



CA55 Series

Featuring PH & PX Chipbreakers for Heavy Macchining

■ *CVD Coated Carbide Grades for Steel*

CA5505
High Speed

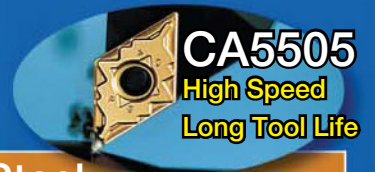
CA5515
Light Interruptions

CA5525
General Purpose

CA5535
Heavy Interruptions

Innovative CVD Coated Carbides for Steel Machining

CA55^{05/15/25/35}



1 Bright Gold Coating

- Prevents chip adhesion and sudden fractures
- Increases productivity due to crack free coating technology
- Promotes excellent surface finish

Bright Gold Coating

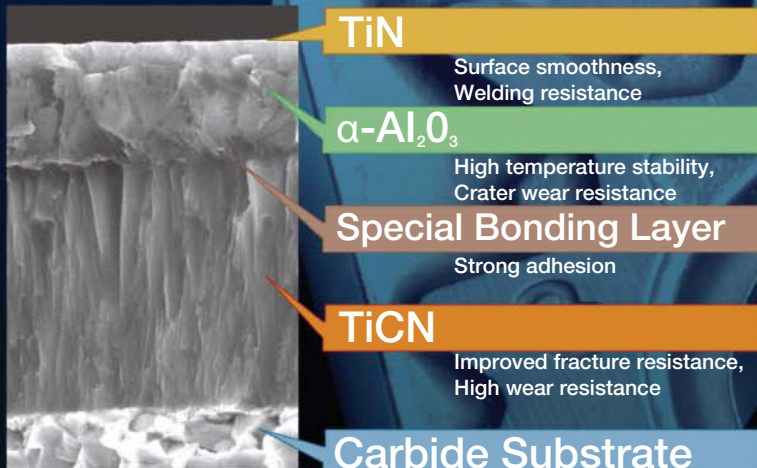


Conventional Coating



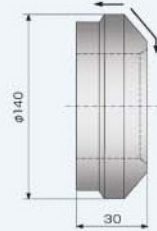
2 Coating Layer Composition

The tough ultra-fine TiCN and Al₂O₃ coating layers allow for higher speeds and increased efficiency when machining steels



Chromium Steel

Ring Gear
v = 1300 sfm
d.o.c. = 0.04 ~ 0.06
f = 0.014 ipr
Wet
CNMG 433CQ



CA55⁰⁵

120 pcs/edge

Competitor A (coated)

100 pcs/edge

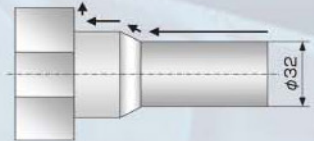
Using CA5505 with the CQ chipbreaker, chip control is improved and 1.2 times as many workpieces were machined.

CA5515

Light
Interruption

Carbon Steel

Bolt
v = 750 sfm
d.o.c. = 0.04 ~ 0.06
f = 0.009 ipr
Wet
TNMG 332PS



CA5515

500 pcs/edge

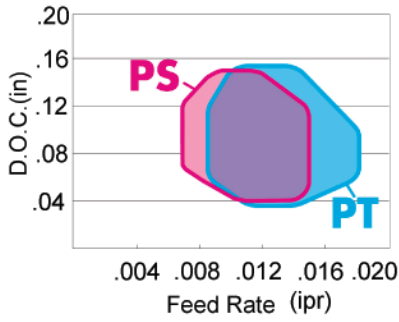
Competitor B (coated)

350 pcs/edge

CA5515 machined 1.4 times as many workpieces as competitor B.

CA5515 enabled stable machining without chipping even with increased cutting velocity
V=650 → 750

PS & PT Chipbreakers

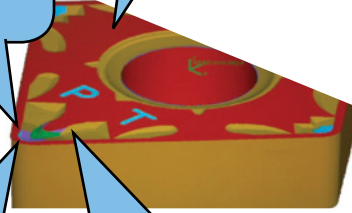


K land support structure promotes a tougher cutting edge

Red area indicates locating surface

Cutting edge has a shallower K land for smooth cutting and toughness

Sharper relief angle promotes smooth machining when high feed turning



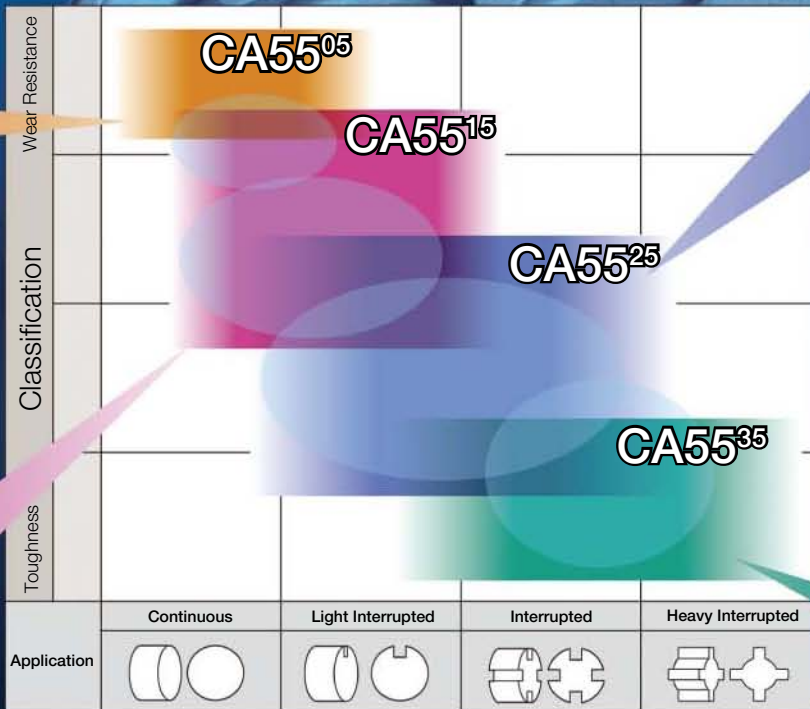
CA5525
General Purpose
& Interrupted Cutting



