EUROLOY

MADE IN EUROPE

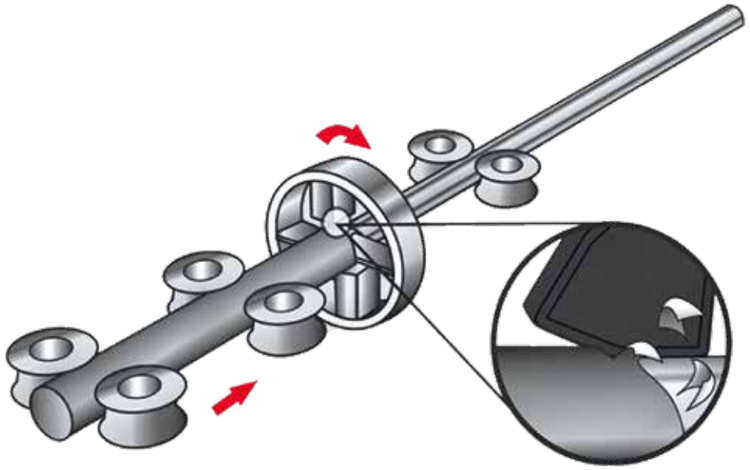
BAR PEELING CATALOG

BAR PEELING

Bar Peeling is the machining process by which a raw forged blank is converted into a polished bar.

During this peeling process, surface cracks and oxide layers are removed giving a perfect roundness with good surface and dimensional accuracy to the bar.

The range of materials that can be machined with these tools is vast and goes from all kind of Steels to Cast Iron parts.

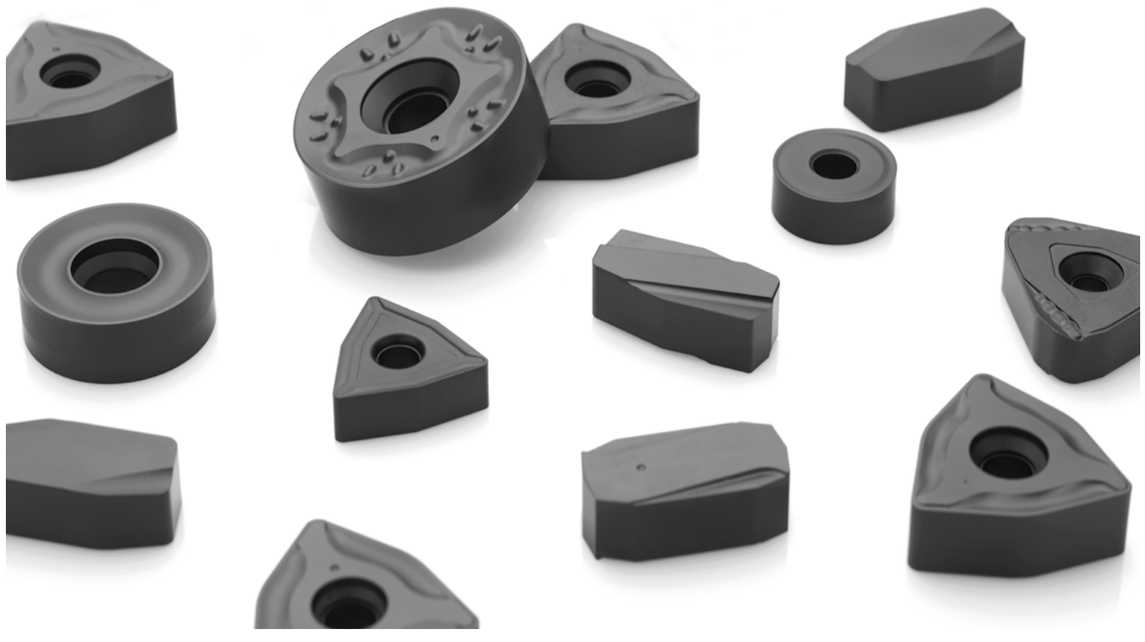


The size of blank bar can go from 4 mm (157 inch) to over 400 mm (15.75 inch) in diameter.

The surface quality and dimensional tolerances are also high, which leads to less machining at later stages.

Our aim is at the same time improving your productivity (by removing maximal chips volume) and at the same time attending or surpassing your surface quality requirements. This is why our Bar Peeling program is vast comprising both standard tools and also special custom-made solutions to every customer needs.

This flyer has only a small portion of our possible range of production. Please don't hesitate to contact us regarding other possible geometries that we may have although not presented in this brochure.



