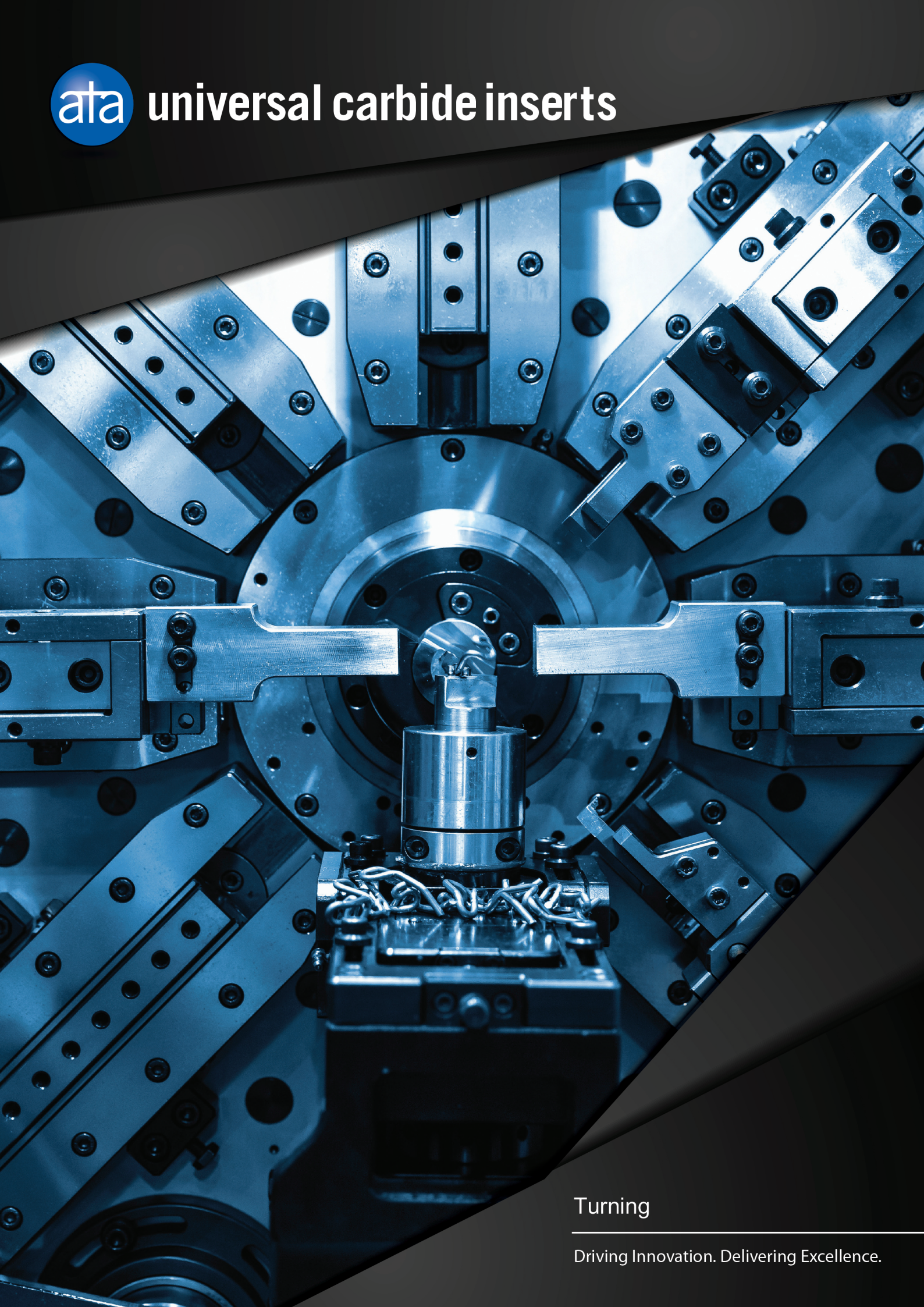
universal carbide inserts



Turning

Driving Innovation. Delivering Excellence.

Universal Carbide Inserts

High Performance for all your Turning Applications

Covering a wide range of materials, our turning carbide inserts are the perfect match for all applications. Thanks to our **UNIVERSAL CARBIDE** grades and specific geometries, the new ATA Carbide Inserts will fulfill all turning requirements while significantly reducing production downtime and improving production costs!

ATA is committed to supporting your efforts to improve **productivity and reduce costs** by providing **the highest quality and truly innovative products** to suit your requirements. Thanks to our team of technical experts, ATA is here to help you to:

- Optimize tool selection for the application;
- Reduce carbide inserts inventory by 50%;
- Reduce machining downtime by up to 40%.



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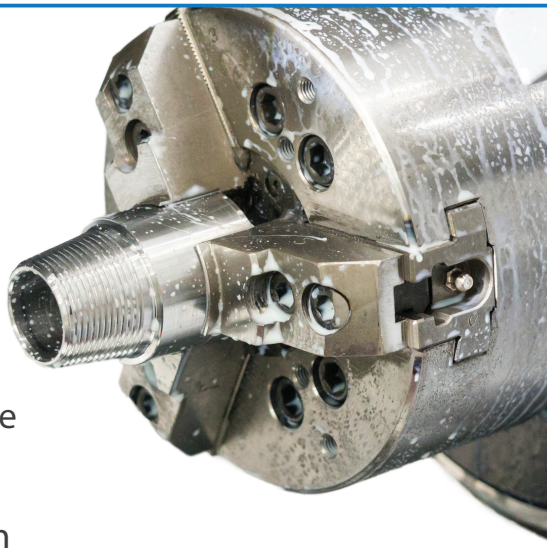
CARBIDE INSERTS

Product Benefits



- Unique carbide grade to achieve the highest tool performance on the majority of workpiece materials;
- Specific geometry to allow for optimal chip control while achieving excellent surface finish;
- Superior tool life and consistent quality thanks to best in class manufacturing processes;
- Focused range that cover 80% of all turning applications, reducing changeover times;
- Reduced inventory requirements thanks to product versatility.

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PRODUCT OVERVIEW

Grade & Coating Technology

Cast Iron / Hard Steels K

AT101

Substrate specifically designed for highest wear resistance. Thick Aluminum Oxide coating ensures improved wear resistance at high cutting speeds including dry machining.

Low-Mild Steels / Stainless / High-Temps P M S H

AT201

Recommended for mild steel, stainless steel and boring applications – can be used for higher carbon steels (hard steels) and cast iron.

Substrate and special CVD/ PVD coating for excellent wear resistance.



