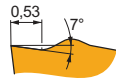




Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

TCMT 06T104E-FF2	T7325	0.4	✓	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.4	■	145	0.12	0.8	–	–	–	■	135	0.12	0.8	–	–	–	–	–	–
	T8430	0.4	■	180	0.12	0.8	–	–	–	■	145	0.12	0.8	–	–	–	–	–	–
	T9315	0.4	■	245	0.12	0.8	–	–	–	■	230	0.12	0.8	–	–	–	–	–	–
	T9325	0.4	■	220	0.12	0.8	–	–	–	■	205	0.12	0.8	–	–	–	–	–	–
TCMT 090204E-FF2	T5315	0.4	✓	240	0.12	1.0	–	–	–	■	225	0.12	1.0	–	–	–	–	–	–
	T7325	0.4	✓	165	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	
	T8330	0.4	■	140	0.12	1.0	–	–	–	■	130	0.12	1.0	–	–	–	–	–	
	T8430	0.4	■	175	0.12	1.0	–	–	–	■	140	0.12	1.0	–	–	–	–	–	
	T9315	0.4	■	240	0.12	1.0	–	–	–	■	225	0.12	1.0	–	–	–	–	–	
TCMT 110204E-FF2	T9325	0.4	■	215	0.12	1.0	–	–	–	■	200	0.12	1.0	–	–	–	–	–	
	T7325	0.4	✓	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–		
	T8330	0.4	■	145	0.12	0.8	–	–	–	■	135	0.12	0.8	–	–	–	–		
	T8430	0.4	■	180	0.12	0.8	–	–	–	■	145	0.12	0.8	–	–	–	–		
	T9315	0.4	■	245	0.12	0.8	–	–	–	■	230	0.12	0.8	–	–	–	–		
	T9325	0.4	■	220	0.12	0.8	–	–	–	■	205	0.12	0.8	–	–	–	–		
	T9335	0.4	■	185	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–		
TCMT 110208E-FF2	T7325	0.8	✓	180	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–		
	T8330	0.8	■	155	0.17	0.8	–	–	–	■	145	0.17	0.8	–	–	–	–		
	T8430	0.8	■	185	0.17	0.8	–	–	–	■	150	0.17	0.8	–	–	–	–		
	T9315	0.8	■	250	0.17	0.8	–	–	–	■	235	0.17	0.8	–	–	–	–		
	T9325	0.8	■	225	0.17	0.8	–	–	–	■	210	0.17	0.8	–	–	–	–		
TCMT 16T304E-FF2	T7325	0.4	✓	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–		
	T8330	0.4	■	145	0.12	0.8	–	–	–	■	135	0.12	0.8	–	–	–	–		
	T8430	0.4	■	180	0.12	0.8	–	–	–	■	145	0.12	0.8	–	–	–	–		
	T9315	0.4	■	245	0.12	0.8	–	–	–	■	230	0.12	0.8	–	–	–	–		
	T9325	0.4	■	220	0.12	0.8	–	–	–	■	205	0.12	0.8	–	–	–	–		
	T9335	0.4	■	185	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–		
TCMT 16T308E-FF2	TT010	0.4	■	295	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–		
	T7325	0.8	✓	180	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–		
	T8330	0.8	■	155	0.17	0.8	–	–	–	■	145	0.17	0.8	–	–	–	–		
	T8430	0.8	■	185	0.17	0.8	–	–	–	■	150	0.17	0.8	–	–	–	–		
	T9315	0.8	■	250	0.17	0.8	–	–	–	■	235	0.17	0.8	–	–	–	–		
	T9325	0.8	■	225	0.17	0.8	–	–	–	■	210	0.17	0.8	–	–	–	–		
	T9335	0.8	■	195	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–		



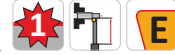
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

TCMT 110202E-FM	T7325	0.2	✓	185	0.10	0.8	■	140	0.09	0.8	–	–	–	–	–	–	–	–	
	T7335	0.2	✓	185	0.10	0.8	■	140	0.09	0.8	–	–	–	–	–	–	–	–	
	T8315	0.2	✓	170	0.10	0.8	■	100	0.09	0.8	■	160	0.10	0.8	■	510	0.12	0.8	–
	T8330	0.2	■	160	0.10	0.8	■	95	0.09	0.8	■	150	0.10	0.8	■	480	0.12	0.8	–
	T8430	0.2	■	195	0.10	0.8	■	105	0.09	0.8	■	160	0.10	0.8	■	540	0.12	0.8	–
	T9315	0.2	■	270	0.10	0.8	–	–	–	–	■	255	0.10	0.8	–	–	–	–	
TCMT 110204E-FM	T9325	0.2	■	245	0.10	0.8	■	145	0.09	0.8	■	230	0.10	0.8	–	–	–	–	
	T7325	0.4	✓	160	0.19	0.8	■	120	0.17	0.8	–	–	–	–	–	–	–		
	T7335	0.4	✓	155	0.19	0.8	■	120	0.17	0.8	–	–	–	–	–	–	–		
	T8315	0.4	✓	170	0.12	0.8	■	100	0.11	0.8	■	160	0.12	0.8	■	510	0.14	0.8	–
	T8330	0.4	■	160	0.12	0.8	■	95	0.11	0.8	■	150	0.12	0.8	■	480	0.14	0.8	–
	T8430	0.4	■	195	0.12	0.8	■	105	0.11	0.8	■	160	0.12	0.8	■	540	0.14	0.8	–
	T9315	0.4	■	270	0.12	0.8	–	–	–	–	■	255	0.12	0.8	–	–	–	–	
T9325	0.4	■	205	0.18	0.8	■	120	0.16	0.8	■	190	0.18	0.8	–	–	–	–		



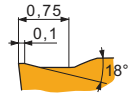
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