CODE KEY

L	N	G	F	20	10	35	-	PM
1	2	3	4	5	6	7		8

1 - Insert Shape

I	J	**L**	R	S
T (60°)	U	W (75° / 80°)	X (85° / 90°)	

2 - Clearance Angle

N (0°)

3 - Tolerances

symbol	m (mm)	d (mm)	s (mm)
A	±0.005	±0.025	±0.025
F	±0.005	±0.013	±0.025
C	±0.013	±0.025	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J	±0.005	±0.05~±0.13	±0.025
K*	±0.013	±0.05~±0.13	±0.025
L*	±0.025	±0.05~±0.13	±0.025
M*	±0.08~±0.20	±0.05~±0.13	±0.13
N*	±0.08~±0.20	±0.05~±0.13	±0.025
U*	±0.13~±0.38	±0.08~0.25	±0.13

* As a rule, the sides of these inserts are as sintered. Tolerance differs with insert size, for the accuracy of Class M, refer to the table on the right.

4 - Insert type

symbol	Type	Type of hole	Chipbreaker	Shape
W	with hole	Round hole / one countersink (40°~60°)	Without chipbreaker	
T	with hole		Chipbreaker on one side	
Q	with hole	Round hole / double countersink (40°~60°)	Without chipbreaker	
U	with hole		Chipbreaker on both sides	
B	with hole	Round hole / double countersink (70°~90°)	Without chipbreaker	
H	with hole		Chipbreaker on one side	
C	with hole		Without chipbreaker	
J	with hole		Chipbreaker on both sides	
A	with hole	Round hole	Without chipbreaker	
M	with hole		Chipbreaker on one side	
G	with hole		Chipbreaker on both sides	
N	without hole	--	Without chipbreaker	
R	without hole	--	Chipbreaker on one side	
F	without hole	--	Chipbreaker on both sides	
X	-	-	--	On request

5 - Length of Cutting Edge (ln)

The length of the secondary cutting edge is indicated in mm

13 mm	25 mm
14 mm	27 mm
15 mm	28 mm
17 mm	38 mm
20 mm	44 mm
22 mm	50 mm

6 - Thickness (S)

The length of the secondary cutting edge is indicated in mm

- 08 = 8,00 mm
- 09 = 9,52 mm
- **10 = 10,00 mm**
- 12 = 12,00 mm
- 12 = 12,70 mm
- 13 = 13,00 mm
- 14 = 14,00 mm
- 18 = 18,00 mm

7 - Deph of Cut (ap)

Maximum depth of cut

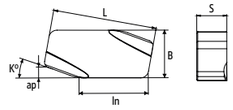
- 20 = 2,00 mm
- 25 = 2,50 mm
- **35 = 3,50 mm**
- 40 = 4,00 mm
- 80 = 8,00 mm

8 - Chip Breaker

Chip breaker according to Palbit geometries

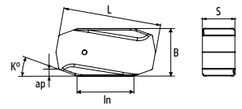
PF	HM
KF	RR
PM	HL

INGR Rectangular 90º negative



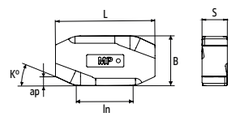
Grade code				P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	L	ln	B	S	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
		INGR 221240-PM	INGR 221240-PM	●	○	○	○	○	38,25	22,00	17,50	12,00	4,00	20	2,00	0,40	4,00	3,50	1,00	8,00

JNGF Rectangular 90º negative



Grade code				P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	L	ln	B	S	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	JNGF 201220-PM	JNGF 201220-PM	○	●	●	○	○	36,90	20,00	18,00	12,35	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00
	JNGF 201220-PM SP1	JNGF 201220-PM SP1	○	○	○	○	○	36,30	20,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00
	JNGF 201220-PM SP2	JNGF 201220-PM SP2	●	●	●	○	○	36,50	20,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00
	JNGF 271220-PM	JNGF 271220-PM	○	○	●	○	○	36,90	27,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00

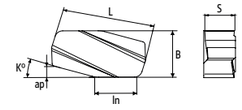
LNGF Rectangular 90º negative



Grade code				P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	L	ln	B	S	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	LNGF 201035-PM	LNGF 201035-PM	●	○	○	○	○	40,00	20,00	20,00	10,00	3,50	25	2,00	0,80	3,50	2,50	1,00	6,50
	LNGF 201235-PM	LNGF 201235-PM	●	○	○	○	○	40,00	20,00	20,00	12,00	3,50	25	2,00	0,80	3,50	2,50	1,00	6,50

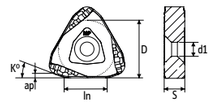
● Stock item - First choice ● Stock item ○ Available under request

UNGF Rectangular 90º negative



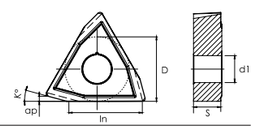
Grade code				P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	L	ln	B	S	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	UNGF 171240-PM	UNGF 171240-PM	○	●	●	○	○	36,50	17,00	18,00	12,00	4,00	15	1,50	0,35	4,00	2,00	1,00	5,00