CARBIDE INSERTS

Cutting Speed

1	2	3	4	5	6	7	8	9
C	C	M	T	12	04	08	-AG	AT201
Shape	Clearance	Tolerance	Clamping / Chipbreaker	Insert Size	Insert Thickness	Corner Radius	Chipbreaker Geometry	Grade

1 SHAPE

Symbol	Shape
A	parallelogram 85°
B	parallelogram 82°
C	diamond 80°
D	diamond 55°
E	diamond 75°
H	hexagon
K	diamond 55°
L	rectangle
M	diamond 86°
O	octagon
P	pentagon
R	round
S	square
T	triangle
V	diamond 35°
W	trigon 80°

2 CLEARANCE

Symbol	Shape
N	No relief angle
C	Relief 7°
P	Relief 11°
D	Relief 15°
E	Relief 20°
F	Relief 25°
O	Special

3 TOLERANCE

Symbol	Inner Circle IC (mm)	Nose Height M (mm)	Thickness S (mm)
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
K	±0.05-0.15	±0.013	±0.025
M	±0.05-0.15	±0.08-0.2	±0.13
U	±0.08-0.25	±0.13-0.38	±0.13

4 CLAMPING / CHIPBREAKER

Symbol	Clamping	Chipbreaker
N	No Clamping Hole	X
R		One Face
A	Cylindrical Clamping Hole	X
M		One Face
G		Both Faces
W	Screw Hole	X
T		One Face
U		Both Faces
X		Special

5 INSERT SIZE

Metric							Inner Circle IC (mm)	Inch
S	T	C	D	V	W	R		
06	11	06	07	11			6.35	2
07							7.94	2.5
09	16	09	11	16	06	09 (00)	9.525	3
12	22	12	15	22	08	12 (00)	12.7	4
15		16					15.875	5
		19					19.05	6
						06 (00)	6	
						08 (00)	8	
						10 (00)	10	
						12 (00)	12	
						16 (00)	16	

6 INSERT THICKNESS

Metric	Thickness - S (mm)	Inch
T1	1.98	1.2
3.18	2.38	1.5
03	3.18	2
T3	3.97	2.5
04	4.76	3
05	5.56	3.5
06	6.35	4
07	7.94	5

7 CORNER RADIUS

Metric	Corner Radius - S (mm)	Inch
01	0.1	0
02	0.2	0.5
04	0.4	1
08	0.8	2
12	1.2	3
16	1.6	4
20	2.0	5
24	2.4	6

8 CHIP BREAKER - GEOMETRY

CARBIDE INSERTS
ATA GEOMETRIES

Negative cutting edge geometry: ß = 90°
- Stable cutting edge – suited for an interrupted cut
- Twice the number of cutting edges compared to positive geometries
- Increased cutting forces and power consumption
- Strong compression of chips

Positive cutting edge geometry: ß < 90°
- Low cutting force
- Low tendency to vibration
- Easy chip evacuation
- Weakening of the cutting edge
- Risk of breakage

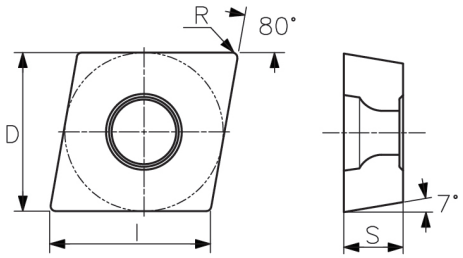
	Geometry	Application	Feed Rate	Depth of Cut
			Fn	Ap
NEGATIVE	AF	Finishing	0.05~0.2 mm/rev	0.5~1.5 mm
			.002~.008 in/rev	.02~.06 in
	AL	Semi Finishing	0.05~0.3 mm/rev	1~3 mm
			.002~.012 in/rev	.04~.12 in
	AG	Medium	0.25~0.4 mm/rev	1.5~4 mm
			.010~.016 in/rev	.06~.16 in
	AC	Medium Roughing & Cast Iron	0.25~0.5 mm/rev	1.5~4 mm
			.010~.020 in/rev	.06~.16 in
	AR	Roughing	0.3~0.6 mm/rev	2~6 mm
			.012~.024 in/rev	.08~.24
POSITIVE	AF	Finishing	0.05~0.2 mm/rev	0.5~1.5 mm
			.002~.008 in/rev	.02~.06 in
	AG	Medium	0.15~0.3 mm/rev	1~3 mm
			.006~.012 in/rev	.04~.12 in
CHIPBREAKER	AP	Sharp Chipbreaker	0.04~0.18 mm/rev	
		Sticky materials	.002~.007 in/rev	
		Stainless Steel & Super Alloys		
	AN	General Chipbreaker	0.06~0.25 mm/rev	
		General Steel and Cast Irons	.002~.010 in/rev	

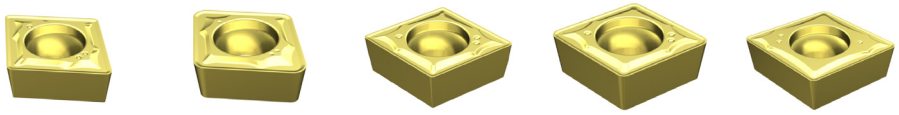
8 GRADE

	ISO 513	P			M		K		N	S	H
	Materials group	Non Alloy Steel	Low Alloy Steel	High Alloy Steel	Ferritic & Martensitic	Austenitic Stainless Steel	Grey Cast Iron	Nodular Cast Iron	Aluminum	Heat Resistant Super Alloy	Hardened Material
	METRIC - Vc (m/min)										
AT101	Minimum	220	220	-	-	-	170	120	-	-	-
	Maximum	480	420	-	-	-	420	410	-	-	-
AT201	Minimum	120	70	70	60	60	60	60	-	35	40
	Maximum	250	230	180	180	150	160	120	-	60	80

Universal Carbide Turning Insert - Turning

CCMT





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
CCMT	AF	AT201	PVD Grade	CCMT060204-AF-AT201	6.5	6.35	2.38	0.4	•	•	o	•	•	o	90000
CCMT	AG	AT201	PVD Grade	CCMT060208-AG-AT201	6.5	6.35	2.38	0.8	•	•	o	•	•	o	90001
CCMT	AF	AT201	PVD Grade	CCMT09T304-AF-AT201	9.7	9.53	3.97	0.4	•	•	o	•	•	o	90002
CCMT	AG	AT201	PVD Grade	CCMT09T308-AG-AT201	9.7	9.53	3.97	0.8	•	•	o	•	•	o	90003
CCMT	AG	AT201	PVD Grade	CCMT120408-AG-AT201	12.9	12.7	4.76	0.8	•	•	o	•	•	o	90004

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
CCMT060204-AF-AT201	90000	0.04	0.2	0.12	0.5	2.1	1.30
CCMT060208-AG-AT201	90001	0.04	0.2	0.12	0.8	2.1	1.45
CCMT09T304-AF-AT201	90002	0.05	0.23	0.14	0.5	3	1.75
CCMT09T308-AG-AT201	90003	0.11	0.5	0.31	0.8	4	2.40
CCMT120408-AG-AT201	90004	0.11	0.5	0.31	0.8	5	2.90

3. Check the cutting speed to ensure optimum performance.

Please refer to page 4 to check the cutting speed.

