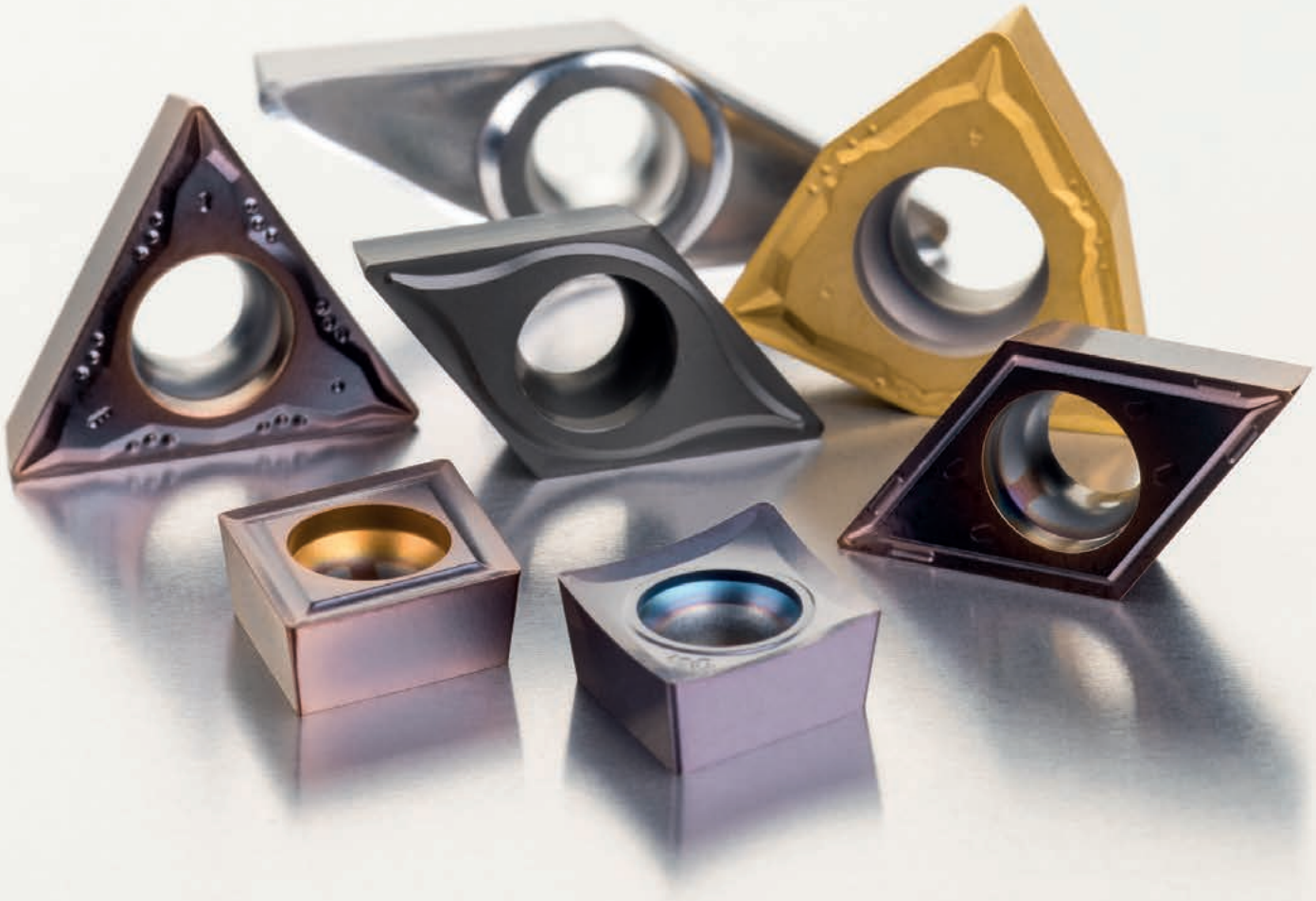
DORMER PRAMET

TURNING

2024

PRAMET

INDEXABLE INSERTS – CONTENT (ALPHABETICAL)



POSITIVE INSERTS

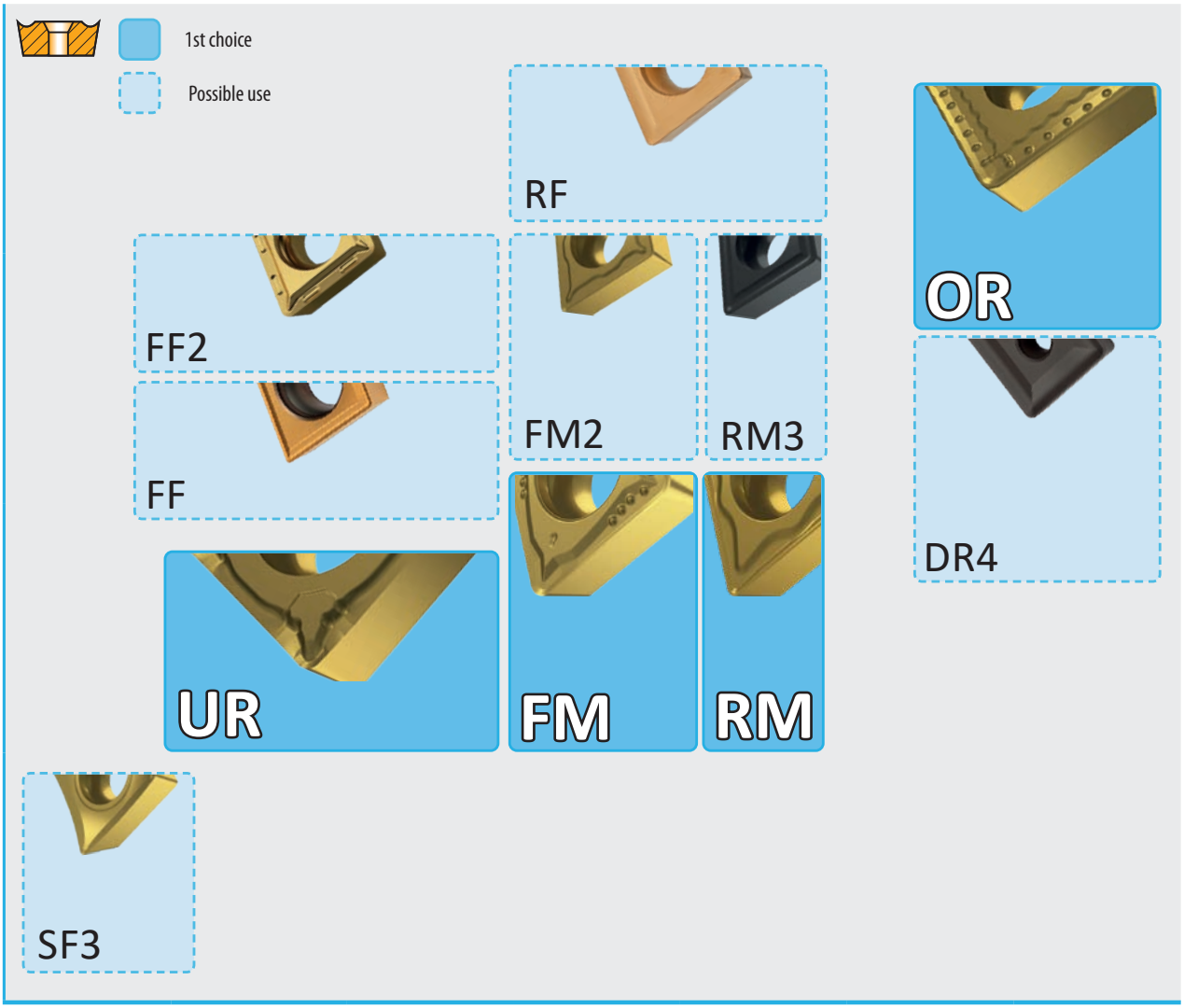
P

Very unstable working conditions

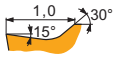
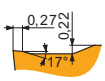
Unstable working conditions

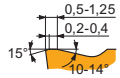
Stable working conditions

Thin -walled and slim workpieces



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

UR		Designed for fine to finish machining, steels and cast irons and potentially stainless steel, continuous and interrupted cuts
FM		Designed for finish to semi-rough machining, steels and stainless steels, potentially cast irons and non ferrous materials, continuous and moderately interrupted cuts
RM		Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts

OR		Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts

M

Very unstable working conditions

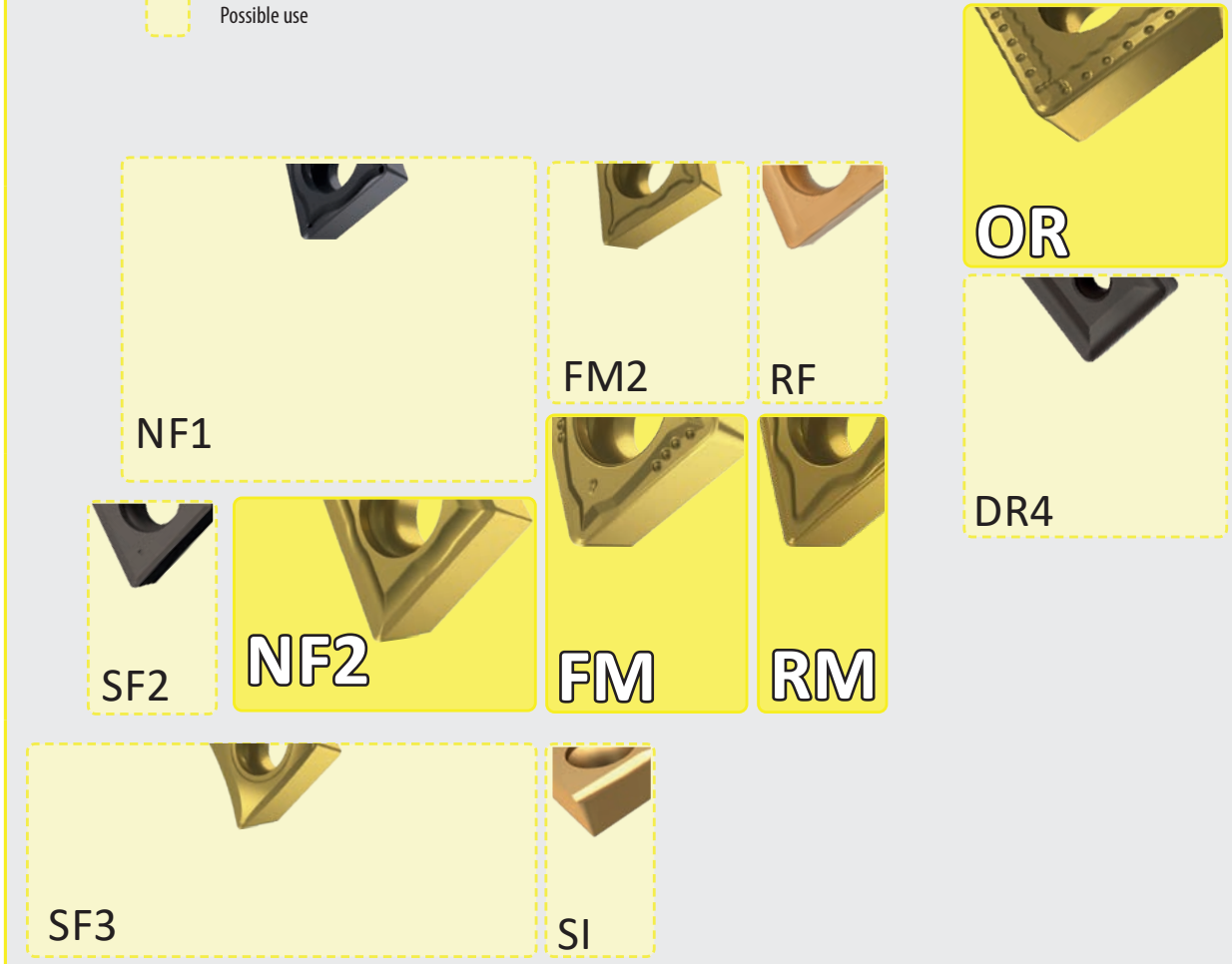
Unstable working conditions

Stable working conditions

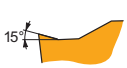
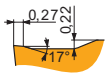
Thin -walled and slim workpieces

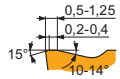
1st choice

Possible use

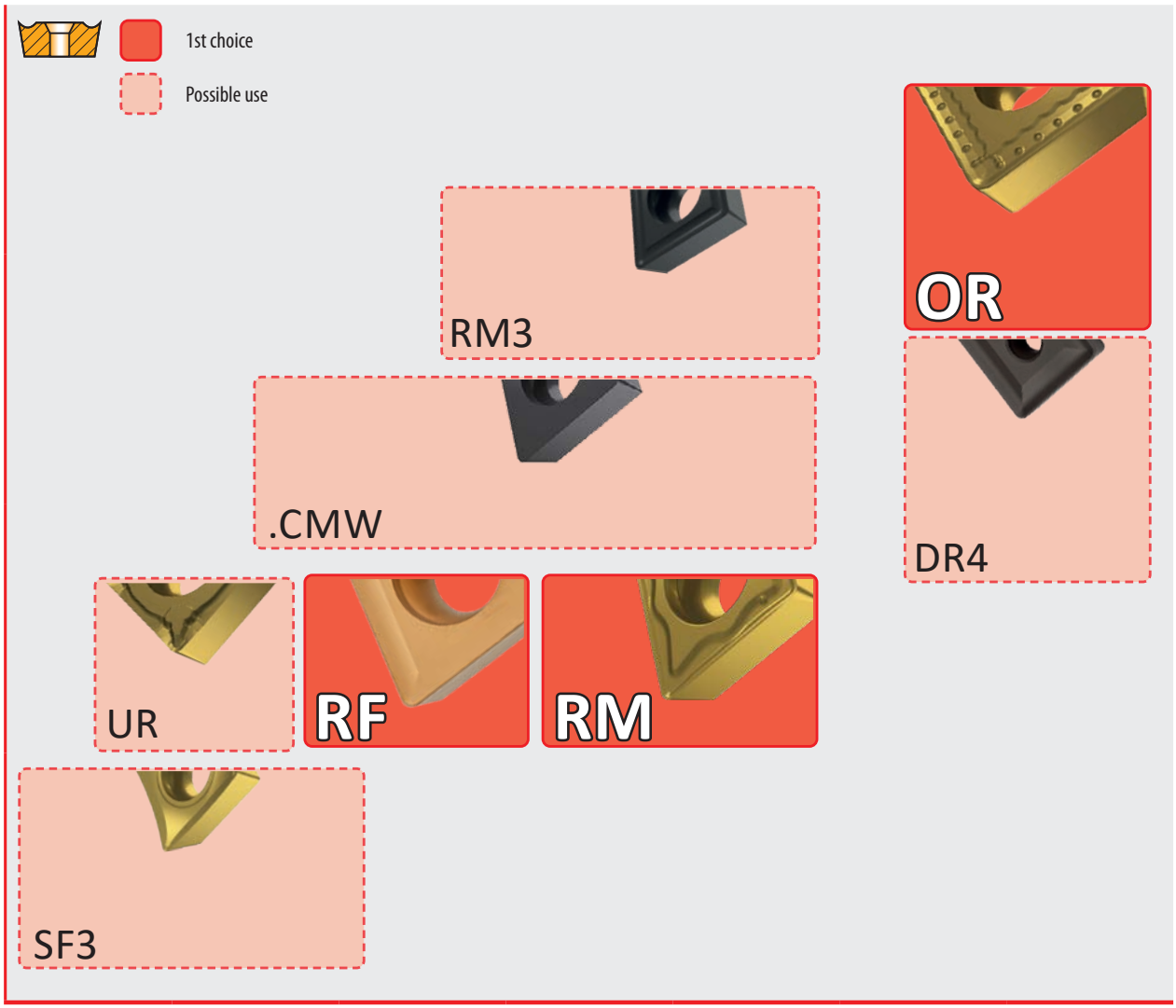


	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

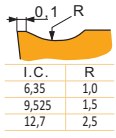
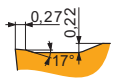
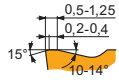
NF2		Positive design for fine-finish to semi rough machining, stainless steels and super alloys, continuous cuts
FM		Designed for finish to semi-rough machining, steels and stainless steels, potentially cast irons and non ferrous materials, continuous and moderately interrupted cuts
RM		Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts

OR		Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts

K



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

RF	 I.C. / R: 6,35 / 1,0; 9,525 / 1,5; 12,7 / 2,5	Designed for rough machining, cast irons, potentially steels, stainless steels and hard materials, continuous and interrupted cuts
RM		Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts
OR		Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts

N

Very unstable working conditions

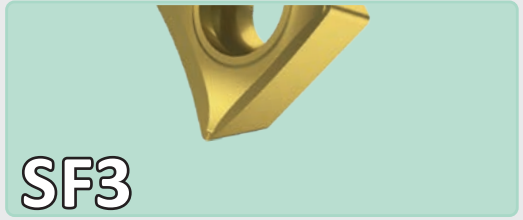
Unstable working conditions

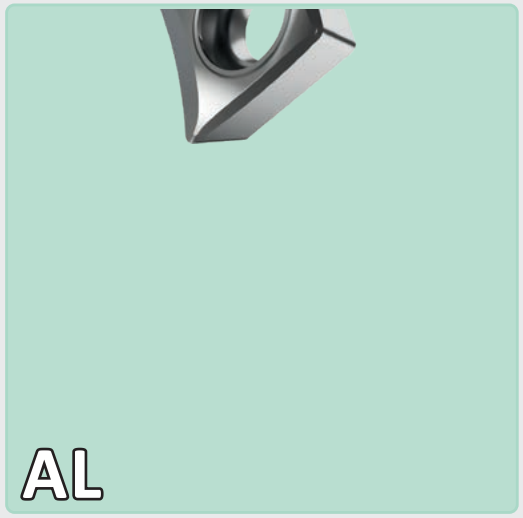
Stable working conditions

Thin -walled and slim workpieces

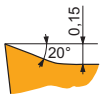
1st choice

Possible use





	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF3		Very positive design for fine and finish machining, super alloys, stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts
AL		Highly positive design for fine finish to rough machining, aluminium, aluminium alloys and other non ferrous materials, potentially super alloys, continuous cuts

S

1st choice

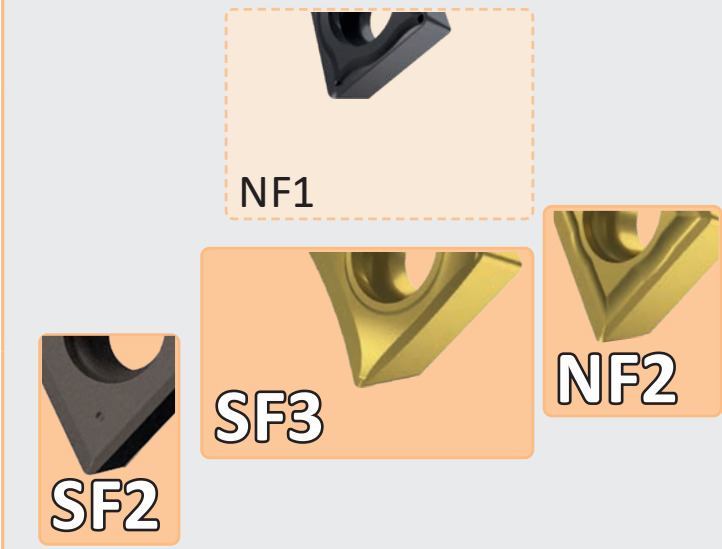
Possible use

Very unstable working conditions

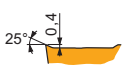
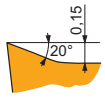
Unstable working conditions

Stable working conditions

Thin -walled and slim workpieces



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF2		Very positive design for fine and finish machining, super alloys, potentially stainless steels, steels and non ferrous materials, continuous cuts
SF3		Very positive design for fine and finish machining, super alloys, stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts
NF2		Positive design for fine-finish to semi rough machining, stainless steels and super alloys, continuous cuts

H

1st choice

Possible use

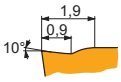
Very unstable working conditions

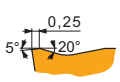
Unstable working conditions

Stable working conditions

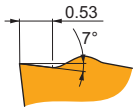
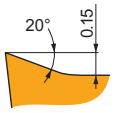
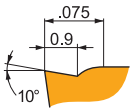
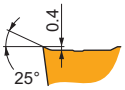
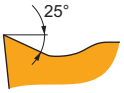
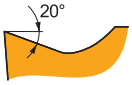
Thin -walled and slim workpieces

	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

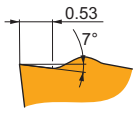
SF3		Very positive design for fine and finish machining, super alloys,stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts
NF1		Positive design for fine-finish to medium machining, stainless steels and super alloys, potentially steels, non ferrous and hard materials, continuous cuts
.CMW		Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts

RM3		Designed for rough machining, cast irons, potentially steels, stainless steels and hard materials, continuous and interrupted cuts

FINE-FINISHING – NAVIGATOR

FF2			**FF2** chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.
SF3			**SF3** chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.
NF1			**NF1** chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.
SF2			**SF2** chip breaker is sharp and designed for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Steels and Non-ferrous alloys.
AL			**AL** chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.
JQ JR JZ			**JQ** chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.