3

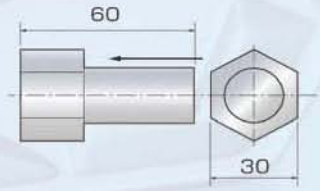
Applicable Cutting Range

The CA55 series has proven to outperform competitor's coated carbides in a wide range of applications



Structural Steel

Hex Stock
v = 500~600 sfm
d.o.c. = 0.06
f = 0.008~.012 ipr
Wet
CNMG 432GS



CA5525

60 pcs/edge

Competitor C (coated)

20-30 pcs/edge

CA5525 machines 2-3 times as many workpieces as Competitor C.

Cutting edge condition of CA5525 was better than Competitor C and still good for further machining even after 60 pcs/edge.

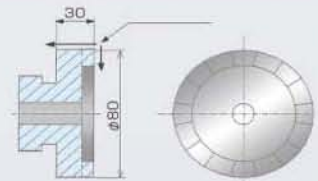
CA5535

Heavy Interrupted



Carbon Steel

Sifter Gear
v = 400 sfm
d.o.c. = 0.07
f = 0.008 ipr
Wet
CNMG 432PT



CA5535

300 pcs/edge

Competitor D (coated)

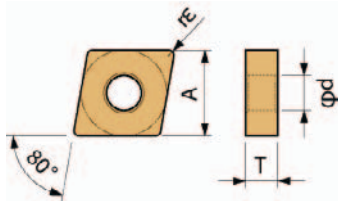
200 pcs/edge

CA5535 machined 1.5 times as many workpieces as Competitor D.



80° Diamond Negative with Hole (in)

Description	A	T	ød
CN_33_	3/8	3/16	0.150
CN_43_	1/2		0.203
CN_54_	5/8	1/4	0.250
CN_64_	3/4		0.312

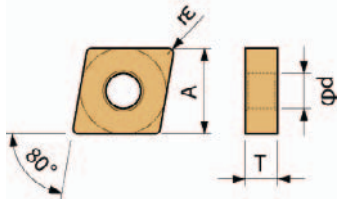


Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide	Applicable Chipbreaker Range	
					rε
With Wiper Edge	Finishing	CNMG 431WP	1/64	● ● ● ●	
		CNMG 432WP	1/32	● ● ● ●	
	Finishing-Medium	CNMG 431WQ	1/64	● ● ● ●	
		CNMG 432WQ	1/32	● ● ● ●	
		CNMG 433WQ	3/64	● ● ● ●	
		CNMG 431GP	1/64	● ● ● ●	
Finishing	CNMG 432GP	1/32	● ● ● ●		
	CNMG 4305GP	.008	● ● ● ●		
Finishing-Medium	CNGG 432GP	1/64	● ● ● ●		
		1/32	● ● ● ●		
	CNMG 331HQ	1/64	● ● ● ●		
	CNMG 332HQ	1/32	● ● ● ●		
	CNGG 431HQ	1/64	● ● ● ●		
		1/32	● ● ● ●		
3/64		● ● ● ●			
Finishing-Medium / Up facing	CNMG 431CQ	1/64	● ● ● ●		
		1/32	● ● ● ●		
		3/64	● ● ● ●		
	CNMG 542CQ	1/32	● ● ● ●		
		3/64	● ● ● ●		
		3/64	● ● ● ●		
CNMG 432CJ	1/32	○ ● ● ●			
	3/64	○ ● ● ●			
	3/64	○ ● ● ●			
CNMG 543CJ	3/64	○ ● ● ●			
	1/16	○ ● ● ●			
	1/16	○ ● ● ●			
With Wiper Edge	Finishing-Medium	CNMG 431CS	1/64	● ● ● ●	
		CNMG 432CS	1/32	● ● ● ●	
		CNMG 433CS	3/64	● ● ● ●	
Medium-Roughing	CNMG 331GS	1/64	● ● ● ●		
		1/32	● ● ● ●		
		3/64	● ● ● ●		
	CNMG 431GS	1/64	● ● ● ●		
		1/32	● ● ● ●		
		3/64	● ● ● ●		
	CNMG 431PS	1/64	● ● ● ●		
		1/32	● ● ● ●		
		3/64	● ● ● ●		
	CNMG 433PS	1/16	● ● ● ●		
		1/16	● ● ● ●		
		1/16	● ● ● ●		
CNMG 431HS	1/64	● ● ● ●			
	1/32	● ● ● ●			
	3/64	● ● ● ●			
CNMG 433HS	1/16	● ● ● ●			
	1/16	● ● ● ●			
	1/16	● ● ● ●			

Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide	Applicable Chipbreaker Range
Medium-Roughing / High-Feed	CNMG 432PT	1/32	● ● ● ●	
		3/64	● ● ● ●	
	CNMG 542PT	1/32	● ● ● ●	
		3/64	● ● ● ●	
		1/16	● ● ● ●	
		1/16	● ● ● ●	
CNMG 432GT	1/32	● ● ● ●		
	1/64	● ● ● ●		
CNMG 643GT	3/64	● ● ● ●		
Roughing	CNMG 431	1/64	○ ● ● ●	
		1/32	○ ● ● ●	
		3/64	○ ● ● ●	
		1/16	○ ● ● ●	
	CNMG 542	1/32	● ● ● ●	
		3/64	● ● ● ●	
		1/16	○ ● ● ●	
	CNMG 642	1/32	● ● ● ●	
		3/64	● ● ● ●	
		1/16	○ ● ● ●	
	CNMG 644	1/16	○ ● ● ●	
		3/32	○ ● ● ●	
3/32		○ ● ● ●		
Single Sided / Roughing / High Feed	CNMG 432PH	1/32	○ ● ● ●	
		3/64	○ ● ● ●	
		1/16	○ ● ● ●	
	CNMG 542PH	1/32	○ ● ● ●	
		3/64	○ ● ● ●	
		1/16	○ ● ● ●	
CNMG 642PH	1/32	○ ● ● ●		
	3/64	○ ● ● ●		
	1/16	○ ● ● ●		
Low Carbon Steel	CNMM 432PX	1/32	○ ● ● ●	
		3/64	○ ● ● ●	
		1/16	○ ● ● ●	
	CNMM 542PX	1/32	○ ● ● ●	
		3/64	○ ● ● ●	
		1/16	○ ● ● ●	
CNMM 642PX	1/32	○ ● ● ●		
	3/64	○ ● ● ●		
	1/16	○ ● ● ●		
Finishing	CNMG 431XP	1/64	● ● ● ●	
		1/32	● ● ● ●	
	CNMG 431XQ	1/64	● ● ● ●	
		1/32	● ● ● ●	
		1/32	● ● ● ●	
		1/32	● ● ● ●	
Medium	CNMG 432XS	1/32	● ● ● ●	
		1/32	● ● ● ●	
Roughing	CNMG 432XS	1/32	● ● ● ●	
		1/32	● ● ● ●	

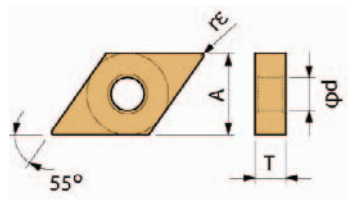
80° Diamond Negative with Hole

Description	A	T	ød
CN_33_	3/8	3/16	0.150
CN_43_	1/2		0.203
CN_54_	5/8	1/4	0.250
CN_64_	3/4		0.312

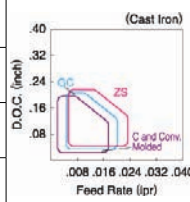


55° Diamond Negative with Hole

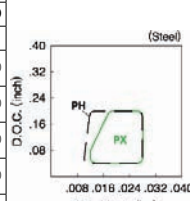
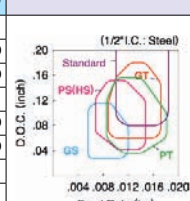
Description	A	T	ød
DN_33_	3/8	3/16	0.150
DN_43_	1/2		0.203
DN_44_	1/2	1/4	0.203



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide			Applicable Chipbreaker Range			
			rε	CA5505	CA5515		CA5525	CA5535	
Cast Iron		Roughing	CNMG 431C 432C 433C 434C	1/64	○	○	○	○	
				1/32	○	○	○	○	
				3/64	○	○	○	○	
				1/16	○	○	○	○	
	CNMG 543	3/64	●	●	●	●			
Roughing	CNMG 432ZS 433ZS	1/32	●	○	○	○			
		3/64	●	○	○	○			
Roughing	CNMG 432GC 433GC	1/32	●	○	○	○			
		3/64	○	○	○	○			
Roughing	CNMA 431 432 433 434	1/64	●	○	○	○			
		1/32	●	○	○	○			
		3/64	●	○	○	○			
		1/12	●	○	○	○			
	CNMA 543	3/32	○	○	○	○			

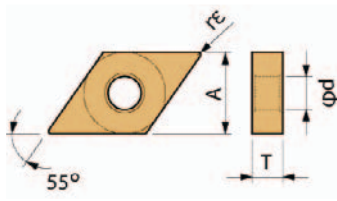


Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide			Applicable Chipbreaker Range		
			rε	CA5505	CA5515		CA5525	CA5535
Finishing		DNMG 331GP 332GP	1/64	○	○	○	○	
			1/32	○	○	○	○	
Finishing-Medium		DNMG 4305GP 431GP 432GP	0.008	○	○	○	○	
			1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
Finishing-Medium / Up Facing		DNMG 431CQ 432CQ 433CQ	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/12	○	○	○	○	
Finishing-Medium / Up Facing		DNMG 431CQ 432CQ 433CQ	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/12	○	○	○	○	
Finishing-Medium / Up Facing		DNMG 432CJ 433CJ	1/32	○	○	○	○	
			3/64	○	○	○	○	
Finishing-Medium / Up Facing		DNMG 442CJ 443CJ	1/32	○	○	○	○	
			3/64	○	○	○	○	
Medium-Roughing		DNMG 431CS 432CS	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/12	○	○	○	○	
Medium-Roughing		DNMG 331GS 332GS	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/12	○	○	○	○	
Medium-Roughing		DNMG 431GS 432GS 433GS	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/12	○	○	○	○	
Medium-Roughing		DNMG 431PS 432PS 433PS 434PS	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/16	○	○	○	○	
Medium-Roughing		DNMG 441PS 442PS 443PS	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			3.64	○	○	○	○	
Medium-Roughing / High Feed		DNMG 431HS 432HS 433HS	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			3/64	○	○	○	○	
Medium-Roughing / High Feed		DNMG 441HS 442HS 443HS	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			3/64	○	○	○	○	
Medium-Roughing / High Feed		DNMG 432PT 433PT	1/32	○	○	○	○	
			3/64	○	○	○	○	
Medium-Roughing / High Feed		DNMG 432PT 433PT	1/32	○	○	○	○	
			3/64	○	○	○	○	
Medium-Roughing / High Feed		DNMG 432GT 433GT	1/32	○	○	○	○	
			3/64	○	○	○	○	
Medium-Roughing / High Feed		DNMG 442GT 443GT	1/32	○	○	○	○	
			3/64	○	○	○	○	
Medium-Roughing / High Feed		DNMG 432HT 433HT	1/32	○	○	○	○	
			3/64	○	○	○	○	
Medium-Roughing / High Feed		DNMG 442HT 443HT	1/32	○	○	○	○	
			3/64	○	○	○	○	