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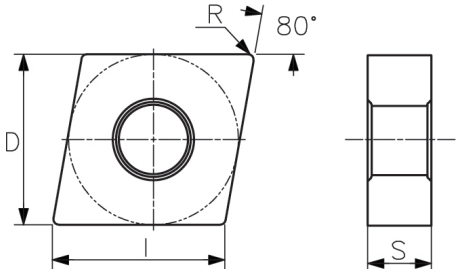
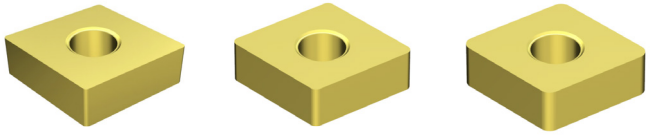
Universal Carbide Turning Insert - Turning

CNMA





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
CNMA	AA	AT101	CVD Grade	CNMA120404-AT101	12.9	12.7	4.76	0.8			•				90005
CNMA	AA	AT101	CVD Grade	CNMA120408-AT101	12.9	12.7	4.76	0.8			•				90006
CNMA	AA	AT101	CVD Grade	CNMA120412-AT101	12.9	12.7	4.76	1.2			•				90007

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
CNMA431-AT101	90005	0.2	0.8	0.50	0.8	6	3.40
CNMA432-AT101	90006	0.2	0.8	0.50	0.8	6	3.40
CNMA433-AT101	90007	0.2	0.7	0.45	1.2	6	3.60

3. Check the cutting speed to ensure optimum performance.

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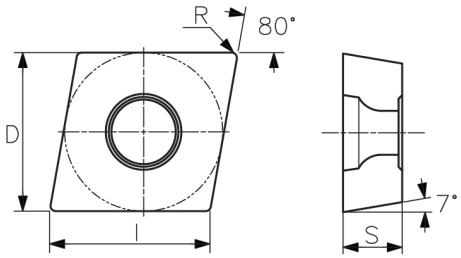
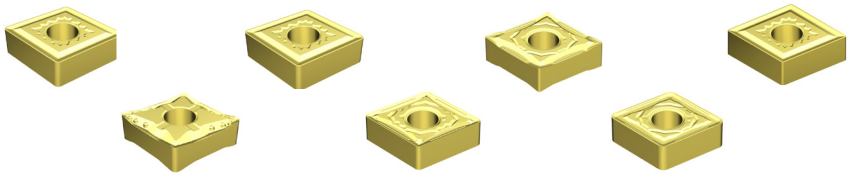
CNMG





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
CNMG	AC	AT101	CVD Grade	CNMG120404-AC-AT101	12.9	12.7	4.76	0.4			•			•	90008
CNMG	AF	AT201	PVD Grade	CNMG120404-AF-AT201	12.9	12.7	4.76	0.4	•	•	o	•	•	o	90009
CNMG	AC	AT101	CVD Grade	CNMG120408-AC-AT101	12.9	12.7	4.76	0.8			•			•	90010
CNMG	AG	AT201	PVD Grade	CNMG120408-AG-AT201	12.9	12.7	4.76	0.8	•	•	o	•	•	o	90011
CNMG	AL	AT201	PVD Grade	CNMG120408-AL-AT201	12.9	12.7	4.76	0.8	•	•	o	•	•	o	90012
CNMG	AC	AT101	CVD Grade	CNMG120412-AC-AT101	12.9	12.7	4.76	1.2			•			•	90013
CNMG	AR	AT201	PVD Grade	CNMG120412-AR-AT201	12.9	12.7	4.76	1.2	•	•	o	•	•	o	90014

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
CNMG120404-AC-AT101	90008	0.11	0.5	0.31	0.5	5	2.75
CNMG120404-AF-AT201	90009	0.05	0.23	0.14	0.5	3	1.75
CNMG120408-AC-AT101	90010	0.11	0.5	0.31	0.8	6	3.40
CNMG120408-AG-AT201	90011	0.11	0.5	0.31	0.8	5	2.90
CNMG120408-AL-AT201	90012	0.05	0.23	0.14	0.8	3	1.90
CNMG120412-AC-AT101	90013	0.14	0.68	0.41	1.2	6	3.60
CNMG120412-AR-AT201	90014	0.14	0.68	0.41	1.2	6	3.60

3. Check the cutting speed to ensure optimum performance.

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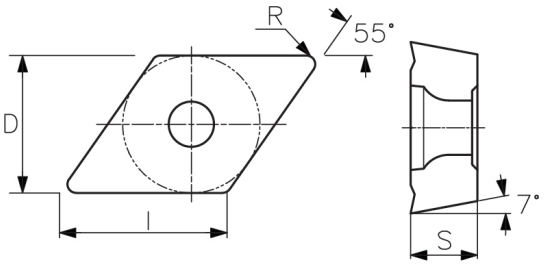
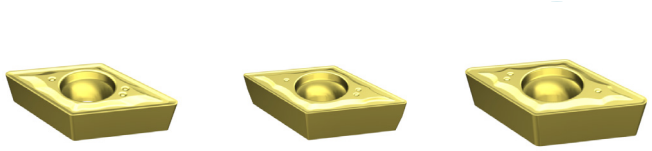
DCMT





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
DCMT	AF	AT201	PVD Grade	DCMT070204-AF-AT201	7.8	6.35	2.38	0.4	●	●	o	●	●	o	90015
DCMT	AF	AT201	PVD Grade	DCMT11T304-AF-AT201	11.6	9.53	3.97	0.4	●	●	o	●	●	o	90016
DCMT	AG	AT201	PVD Grade	DCMT11T308-AG-AT201	11.6	9.53	3.97	0.8	●	●	o	●	●	o	90017

● Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
DCMT070204-AF-AT201	90015	0.04	0.2	0.12	0.5	2.1	1.30
DCMT11T304-AF-AT201	90016	0.05	0.23	0.14	0.5	3	1.75
DCMT11T308-AG-AT201	90017	0.11	0.5	0.31	0.8	4	2.40