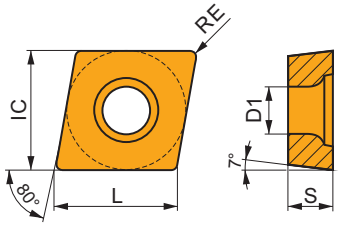
FF2



FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

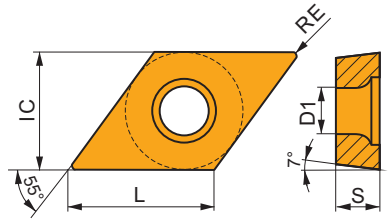
CCGT / CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97



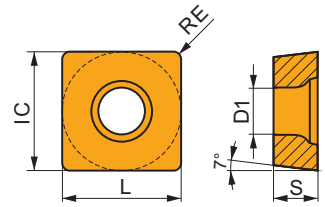
DCGT / DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



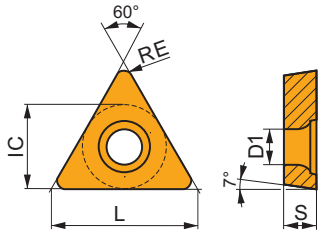
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97



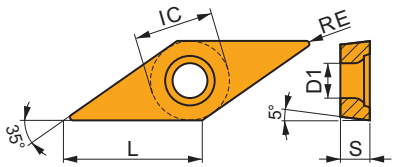
TCGT / TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



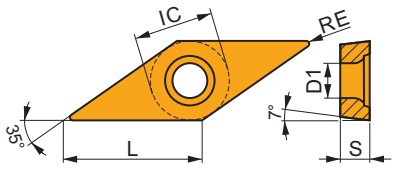
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



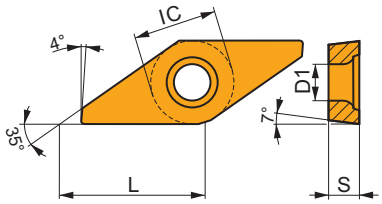
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1303	7.940	3.40	13.80	3.18



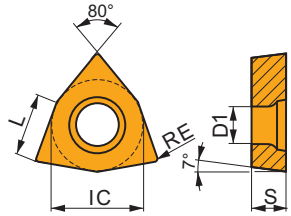
VCGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

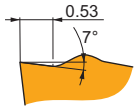
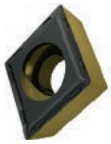
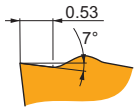
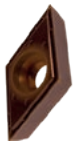
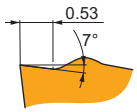
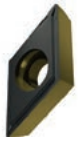
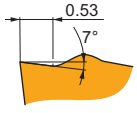


WCGT

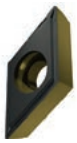
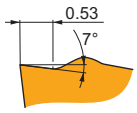
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0201	3.970	2.20	2.70	1.59



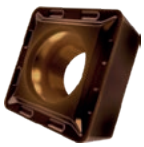
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

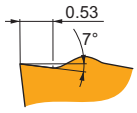
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																			
CCGT 09T302E-FF2:T9325	0.2	345	0.05	1.0	–	–	–	325	0.05	1.0	–	–	–	–	–	–	–	–	–
 																			
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																			
CCMT 060202E-FF2:T8430	0.2	280	0.05	0.8	–	–	–	230	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:T9325	0.2	350	0.05	0.8	–	–	–	330	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:T9415	0.2	395	0.05	0.8	–	–	–	375	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-FF2:TT010	0.2	345	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T7325	0.4	190	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T8430	0.4	205	0.12	1.0	–	–	–	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9325	0.4	255	0.12	1.0	–	–	–	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9335	0.4	215	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:T9415	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-FF2:TT010	0.4	280	0.12	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080302E-FF2:T8430	0.2	280	0.05	0.8	–	–	–	230	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 080302E-FF2:T9325	0.2	350	0.05	0.8	–	–	–	330	0.05	0.8	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T7325	0.4	190	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T8430	0.4	205	0.12	1.0	–	–	–	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:T9325	0.4	255	0.12	1.0	–	–	–	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FF2:TT010	0.4	350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080308E-FF2:T8430	0.8	210	0.17	1.0	–	–	–	175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FF2:T9325	0.8	260	0.17	1.0	–	–	–	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T8430	0.4	200	0.12	1.2	–	–	–	165	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9325	0.4	250	0.12	1.2	–	–	–	235	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9335	0.4	215	0.12	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:T9415	0.4	300	0.12	1.2	–	–	–	285	0.12	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FF2:TT010	0.4	350	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T8430	0.8	205	0.17	1.2	–	–	–	170	0.17	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T9325	0.8	255	0.17	1.2	–	–	–	240	0.17	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:T9415	0.8	300	0.20	1.2	–	–	–	285	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FF2:TT010	0.8	350	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																			
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																			
DCGT 11T302E-FF2:T8430	0.2	225	0.05	0.8	–	–	–	185	0.05	0.8	–	–	–	–	–	–	–	–	–
DCGT 11T302E-FF2:T9325	0.2	280	0.05	0.8	–	–	–	265	0.05	0.8	–	–	–	–	–	–	–	–	–
DCGT 11T302E-FF2:TT010	0.2	275	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																			
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																			
DCMT 070202E-FF2:T7325	0.2	190	0.05	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:T8430	0.2	225	0.05	0.8	–	–	–	185	0.05	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:T9325	0.2	280	0.05	0.8	–	–	–	265	0.05	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-FF2:TT010	0.2	275	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T7325	0.4	160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T8430	0.4	170	0.12	0.8	–	–	–	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T9325	0.4	205	0.12	0.8	–	–	–	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FF2:T9415	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T7325	0.8	170	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T8430	0.8	175	0.17	0.8	–	–	–	140	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T9325	0.8	215	0.17	0.8	–	–	–	200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 070208E-FF2:T9415	0.8	265	0.17	0.8	–	–	–	250	0.17	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	P			M			K			N			S			H		
		(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)	vc (m/min)	f (mm/rev)	ap (mm)
																				
DCMT 11T304E-FF2:T7325	●	0.4	160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T8430	●	0.4	170	0.12	0.8	–	–	–	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T9325	●	0.4	205	0.12	0.8	–	–	–	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:T9415	●	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FF2:TT010	●	0.4	280	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T7325	●	0.8	170	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T8430	●	0.8	175	0.17	0.8	–	–	–	140	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T9325	●	0.8	215	0.17	0.8	–	–	–	200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:T9415	●	0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FF2:TT010	●	0.8	280	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

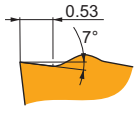
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.





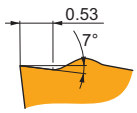
SCMT 09T304E-FF2:T8430	●	0.4	210	0.12	1.2	–	–	–	175	0.12	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FF2:T9325	●	0.4	260	0.12	1.2	–	–	–	245	0.12	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FF2:T8430	●	0.8	220	0.17	1.2	–	–	–	180	0.17	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FF2:T9325	●	0.8	265	0.17	1.2	–	–	–	250	0.17	1.2	–	–	–	–	–	–	–	–	–

FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.



TCGT 06T102E-FF2:T8430	●	0.2	235	0.05	0.8	–	–	–	190	0.05	0.8	–	–	–	–	–	–	–	–	–
TCGT 06T102E-FF2:TT010	●	0.2	295	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCGT 090202E-FF2:TT010	●	0.2	295	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

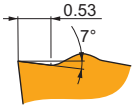
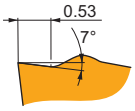
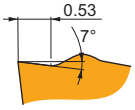
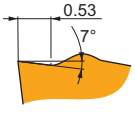
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.



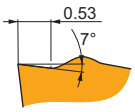
TCMT 06T102E-FF2:T8430	●	0.2	235	0.05	0.8	–	–	–	190	0.05	0.8	–	–	–	–	–	–	–	–	–
TCMT 06T102E-FF2:T9415	●	0.2	335	0.05	0.8	–	–	–	315	0.05	0.8	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T7325	●	0.4	170	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T8430	●	0.4	180	0.12	0.8	–	–	–	145	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T9325	●	0.4	220	0.12	0.8	–	–	–	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 06T104E-FF2:T9415	●	0.4	265	0.12	0.8	–	–	–	250	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T5315	●	0.4	240	0.12	1.0	–	–	–	225	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T7325	●	0.4	165	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T8430	●	0.4	175	0.12	1.0	–	–	–	140	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T9325	●	0.4	215	0.12	1.0	–	–	–	200	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 090204E-FF2:T9415	●	0.4	260	0.12	1.0	–	–	–	245	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T8430	●	0.4	180	0.12	0.8	–	–	–	145	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9325	●	0.4	220	0.12	0.8	–	–	–	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9335	●	0.4	185	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-FF2:T9415	●	0.4	265	0.12	0.8	–	–	–	250	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FF2:T8430	●	0.8	185	0.17	0.8	–	–	–	150	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FF2:T9325	●	0.8	225	0.17	0.8	–	–	–	210	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FF2:T9415	●	0.8	280	0.17	0.8	–	–	–	265	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T8430	●	0.4	180	0.12	0.8	–	–	–	145	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9325	●	0.4	220	0.12	0.8	–	–	–	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9335	●	0.4	185	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:T9415	●	0.4	265	0.12	0.8	–	–	–	250	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-FF2:TT010	●	0.4	295	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

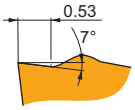
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																			
TCMT 16T308E-FF2:T8430	0.8	185	0.17	0.8	–	–	–	150	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9325	0.8	225	0.17	0.8	–	–	–	210	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9335	0.8	195	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FF2:T9415	0.8	280	0.17	0.8	–	–	–	265	0.17	0.8	–	–	–	–	–	–	–	–	–
 																			
