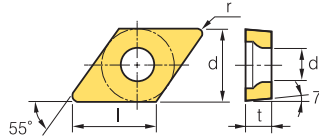


# DC

Rhombic **55° Positive**  
Relief Angle: 7°



| Dimensions (mm) |       |      |                |
|-----------------|-------|------|----------------|
| Size            | d     | t    | d <sub>1</sub> |
| 07              | 6.35  | 2.38 | 2.8            |
| 11              | 9.525 | 3.97 | 4.4            |

| Workpiece                            | Machining types |   |   |   |   |   |   |   |   |   |   |   |
|--------------------------------------|-----------------|---|---|---|---|---|---|---|---|---|---|---|
|                                      | P               | M | K | N | S | H |   |   |   |   |   |   |
| Steel                                | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Stainless steel                      | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Cast iron                            | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Non-ferrous metal                    | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Heat resistant alloy, Titanium alloy | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Hardened steel                       | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |

● Continuous cutting  
 ● General cutting  
 ✱ Interrupted cutting

| Inserts                                     | Designation  | Cermet        |        | Coated |        | Coated |        |        |        |        |        |        |        |        |        | Uncoated |        | Cutting Condition |        |        |        |        |     |     |                            |                        |           |           |           |           |
|---|--------------|---------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|----------|--------|-------------------|--------|--------|--------|--------|-----|-----|----------------------------|------------------------|-----------|-----------|-----------|-----------|
|   |              | CN1500        | CN2000 | CN2500 | CC1500 | CC2500 | NC3215 | NC3120 | NC3225 | NC3030 | NC5330 | NC6310 | NC6315 | NC9115 | NC9125 | NC9135   | PC5300 | PC5400            | PC8105 | PC8110 | PC8115 | PC9030 | H01 | H05 | f <sub>n</sub><br>(mm/rev) | a <sub>p</sub><br>(mm) |           |           |           |           |
| Finishing<br><br>[High precision]           | <b>DCET</b>  | 0702005MFR-KF |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            | 0.01~0.06              | 0.04~1.30 |           |           |           |
|   |              | 070201MFR-KF  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.02~0.08 | 0.05~1.50 |           |           |
|   |              | 070202MFR-KF  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.03~0.11 | 0.06~1.70 |           |           |
|   |              | 11T3005MFR-KF |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.02~0.08 | 0.05~1.50 |           |           |
|   |              | 11T301MFR-KF  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.03~0.11 | 0.06~1.70 |           |           |
|   |              | 11T302MFR-KF  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.04~0.15 | 0.08~2.00 |           |           |
|   |              | 0702005MFL-KF |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.01~0.06 | 0.04~1.30 |           |           |
|   |              | 070201MFL-KF  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        |           | 0.02~0.08 | 0.05~1.50 |           |
|   |              | 070202MFL-KF  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        |           | 0.03~0.11 | 0.06~1.70 |           |
|   |              | 11T3005MFL-KF |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        |           | 0.02~0.08 | 0.05~1.50 |           |
|   |              | 11T301MFL-KF  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        |           | 0.03~0.11 | 0.06~1.70 |           |
|   | 11T302MFL-KF |               |        |        |        |        |        |        |        |        |        |        |        |        | ●      |          |        |                   | ●      |        |        |        |     |     |                            |                        | 0.04~0.15 | 0.08~2.00 |           |           |
| Medium to finishing<br><br>[High precision] | <b>DCET</b>  | 0702005MFR-KM |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            | 0.01~0.06              | 0.04~1.30 |           |           |           |
|   |              | 070201MFR-KM  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.02~0.08 | 0.05~1.50 |           |           |
|   |              | 070202MFR-KM  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.03~0.11 | 0.06~1.70 |           |           |
|   |              | 11T3005MFR-KM |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.02~0.08 | 0.05~1.50 |           |           |
|   |              | 11T301MFR-KM  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.03~0.11 | 0.06~1.70 |           |           |
|   |              | 11T302MFR-KM  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.04~0.15 | 0.08~2.00 |           |           |
|   |              | 0702005MFL-KM |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        | 0.01~0.06 | 0.04~1.30 |           |           |
|   |              | 070201MFL-KM  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        |           | 0.02~0.08 | 0.05~1.50 |           |
|   |              | 070202MFL-KM  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        |           | 0.03~0.11 | 0.06~1.70 |           |
|   |              | 11T3005MFL-KM |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        |           | 0.02~0.08 | 0.05~1.50 |           |
|   |              | 11T301MFL-KM  |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   |        | ●      |        |        |     |     |                            |                        |           | 0.03~0.11 | 0.06~1.70 |           |
|   | 11T302MFL-KM |               |        |        |        |        |        |        |        |        |        |        |        |        | ●      |          |        |                   | ●      |        |        |        |     |     |                            |                        | 0.04~0.15 | 0.08~2.00 |           |           |
| Finishing<br>                               | <b>DCGT</b>  | 0702003R-KF   |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        | 0.01~0.06 | 0.04~1.30 |           |           |
|   |              | 070201R-KF    |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           | 0.02~0.08 | 0.05~1.50 |           |
|   |              | 070202R-KF    |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           | 0.03~0.11 | 0.06~1.50 |           |
|   |              | 11T3003R-KF   |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           | 0.02~0.08 | 0.05~1.50 |           |
|   |              | 11T301R-KF    |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           | 0.03~0.11 | 0.06~1.70 |           |
|   |              | 11T302R-KF    |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        | ●   |     |                            |                        |           | 0.04~0.15 | 0.08~2.00 |           |
|   |              | 0702003L-KF   |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           | 0.01~0.06 | 0.04~1.30 |           |
|   |              | 070201L-KF    |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           |           | 0.02~0.08 | 0.05~1.50 |
|   |              | 070202L-KF    |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           |           | 0.03~0.11 | 0.06~1.50 |
|   |              | 11T3003L-KF   |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           |           | 0.02~0.08 | 0.05~1.50 |
|   |              | 11T301L-KF    |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           |           | 0.03~0.11 | 0.06~1.70 |
|   | 11T302L-KF   |               |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |     |                            |                        |           | 0.04~0.15 | 0.08~2.00 |           |