3. Check the cutting speed to ensure optimum performance.

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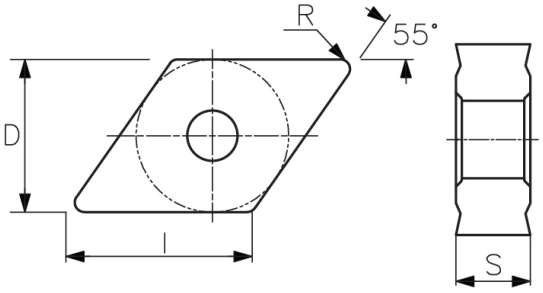
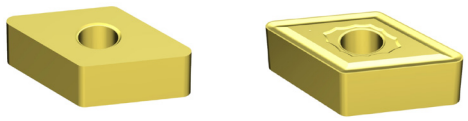
DNMA





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
DNMA	AA	AT101	CVD Grade	DNMA150608-AT101	15.5	12.7	6.35	0.8			•				90018
DNMA	AA	AT101	CVD Grade	DNMA150612-AT101	15.5	12.7	6.35	1.2			•				90019

• Recommended O Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
DNMA150608-AT101	90018	0.11	0.5	0.31	0.8	5	2.90
DNMA150612-AT101	90019	0.11	0.5	0.31	1.2	6	3.60

3. Check the cutting speed to ensure optimum performance.

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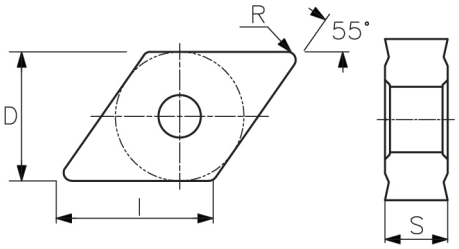
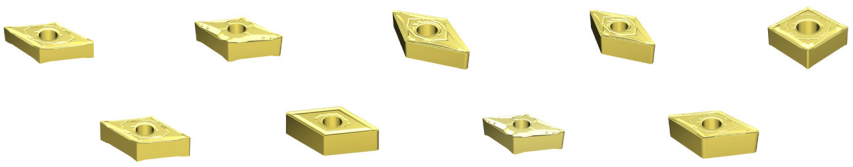
DNMG





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
DNMG	AF	AT201	PVD Grade	DNMG150404-AF-AT201	12.9	12.7	4.76	0.4	•	•	o	•	•	o	90020
DNMG	AG	AT201	PVD Grade	DNMG150408-AG-AT201	12.9	12.7	4.76	0.8	•	•	o	•	•	o	90021
DNMG	AL	AT201	PVD Grade	DNMG150408-AL-AT201	12.9	12.7	4.76	0.8	•	•	o	•	•	o	90022
DNMG	AF	AT201	PVD Grade	DNMG150604-AF-AT201	12.9	12.7	6.35	0.8	•	•	o	•	•	o	90023
DNMG	AC	AT101	CVD Grade	DNMG150608-AC-AT101	12.9	12.7	6.35	0.8			•			•	90024
DNMG	AG	AT201	PVD Grade	DNMG150608-AG-AT201	12.9	12.7	6.35	0.8	•	•	o	•	•	o	90025
DNMG	AL	AT201	PVD Grade	DNMG150608-AL-AT201	12.9	12.7	6.35	0.8	•	•	o	•	•	o	90026
DNMG	AC	AT101	CVD Grade	DNMG150612-AC-AT101	12.9	12.7	6.35	1.2			•			•	90027
DNMG	AR	AT201	PVD Grade	DNMG150612-AR-AT201	12.9	12.7	6.35	1.2	•	•	o	•	•	o	90028

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
DNMG150404-AF-AT201	90020	0.05	0.23	0.14	0.5	3	1.75
DNMG150408-AG-AT201	90021	0.11	0.5	0.31	0.8	5	2.90
DNMG150408-AL-AT201	90022	0.11	0.5	0.31	0.8	5	2.90
DNMG150604-AF-AT201	90023	0.05	0.23	0.14	0.5	3	1.75
DNMG150608-AC-AT101	90024	0.11	0.5	0.31	0.8	5	2.90
DNMG150608-AG-AT201	90025	0.11	0.5	0.31	0.8	5	2.90
DNMG150608-AL-AT201	90026	0.11	0.5	0.31	0.8	5	2.90
DNMG150612-AC-AT101	90027	0.11	0.5	0.31	1.2	6	3.60
DNMG150612-AR-AT201	90028	0.14	0.68	0.41	1.2	6	3.60

3. Check the cutting speed to ensure optimum performance.

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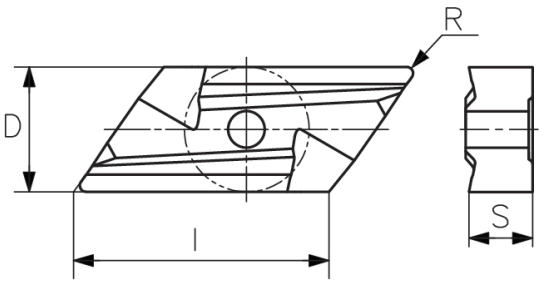
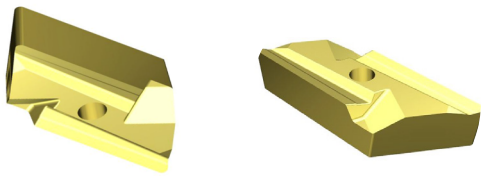
KNUX





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
KNUX	AX	AT201	PVD Grade	KNUX160405L-AT201	16	9.53	4.76	0.5	●	●	○	●	●	○	90029
KNUX	AX	AT201	PVD Grade	KNUX160405R-AT201	16	9.53	4.76	0.5	●	●	○	●	●	○	90030

● Recommended ○ Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
KNUX160405L-AT201	90029	0.05	0.23	0.14	0.5	5	2.75
KNUX160405R-AT201	90030	0.05	0.23	0.14	0.5	5	2.75

3. Check the cutting speed to ensure optimum performance.

Please refer to page 4 to check the cutting speed.

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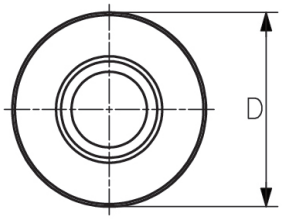
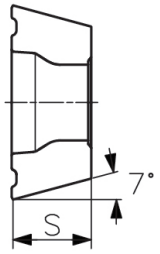
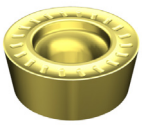
RCMT













1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
RCMT	General	AT201	PVD Grade	RCMT0602M0-AT201	-	6	2.38	-	•	•	o	•	•	o	90031
RCMT	General	AT201	PVD Grade	RCMT0803M0-AT201	-	8	3.18	-	•	•	o	•	•	o	90032
RCMT	General	AT201	PVD Grade	RCMT10T3M0-AT201	-	10	3.97	-	•	•	o	•	•	o	90033
RCMT	General	AT201	PVD Grade	RCMT1204M0-AT201	-	12	4.76	-	•	•	o	•	•	o	90034

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
RCMT0602M0-AT201	90031	0.05	0.4	0.23	0.3	3	1.65
RCMT0803M0-AT201	90032	0.05	0.4	0.23	0.3	4	2.15
RCMT10T3M0-AT201	90033	0.05	0.4	0.23	0.3	5	2.65
RCMT1204M0-AT201	90034	0.05	0.4	0.23	0.5	6	3.25

3. Check the cutting speed to ensure optimum performance.

Please refer to page 4 to check the cutting speed.