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																			
VBMT 160404E-FF2:T7325	0.4	145	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T8430	0.4	150	0.12	0.8	–	–	–	125	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9325	0.4	190	0.12	0.8	–	–	–	180	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9335	0.4	160	0.12	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FF2:T9415	0.4	230	0.12	0.8	–	–	–	215	0.12	0.8	–	–	–	–	–	–	–	–	–
 																			
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																			
VCGT 070202E-FF2:T8315	0.2	150	0.05	0.8	–	–	–	140	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070202E-FF2:T8415	0.2	185	0.05	0.8	–	–	–	165	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070202E-FF2:T8430	0.2	190	0.05	0.8	–	–	–	155	0.05	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8315	0.4	125	0.12	0.8	–	–	–	115	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8415	0.4	155	0.12	0.8	–	–	–	140	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 070204E-FF2:T8430	0.4	145	0.12	0.8	–	–	–	120	0.12	0.8	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T5315	0.2	250	0.05	1.0	–	–	–	235	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T8430	0.2	185	0.05	1.0	–	–	–	150	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T9325	0.2	240	0.05	1.0	–	–	–	225	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:T9415	0.2	270	0.05	1.0	–	–	–	255	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130302E-FF2:TT010	0.2	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T5315	0.4	195	0.12	1.0	–	–	–	185	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T7325	0.4	135	0.12	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T8430	0.4	140	0.12	1.0	–	–	–	115	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T9325	0.4	175	0.12	1.0	–	–	–	165	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:T9415	0.4	215	0.12	1.0	–	–	–	200	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2:TT010	0.4	245	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:T9325	0.8	180	0.17	1.0	–	–	–	170	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:T9415	0.8	225	0.17	1.0	–	–	–	210	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2:TT010	0.8	245	0.10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																			
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																			
VCGX 130300FR-FF2:T6310	0.0	140	0.05	1.0	–	–	–	110	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:T8315	0.0	150	0.05	1.0	–	–	–	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:T8415	0.0	180	0.05	1.0	–	–	–	160	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FR-FF2:TT010	0.0	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T6310	0.1	140	0.05	1.0	–	–	–	110	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T8315	0.1	150	0.05	1.0	–	–	–	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:T8415	0.1	180	0.05	1.0	–	–	–	160	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FR-FF2:TT010	0.1	240	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

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

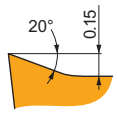
Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																				
VCGX 130300FL-FF2:T8315	●	0.0	◪	150	0.05	1.0	–	–	–	■	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FL-FF2:T8415	●	0.0	■	180	0.05	1.0	–	–	–	■	160	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130300FL-FF2:TT010	●	0.0	■	240	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
VCGX 130301FL-FF2:T8315	●	0.1	◪	150	0.05	1.0	–	–	–	■	140	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGX 130301FL-FF2:T8415	●	0.1	■	180	0.05	1.0	–	–	–	■	160	0.05	1.0	–	–	–	–	–	–	–	–	–

FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

																				
WCGT 020102E-FF2:HF7	●	0.2	–	–	–	–	–	–	■	210	0.05	0.8	–	–	–	–	–	–	–	–	–	–
WCGT 020102E-FF2:T8430	●	0.2	■	280	0.05	0.8	–	–	–	◪	230	0.05	0.8	–	–	–	–	–	–	–	–	–
WCGT 020102E-FF2:TT010	●	0.2	■	345	0.05	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:HF7	●	0.4	–	–	–	–	–	–	■	155	0.12	0.8	–	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:T8430	●	0.4	■	205	0.12	0.8	–	–	–	◪	170	0.12	0.8	–	–	–	–	–	–	–	–	–
WCGT 020104E-FF2:TT010	●	0.4	■	350	0.06	0.5	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–

FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

SF3

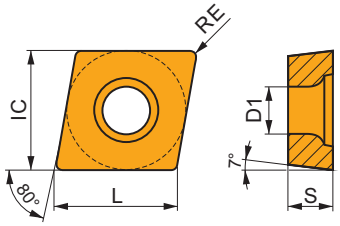


SF3 chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.

PRAMET

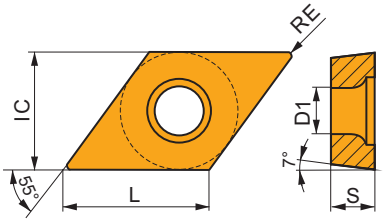
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602-SF3	6.350	2.80	6.40	2.58
0803-SF3	7.940	3.40	8.10	3.43
09T3-SF3	9.525	4.40	9.70	4.22
1204-SF3	12.700	5.50	12.90	5.01



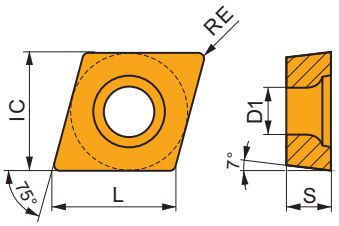
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702-SF3	6.350	2.80	7.80	2.58
11T3-SF3	9.525	4.40	11.60	4.22



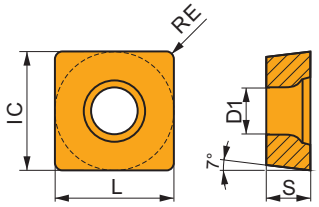
ECGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602-SF3	6.350	2.80	6.50	2.58
0803-SF3	7.940	3.40	8.20	3.43



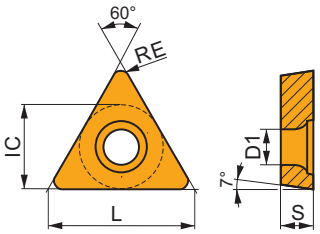
SCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3-SF3	9.525	4.40	9.53	4.22



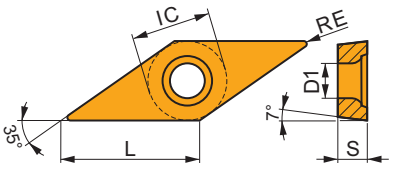
TCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102-SF3	6.350	2.80	11.00	2.58
16T3-SF3	9.525	4.40	16.50	4.22



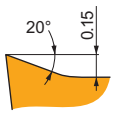
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1102-SF3	6.350	2.80	11.10	2.58
1103-SF3	6.350	2.80	11.10	3.43
1303-SF3	7.940	3.40	13.80	3.43
1604-SF3	9.525	4.40	16.60	5.01



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	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)
	(mm)																		

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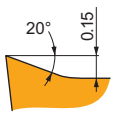
CCGT 060201E-SF3:T6310	●	0.1	200	0.05	0.5	140	0.05	0.5	160	0.05	0.5	600	0.06	0.5	60	0.04	0.4	40	0.05	0.1
CCGT 060202E-SF3:T6310	●	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 060202E-SF3:T8315	●	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 060202E-SF3:T8415	●	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 060204E-SF3:H07	●	0.4	–	–	–	95	0.09	0.8	150	0.10	0.8	485	0.12	0.8	45	0.07	0.6	–	–	–
CCGT 060204E-SF3:T6310	●	0.4	180	0.10	0.8	125	0.09	0.8	145	0.10	0.8	540	0.12	0.8	50	0.07	0.6	35	0.07	0.3
CCGT 060204E-SF3:T8315	●	0.4	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	570	0.12	0.8	45	0.07	0.6	35	0.07	0.3
CCGT 060204E-SF3:T8415	●	0.4	230	0.10	0.8	120	0.09	0.8	210	0.10	0.8	585	0.12	0.8	50	0.07	0.6	40	0.07	0.3
CCGT 080302E-SF3:T6310	●	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 080302E-SF3:T8315	●	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 080302E-SF3:T8415	●	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 080304E-SF3:T6310	●	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.10	0.3
CCGT 080304E-SF3:T8315	●	0.4	190	0.10	1.0	110	0.09	1.0	180	0.10	1.0	570	0.12	1.0	45	0.07	0.8	35	0.10	0.3
CCGT 080304E-SF3:T8415	●	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.10	0.3
CCGT 09T301E-SF3:T6310	●	0.1	200	0.05	0.5	140	0.05	0.5	160	0.05	0.5	600	0.06	0.5	60	0.04	0.4	40	0.05	0.1
CCGT 09T302E-SF3:T6310	●	0.2	205	0.05	0.8	145	0.05	0.8	165	0.05	0.8	615	0.06	0.8	60	0.04	0.6	40	0.05	0.2
CCGT 09T302E-SF3:T8315	●	0.2	215	0.05	0.8	125	0.05	0.8	200	0.05	0.8	645	0.06	0.8	50	0.04	0.6	40	0.05	0.2
CCGT 09T302E-SF3:T8415	●	0.2	270	0.05	0.8	140	0.04	0.8	245	0.05	0.8	675	0.06	0.8	60	0.04	0.6	45	0.05	0.2
CCGT 09T304E-SF3:H07	●	0.4	–	–	–	95	0.09	1.0	150	0.10	1.0	485	0.12	1.0	45	0.07	0.8	–	–	–
CCGT 09T304E-SF3:T6310	●	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.05	0.3
CCGT 09T304E-SF3:T8315	●	0.4	190	0.10	1.0	110	0.09	1.0	180	0.10	1.0	570	0.12	1.0	45	0.07	0.8	35	0.05	0.3
CCGT 09T304E-SF3:T8415	●	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.05	0.3
CCGT 09T308E-SF3:H07	●	0.8	–	–	–	110	0.09	1.0	175	0.10	1.0	565	0.12	1.0	55	0.08	0.8	–	–	–
CCGT 09T308E-SF3:T6310	●	0.8	210	0.10	1.0	150	0.09	1.0	165	0.10	1.0	630	0.12	1.0	60	0.08	0.8	40	0.08	0.7
CCGT 09T308E-SF3:T8315	●●●	0.8	225	0.10	1.0	135	0.09	1.0	210	0.10	1.0	675	0.12	1.0	55	0.08	0.8	45	0.08	0.7
CCGT 09T308E-SF3:T8415	●●●	0.8	275	0.10	1.0	140	0.09	1.0	250	0.10	1.0	690	0.12	1.0	60	0.08	0.8	45	0.08	0.7
CCGT 120404E-SF3:T6310	●	0.4	180	0.10	1.0	125	0.09	1.0	145	0.10	1.0	540	0.12	1.0	50	0.07	0.8	35	0.07	0.3
CCGT 120404E-SF3:T8415	●	0.4	225	0.10	1.0	115	0.09	1.0	205	0.10	1.0	570	0.12	1.0	50	0.07	0.8	35	0.07	0.3
CCGT 120408E-SF3:H07	●	0.8	–	–	–	105	0.12	1.0	165	0.12	1.0	525	0.14	1.0	50	0.11	0.8	–	–	–
CCGT 120408E-SF3:T6310	●	0.8	200	0.12	1.0	140	0.12	1.0	160	0.12	1.0	600	0.14	1.0	60	0.11	0.8	40	0.10	0.7
CCGT 120408E-SF3:T8315	●●●	0.8	210	0.12	1.0	125	0.12	1.0	195	0.12	1.0	630	0.14	1.0	50	0.11	0.8	40	0.10	0.7
CCGT 120408E-SF3:T8415	●●●	0.8	255	0.12	1.0	135	0.12	1.0	230	0.12	1.0	645	0.14	1.0	55	0.11	0.8	45	0.10	0.7