TNMJ Triangular 60º negative



Grade code				P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	ln	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	TNMJ 201025-PM	TNMJ 201025-PM	○	●	●	○	○	28,60	20,00	10,00	7,00	2,50	20	1,00	0,70	2,50	3,00	1,00	5,50
	TNMJ 201425-PM	TNMJ 201425-PM	○	●	●	○	○	28,60	20,00	14,00	7,00	2,50	20	1,00	0,70	2,50	3,00	1,00	5,50

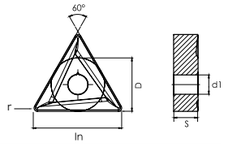
TNGM Triangular 60º negative



Grade code				P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	N2	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	ln	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	TNGM 220812-PM	TNGM 220812-PM	○	●	●	○	○	19,05	22,00	8,00	7,96	1,20	15	0,70	0,20	1,30	14,00	5,00	18,00

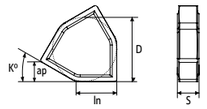
● Stock item - First choice ● Stock item ○ Available under request

TNMM Triangular 60º negative



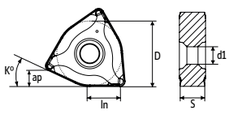
		Grade code		P		M		K	Dimensions (mm)						Cutting conditions					
				L7	N2	N2	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	In	S	d1	r	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
		TNMM 441116-HL	TNMM 441116-HL	○	◎	◎	○	○	25,40	44,00	11,35	9,20	1,60	-	12,00	2,00	25,00	0,80	0,50	1,60

XNGF Special 85º negative



		Grade code		P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	In	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
		XNGF 150980-PF	XNGF 150980-PF	○	○	○	◎	○	28,58	15,00	8,88	-	8,00	30	3,00	1,00	4,50	6,00	4,00	12,00

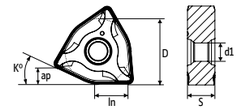
XNMJ Special 85º negative



		Grade code		P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	In	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
		XNMJ 151380-PM	XNMJ 151380-PM	○	◎	◎	◎	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00
		XNMJ 151380-HM	XNMJ 151380-HM	○	◎	◎	◎	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00

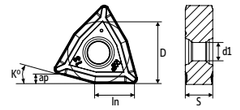
◎ Stock item - First choice ◎ Stock item ○ Available under request

XNGJ Special 85º negative



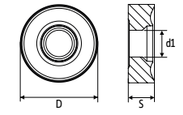
		Grade code		P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	In	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
		XNGJ 151380-RR	XNGJ 151380-RR	○	○	○	◎	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00

WNGJ Special 75º negative



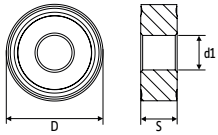
		Grade code		P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	In	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
		WNGJ 130950-PM	WNGJ 130950-PM	○	◎	◎	◎	◎	22,23	13,00	9,56	7,93	5,00	15	3,00	0,50	5,00	6,00	3,00	11,00

RNMX Round Rº negative



		Grade code		P		M		K	Dimensions (mm)						Cutting conditions					
				L7	L8	L8	P1	L6												
		ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	In	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
		RNMX 381200-PM	RNMX 381200-PM	○	○	○	◎	○	38,10	-	12,70	13,00	-	-	4,00	2,00	8,00	2,00	1,00	4,00
		RNMX 5018M0-PM	RNMX 5018M0-PM	○	○	○	◎	○	50,00	-	18,00	12,70	-	-	6,00	2,00	12,00	3,50	2,50	6,50
		RNMX 5018M0-RR	RNMX 5018M0-RR	○	○	○	◎	○	50,00	-	18,00	12,70	-	-	6,00	2,00	12,00	6,00	4,00	10,50

◎ Stock item - First choice ◎ Stock item ○ Available under request



RNMG Round Rº negative

				P		M		K	Dimensions (mm)						Cutting conditions					
		Grade code		L7	L8	L8	P1	L6												
	Geometry	ISO Reference	ANSI Reference	TCT115P	TCT125P	TCT125P	TCT228P	TCT220P	D	In	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
																				
		RNMG 250900-KF	RNMG 860-KF	◯	◯	◯	◯	⛢	25,40	-	9,52	9,12	-	-	5,00	2,50	10,00	1,00	0,25	2,50

⛢ Stock item - First choice ⛢ Stock item ◯ Available under request

EUROLOY

We merge technology with excellence

Head Office: Corso Ventidue Marzo 33 20129 Milano MI ITALIA
Tel: +39 02 89732 118 | www.euroloy.com | info@euroloy.com