooving, and copy turning. Very good chip control for broad general use. Accurate, reproducible cutting edge positioning.

**LG System • 0 and 1**

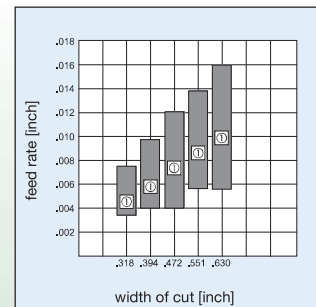


0

1

...0  
Inserts with wide range of applications in grooving and deep grooving. With additional chip control element for good chip control, even with varying widths of cut.

...1  
Inserts with wide range of uses in grooving and deep grooving of short chipping materials.



① Recommended Starting Feed

Material Group		Cutting Speed – vc m/min																	
		TN6030			TN7525			TN7535			TN8025			THM			TTM		
		min	Start	max	min	Start	max	min	Start	max	min	Start	max	min	Start	max	min	Start	max
P	0 / 1	130	140	150	200	215	230	140	175	210	-	-	-	-	-	-	90	95	100
	2	110	145	175	170	220	270	115	145	175	-	-	-	-	-	-	75	100	125
	3	110	145	175	170	220	270	115	145	175	-	-	-	-	-	-	75	100	125
	4	75	95	115	115	145	175	75	100	120	-	-	-	-	-	-	55	65	80
	5	100	125	145	155	190	220	105	140	170	-	-	-	-	-	-	70	85	100
	6	40	55	65	65	85	100	45	60	75	-	-	-	-	-	-	30	40	45
M	1	90	110	140	-	-	-	-	-	-	90	120	150	-	-	-	60	75	90
	2	55	70	90	-	-	-	-	-	-	55	75	95	-	-	-	40	50	55
	3	60	75	95	-	-	-	-	-	-	60	80	100	-	-	-	40	50	60
K	1	60	80	90	120	150	180	-	-	-	-	-	-	60	80	90	-	-	-
	2	60	75	85	120	150	180	-	-	-	-	-	-	60	75	85	-	-	-
	3	60	75	90	110	140	170	-	-	-	-	-	-	60	75	90	-	-	-
N	1	-	-	-	-	-	-	-	-	-	-	-	-	600	750	900	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	535	685	835	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	230	300	370	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-	135	180	225	-	-	-
	5	-	-	-	-	-	-	-	-	-	-	-	-	70	90	110	-	-	-
	6	-	-	-	-	-	-	-	-	-	-	-	-	445	565	690	-	-	-
	7	-	-	-	-	-	-	-	-	-	-	-	-	550	700	850	-	-	-
S	1	-	-	-	-	-	-	-	-	-	-	-	-	25	35	40	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	15	20	20	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	40	60	70	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-	20	30	35	-	-	-
H	1	-	-	-	-	-	-	-	-	-	-	-	-	10	20	35	-	-	-
	2	-	-	-	-	-	-	-	-	-	-	-	-	10	20	35	-	-	-
	3	-	-	-	-	-	-	-	-	-	-	-	-	10	20	35	-	-	-
	4	-	-	-	-	-	-	-	-	-	-	-	-	10	20	35	-	-	-

Material Group		Cutting Speed – vc SFM																	
		TN6030			TN7525			TN7535			TN8025			THM			TTM		
		min	Start	max	min	Start	max	min	Start	max	min	Start	max	min	Start	max	min	Start	max
P	0 / 1	425	455	490	655	705	750	455	570	685	–	–	–	–	–	–	295	310	325
	2	360	465	575	555	720	885	380	475	575	–	–	–	–	–	–	245	320	405
	3	360	465	575	555	720	885	380	475	575	–	–	–	–	–	–	245	320	405
	4	235	300	365	370	470	570	245	320	390	–	–	–	–	–	–	170	210	260
	5	325	400	475	510	615	720	345	450	555	–	–	–	–	–	–	230	280	330
	6	130	180	210	210	275	325	145	195	245	–	–	–	–	–	–	95	130	145
M	1	295	390	490	–	–	–	–	–	–	295	390	490	–	–	–	195	245	295
	2	180	245	310	–	–	–	–	–	–	180	245	310	–	–	–	130	160	180
	3	195	260	320	–	–	–	–	–	–	195	260	320	–	–	–	130	165	195
K	1	195	255	295	390	490	590	–	–	–	–	–	–	195	255	295	–	–	–
	2	195	240	280	390	490	590	–	–	–	–	–	–	195	240	280	–	–	–
	3	195	245	295	360	455	555	–	–	–	–	–	–	195	245	295	–	–	–
N	1	–	–	–	–	–	–	–	–	–	–	–	–	1965	2460	2950	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	1750	2240	2730	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	750	980	1210	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	445	590	730	–	–	–
	5	–	–	–	–	–	–	–	–	–	–	–	–	230	295	360	–	–	–
	6	–	–	–	–	–	–	–	–	–	–	–	–	1450	1855	2260	–	–	–
	7	–	–	–	–	–	–	–	–	–	–	–	–	1805	2295	2785	–	–	–
S	1	–	–	–	–	–	–	–	–	–	–	–	–	75	110	130	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	40	55	65	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	135	195	235	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	65	95	115	–	–	–
H	1	–	–	–	–	–	–	–	–	–	–	–	–	35	70	115	–	–	–
	2	–	–	–	–	–	–	–	–	–	–	–	–	35	70	115	–	–	–
	3	–	–	–	–	–	–	–	–	–	–	–	–	35	70	115	–	–	–
	4	–	–	–	–	–	–	–	–	–	–	–	–	35	70	115	–	–	–