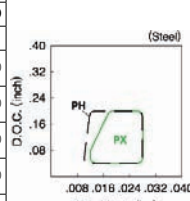
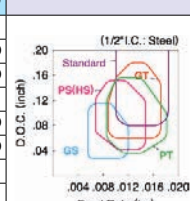


55° Diamond Negative with Hole

Description	A	T	ød
DN_33_	3/8	3/16	0.150
DN_43_	1/2		0.203
DN_44_	1/2	1/4	0.203

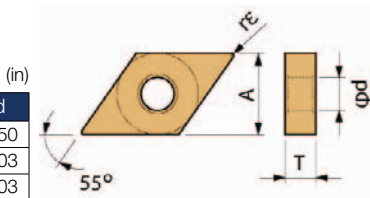


Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide			Applicable Chipbreaker Range		
			rε	CA5505	CA5515		CA5525	CA5535
Roughing		DNMG 431 432 433	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/16	○	○	○	○	
Roughing		DNMG 441 442 443	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/16	○	○	○	○	
Roughing		DNMG 432PH 433PH 434PH	1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/16	○	○	○	○	
			1/16	○	○	○	○	
Roughing		DNMG 442PH 443PH 444PH	1/64	○	○	○	○	
			1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/16	○	○	○	○	
Single Sided \ Roughing \ High Feed		DNMM 432PX 433PX 434PX	1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/16	○	○	○	○	
			1/16	○	○	○	○	
Single Sided \ Roughing \ High Feed		DNMM 442PX 443PX 444PX	1/32	○	○	○	○	
			3/64	○	○	○	○	
			1/16	○	○	○	○	
			1/16	○	○	○	○	



55° Diamond Negative with Hole

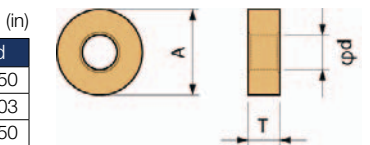
Description	A	T	ød
DN_33_	3/8	3/16	0.150
DN_43_	1/2		0.203
DN_44_	1/2	1/4	0.203



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Low Carbon Steel	Finishing DNMG 431XP 432XP	1/64 1/32	●	●	●	●	
	Medium DNMG 431XQ 432XQ	1/64 1/32	●	●	●	●	
	Roughing DNMG 432XS	1/32	●	●	●	●	
Stainless Steel	Medium-Roughing DNMG 441 1/2 -ST 442 1/2 -ST	1/64 1/32	○	○	○	○	
	Roughing DNMG 441C 442C 443C	1/64 1/32 3/64	○	○	○	○	
Cast Iron	Roughing DNMG 432ZS 433ZS	1/32 3/64	●	●	●	●	
	Roughing DNMG 442ZS 443ZS	1/32 3/64	○	○	○	○	
	Roughing DNMG 432GC 433GC	1/32 3/64	○	○	○	○	
	Roughing DNMG 442GC 443GC	1/32 3/64	○	○	○	○	
	Without Chipbreaker DNMA 431 432	1/64 1/32	●	●	●	●	

Round Negative with Hole

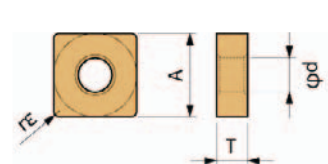
Description	A	T	ød
RN_32_	3/8	1/8	0.150
RN_43_	1/2	3/16	0.203
RN_54_	5/8	1/4	0.250



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Medium-Roughing	RNMG 32	-	●	●	●	●	
	RNMG 43	-	●	●	●	●	
	RNMG 54	-	●	●	●	●	

90° Square Negative with Hole

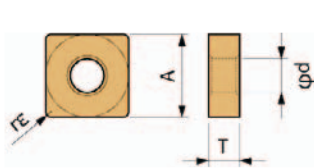
Description	A	T	ød
SN_32_	3/8	1/8	0.150
SN_43_	1/2	3/16	0.203
SN_54_	5/8	1/4	0.250
SN_64_	3/4		0.312



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range	
			rε	CA5505	CA5515	CA5525		CA5535
Finishing-Medium	SNMG 432HS 433HS 434HS	1/64 1/32 3/64	○	●	●	●		
	Medium-Roughing	SNMG 432PS 433PS 434PS	1/64 1/32 1/16	●	●	●		●
		SNMG 432HS 433HS 434HS	1/32 3/64 1/16	○	●	●		●
Medium-Roughing / High Feed		SNMG 432PT 433PT	1/32 3/64	●	●	●	●	
	Medium-Roughing / High Feed	SNMG 432HT	1/32	●	●	●	●	
Roughing		SNMG 321 322	1/64 1/32	○	○	○	○	
	SNMG 431 432 433 434 435	1/64 1/32 3/64 1/16 5/64	○	○	○	○		
	SNMG 643 644	3/64 1/16	○	○	○	○		
	SNMG 432PH 433PH 434PH	1/32 3/64 1/16	○	○	○	○		
	SNMG 543PH 544PH	3/64 1/16	○	○	○	○		
	SNMG 643PH 644PH 646PH	3/64 1/16 3/32	○	○	○	○		
	Single Steel / Roughing / High Feed	SNMM 432PX 433PX 434PX	1/32 3/64 1/16	○	○	○	○	
		SNMM 543PX 544PX	3/64 1/16	○	○	○	○	
		SNMM 643PX 644PX 646PX	3/64 1/16 3/32	○	○	○	○	
		Low Carbon Steel	SNMG 432XP	1/32	●	●	●	

