

# Brake Drum and Rotor Turning Inserts

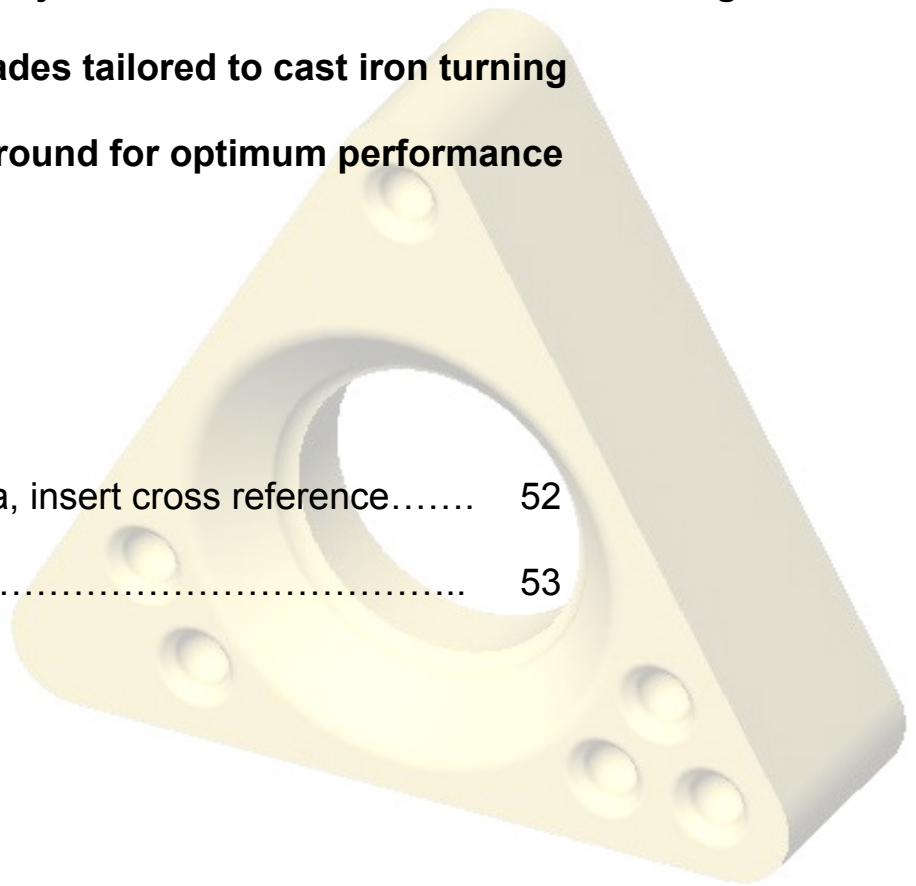
Inserts compatible with major brands of brake drum / rotor turning lathes

Coated and uncoated grades tailored to cast iron turning

Parallel and peripheral ground for optimum performance

Grade and application data, insert cross reference..... 52

Insert selection..... 53






# Brake Drum and Rotor Turning Inserts

## Grade and Application Data, Insert Cross Reference

UNCOATED			
Grade	ISO Class	Industry Class	Description
AN2	K10-K25 N05-N15	C2	AN2 is an uncoated, unalloyed grade with good abrasive wear resistance. Designed specifically for turning of cast iron and other non-ferrous materials, this is the perfect general purpose grade for brake drum and rotor turning.

CVD COATED				
Grade	ISO Class	Industry Class	Description	Coating
AN3005	K05-K20	C2	AN3005 is CVD coated grade with thick layers of TiCN, Al <sub>2</sub> O <sub>3</sub> , and TiN for wear resistance. The coating adds significant strength and lubricity to provide maximum performance in brake drum and rotor turning operations.	 <div style="display: flex; flex-direction: column; align-items: center;"> <div style="width: 10px; height: 10px; background-color: yellow; margin-bottom: 2px;"></div> <div style="width: 10px; height: 10px; background-color: grey; margin-bottom: 2px;"></div> <div style="width: 10px; height: 10px; background-color: black; margin-bottom: 2px;"></div> <div style="width: 10px; height: 10px; background-color: white; margin-bottom: 2px;"></div> </div> <div style="font-size: small; margin-top: 5px;">             TiN              Al<sub>2</sub>O<sub>3</sub>              TiCN              Substrate           </div>





