

All-hou Grand Sea Cemented Carbide Co, .ltd is the wholly owned subsidiary of Hohlhoul Grand Sea Group which is Sino-Foreign Joint Venture is invested by Kyocera Corporation.

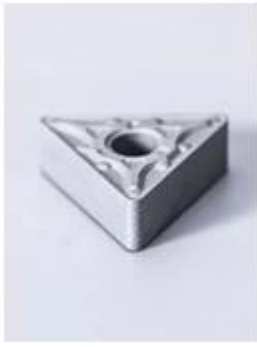
Now carbide insertion Project is the key development project of Bigsea Cemented hard metal, Grand sea Has 5 electric presses imported from Japan, to produce hard metal insertion 2 million Per Month.

Our advantage

1. 100% tungsten carbide raw material.
2. R & D and production capability to keep up with the market trends.
3. Technical support to solve the processing solutions for customers in all aspects.
4. Reasonable stock to ensure fast delivery.
5. We are the supplier that can wholesale and customize the carbide inserts for you.



















The Gardin Recommendation:

Degree	Toilet %	bullet %	Grain (Ah)	density (G / cm ³) ± 0.1	hardness (HRA) ± 0.5	TRS. (kgf / mm ²)
H10f.	90.	10.	0.8.	14.40.	91.8.	> 350.
H11f.	87.	12.	0.3.	14.50.	91.4.	> 350.
H12a	88.	22.	1.2.	14.20.	90.5.	> 350.












1 2 3 4 5 6 7 8 9 10
C N M G 12 04 08 (E) (N)-MP

1. Insert Shape

1. Insert Shape		
Symbol	Insert Shape	
H	Hexagonal	
O	Octagonal	
P	Pentagonal	
S	Square	
T	Triangular	
C	Rhombic 80°	
D	Rhombic 55°	
E	Rhombic 75°	
F	Rhombic 50°	
M	Rhombic 86°	
V	Rhombic 35°	
W	Trigon	
L	Rectangular	
A	Parallelogram 85°	
B	Parallelogram 82°	
K	Parallelogram 55°	
R	Round	
X	Special Design	

2. Relief Angle

2. Relief Angle		
Symbol	Normal Clearance	
A	3°	
B	5°	
C	7°	
D	15°	
E	20°	
F	25°	
G	30°	
N	0°	
P	11°	
O	Other Relief Angle	
Major Relief Angle		

3. Tolerance Class

3. Tolerance Class										
3. Tolerance Class				Detail of M Class Insert Tolerance						
Symbol	Tolerance of Nose Height M (mm)	Tolerance of Inscribed Circle IC (mm)	Tolerance of Thickness S (mm)	●Tolerance of Nose Height M (mm)						
				D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
A	±0.005	±0.025	±0.025	6.35	±0.08	±0.08	±0.08	±0.11	±0.16	—
F	±0.005	±0.013	±0.025	9.525	±0.08	±0.08	±0.08	±0.11	±0.16	—
C	±0.013	±0.025	±0.025	12.70	±0.13	±0.13	±0.13	±0.15	—	—
H	±0.013	±0.013	±0.025	15.875	±0.15	±0.15	±0.15	±0.18	—	—
E	±0.025	±0.025	±0.025	19.05	±0.15	±0.15	±0.15	±0.18	—	—
G	±0.025	±0.025	±0.13	25.40	—	±0.18	—	—	—	—
J	±0.005	±0.05—±0.15	±0.025	31.75	—	±0.20	—	—	—	—
K*	±0.013	±0.05—±0.15	±0.025	●Tolerance of Inscribed Circle IC (mm)						
L*	±0.025	±0.05—±0.15	±0.025	D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
M*	±0.08—±0.18	±0.05—±0.15	±0.13	6.35	±0.05	±0.05	±0.05	±0.05	±0.05	—
N*	±0.08—±0.18	±0.05—±0.15	±0.025	9.525	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05
U*	±0.13—±0.38	±0.08—±0.25	±0.13	12.70	±0.08	±0.08	±0.08	±0.08	—	±0.08
The surface of insert with * mark is sintered.				15.875	±0.10	±0.10	±0.10	±0.10	—	±0.10
				19.05	±0.10	±0.10	±0.10	±0.10	—	±0.10
				25.40	—	±0.13	—	—	—	±0.13
				31.75	—	±0.15	—	—	—	±0.15


4. Chipbreaker and Clamping System

4. Chipbreaker and Clamping System									
Metric									
Symbol	Hole	Hole Configuration	Chip Breaker	Figure	Symbol	Hole	Hole Configuration	Chip Breaker	Figure
W	With Hole	Cylindrical Hole	No		A	With Hole	Cylindrical Hole	No	
T	With Hole	One Countersink (40—60°)	One Sided		M	With Hole	Cylindrical Hole	Single Sided	
Q	With Hole	Cylindrical Hole	No		G	With Hole	Cylindrical Hole	Double Sided	
U	With Hole	Double Countersink (40—60°)	Double Sided		N	Without Hole	—	No	
B	With Hole	Cylindrical Hole	No		R	Without Hole	—	Single Sided	
H	With Hole	One Countersink (70—90°)	One Sided		F	Without Hole	—	Double Sided	
C	With Hole	Cylindrical Hole	No		X	—	—	—	Special Design
J	With Hole	Double Countersink (70—90°)	Double Sided						

5. Insert Size

5. Insert Size							
Symbol							Diameter of Inscribed Circle (mm)
R	W	V	D	C	S	T	
	02		04	03	03	06	3.97
	L3	08	05	04	04	08	4.76
	03	09	06	05	05	09	5.56
06							6.00
	04	11	07	06	06	11	6.35
	05	13	09	08	07	13	7.94
08							8.00
09	06	16	11	09	09	16	9.525
10							10.00
12							12.00
12	08	22	15	12	12	22	12.70
15	10		19	16	15	27	15.875
16							16.00
19	13		23	19	19	33	19.05
20							20.00
			27	22	22	38	22.225
25							25.00
25			31	25	25	44	25.40
31			38	32	31	54	31.75
32							32.00

6. Insert Thickness

6. Insert Thickness	
 <p>*Thickness is from the bottom of the insert to the top of the cutting edge.</p>	
Symbol	Thickness (mm)
S1	1.39
01	1.59
T0	1.79
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
06	6.35
07	7.94
09	9.52

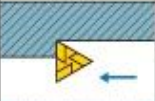
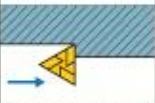

7. Insert Corner Configuration

7. Insert Corner Configuration	
Symbol	Corner Radius (mm)
00	Sharp Nose
V3	0.03
V5	0.05
01	0.1
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2
00 : Inch M0 : Metric	Round Insert

8. Cutting Edge Condition

8. Cutting Edge Condition		
Figure	Cutting Edge	Symbol
	Sharp Cutting Edges	F
	Round Cutting Edges	E
	Chamfered Cutting Edges	T
	Chamfered and Rounded Cutting Edges	S
Mitsubishi Materials omit the honing symbol.		

9. Cutting Direction

9. Cutting Direction		
Figure	Hand	Symbol
	Right	R
	Left	L
	Neutral	N

10. Chip Breaker

10. Chip Breaker		
LP	MP	RP
		
LM	MM	RM
		
LK	MK	RK
		
LS	MS	RS
		
FP	LP	MP
		
MA	SW	MW
		
HZ	HX	HV
		