90° Square Negative with Hole

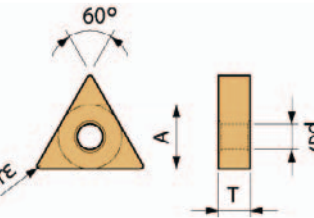
Description	A (in)	T (in)	ød (in)
SN_32_	3/8	1/8	0.150
SN_43_	1/2	3/16	0.203
SN_54_	5/8	1/4	0.250
SN_64_	3/4		0.312



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide	Applicable Chipbreaker Range
Cast Iron	SNMG 432C 433C	1/32	CA5505	
		3/64	CA5515	
	SNMG 432ZS 433ZS	1/32	CA5525	
		3/64	CA5535	
SNMG 4312GC 433GC	1/32			
	3/64			
Roughing	SNMA 431 432 433 434 435	1/64		
		1/32		
		3/64		
		1/16		
		5/64		

60° Triangle Negative with Hole

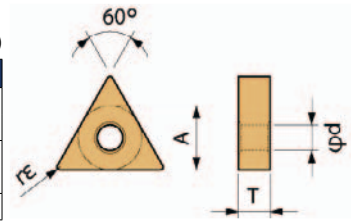
Description	A (in)	T (in)	ød (in)
TN_22_	1/4	1/8	0.110
TN_23_		3/16	
TN_32_	3/8	1/8	0.150
TN_33_		3/16	
TN_43_	1/2	3/16	0.203



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide	Applicable Chipbreaker Range
Low Carbon Steel	TNMG 331XP 332XP	1/64	CA5505	
		1/32	CA5515	
	TNMG 332XQ 332XQ	1/64	CA5525	
1/32		CA5535		
Medium	TNMG 332XS	1/32		
Stainless Steel	TNMG 332HU 333HU	1/32		
		3/64		
Medium-Roughing	TNMG 331 1/2-ST 332 1/2-ST	1/64		
		1/32		

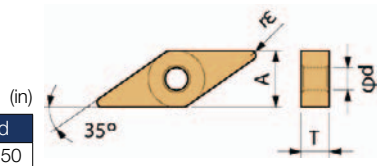
60° Triangle Negative with Hole

Description	A (in)	T (in)	ød (in)
TN_22_	1/4	1/8	0.110
TN_23_		3/16	
TN_32_	3/8	1/8	0.150
TN_33_		3/16	
TN_43_	1/2	3/16	0.203



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide	Applicable Chipbreaker Range
Finishing	TNMG 3305GP 331GP 332GP	0.008		
		1/64		
		1/32		
Finishing-Medium	TNMG 231HQ 232HQ	1/64		
		1/32		
Finishing-Medium / Up-facing	TNMG 331HQ 332HQ 333HQ	1/64		
		1/32		
		3/64		
Finishing-Medium / Up-facing	TNMG 332CQ 333CQ	1/64		
		1/32		
		3/64		
Finishing-Medium / Up-facing	TNMG 432CQ 433CQ	1/32		
		1/32		
		3/64		
Medium-Roughing	TNMG 331CS 332CS	1/64		
		1/32		
Medium-Roughing	TNMG 231GS 232GS	1/64		
		1/32		
Medium-Roughing	TNMG 331GS 332GS	1/64		
		1/32		
Medium-Roughing	TNMG 331PS 332PS 333PS	1/64		
		1/32		
		3/64		
Medium-Roughing	TNMG 431PS 432PS 433PS 434PS	1/64		
		1/32		
		3/64		
Medium-Roughing / High Feed	TNMG 331HS 332HS 333HS	1/64		
		1/32		
		3/64		
Medium-Roughing / High Feed	TNMG 431HS 432HS 433HS	1/64		
		1/32		
		3/64		
Medium-Roughing / High Feed	TNMG 332GT 333GT	1/32		
		3/64		
Medium-Roughing / High Feed	TNMG 332HT 333HT	1/32		
		3/64		
Roughing	TNMG 331 332 333 334 335	1/64		
		1/32		
		3/64		
		1/16		
		5/64		
Medium-Roughing	TNMG 431 432 433	1/64		
		1/32		
		3/64		
		3/64		
Single-Seed / Roughing	TNMM 332PX 333PX 432PX 433PX 434PX	1/32		
		3/64		
		1/32		
		3/64		

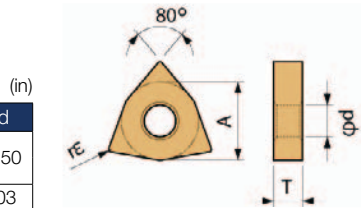
35° Diamond Negative with Hole



Description	A	T	ød
VN_33_	3/8	3/16	0.150

Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Finishing	VNMG 3305GP 331GP 332GP	0.008	●	●	●	●	
		1/64	●	●	●	●	
		1/32	●	●	●	●	
Finishing / Medium	VNMG 331VF 332VF 333VF	1/64	●	●	●	●	
		1/32	●	●	●	●	
		3/64	●	●	●	●	
Finishing / Medium	VNMG 331HQ 332HQ 333HQ	1/64	●	●	●	●	
		1/32	●	●	●	●	
		3/64	●	●	●	●	
Roughing	VNMG 331 332	1/64	●	●	●	●	
		1/32	●	●	●	●	