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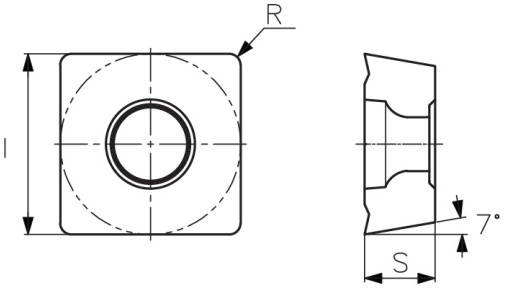
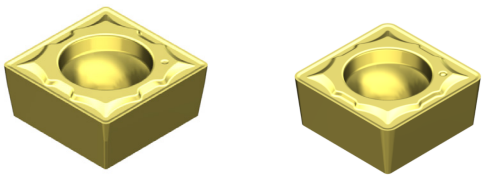
SCMT





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	I	D	s	r	P	M	K	N	S	H	ATA EDP No.
SCMT	AF	AT201	PVD Grade	SCMT09T304-AF-AT201	9.53	9.53	3.97	0.4	•	•	o	•	•	o	90035
SCMT	AG	AT201	PVD Grade	SCMT09T308-AG-AT201	9.53	9.53	3.97	0.8	•	•	o	•	•	o	90036

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
SCMT09T304-AF-AT201	90035	0.05	0.26	0.16	0.5	3	1.75
SCMT09T308-AG-AT201	90036	0.11	0.5	0.31	0.8	3	1.90

3. Check the cutting speed to ensure optimum performance.

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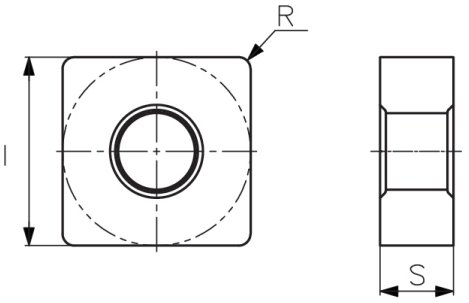
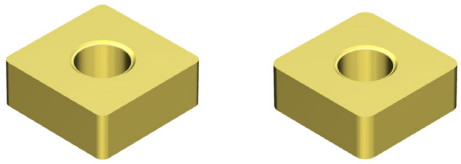
Universal Carbide Turning Insert - Turning

SNMA





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	I	D	s	r	P	M	K	N	S	H	ATA EDP No.
SNMA	AA	AT101	CVD Grade	SNMA120408-AT101	12.7	12.7	4.76	0.8			•				90037
SNMA	AA	AT101	CVD Grade	SNMA120412-AT101	12.7	12.7	4.76	1.2			•				90038

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
SNMA120408-AT101	90037	0.15	0.7	0.43	1	6	3.50
SNMA120412-AT101	90038	0.2	0.8	0.50	1.5	6	3.75

3. Check the cutting speed to ensure optimum performance.

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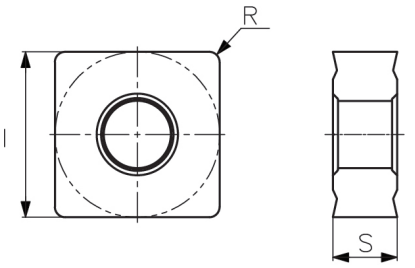
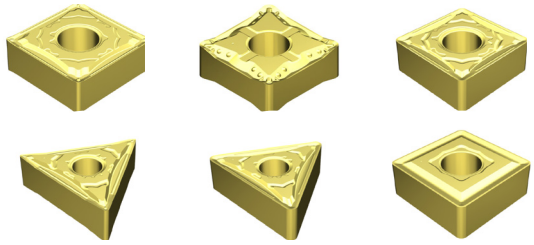
Universal Carbide Turning Insert - Turning

SNMG





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
SNMG	AF	AT201	PVD Grade	SNMG120404-AF-AT201	12.7	12.7	4.76	0.4	•	•	o	•	•	o	90039
SNMG	AC	AT201	CVD Grade	SNMG120408-AC-AT101	12.7	6.35	4.76	1.2			•			•	90040
SNMG	AG	AT201	PVD Grade	SNMG120408-AG-AT201	12.7	12.7	4.76	0.8	•	•	o	•	•	o	90041
SNMG	AL	AT201	PVD Grade	SNMG120408-AL-AT201	12.7	12.7	4.76	0.8	•	•	o	•	•	o	90042
SNMG	AC	AT101	CVD Grade	SNMG120412-AC-AT101	12.9	12.7	4.76	0.8			•			•	90043
SNMG	AR	AT201	PVD Grade	SNMG120412-AR-AT201	12.7	12.7	4.76	1.2	•	•	o	•	•	o	90044

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
SNMG120404-AF-AT201	90039	0.16	0.7	0.43	0.5	5	2.75
SNMG120408-AC-AT101	90040	0.16	0.7	0.43	1.2	5	3.10
SNMG120408-AG-AT201	90041	0.16	0.7	0.43	0.8	5	2.90
SNMG120408-AL-AT201	90042	0.16	0.7	0.43	0.8	5	2.90
SNMG120412-AC-AT101	90043	0.16	0.7	0.43	0.8	5	2.90
SNMG120412-AR-AT201	90044	0.19	0.95	0.57	1.2	6	3.60

3. Check the cutting speed to ensure optimum performance.

Please refer to page 4 to check the cutting speed.