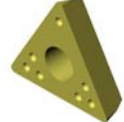







INSERT CROSS REFERENCE					
Machine	Model Numbers	Mfr. Part Number	Edges	Rake	ANC Part Number
Accu-Turn	All combination disc/drum lathes	433796	3	Pos	TDUA2.52(020)
	On-the-car lathes	878051	6	Neg	TNUC21.52 / D, TNUC222 / D
All-Tool	747	3331	6	Neg	TNUC21.52 / D, TNUC222 / D
Ammco	700, 710, 1000, 2002, 3000, 4000, 4100, 7000, 7500, 7700 and twin cutter models 6900, 6950, 7900	6914	6	Neg	TNUC21.52 / D, TNUC222 / D
	small (1/64") radius	6918	3	Pos	TP41
	larger (1/32") radius	7681	3	Pos	TP42
Ammco HD	5000, 6000, 6002	5677	3	Pos	TPGB322
Bean	B401, B410, B501, B601	90487	3	Pos	TDUA2.52(020)
Bear	1410, 1466, 1467, 1468, 1469, 14787	2264, 72265	6	Neg	TNUC21.52 / D, TNUC222 / D
FMC	600, 601, 700, 701, RotoTruer	90487	3	Pos	TDUA2.52(020)
	505, On-the-car lathes	91212	3	Pos	TP41
Hoffman	660	3331	6	Neg	TNUC21.52 / D, TNUC222 / D
Hunter	BL300 On-the car lathe	221580-2	6	Neg	TNUC21.52 / D, TNUC222 / D
	BL500, BL501, BL505	6918	3	Pos	TP41
Kwik-Way	CBL, NCL, SDL, Kwik-Lathe On-the-car lathe	109-1092-23	3	Pos	TP41
Performance	6600, 7200, 7100, 7600	3331	6	Neg	TNUC21.52 / D, TNUC222 / D
Pro-Cut	On-the-car lathe	50-701	3	Pos	TP41
RJ West	915D disc lathes	W136	6	Neg	TNMA432
	Perfect 400, 1115HD	W139	3	Pos	TDUA2.52(020)
RTI	BRC35 On-the-car lathe	91212	3	Pos	TP42
Snap-On	YA282, YA277, YA278, YA180 On-the-car lathe	109-1092-23	3	Pos	TP41
Star	XDS, XDL, 1776, 835A	CD-60	6	Neg	TNUC21.52 / D, TNUC222 / D
Van Norman / Rels	204, 204D, 205, 205DC, 415, 243XV	29687	3	Pos	TPG322
	small (1/64") radius		3	Pos	TPG321
	204, 304, 405	29005	6	Neg	TNMG322GM
	Flywheel cutter	25368	3	Pos	TPG433
	303, 304, 305, 404, 405, V22	304-7167	2	Pos	D0083
	204, 205, 205DR, 300, 302, 333, 243, 243XV	302-7167	2	Pos	D0084
VBG	On-the-car lathe	50-701	3	Pos	TP41
Round tips (all machines)				Pos	RFX2.51.5



# Brake Drum and Rotor Turning Inserts

## BRAKE DRUM AND ROTOR TURNING

replacement inserts for most popular brands of lathes

	Part Number	Grades		Dimensions (inches)			
		AN3005	AN2	IC	Thick.	Radius	Hole
<b>D0083</b> 	D0083	•	•	.190 (width) .865 (length)	.095	.031	-
<b>D0084</b> 	D0084	•	•	.190 (width) .865 (length)	.095	.031	-
<b>RFX</b> Round  	RFX 2.51.5	•	•	5/16	3/32	-	-
<b>TDUA</b> Triangle  	TDUA 2.52020	•	•	5/16	1/8	.020	.150
<b>TNMA</b> Triangle  	TNMA 432	•	•	1/2	3/16	1/32	.203
<b>TNMG-GM</b> Triangle  	TNMG 322-GM	•	•	3/8	1/4	1/32	.150
<b>TNUC</b> Triangle  	TNUC 21.52	•	•	1/4	3/32	1/32	.136
	TNUC 222	•	•	1/4	1/8	1/32	.136

Grade details, see page 52

Nomenclature explanation, see page 2



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replacement inserts for most popular brands of lathes

### TNUC-D



Triangle

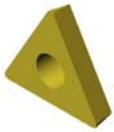
TNUC 21.52D  
TNUC 222D

Grades  
AN3005  
AN2

Dimensions (inches)  
IC  
Thick.  
Radius  
Hole

1/4  
3/32  
1/32  
.136  
1/4  
1/8  
1/32  
.136

### TP



Triangle

TP 41  
TP 42

1/4  
3/32  
1/64  
.137  
1/4  
3/32  
1/32  
.137

### TPG

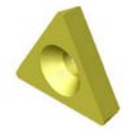


Triangle

TPG 321  
TPG 322  
TPG 433

3/8  
1/8  
1/64  
-  
3/8  
1/8  
1/32  
-  
1/2  
3/16  
3/64  
-

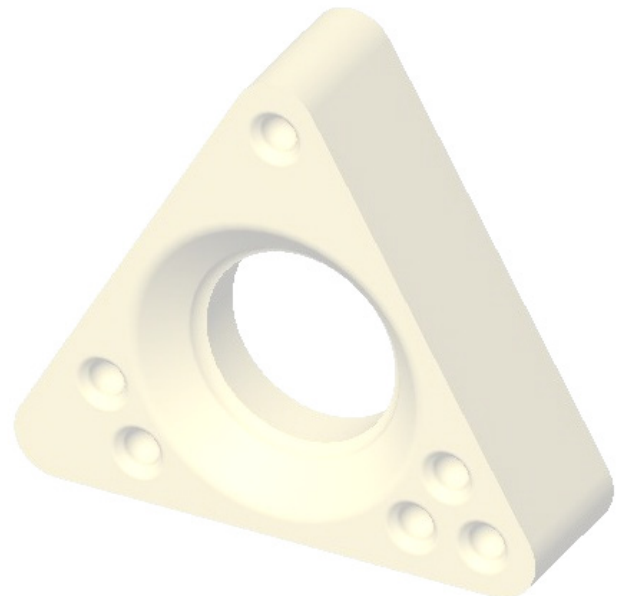
### TPGB



Triangle

TPGB 322

3/8  
1/8  
1/32  
.152



Grade details, see page 52

Nomenclature explanation, see page 2