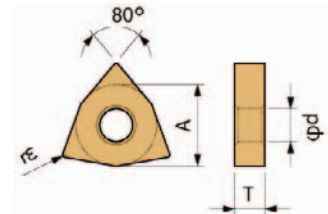
80° Trigon Negative with Hole



Description	A	T	ød
WN_325	3/8	5/32	0.150
WN_33_		3/16	
WN_43_	12.70	3/16	.203

Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Low Carbon Steel	WNMG 431XP 432XP	1/64	●	●	●	●	
		1/32	●	●	●	●	
	WNMG 431XQ 432XQ	1/64	●	●	●	●	
		1/32	●	●	●	●	
Roughing	WNMG 432XS	1/32	●	●	●	●	
		1/32	●	●	●	●	
Stainless Steel	WNMG 432HU 433HU	1/32	●	●	●	●	
		3/64	●	●	●	●	

80° Trigon Negative with Hole



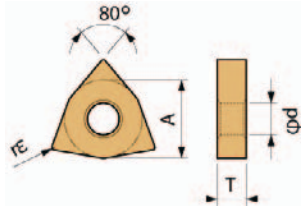
Description	A	T	ød
WN_325	3/8	5/32	0.150
WN_33_		3/16	
WN_43_	12.70	3/16	.203


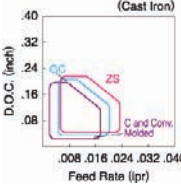



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
With Wiper Edge	WNMG 431WP 432WP	1/64	●	●	●	●	
		1/32	●	●	●	●	
	Finishing-Medium	WNMG 431WP 432WP 433WP	1/64	●	●	●	
1/32			●	●	●	●	
3/64			●	●	●	●	
Finishing-Medium	WNMG 3251HQ 3252HQ	1/64	○	○	○	○	
		1/32	○	○	○	○	
	WNMG 331HQ 332HQ	1/64	●	●	●	●	
		1/32	●	●	●	●	
	WNMG 431HQ 432HQ 433HQ	1/64	●	●	●	●	
		1/32	●	●	●	●	
Finishing-Medium / Up facing	WNMG 431HQ 432HQ 433HQ	1/64	●	●	●	●	
		1/32	●	●	●	●	
	WNMG 432CJ 433CJ	1/32	○	○	○	○	
		3/64	○	○	○	○	
Medium-Roughing	WNMG 432CS	1/32	●	●	●	●	
		1/32	●	●	●	●	
	WNMG 331GS 332GS	1/64	●	●	●	●	
		1/32	●	●	●	●	
	WNMG 431GS 432GS 433GS	1/64	●	●	●	●	
		1/32	●	●	●	●	
Medium-Roughing / High Feed	WNMG 431PS 432PS 433PS 434PS	1/64	●	●	●	●	
		1/32	●	●	●	●	
	WNMG 431HS 432HS 433HS	1/64	●	●	●	●	
		1/32	●	●	●	●	
Finishing-Medium / Up facing	WNMG 432PT 433PT	1/32	●	●	●	●	
		3/64	●	●	●	●	
	WNMG 432GT 433GT	1/32	●	●	●	●	
		3/64	●	●	●	●	
Roughing	WNMG 431 432 433	1/64	●	●	●	●	
		1/32	●	●	●	●	
	WNMG 431 432 433	1/64	●	●	●	●	
		3/64	●	●	●	●	

80° Trigon Negative with Hole

(in)

Description	A	T	ød
WN_325	3/8	5/32	0.150
WN_33_		3/16	
WN_43_	12.70	3/16	.203

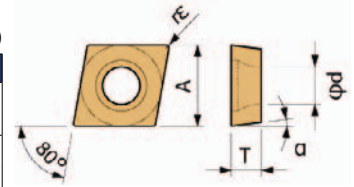



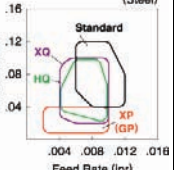







Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide			Applicable Chipbreaker Range
			rε	CA5505	CA5515	
 Roughing	WNMG 431C	1/64	○	○	○	 (Cast Iron) D.O.C. (inch) .08 .16 .24 .32 .40 Feed Rate (ipr) .008 .016 .024 .032 .04C
	432C	1/32	○	○	○	
	433C	3/64	○	○	○	
 Roughing	WNMG 432ZS	1/32	●	●	●	
	433ZS	3/64	●	●	●	
 Roughing	WNMG 432GC	1/32	○	○	○	
	433GC	3/64	○	○	○	
 Without Chipbreaker	WNMA 432	1/32	●	○	○	
	433	3/64	●	○	○	

80° Diamond Positive with Hole

(in)

Description	A	T	ød	α
CPMT2515_	5/16	3/32	0.130	11°
CPMT32_	3/8	1/8	0.173	
CP_251_	5/16	3/32	0.138	11°
CP_32_	3/8	1/8	0.177	

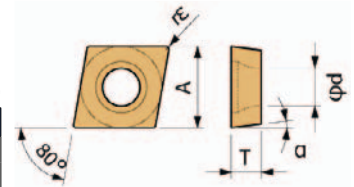







Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide			Applicable Chipbreaker Range
			rε	CA5505	CA5515	
 Finishing	CPMT 2515GP	1/64	●	●	○	 (Steel) D.O.C. (inch) .04 .08 .12 .16 Feed Rate (ipr) .004 .008 .012 .016
	CPMT 321GP	1/64	●	●	○	
 Finishing-Medium	322GP	1/32	●	●	○	
	CPMH 2515HQ	1/64	●	●	●	
 Finishing-Medium	25152HQ	1/32	●	●	●	
	CPMH 321HQ	1/64	●	●	●	
 Medium	322HQ	1/32	●	●	●	
	CPMH 25151	1/64	●	●	●	
 Medium	25152	1/32	●	●	●	
	CPMH 321	1/64	●	●	●	
 Soft Steel Finishing	322	1/32	●	●	●	
	CPMT 25151XP	1/64	●	●	○	
 Soft Steel Finishing	CPMT 321XP	1/64	●	●	○	
	322XP	1/32	●	●	○	
 Soft Steel Finishing-Medium	CPMT 321XQ	1/64	●	●	○	
	322XQ	1/32	●	●	○	