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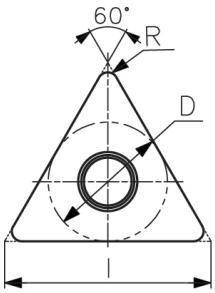
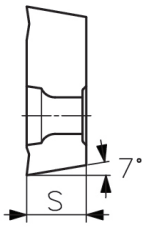
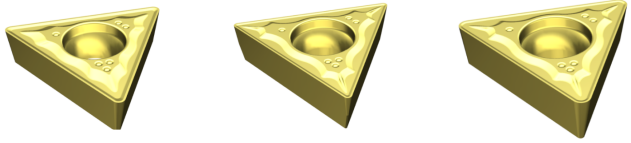
TCMT







1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
TCMT	AF	AT201	PVD Grade	TCMT110204-AF-AT201	11	6.35	2.38	0.4	•	•	o	•	•	o	90045
TCMT	AF	AT201	PVD Grade	TCMT16T304-AF-AT201	16.5	9.53	3.97	0.4	•	•	o	•	•	o	90046
TCMT	AG	AT201	PVD Grade	TCMT16T308-AG-AT201	16.5	9.53	3.97	0.8	•	•	o	•	•	o	90047

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
TCMT110204-AF-AT201	90045	0.04	0.2	0.12	0.5	2.1	1.30
TCMT16T304-AF-AT201	90046	0.05	0.23	0.14	0.5	3	1.75
TCMT16T308-AG-AT201	90047	0.11	0.43	0.27	0.8	5	2.90

3. Check the cutting speed to ensure optimum performance.

Please refer to page 4 to check the cutting speed.

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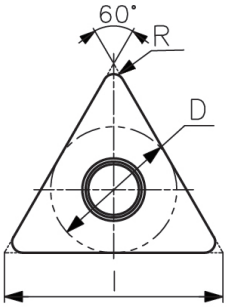
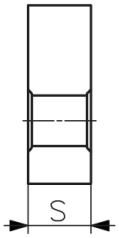
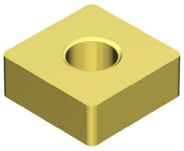
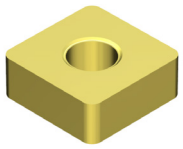
TNMA









1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
TNMA	AA	AT101	CVD Grade	TNMA160408-AT101	16.5	9.53	4.76	0.8			•				90048
TNMA	AA	AT101	CVD Grade	TNMA160412-AT101	16.5	9.53	4.76	1.2			•				90049

• Recommended ○ Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
TNMA160408-AT101	90048	0.1	0.4	0.25	1	4	2.50
TNMA160412-AT101	90049	0.1	0.5	0.30	1.5	4.5	3.00

3. Check the cutting speed to ensure optimum performance.

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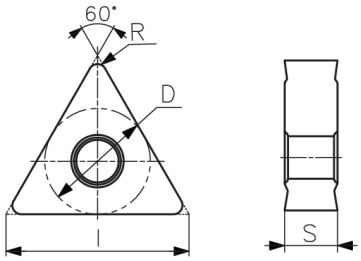
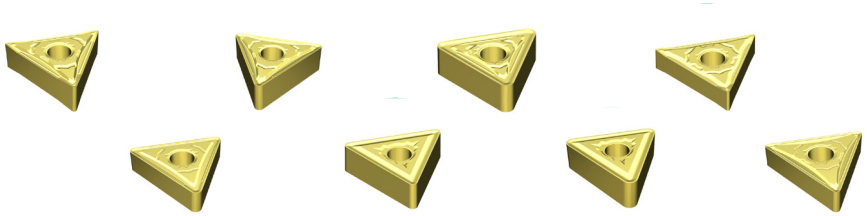
TNMG





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
TNMG	AF	AT201	PVD Grade	TNMG160404-AF-AT201	16.5	9.53	4.76	0.4	•	•	o	•	•	o	90050
TNMG	AC	AT101	CVD Grade	TNMG160408-AC-AT101	16.5	9.53	4.76	0.8			•			•	90051
TNMG	AG	AT201	PVD Grade	TNMG160408-AG-AT201	16.5	9.53	4.76	0.8	•	•	o	•	•	o	90052
TNMG	AC	AT101	CVD Grade	TNMG160412-AC-AT101	16.5	9.53	4.76	1.2			•			•	90053
TNMG	AR	AT201	PVD Grade	TNMG160412-AR-AT201	16.5	9.53	4.76	1.2	•	•	o	•	•	o	90054
TNMG	AF	AT201	PVD Grade	TNMG220404-AF-AT201	22	12.7	4.76	0.4	•	•	o	•	•	o	90055
TNMG	AG	AT201	PVD Grade	TNMG220408-AG-AT201	22	12.7	4.76	0.8	•	•	o	•	•	o	90056
TNMG	AR	AT201	PVD Grade	TNMG220412-AR-AT201	22	12.7	4.76	1.2	•	•	o	•	•	o	90057

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
TNMG160404-AF-AT201	90050	0.05	0.23	0.14	0.5	3	1.75
TNMG160408-AC-AT101	90051	0.11	0.5	0.31	0.8	5	2.90
TNMG160408-AG-AT201	90052	0.11	0.5	0.31	0.8	5	2.90
TNMG160412-AC-AT101	90053	0.14	0.68	0.41	1.2	5	3.10
TNMG160412-AR-AT201	90054	0.14	0.68	0.41	1.2	5	3.10
TNMG220404-AF-AT201	90055	0.05	0.23	0.14	0.5	3	1.75
TNMG220408-AG-AT201	90056	0.11	0.5	0.31	0.8	5	2.90
TNMG220412-AR-AT201	90057	0.14	0.68	0.41	1.2	7	4.10

3. Check the cutting speed to ensure optimum performance.

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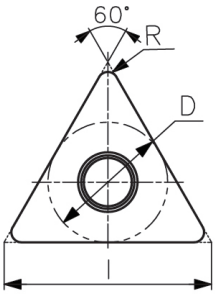
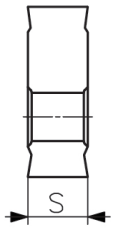
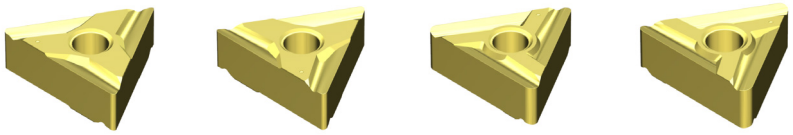
TNUX







1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
TNUX	AX	AT201	PVD Grade	TNUX160404L-AT201	16.5	9.53	4.76	0.4	•	•	o	•	•	o	90079
TNUX	AX	AT201	PVD Grade	TNUX160404R-AT201	16.5	9.53	4.76	0.4	•	•	o	•	•	o	90058
TNUX	AX	AT201	PVD Grade	TNUX160408L-AT201	16.5	9.53	4.76	0.8	•	•	o	•	•	o	90059
TNUX	AX	AT201	PVD Grade	TNUX160408R-AT201	16.5	9.53	4.76	0.8	•	•	o	•	•	o	90060