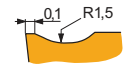
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

TCMT 110208E-FM	T7325	0.8	✓	195	0.17	0.8	■	150	0.15	0.8	■	–	–	–	–	–	–	–	–
	T8330	0.8	■	175	0.17	0.8	■	105	0.15	0.8	✓	165	0.17	0.8	✓	525	0.20	0.8	–
	T8430	0.8	■	200	0.17	0.8	■	110	0.15	0.8	✓	165	0.17	0.8	✓	555	0.20	0.8	–
	T9315	0.8	■	275	0.17	0.8	■	–	–	–	■	260	0.17	0.8	■	–	–	–	–
	T9325	0.8	■	250	0.17	0.8	■	150	0.15	0.8	■	235	0.17	0.8	■	–	–	–	–
TCMT 16T304E-FM	T7325	0.4	✓	150	0.19	1.7	■	115	0.17	1.7	■	–	–	–	–	–	–	–	–
	T7335	0.4	✓	145	0.19	1.7	■	110	0.17	1.7	■	–	–	–	–	–	–	–	
	T8315	0.4	✓	155	0.12	1.7	■	90	0.11	1.7	✓	145	0.12	1.7	✓	465	0.14	1.7	–
	T8330	0.4	■	150	0.12	1.7	■	90	0.11	1.7	✓	140	0.12	1.7	✓	450	0.14	1.7	–
	T8430	0.4	■	180	0.12	1.7	■	95	0.11	1.7	✓	145	0.12	1.7	✓	495	0.14	1.7	–
	T9315	0.4	■	250	0.12	1.7	■	–	–	–	■	235	0.12	1.7	■	–	–	–	–
TCMT 16T308E-FM	T9325	0.4	■	190	0.18	1.7	■	110	0.16	1.7	✓	180	0.18	1.7	■	–	–	–	–
	T7325	0.8	✓	180	0.17	1.7	■	140	0.15	1.7	■	–	–	–	–	–	–	–	
	T7335	0.8	✓	175	0.17	1.7	■	135	0.15	1.7	■	–	–	–	–	–	–	–	
	T8315	0.8	✓	170	0.17	1.7	■	100	0.15	1.7	✓	160	0.17	1.7	✓	510	0.20	1.7	–
	T8330	0.8	■	160	0.17	1.7	■	95	0.15	1.7	✓	150	0.17	1.7	✓	480	0.20	1.7	–
	T8430	0.8	■	185	0.17	1.7	■	100	0.15	1.7	✓	150	0.17	1.7	✓	510	0.20	1.7	–
	T9315	0.8	■	255	0.17	1.7	■	–	–	–	■	240	0.17	1.7	■	–	–	–	–
T9325	0.8	■	230	0.17	1.7	■	135	0.15	1.7	✓	215	0.17	1.7	■	–	–	–	–	



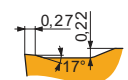
FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

TCMT 110204E-FM2	T8330	0.4	■	145	0.12	0.8	✓	85	0.11	0.8	■	135	0.12	0.8	■	–	–	–	–
	T8430	0.4	■	180	0.12	0.8	✓	95	0.11	0.8	✓	145	0.12	0.8	■	–	–	–	–
	T9325	0.4	■	220	0.12	0.8	✓	130	0.11	0.8	✓	205	0.12	0.8	■	–	–	–	–
TCMT 110208E-FM2	T8330	0.8	■	155	0.17	0.8	✓	90	0.15	0.8	■	145	0.17	0.8	■	–	–	–	–
	T8430	0.8	■	185	0.17	0.8	✓	100	0.15	0.8	✓	150	0.17	0.8	■	–	–	–	–
	T9325	0.8	■	225	0.17	0.8	✓	135	0.15	0.8	✓	210	0.17	0.8	■	–	–	–	–
	T9335	0.8	■	195	0.17	0.8	✓	115	0.15	0.8	■	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2	T7325	0.8	✓	170	0.20	1.0	✓	130	0.18	1.0	■	–	–	–	–	–	–	–	
	T8330	0.8	■	145	0.20	1.0	✓	85	0.18	1.0	■	135	0.20	1.0	■	–	–	–	–
	T8430	0.8	■	170	0.20	1.0	✓	90	0.18	1.0	✓	135	0.20	1.0	■	–	–	–	–
	T9325	0.8	■	205	0.20	1.0	✓	120	0.18	1.0	✓	190	0.20	1.0	■	–	–	–	–
	T9335	0.8	■	175	0.20	1.0	✓	105	0.18	1.0	■	–	–	–	–	–	–	–	–



RF geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TCMT 16T308E-RF	T9325	0.8	■	175	0.20	1.5	✓	105	0.18	1.5	✓	165	0.20	1.5	■	–	–	–	–
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RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TCMT 16T308E-RM	T5305	0.8	✓	265	0.27	1.9	■	–	–	–	■	250	0.27	1.9	■	–	–	–	50
	T5315	0.8	✓	235	0.27	1.9	■	–	–	–	■	220	0.27	1.9	■	–	–	–	45
	T7335	0.8	✓	155	0.27	1.9	■	120	0.24	1.9	■	–	–	–	■	50	0.19	1.5	–
	T8330	0.8	■	145	0.27	1.9	■	85	0.24	1.9	■	135	0.27	1.9	■	35	0.19	1.5	■
	T8430	0.8	■	165	0.27	1.9	■	90	0.24	1.9	■	135	0.27	1.9	■	35	0.19	1.5	■
	T9315	0.8	■	215	0.27	1.9	■	–	–	–	■	200	0.27	1.9	■	–	–	–	40
	T9325	0.8	■	195	0.27	1.9	■	115	0.24	1.9	✓	185	0.27	1.9	■	40	0.19	1.5	■