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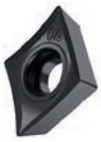
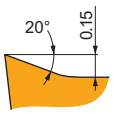
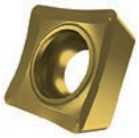
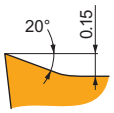
DCGT 070201E-SF3:T6310	●	0.1	160	0.05	0.5	115	0.05	0.5	125	0.05	0.5	480	0.06	0.5	45	0.04	0.4	30	0.05	0.1
DCGT 070202E-SF3:T6310	●	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.05	0.2
DCGT 070202E-SF3:T8315	●	0.2	175	0.05	0.8	105	0.05	0.8	165	0.05	0.8	525	0.06	0.8	40	0.04	0.6	35	0.05	0.2
DCGT 070202E-SF3:T8415	●	0.2	215	0.05	0.8	110	0.04	0.8	195	0.05	0.8	540	0.06	0.8	45	0.04	0.6	35	0.05	0.2
DCGT 070204E-SF3:H07	●	0.4	–	–	–	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	–	–	–
DCGT 070204E-SF3:T6310	●	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.07	0.3
DCGT 070204E-SF3:T8315	●	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.07	0.3
DCGT 070204E-SF3:T8415	●	0.4	185	0.10	0.8	95	0.09	0.8	165	0.10	0.8	465	0.12	0.8	40	0.07	0.6	30	0.07	0.3
DCGT 11T301E-SF3:T6310	●	0.1	160	0.05	0.5	115	0.05	0.5	125	0.05	0.5	480	0.06	0.5	45	0.04	0.4	30	0.05	0.1
DCGT 11T302E-SF3:H07	●	0.2	–	–	–	95	0.05	0.8	150	0.05	0.8	485	0.06	0.8	45	0.04	0.6	–	–	–
DCGT 11T302E-SF3:T6310	●	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.05	0.2
DCGT 11T302E-SF3:T8415	●	0.2	215	0.05	0.8	110	0.04	0.8	195	0.05	0.8	540	0.06	0.8	45	0.04	0.6	35	0.05	0.2
DCGT 11T304E-SF3:H07	●	0.4	–	–	–	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	–	–	–
DCGT 11T304E-SF3:T6310	●	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.07	0.3
DCGT 11T304E-SF3:T8315	●	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.07	0.3
DCGT 11T304E-SF3:T8415	●	0.4	185	0.10	0.8	95	0.09	0.8	165	0.10	0.8	465	0.12	0.8	40	0.07	0.6	30	0.07	0.3
DCGT 11T308E-SF3:H07	●	0.8	–	–	–	90	0.09	0.8	145	0.10	0.8	455	0.12	0.8	45	0.08	0.6	–	–	–
DCGT 11T308E-SF3:T6310	●	0.8	170	0.10	0.8	120	0.09	0.8	135	0.10	0.8	510	0.12	0.8	50	0.08	0.6	30	0.08	0.7
DCGT 11T308E-SF3:T8315	●	0.8	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	540	0.12	0.8	45	0.08	0.6	35	0.08	0.7
DCGT 11T308E-SF3:T8415	●	0.8	220	0.10	0.8	115	0.09	0.8	200	0.10	0.8	555	0.12	0.8	50	0.08	0.6	35	0.08	0.7

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SF3 chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.																			
ECGT 060202E-SF3:H07	0.2	–	–	–	105	0.05	0.8	170	0.05	0.8	540	0.06	0.8	55	0.04	0.6	–	–	–
ECGT 060202E-SF3:T6310	0.2	185	0.05	0.8	130	0.05	0.8	145	0.05	0.8	555	0.06	0.8	55	0.04	0.6	35	0.05	0.2
ECGT 060202E-SF3:T8415	0.2	240	0.05	0.8	125	0.04	0.8	215	0.05	0.8	600	0.06	0.8	55	0.04	0.6	40	0.05	0.2
ECGT 080304E-SF3:H07	0.4	–	–	–	85	0.09	1.0	135	0.10	1.0	430	0.12	1.0	40	0.07	0.8	–	–	–
ECGT 080304E-SF3:T6310	0.4	160	0.10	1.0	115	0.09	1.0	125	0.10	1.0	480	0.12	1.0	45	0.07	0.8	30	0.05	0.3
ECGT 080304E-SF3:T8415	0.4	200	0.10	1.0	105	0.09	1.0	185	0.10	1.0	510	0.12	1.0	45	0.07	0.8	35	0.05	0.3
  																			
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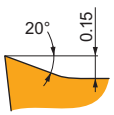
SCGT 09T304E-SF3:H07	0.4	–	–	–	95	0.09	1.0	155	0.10	1.0	495	0.12	1.0	50	0.07	0.8	–	–	–
SCGT 09T304E-SF3:T6310	0.4	185	0.10	1.0	130	0.09	1.0	145	0.10	1.0	555	0.12	1.0	55	0.07	0.8	35	0.05	0.3
SCGT 09T304E-SF3:T8315	0.4	200	0.10	1.0	120	0.09	1.0	190	0.10	1.0	600	0.12	1.0	50	0.07	0.8	40	0.05	0.3
SCGT 09T304E-SF3:T8415	0.4	240	0.10	1.0	125	0.09	1.0	215	0.10	1.0	600	0.12	1.0	55	0.07	0.8	40	0.05	0.3
SCGT 09T308E-SF3:T6310	0.8	210	0.12	1.0	150	0.12	1.0	165	0.12	1.0	630	0.14	1.0	60	0.11	0.8	40	0.10	0.7
SCGT 09T308E-SF3:T8315	0.8	220	0.12	1.0	130	0.12	1.0	205	0.12	1.0	660	0.14	1.0	55	0.11	0.8	40	0.10	0.7
SCGT 09T308E-SF3:T8415	0.8	270	0.12	1.0	140	0.12	1.0	245	0.12	1.0	675	0.14	1.0	60	0.11	0.8	45	0.10	0.7
  																			
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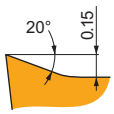
TCGT 110202E-SF3:T6310	0.2	175	0.05	0.8	125	0.05	0.8	140	0.05	0.8	525	0.06	0.8	50	0.04	0.6	35	0.05	0.2
TCGT 110202E-SF3:T8315	0.2	185	0.05	0.8	110	0.05	0.8	175	0.05	0.8	555	0.06	0.8	45	0.04	0.6	35	0.05	0.2
TCGT 110202E-SF3:T8415	0.2	225	0.05	0.8	115	0.04	0.8	205	0.05	0.8	570	0.06	0.8	50	0.04	0.6	35	0.05	0.2
TCGT 110204E-SF3:H07	0.4	–	–	–	80	0.09	0.8	130	0.10	0.8	415	0.12	0.8	40	0.07	0.6	–	–	–
TCGT 110204E-SF3:T6310	0.4	155	0.10	0.8	110	0.09	0.8	125	0.10	0.8	465	0.12	0.8	45	0.07	0.6	30	0.07	0.3
TCGT 110204E-SF3:T8315	0.4	165	0.10	0.8	95	0.09	0.8	155	0.10	0.8	495	0.12	0.8	40	0.07	0.6	30	0.07	0.3
TCGT 110204E-SF3:T8415	0.4	195	0.10	0.8	100	0.09	0.8	180	0.10	0.8	495	0.12	0.8	45	0.07	0.6	30	0.07	0.3
TCGT 16T304E-SF3:H07	0.4	–	–	–	80	0.09	1.0	125	0.10	1.0	405	0.12	1.0	40	0.07	0.8	–	–	–
TCGT 16T304E-SF3:T6310	0.4	150	0.10	1.0	105	0.09	1.0	120	0.10	1.0	450	0.12	1.0	45	0.07	0.8	30	0.07	0.3
TCGT 16T304E-SF3:T8315	0.4	160	0.10	1.0	95	0.09	1.0	150	0.10	1.0	480	0.12	1.0	40	0.07	0.8	30	0.07	0.3
TCGT 16T304E-SF3:T8415	0.4	195	0.10	1.0	100	0.09	1.0	180	0.10	1.0	495	0.12	1.0	45	0.07	0.8	30	0.07	0.3
TCGT 16T308E-SF3:H07	0.8	–	–	–	90	0.09	1.2	145	0.10	1.2	470	0.12	1.2	45	0.08	1.0	–	–	–
TCGT 16T308E-SF3:T6310	0.8	175	0.10	1.2	125	0.09	1.2	140	0.10	1.2	525	0.12	1.2	50	0.08	1.0	35	0.08	0.7
TCGT 16T308E-SF3:T8315	0.8	185	0.10	1.2	110	0.09	1.2	175	0.10	1.2	555	0.12	1.2	45	0.08	1.0	35	0.08	0.7
TCGT 16T308E-SF3:T8415	0.8	225	0.10	1.2	115	0.09	1.2	205	0.10	1.2	570	0.12	1.2	50	0.08	1.0	35	0.08	0.7
TCGT 16T312E-SF3:T6310	1.2	150	0.20	1.2	105	0.18	1.2	120	0.20	1.2	450	0.24	1.2	45	0.14	1.0	30	0.10	0.9
TCGT 16T312E-SF3:T8415	1.2	190	0.20	1.2	100	0.18	1.2	170	0.20	1.2	480	0.24	1.2	40	0.14	1.0	30	0.10	0.9