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
TNUX160404L-AT201	90079	0.05	0.23	0.14	0.5	3	1.75
TNUX160404R-AT201	90058	0.05	0.23	0.14	0.5	3	1.75
TNUX160408L-AT201	90059	0.11	0.5	0.31	0.8	5	2.90
TNUX160408R-AT201	90060	0.11	0.5	0.31	0.8	5	2.90

3. Check the cutting speed to ensure optimum performance.

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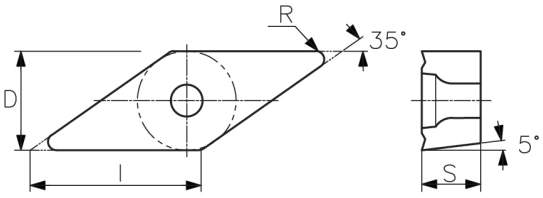
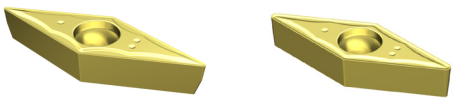
Universal Carbide Turning Insert - Turning

VBMT





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
VBMT	AF	AT201	PVD Grade	VBMT160404-AF-AT201	16	9.53	4.76	0.4	•	•	o	•	•	•	90061
VBMT	AG	AT201	PVD Grade	VBMT160408-AG-AT201	16	9.53	4.76	0.8	•	•	o	•	•	•	90062

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
VBMT160404-AF-AT201	90061	0.05	0.23	0.14	0.5	3	1.75
VBMT160408-AG-AT201	90062	0.1	0.4	0.25	0.8	3.5	2.15

3. Check the cutting speed to ensure optimum performance.

Please refer to page 4 to check the cutting speed.

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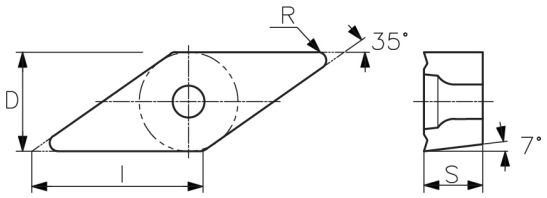
VCMT



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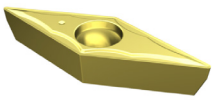

1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
VCMT	AF	AT201	PVD Grade	VCMT160404-AF-AT201	16	9.53	4.76	0.4	•	•	o	•	•	o	90063

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
VCMT160404-AF-AT201	90063	0.05	0.23	0.14	0.5	3	1.75

3. Check the cutting speed to ensure optimum performance.

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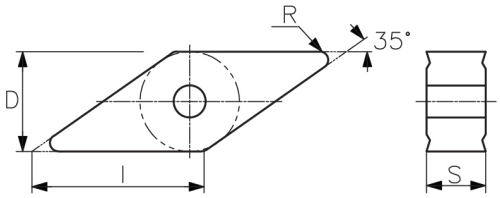
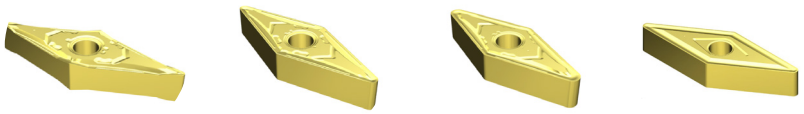
VNMG





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
VNMG	AF	AT201	PVD Grade	VNMG160404-AF-AT201	16	9.53	4.76	0.4	●	●	o	●	●	o	90064
VNMG	AG	AT201	PVD Grade	VNMG160408-AG-AT201	16	9.53	4.76	0.8	●	●	o	●	●	o	90065
VNMG	AR	AT201	PVD Grade	VNMG160412-AR-AT201	16	9.53	4.76	1.2	●	●	o	●	●	o	90066

● Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
VNMG160404-AF-AT201	90064	0.05	0.23	0.14	0.5	3	1.75
VNMG160408-AG-AT201	90065	0.1	0.4	0.25	0.8	4	2.40
VNMG160412-AR-AT201	90066	0.1	0.4	0.25	0.8	4	2.40

3. Check the cutting speed to ensure optimum performance.

Please refer to page 4 to check the cutting speed.

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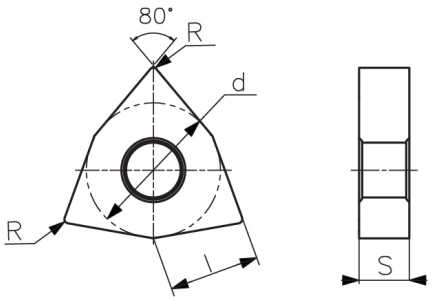
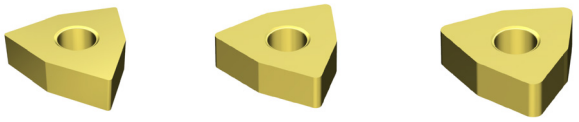
WNMA





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
WNMA	AA	AT101	CVD Grade	WNMA080404-AT101	8.7	12.7	4.76	0.4			•				90067
WNMA	AA	AT101	CVD Grade	WNMA080408-AT101	8.7	12.7	4.76	0.8			•				90068
WNMA	AA	AT101	CVD Grade	WNMA080412-AT101	8.7	12.7	4.76	1.2			•				90069

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
WNMA080404-AT101	90067	0.15	0.6	0.38	1	5	3.00
WNMA080408-AT101	90068	0.15	0.6	0.38	1	6	3.50
WNMA080412-AT101	90069	0.15	0.7	0.43	1.5	6	3.75

3. Check the cutting speed to ensure optimum performance.

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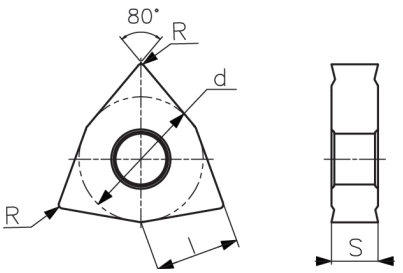
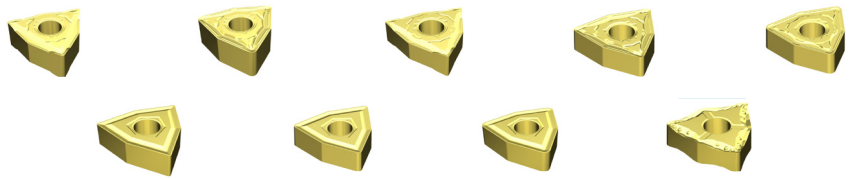
WNMG