80° Diamond Positive with Hole

(in)

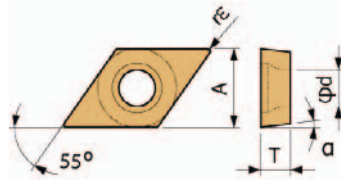
Description	A	T	ød	α
CC_1109_	0.138	0.055	0.075	7°
CC_1411_	0.169	0.071	0.091	



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide			Applicable Chipbreaker Range
			rε	CA5505	CA5515	
 Medium	CCMT 3252	1/32	●	●	●	(3/8\"/> D.O.C. (inch) .04 .08 .12 .16 Feed Rate (ipr)
 Finishing-Medium	CCMT 21505GK	0.008	●	●	●	
	2151GK	1/64	●	●	●	
	CCMT 32505GK	0.008	●	●	●	
	3251GK	1/64	●	●	●	
 Finishing-Medium	CCMT 431GK	1/64	●	●	●	
	432GK	1/32	●	●	●	
	433GK	3/64	●	●	●	
 Finishing-Medium	CCMT 21505HQ	0.008	●	●	●	
	2151HQ	1/64	●	●	●	
	CCMT 32505HQ	0.008	●	●	●	
	3251HQ	1/64	●	●	●	
 Finishing-Medium	3252HQ	1/32	●	●	●	

55° Diamond Positive with Hole

Description	A	T	ød	α
DC_215_	1/4	3/32	0.110	7°
DC_325_	3/8	5/32	0.173	7°

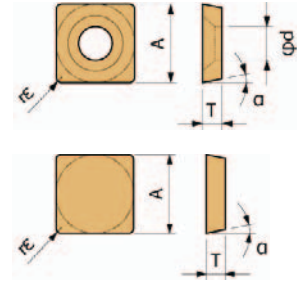


Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Finishing-Medium	DCMT 2150GK 2151GK 2152GK	0.008	●	●	●	●	
		1/64	●	●	●	●	
		1/32	●	●	●	●	
	DCMT 3250GK 3251GK 3252GK	0.008	●	●	●	●	
		1/64	●	●	●	●	
		1/32	●	●	●	●	
Low Carbon Steel	DCMT 2150HQ 2151HQ 2152HQ	0.008	●	●	●	●	
		1/64	●	●	●	●	
		1/32	●	●	●	●	
	DCMT 3250HQ 3251HQ 3252HQ	0.008	●	●	●	●	
		1/64	●	●	●	●	
		1/32	●	●	●	●	
Finishing-Medium	DCMT 3251XQ 3252XQ	1/64	●	●	●	●	
		1/32	●	●	●	●	

90° Square Positive with Hole

90° Square Positive without Hole

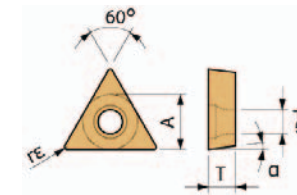
Description	A	T	ød	α
SC_325_	3/8	5/32	0.173	7°
SP_32_	3/8	1/8	-	11°
SP_42_	1/2	1/2	1/8	-



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Finishing-Medium	SCMT 3251HQ 3252HQ	1/64	●	●	●	●	
		1/32	●	●	●	●	
Medium	SPMR 321 322	1/64	●	●	●	●	
		1/32	●	●	●	●	
Cast Iron	SPM 421 422 423	1/64	●	●	●	●	
		1/32	●	●	●	●	
		3/64	●	●	●	●	

60° Triangle Positive with Hole

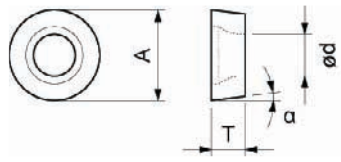
Description	A	T	ød	α
TC_121_	5/32	1/16	-	7°
TC_215_	1/4	3/32	0.110	7°
TC_325_	3/8	5/32	0.173	7°



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Finishing	TBMT 12105DP 1211DP	0.008	●	●	●	●	
		1/64	●	●	●	●	
Finishing-Medium	TCMT 2150HQ 2151HQ 2152HQ	0.008	●	●	●	●	
		1/64	●	●	●	●	
		1/32	●	●	●	●	
		3/64	●	●	●	●	
Finishing-Medium	TCMT 3251HQ 3252HQ 3253HQ	1/64	●	●	●	●	
		1/32	●	●	●	●	
		3/64	●	●	●	●	

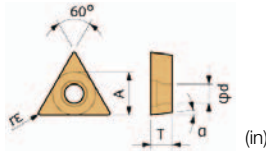
Round Positive with Hole

Description	A	T	ød	α
RC_1003_	0.394	1/8	0.142	7°
RC_1204_	0.472	3/16	0.165	



Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Medium	RCMX 1003M0 RCMX 1204M0	-	○	○	●	●	
		-	○	○	●	●	