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

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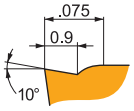
VCGT 070202E-SF3:H07	●	0.2		–	–	–	◪	80	0.05	0.8	◪	130	0.05	0.8	■	415	0.06	0.8	■	40	0.04	0.6		–	–	–
VCGT 070202E-SF3:T6310	●	0.2	◪	145	0.05	0.8	■	100	0.05	0.8	◪	115	0.05	0.8	■	435	0.06	0.8	■	40	0.04	0.6	◪	25	0.05	0.2
VCGT 070202E-SF3:T8415	●	0.2	◪	185	0.05	0.8	■	95	0.04	0.8	◪	165	0.05	0.8	◪	465	0.06	0.8	■	40	0.04	0.6	◪	30	0.05	0.2
VCGT 070204E-SF3:T6310	●	0.4	◪	125	0.10	0.8	■	90	0.09	0.8	◪	100	0.10	0.8	■	375	0.12	0.8	■	35	0.07	0.6	◪	25	0.07	0.3
VCGT 070204E-SF3:T8415	●	0.4	◪	160	0.10	0.8	■	85	0.09	0.8	◪	145	0.10	0.8	◪	405	0.12	0.8	■	35	0.07	0.6	◪	25	0.07	0.3
VCGT 110202E-SF3:T6310	●	0.2	◪	145	0.05	0.8	■	100	0.05	0.8	◪	115	0.05	0.8	■	435	0.06	0.8	■	40	0.04	0.6	◪	25	0.05	0.2
VCGT 110202E-SF3:T8315	●	0.2	◪	150	0.05	0.8	■	90	0.05	0.8	◪	140	0.05	0.8	■	450	0.06	0.8	◪	35	0.04	0.6	◪	30	0.05	0.2
VCGT 110202E-SF3:T8415	●	0.2	◪	185	0.05	0.8	■	95	0.04	0.8	◪	165	0.05	0.8	◪	465	0.06	0.8	■	40	0.04	0.6	◪	30	0.05	0.2
VCGT 110204E-SF3:H07	●	0.4		–	–	–	◪	65	0.09	0.8	◪	105	0.10	0.8	■	335	0.12	0.8	■	30	0.07	0.6		–	–	–
VCGT 110204E-SF3:T6310	●	0.4	◪	125	0.10	0.8	■	90	0.09	0.8	◪	100	0.10	0.8	■	375	0.12	0.8	■	35	0.07	0.6	◪	25	0.07	0.3
VCGT 110204E-SF3:T8315	●	0.4	◪	135	0.10	0.8	■	80	0.09	0.8	◪	125	0.10	0.8	■	405	0.12	0.8	◪	30	0.07	0.6	◪	25	0.07	0.3
VCGT 110204E-SF3:T8415	●	0.4	◪	160	0.10	0.8	■	85	0.09	0.8	◪	145	0.10	0.8	◪	405	0.12	0.8	■	35	0.07	0.6	◪	25	0.07	0.3
VCGT 110301E-SF3:T6310	●	0.1	◪	140	0.05	0.5	■	100	0.05	0.5	◪	110	0.05	0.5	■	420	0.06	0.5	■	40	0.04	0.4	◪	25	0.05	0.1
VCGT 110302E-SF3:T6310	●	0.2	◪	145	0.05	0.8	■	100	0.05	0.8	◪	115	0.05	0.8	■	435	0.06	0.8	■	40	0.04	0.6	◪	25	0.05	0.2
VCGT 110304E-SF3:T6310	●	0.4	◪	125	0.10	0.8	■	90	0.09	0.8	◪	100	0.10	0.8	■	375	0.12	0.8	■	35	0.07	0.6	◪	25	0.07	0.3
VCGT 110304E-SF3:T8415	●	0.4	◪	160	0.10	0.8	■	85	0.09	0.8	◪	145	0.10	0.8	◪	405	0.12	0.8	■	35	0.07	0.6	◪	25	0.07	0.3
VCGT 130302E-SF3:H07	●	0.2		–	–	–	◪	80	0.05	0.8	◪	130	0.05	0.8	■	415	0.06	0.8	■	40	0.04	0.6		–	–	–
VCGT 130302E-SF3:T6310	●	0.2	◪	145	0.05	0.8	■	100	0.05	0.8	◪	115	0.05	0.8	■	435	0.06	0.8	■	40	0.04	0.6	◪	25	0.05	0.2
VCGT 130302E-SF3:T8315	●	0.2	◪	150	0.05	0.8	■	90	0.05	0.8	◪	140	0.05	0.8	■	450	0.06	0.8	◪	35	0.04	0.6	◪	30	0.05	0.2
VCGT 130302E-SF3:T8415	●	0.2	◪	185	0.05	0.8	■	95	0.04	0.8	◪	165	0.05	0.8	◪	465	0.06	0.8	■	40	0.04	0.6	◪	30	0.05	0.2
VCGT 130304E-SF3:H07	●	0.4		–	–	–	◪	65	0.09	1.0	◪	105	0.10	1.0	■	335	0.12	1.0	■	30	0.07	0.8		–	–	–
VCGT 130304E-SF3:T6310	●	0.4	◪	125	0.10	1.0	■	90	0.09	1.0	◪	100	0.10	1.0	■	375	0.12	1.0	■	35	0.07	0.8	◪	25	0.07	0.3
VCGT 130304E-SF3:T8315	●	0.4	◪	130	0.10	1.0	■	75	0.09	1.0	◪	120	0.10	1.0	■	390	0.12	1.0	◪	30	0.07	0.8	◪	25	0.07	0.3
VCGT 130304E-SF3:T8415	●	0.4	◪	160	0.10	1.0	■	85	0.09	1.0	◪	145	0.10	1.0	◪	405	0.12	1.0	■	35	0.07	0.8	◪	25	0.07	0.3
VCGT 130308E-SF3:H07	●	0.8		–	–	–	◪	75	0.09	1.0	◪	120	0.10	1.0	■	390	0.12	1.0	■	35	0.08	0.8		–	–	–
VCGT 130308E-SF3:T6310	●	0.8	◪	145	0.10	1.0	■	100	0.09	1.0	◪	115	0.10	1.0	■	435	0.12	1.0	■	40	0.08	0.8	◪	25	0.08	0.7
VCGT 130308E-SF3:T8315	●	0.8	◪	155	0.10	1.0	■	90	0.09	1.0	◪	145	0.10	1.0	■	465	0.12	1.0	◪	35	0.08	0.8	◪	30	0.08	0.7
VCGT 130308E-SF3:T8415	●	0.8	◪	190	0.10	1.0	■	100	0.09	1.0	◪	170	0.10	1.0	◪	480	0.12	1.0	■	40	0.08	0.8	◪	30	0.08	0.7
VCGT 160402E-SF3:T6310	●	0.2	◪	145	0.05	0.8	■	100	0.05	0.8	◪	115	0.05	0.8	■	435	0.06	0.8	■	40	0.04	0.6	◪	25	0.05	0.2
VCGT 160402E-SF3:T8415	●	0.2	◪	185	0.05	0.8	■	95	0.04	0.8	◪	165	0.05	0.8	◪	465	0.06	0.8	■	40	0.04	0.6	◪	30	0.05	0.2
VCGT 160404E-SF3:H07	●	0.4		–	–	–	◪	65	0.09	1.0	◪	105	0.10	1.0	■	335	0.12	1.0	■	30	0.07	0.8		–	–	–
VCGT 160404E-SF3:T6310	●	0.4	◪	125	0.10	1.0	■	90	0.09	1.0	◪	100	0.10	1.0	■	375	0.12	1.0	■	35	0.07	0.8	◪	25	0.07	0.3
VCGT 160404E-SF3:T8315	●	0.4	◪	130	0.10	1.0	■	75	0.09	1.0	◪	120	0.10	1.0	■	390	0.12	1.0	◪	30	0.07	0.8	◪	25	0.07	0.3
VCGT 160404E-SF3:T8415	●	0.4	◪	160	0.10	1.0	■	85	0.09	1.0	◪	145	0.10	1.0	◪	405	0.12	1.0	■	35	0.07	0.8	◪	25	0.07	0.3
VCGT 160408E-SF3:H07	●	0.8		–	–	–	◪	75	0.09	1.2	◪	120	0.10	1.2	■	390	0.12	1.2	■	35	0.08	1.0		–	–	–
VCGT 160408E-SF3:T6310	●	0.8	◪	145	0.10	1.2	■	100	0.09	1.2	◪	115	0.10	1.2	■	435	0.12	1.2	■	40	0.08	1.0	◪	25	0.08	0.7
VCGT 160408E-SF3:T8315	●	0.8	◪	155	0.10	1.2	■	90	0.09	1.2	◪	145	0.10	1.2	■	465	0.12	1.2	◪	35	0.08	1.0	◪	30	0.08	0.7
VCGT 160408E-SF3:T8415	●	0.8	◪	185	0.10	1.2	■	95	0.09	1.2	◪	165	0.10	1.2	◪	465	0.12	1.2	■	40	0.08	1.0	◪	30	0.08	0.7
VCGT 160412E-SF3:H07	●	1.2		–	–	–	◪	60	0.18	1.2	◪	95	0.20	1.2	■	310	0.24	1.2	■	30	0.14	1.0		–	–	–
VCGT 160412E-SF3:T6310	●	1.2	◪	125	0.20	1.2	■	90	0.18	1.2	◪	100	0.20	1.2	■	375	0.24	1.2	■	35	0.14	1.0	◪	25	0.10	0.9
VCGT 160412E-SF3:T8415	●	1.2	◪	160	0.20	1.2	■	85	0.18	1.2	◪	145	0.20	1.2	◪	405	0.24	1.2	■	35	0.14	1.0	◪	25	0.10	0.9

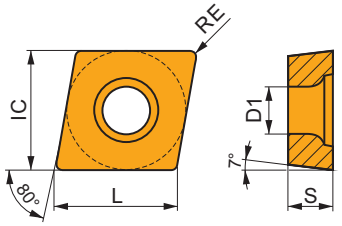
NF1



NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.