Cutting edge geometry **A52~A61**  
 Recommended chip breaker **B04~B11**  
 Code system **B26~B27**  
 ● : Stock item

| Available tool holders |           |             |      |
|------------------------|-----------|-------------|------|
| Designation            | Page      | Designation | Page |
| SDACR/L                | B178      | SDQCR/L     | B206 |
| SDJCR/L                | B113, 179 | SDUCR/L     | B207 |
| SDNCN                  | B114, 179 | SDZCR/L     | B208 |

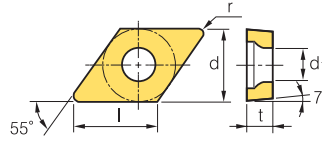


# B Turning Insert (Positive)

## DC



**Rhombic 55° Positive**  
Relief Angle: 7°



| Dimensions (mm) |       |      |                |
|-----------------|-------|------|----------------|
| Size            | d     | t    | d <sub>1</sub> |
| 07              | 6.35  | 2.38 | 2.8            |
| 11              | 9.525 | 3.97 | 4.4            |

| Workpiece                            | Machining types |   |   |   |   |   |   |   |   |   |   |   |
|--------------------------------------|-----------------|---|---|---|---|---|---|---|---|---|---|---|
|                                      | P               | M | K | N | S | H |   |   |   |   |   |   |
| Steel                                | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Stainless steel                      | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Cast iron                            | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Non-ferrous metal                    | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Heat resistant alloy, Titanium alloy | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| Hardened steel                       | ●               | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |

| Inserts                           | Designation               | Cermets |        | Coated |        | Coated |        |        |        |        |        |        |        |        |        | Uncoated |        | Cutting Condition |        |        |        |        |     |           |                            |                        |           |
|-----------------------------------|---------------------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|----------|--------|-------------------|--------|--------|--------|--------|-----|-----------|----------------------------|------------------------|-----------|
|                                   |                           | CN1500  | CN2000 | CN2500 | CC1500 | CC2500 | NC3215 | NC3120 | NC3225 | NC3030 | NC5330 | NC6310 | NC6315 | NC9115 | NC9125 | NC9135   | PC5300 | PC5400            | PC8105 | PC8110 | PC8115 | PC9030 | H01 | H05       | f <sub>n</sub><br>(mm/rev) | a <sub>p</sub><br>(mm) |           |
| Finishing<br>                     | <b>DCGT</b> 070201-VP1    |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        | ●                 | ●      | ●      |        | ●      |     | 0.03-0.06 | 0.06-1.00                  |                        |           |
|                                   | 070202-VP1                |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        | ●                 | ●      | ●      |        | ●      |     | 0.03-0.10 | 0.08-1.50                  |                        |           |
|                                   | 070204-VP1                |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        | ●                 | ●      | ●      |        | ●      |     | 0.05-0.12 | 0.10-1.50                  |                        |           |
|                                   | 11T301-VP1                |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   | ●      |        |        |        | ●   |           | 0.03-0.13                  | 0.06-1.00              |           |
|                                   | 11T302-VP1                |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        | ●                 | ●      | ●      |        | ●      |     | 0.04-0.15 | 0.08-1.50                  |                        |           |
|                                   | 11T304-VP1                |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        | ●                 | ●      | ●      |        | ●      |     | 0.06-0.20 | 0.10-1.50                  |                        |           |
| Finishing<br><br>[High precision] | <b>DCGT</b> 070201MFN-VP1 |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   | ●      |        |        |        |     | 0.03-0.06 | 0.06-1.00                  |                        |           |
|                                   | 070202MFN-VP1             |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   | ●      |        |        |        |     | 0.03-0.10 | 0.08-1.50                  |                        |           |
|                                   | 070204MFN-VP1             |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   | ●      |        |        |        |     | 0.05-0.12 | 0.10-1.50                  |                        |           |
|                                   | 11T301MFN-VP1             |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   | ●      |        |        |        |     | 0.03-0.13 | 0.06-1.00                  |                        |           |
|                                   | 11T302MFN-VP1             |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        | ●                 | ●      |        |        |        |     | 0.04-0.15 | 0.08-1.50                  |                        |           |
|                                   | 11T304MFN-VP1             |         |        |        |        |        |        |        |        |        |        |        |        |        |        | ●        |        | ●                 | ●      |        |        |        |     | 0.06-0.20 | 0.10-1.50                  |                        |           |
| Medium to finishing<br>           | <b>DCGT</b> 0702003R-KM   |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     | 0.01-0.06 | 0.04-1.30                  |                        |           |
|                                   | 070201R-KM                |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           | 0.02-0.08                  | 0.05-1.50              |           |
|                                   | 070202R-KM                |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           | 0.03-0.11                  | 0.06-1.50              |           |
|                                   | 11T3003R-KM               |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           | 0.02-0.08                  | 0.05-1.50              |           |
|                                   | 11T301R-KM                |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           | 0.03-0.11                  | 0.06-1.70              |           |
|                                   | 11T302R-KM                |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           | 0.04-0.15                  | 0.08-2.00              |           |
|                                   | 0702003L-KM               |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           | 0.01-0.06                  | 0.04-1.30              |           |
|                                   | 070201L-KM                |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           |                            | 0.02-0.08              | 0.05-1.50 |
|                                   | 070202L-KM                |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           |                            | 0.03-0.11              | 0.06-1.50 |
|                                   | 11T3003L-KM               |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           |                            | 0.02-0.08              | 0.05-1.50 |
|                                   | 11T301L-KM                |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           |                            | 0.03-0.11              | 0.06-1.70 |
|                                   | 11T302L-KM                |         |        |        |        |        |        |        |        |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           |                            | 0.04-0.15              | 0.08-2.00 |
| Finishing<br><br>[High precision] | <b>DCMT</b> 070202-VF     |         |        | ●      |        |        |        |        | ●      |        |        |        |        |        |        |          |        |                   | ●      |        |        |        |     | 0.03-0.10 | 0.06-1.00                  |                        |           |
|                                   | 070204-VF                 |         | ●      | ●      |        |        |        |        | ●      |        |        |        |        |        |        | ●        |        |                   | ●      |        |        |        |     |           | 0.05-0.20                  | 0.30-1.20              |           |
|                                   | 11T302-VF                 |         | ●      |        |        |        |        |        | ●      |        |        |        |        |        |        |          |        |                   |        |        |        |        |     |           | 0.04-0.15                  | 0.08-1.50              |           |
|                                   | 11T304-VF                 |         | ●      | ●      | ●      |        |        |        | ●      |        |        |        |        |        |        | ●        |        |                   | ●      |        |        |        |     |           | 0.05-0.20                  | 0.30-1.50              |           |
|                                   | 11T308-VF                 |         | ●      | ●      |        |        |        |        |        |        |        |        |        |        |        | ●        |        |                   | ●      |        |        |        |     |           | 0.10-0.25                  | 0.30-1.50              |           |

➤ Cutting edge geometry A52~A61
➤ Recommended chip breaker B04~B11
➤ Code system B26~B27
● : Stock item

| Available tool holders |           |             |      |
|------------------------|-----------|-------------|------|
| Designation            | Page      | Designation | Page |
| SDACR/L                | B178      | SDQCR/L     | B206 |
| SDJCR/L                | B113, 179 | SDUCR/L     | B207 |
| SDNCN                  | B114, 179 | SDZCR/L     | B208 |