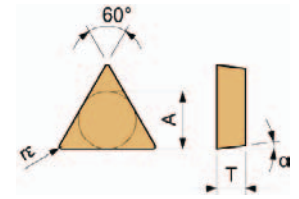
60° Triangle Positive with Hole



Description	A	T	ød	α
TP_1515_	3/16	3/32	0.095	11°
TPMT1815_	7/32		0.110	11°
TP_1815	7/32		0.118	11°
TP_215	1/4		0.138	11°

Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide			Applicable Chipbreaker Range	
			CA5505	CA5515	CA5525		CA5535
Finishing		1/64	●	●	●		
			TPMT 181505GP	●	●		●
			TPMT 18151GP	●	●		●
Finishing-Medium		1/64	●	●	●		
			TPMT 181505HQ	●	●		●
		TPMT 18151HQ	●	●	●		
		0.008	●	●	●		
			TPMT 2205HQ	●	●		●
		1/64	●	●	●		
TPMT 3205HQ	●		●	●			
Low-Carbon Steel		1/64	●	●	●		
			TPMT 18151XP	●	●		●
		1/64	●	●	●		
			TPMT 221HQ	●	●		●
		1/32	●	●	●		
			TPMT 222HQ	●	●		●
		1/64	●	●	●		
			TPMT 321XP	●	●		●
		1/32	●	●	●		
			TPMT 322XP	●	●		●
Finishing-Medium		1/64	●	●	●		
			TPMT 221XQ	●	●		●
		1/32	●	●	●		
			TPMT 222XQ	●	●		●
1/64	●	●	●				
	TPMT 321XQ	●	●	●			
1/32	●	●	●				
	TPMT 322XQ	●	●	●			

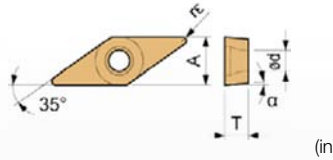
60° Triangle Positive without Hole



Description	A	T	ød	α
TP_1815_	7/32	3/32	-	11°
TP_22_	1/4	1/8	-	11°
TP_32_	3/8		-	11°

Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide			Applicable Chipbreaker Range
			CA5505	CA5515	CA5525	
Finishing		1/64	●	●	●	
Finishing-Medium		1/64	●	●	●	
		TPMR 221HQ	●	●	●	
1/32	TPMR 222HQ	●	●	●		
		TPMR 321HQ	●	●		●
1/32	TPMR 322HQ	●	●	●		
		TPMR 181505G	●	●	●	
Medium		1/64	○	●	●	
			TPMR 221	○	●	
		1/32	○	●	●	
			TPMR 222	○	●	
		1/64	○	●	●	
			TPMR 321	○	●	
1/32	○	●	●			
	TPMR 322	○	●	●		
1/64	TPM 221	●	●	●		
		TPM 222	●	●		●
1/32	TPM 321	●	●	●		
		TPM 322	●	●	●	

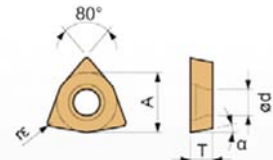
35° Diamond Positive with Hole



Description	A	T	ød	α
VB_22_	1/4	1/8	0.110	5°
VB_33_	3/8	3/16	0.173	5°

Description	A	T	ød	α
VC_1515_	3/16	3/32	0.091	7°
VC_33_	3/8	3/16	0.173	7°

80° Trigon Positive with Hole

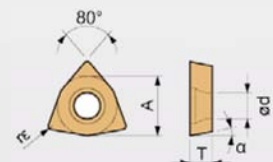


Description	A	T	ød	α
WB_121_	5/32	1/16	0.091	5°
WB_151_	3/16	3/32		5°

Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Finishing	VBMT 221GP	1/64		●	●		
	VBMT 331GP	1/64		●	●		
	332GP	1/32					
	VBMT 2205VF	0.008	○	○	○		
Finishing-Medium	221VF	1/64		●			
	222VF	1/32					
	VBMT 3305VF	0.008	○	○	○		
	331VF	1/64	○	○	○		
Finishing-Medium	332VF	1/32	●	●			
	333VF	3/64		●			
	VBMT 221HQ	1/64		●	●	●	
	222HQ	1/32		●	●	●	
Finishing	VBMT 331HQ	1/64		●	●	●	
	332HQ	1/32		●	●	●	
	333HQ	3/64		●	●	●	
	VCMT 151505VF	0.008	○	○	○		
Finishing-Medium	15151VF	1/64	○	○	○		
	VCMT 151505HQ	0.008	●	●	●		
	15151HQ	1/64	●	●	●		
	VCMT 221HQ	1/64		○	○		
Finishing-Medium	VCMT 331HQ	1/64			○		
	332HQ	1/32			●		

Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Finishing	WBMT 12105%L-DP	0.008		●	●		
	1211%L-DP	1/64		●	●		
	WBMT 151505%L-DP	0.008		●	●		
	15151%L-DP	1/64		●	●		

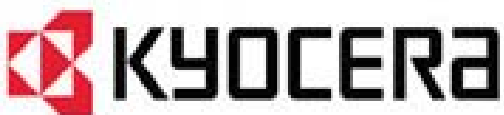
80° Trigon Positive with Hole



Description	A	T	ød	α
WP_215_	1/4	3/32	0.110	11°
WP_1603_	3/8	1/8	0.173	11°

Insert	Description (ANSI)	Dim. (in)	CVD Coated Carbide				Applicable Chipbreaker Range
			rε	CA5505	CA5515	CA5525	
Finishing	WPMT 2151GP	1/64		●	●		
	WPMT 321GP	1/64		●	●		
Finishing-Medium	WPMT 21505HQ	0.008		●	●		
	2151HQ	1/64		●	●		
	WPMT 321HQ	1/64		●	●	●	
Finishing-Medium	322HQ	1/32		●	●	●	

● : Stock Standard | ○ : World Express



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