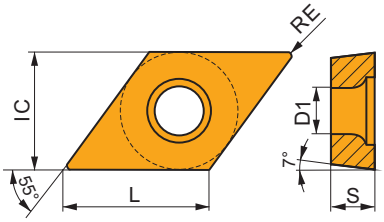
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97



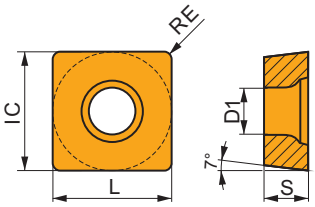
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



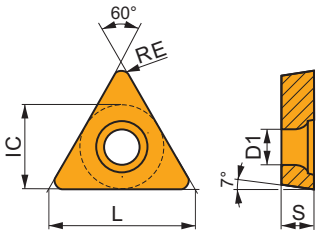
SCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76

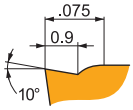
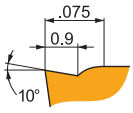
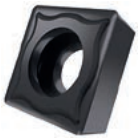
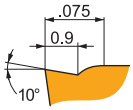
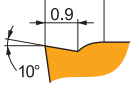


TCGT

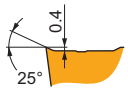
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.																			
CCGT 060204E-NF1:T6310	0.4	180	0.10	0.8	125	0.09	0.8	–	–	–	540	0.12	0.8	50	0.07	0.6	35	0.08	0.3
CCGT 060204E-NF1:T7325	0.4	210	0.10	0.8	160	0.09	0.8	–	–	–	–	–	–	65	0.07	0.6	–	–	–
CCGT 060208E-NF1:T6310	0.8	205	0.12	0.8	145	0.11	0.8	–	–	–	615	0.14	0.8	60	0.11	0.6	40	0.09	0.7
CCGT 09T304E-NF1:T6310	0.4	175	0.10	1.2	125	0.09	1.2	–	–	–	525	0.12	1.2	50	0.07	1.0	35	0.08	0.3
CCGT 09T304E-NF1:T7325	0.4	200	0.10	1.2	155	0.09	1.2	–	–	–	–	–	–	65	0.07	1.0	–	–	–
CCGT 09T308E-NF1:T6310	0.8	190	0.14	1.2	135	0.13	1.2	–	–	–	570	0.17	1.2	55	0.13	1.0	35	0.11	0.7
CCGT 09T308E-NF1:T7325	0.8	215	0.14	1.2	165	0.13	1.2	–	–	–	–	–	–	65	0.13	1.0	–	–	–
 																			
NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.																			
DCGT 11T304E-NF1:T6310	0.4	145	0.10	0.8	100	0.09	0.8	–	–	–	435	0.12	0.8	40	0.07	0.6	25	0.07	0.3
DCGT 11T304E-NF1:T7325	0.4	165	0.10	0.8	125	0.09	0.8	–	–	–	–	–	–	50	0.07	0.6	–	–	–
DCGT 11T308E-NF1:T6310	0.8	155	0.14	0.8	110	0.13	0.8	–	–	–	465	0.17	0.8	45	0.13	0.6	30	0.10	0.7
DCGT 11T308E-NF1:T7325	0.8	180	0.14	0.8	140	0.13	0.8	–	–	–	–	–	–	55	0.13	0.6	–	–	–
 																			
NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.																			
SCGT 09T308E-NF1:T6310	0.8	200	0.14	1.2	140	0.13	1.2	–	–	–	600	0.17	1.2	60	0.13	1.0	40	0.10	0.7
SCGT 120408E-NF1:T6310	0.8	180	0.18	1.4	125	0.16	1.4	–	–	–	540	0.22	1.4	50	0.16	1.1	35	0.13	0.7
SCGT 120408E-NF1:T7325	0.8	205	0.18	1.4	155	0.16	1.4	–	–	–	–	–	–	65	0.16	1.1	–	–	–
 																			
NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.																			
TCGT 110204E-NF1:T6310	0.4	155	0.10	0.8	110	0.09	0.8	–	–	–	465	0.12	0.8	45	0.08	0.6	30	0.08	0.3

SF2

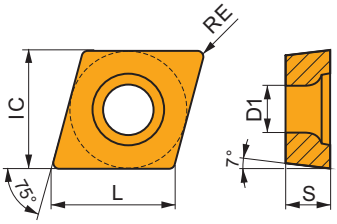


SF2 chip breaker is sharp and designed for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Steels and Non-ferrous alloys.

PRAMET

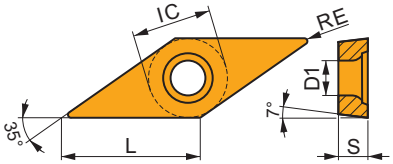
ECGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18

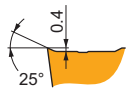
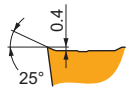


VCGT

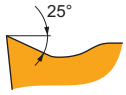
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
	 																			
SF2 chip breaker is sharp and designed for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Steels and Non-ferrous alloys.																				
ECGT 060202E-SF2:H07	●	0.2	–	–	–	105	0.05	1.0	–	–	–	525	0.06	1.0	50	0.04	0.8	–	–	–
ECGT 060202E-SF2:T6310	●	0.2	185	0.05	1.0	130	0.05	1.0	–	–	–	555	0.06	1.0	55	0.04	0.8	–	–	–
ECGT 060204E-SF2:H07	●	0.4	–	–	–	85	0.09	1.0	–	–	–	430	0.12	1.0	40	0.07	0.8	–	–	–
ECGT 060204E-SF2:T6310	●	0.4	160	0.10	1.0	115	0.09	1.0	–	–	–	480	0.12	1.0	45	0.07	0.8	–	–	–
ECGT 080302E-SF2:H07	●	0.2	–	–	–	105	0.05	1.0	–	–	–	525	0.06	1.0	50	0.04	0.8	–	–	–
ECGT 080302E-SF2:T6310	●	0.2	185	0.05	1.0	130	0.05	1.0	–	–	–	555	0.06	1.0	55	0.04	0.8	–	–	–
ECGT 080304E-SF2:H07	●	0.4	–	–	–	85	0.09	1.0	–	–	–	430	0.12	1.0	40	0.07	0.8	–	–	–
ECGT 080304E-SF2:T6310	●	0.4	160	0.10	1.0	115	0.09	1.0	–	–	–	480	0.12	1.0	45	0.07	0.8	–	–	–
	 																			
SF2 chip breaker is sharp and designed for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Steels and Non-ferrous alloys.																				
VCGT 130301E-SF2:H07	●	0.1	–	–	–	80	0.05	1.0	–	–	–	405	0.06	1.0	40	0.04	0.8	–	–	–
VCGT 130301E-SF2:T6310	●	0.1	140	0.05	1.0	100	0.05	1.0	–	–	–	420	0.06	1.0	40	0.04	0.8	–	–	–
VCGT 130302E-SF2:H07	●	0.2	–	–	–	80	0.05	1.0	–	–	–	405	0.06	1.0	40	0.04	0.8	–	–	–
VCGT 130302E-SF2:HF7	●	0.2	–	–	–	90	0.05	1.0	–	–	–	450	0.06	1.0	–	–	–	–	–	–
VCGT 130302E-SF2:T6310	●	0.2	140	0.05	1.0	100	0.05	1.0	–	–	–	420	0.06	1.0	40	0.04	0.8	–	–	–
VCGT 130304E-SF2:H07	●	0.4	–	–	–	65	0.09	1.0	–	–	–	335	0.12	1.0	30	0.07	0.8	–	–	–
VCGT 130304E-SF2:HF7	●	0.4	–	–	–	75	0.09	1.0	–	–	–	375	0.12	1.0	–	–	–	–	–	–
VCGT 130304E-SF2:T6310	●	0.4	125	0.10	1.0	90	0.09	1.0	–	–	–	375	0.12	1.0	35	0.07	0.8	–	–	–
VCGT 130308E-SF2:HF7	●	0.8	–	–	–	85	0.09	1.0	–	–	–	435	0.12	1.0	–	–	–	–	–	–
VCGT 130308E-SF2:T6310	●	0.8	145	0.10	1.0	100	0.09	1.0	–	–	–	435	0.12	1.0	40	0.08	0.8	–	–	–

AL

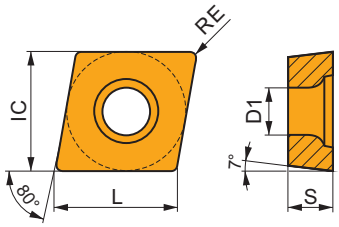


AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.

PRAMET

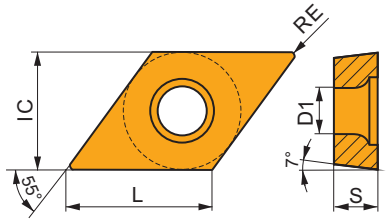
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803-AL	7.940	3.40	8.10	3.43
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



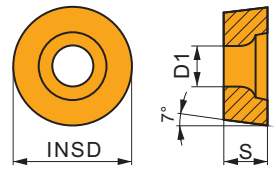
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



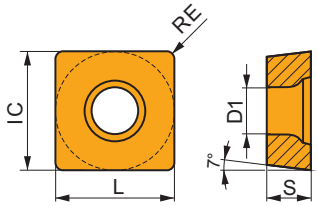
RCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0803	8.000	3.40	3.18	3.97
1003	10.000	4.40	3.18	



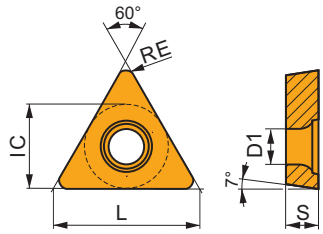
SCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.50	12.70	4.76



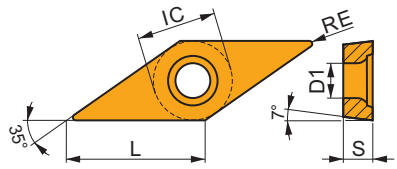
TCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



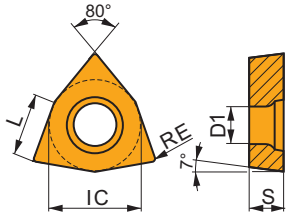
VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	3.970	2.20	6.90	2.38
1103	6.350	2.80	11.10	3.18
1303-AL	7.940	3.40	13.80	3.43
1604	9.525	4.40	16.60	4.76

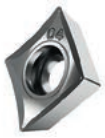
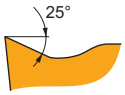
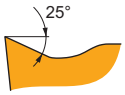
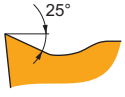
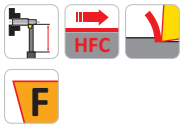
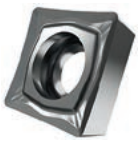
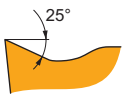


WCGT

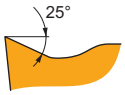
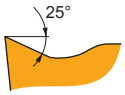
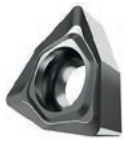
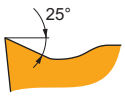
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