1. Select your insert based on geometry, dimensions and material.

Series	ATA Geometry	ATA Grade	Grade	AT Part Number - Metric	l	D	s	r	P	M	K	N	S	H	ATA EDP No.
WNMG	AF	AT201	PVD Grade	WNMG060404-AF-AT201	6.6	9.53	4.76	0.4	•	•	o	•	•	o	90070
WNMG	AG	AT201	PVD Grade	WNMG060408-AG-AT201	6.6	9.53	4.76	0.8	•	•	o	•	•	o	90071
WNMG	AC	AT101	CVD Grade	WNMG080404-AC-AT101	8.7	12.7	4.76	0.4			•			•	90072
WNMG	AF	AT201	PVD Grade	WNMG080404-AF-AT201	8.7	12.7	4.76	0.4	•	•	o	•	•	o	90073
WNMG	AC	AT101	CVD Grade	WNMG080408-AC-AT101	8.7	12.7	4.76	0.8			•			•	90074
WNMG	AG	AT201	PVD Grade	WNMG080408-AG-AT201	8.7	12.7	4.76	0.8	•	•	o	•	•	o	90075
WNMG	AL	AT201	PVD Grade	WNMG080408-AL-AT201	8.7	12.7	4.76	0.8	•	•	o	•	•	o	90076
WNMG	AC	AT101	CVD Grade	WNMG080412-AC-AT101	8.7	12.7	4.76	1.2			•			•	90077
WNMG	AR	AT201	PVD Grade	WNMG080412-AR-AT201	8.7	12.7	4.76	1.2	•	•	o	•	•	o	90078

• Recommended o Suitable

2. Check the cutting conditions for the selected insert.

		Feed (mm/tooth)			Depth of Cut (mm)		
ATA Part Number - Metric	ATA EDP No.	Min.	Max.	Recommended	Min.	Max.	Recommended
WNMG060404-AF-AT201	90070	0.05	0.23	0.14	0.5	3	1.75
WNMG060408-AG-AT201	90071	0.11	0.5	0.31	0.8	3	1.90
WNMG080404-AC-AT101	90072	0.11	0.5	0.31	0.5	3.5	2.00
WNMG080404-AF-AT201	90073	0.05	0.23	0.14	0.5	3	1.75
WNMG080408-AC-AT101	90074	0.11	0.5	0.31	0.8	3.5	2.15
WNMG080408-AG-AT201	90075	0.11	0.5	0.31	0.8	3.5	2.15
WNMG080408-AL-AT201	90076	0.11	0.5	0.31	0.8	3.5	2.15
WNMG080412-AC-AT101	90077	0.13	0.65	0.39	1.2	3.5	2.35
WNMG080412-AR-AT201	90078	0.13	0.65	0.39	1.2	3.5	2.35

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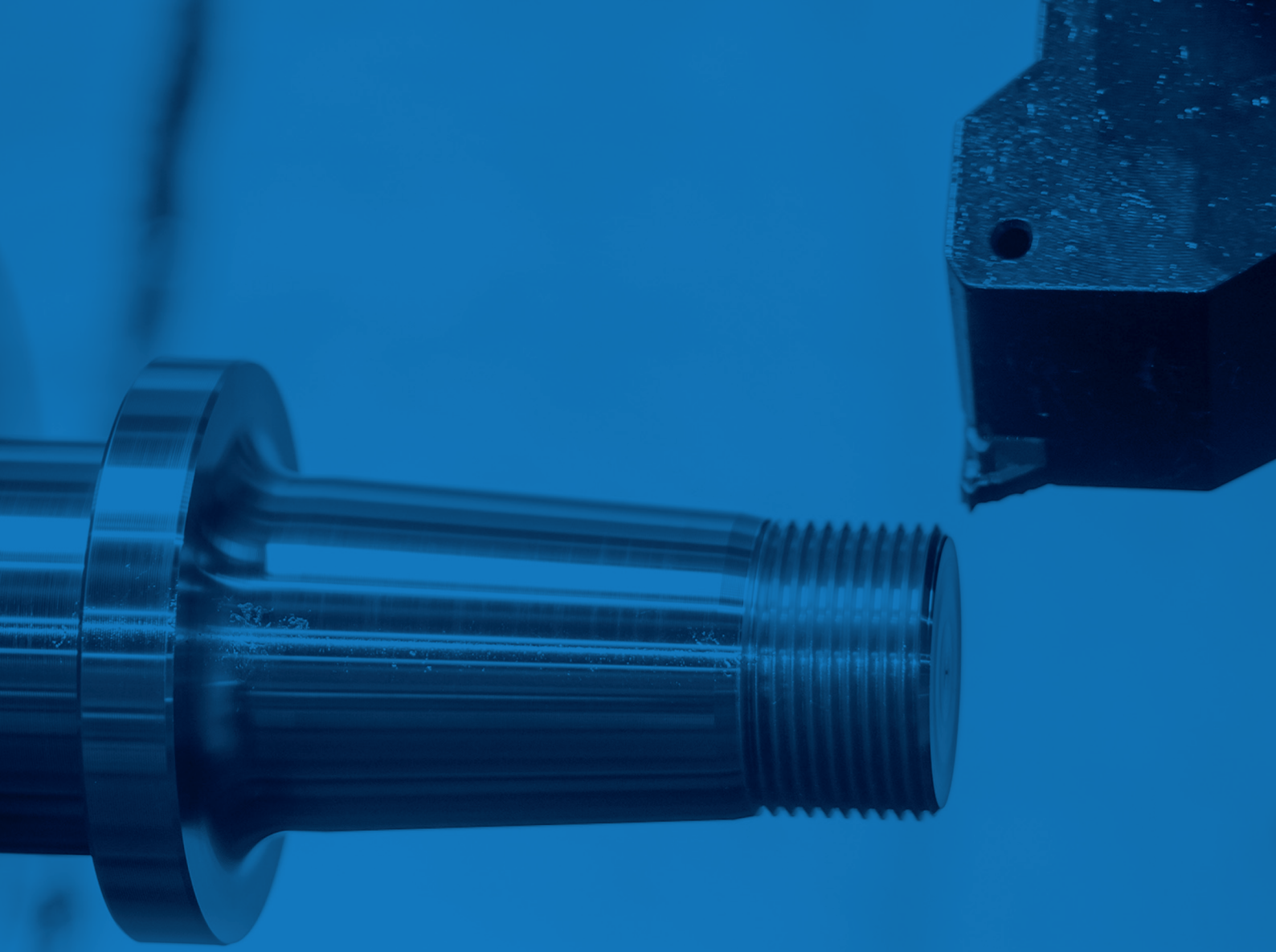

US Offices

t: +1 330-928-7744
f: +1 330-849-2977

e: sales@atatools.com
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ATA Tools Inc., 7 Ascot Parkway,
Cuyahoga Falls, Ohio 44223, USA

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