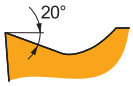
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
		(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)	vc (m/min)	f (mm/rev)	ap (mm)
			 **AL** chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																	
CCGT 060202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 450	0.12	1.0	–	–	–	–	–	–
CCGT 060202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 645	0.12	1.0	–	–	–	–	–	–
CCGT 060204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 360	0.24	1.0	–	–	–	–	–	–
CCGT 060204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 525	0.24	1.0	–	–	–	–	–	–
CCGT 080302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 645	0.12	1.0	–	–	–	–	–	–
CCGT 080304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 360	0.24	1.0	–	–	–	–	–	–
CCGT 080304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 525	0.24	1.0	–	–	–	–	–	–
CCGT 09T302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 450	0.12	1.0	–	–	–	–	–	–
CCGT 09T302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 645	0.12	1.0	–	–	–	–	–	–
CCGT 09T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 345	0.24	1.5	–	–	–	–	–	–
CCGT 09T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 495	0.24	1.5	–	–	–	–	–	–
CCGT 09T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 315	0.48	1.5	–	–	–	–	–	–
CCGT 09T308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 450	0.48	1.5	–	–	–	–	–	–
CCGT 120404F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 330	0.24	2.4	–	–	–	–	–	–
CCGT 120404F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 480	0.24	2.4	–	–	–	–	–	–
CCGT 120408F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 300	0.48	2.4	–	–	–	–	–	–
CCGT 120408F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 435	0.48	2.4	–	–	–	–	–	–
			 **AL** chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																	
DCGT 070202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 360	0.12	1.0	–	–	–	–	–	–
DCGT 070202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 510	0.12	1.0	–	–	–	–	–	–
DCGT 070204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 285	0.24	1.0	–	–	–	–	–	–
DCGT 070204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 420	0.24	1.0	–	–	–	–	–	–
DCGT 11T302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 345	0.12	1.5	–	–	–	–	–	–
DCGT 11T302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 495	0.12	1.5	–	–	–	–	–	–
DCGT 11T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 270	0.24	1.5	–	–	–	–	–	–
DCGT 11T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 390	0.24	1.5	–	–	–	–	–	–
DCGT 11T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 255	0.48	1.5	–	–	–	–	–	–
DCGT 11T308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 360	0.48	1.5	–	–	–	–	–	–
			 **AL** chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																	
RCGT 0803MOF-AL:HF7	●	–	–	–	–	–	–	–	–	–	–	■ 285	1.20	1.0	–	–	–	–	–	–
RCGT 0803MOF-AL:T0315	●	–	–	–	–	–	–	–	–	–	–	■ 420	1.20	1.0	–	–	–	–	–	–
RCGT 1003MOF-AL:HF7	●	–	–	–	–	–	–	–	–	–	–	■ 255	1.50	1.0	–	–	–	–	–	–
RCGT 1003MOF-AL:T0315	●	–	–	–	–	–	–	–	–	–	–	■ 390	1.50	1.0	–	–	–	–	–	–
			 **AL** chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																	
SCGT 120408F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 315	0.48	2.0	–	–	–	–	–	–
SCGT 120408F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 465	0.48	2.0	–	–	–	–	–	–

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	P			M			K			N			S			H		
		(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)	vc (m/min)	f (mm/rev)	ap (mm)
																				
AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																				
TCGT 090202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 375	0.12	1.0	–	–	–	–	–	–
TCGT 090202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 555	0.12	1.0	–	–	–	–	–	–
TCGT 090204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 300	0.24	1.0	–	–	–	–	–	–
TCGT 090204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 450	0.24	1.0	–	–	–	–	–	–
TCGT 110202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 360	0.12	1.5	–	–	–	–	–	–
TCGT 110202F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 525	0.12	1.5	–	–	–	–	–	–
TCGT 110204F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 285	0.24	1.5	–	–	–	–	–	–
TCGT 110204F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 420	0.24	1.5	–	–	–	–	–	–
TCGT 110208F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 270	0.48	1.5	–	–	–	–	–	–
TCGT 16T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 285	0.24	2.4	–	–	–	–	–	–
TCGT 16T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 405	0.24	2.4	–	–	–	–	–	–
TCGT 16T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 255	0.48	2.4	–	–	–	–	–	–
TCGT 16T308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 360	0.48	2.4	–	–	–	–	–	–
																				
AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																				
VCGT 070202F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 315	0.12	1.0	–	–	–	–	–	–
VCGT 110302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 300	0.12	1.5	–	–	–	–	–	–
VCGT 110302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 465	0.12	0.8	–	–	–	–	–	–
VCGT 110304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 240	0.24	1.5	–	–	–	–	–	–
VCGT 110304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 375	0.24	0.8	–	–	–	–	–	–
VCGT 130302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 285	0.12	1.7	–	–	–	–	–	–
VCGT 130302F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 420	0.12	1.7	–	–	–	–	–	–
VCGT 130304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 240	0.24	1.7	–	–	–	–	–	–
VCGT 130304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 345	0.24	1.7	–	–	–	–	–	–
VCGT 130308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 210	0.48	1.7	–	–	–	–	–	–
VCGT 130308F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 315	0.48	1.7	–	–	–	–	–	–
VCGT 160402F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 285	0.12	2.4	–	–	–	–	–	–
VCGT 160402F-AL:T0315	●	0.2	–	–	–	–	–	–	–	–	–	■ 420	0.12	2.4	–	–	–	–	–	–
VCGT 160404F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 225	0.24	2.4	–	–	–	–	–	–
VCGT 160404F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 330	0.24	2.4	–	–	–	–	–	–
VCGT 160408F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 210	0.48	2.4	–	–	–	–	–	–
VCGT 160408F-AL:T0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 300	0.48	2.4	–	–	–	–	–	–
VCGT 160412F-AL:HF7	●	1.2	–	–	–	–	–	–	–	–	–	■ 180	0.72	2.4	–	–	–	–	–	–
VCGT 160412F-AL:T0315	●	1.2	–	–	–	–	–	–	–	–	–	■ 270	0.72	2.4	–	–	–	–	–	–
																				
AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																				
WCGT 06T302F-AL:HF7	●	0.2	–	–	–	–	–	–	–	–	–	■ 450	0.12	1.0	–	–	–	–	–	–
WCGT 06T304F-AL:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 360	0.24	1.0	–	–	–	–	–	–
WCGT 06T304F-AL:T0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 525	0.24	1.0	–	–	–	–	–	–
WCGT 06T308F-AL:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 315	0.48	1.5	–	–	–	–	–	–
WCGT 080412F-AL:HF7	●	1.2	–	–	–	–	–	–	–	–	–	■ 255	0.72	2.4	–	–	–	–	–	–

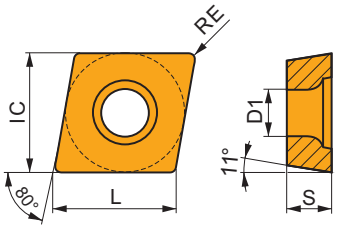
JQ JR JZ



JQ, JR, JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.

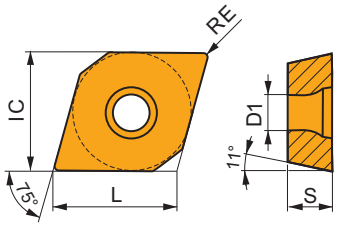
CPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97



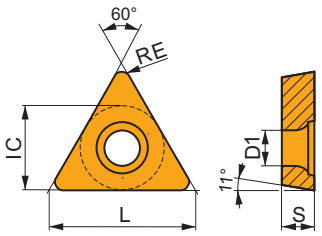
EPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.560	2.50	5.70	2.38



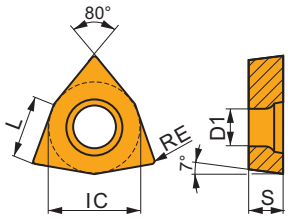
TPGX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97

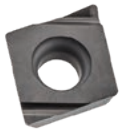
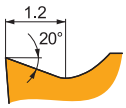
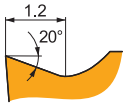
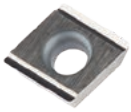
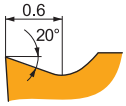
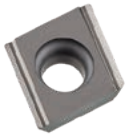
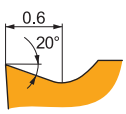
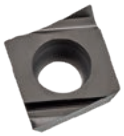
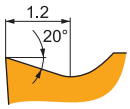
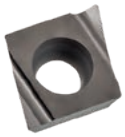
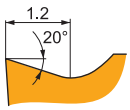
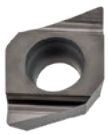
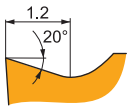
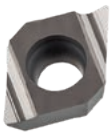
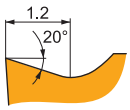
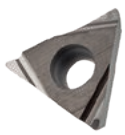
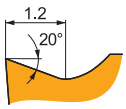


WCGX

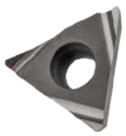
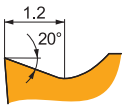
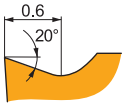
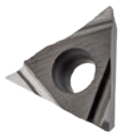
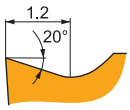
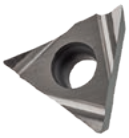
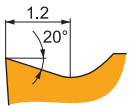
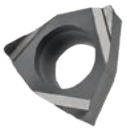
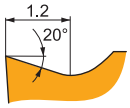
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0201	3.970	2.20	2.70	1.59



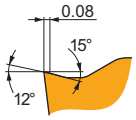
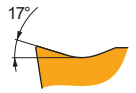
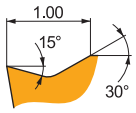
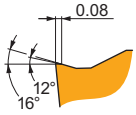
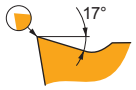
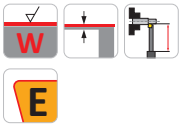
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
JQ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
CPGX 080304FR-JQ:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JQ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
CPGX 080304FL-JQ:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CPGX 09T304FL-JQ:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JR chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
CPGX 060204FR-JR:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CPGX 080304FR-JR:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JR chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
CPGX 060204FL-JR:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CPGX 080304FL-JR:TT010	●	0.4	350	0.06	0.5	210	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
CPGX 060202FR-JZ:TT010	●	0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
CPGX 060202FL-JZ:TT010	●	0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
EPGX 050202FR-JZ:TT010	●	0.2	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
EPGX 050202FL-JZ:TT010	●	0.2	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JQ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
TPGX 110204FR-JQ:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

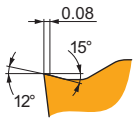
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
JQ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
TPGX 090204FL-JQ:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
TPGX 110204FL-JQ:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JR chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
TPGX 16T304FL-JR:TT010	●	0.4	295	0.06	0.5	175	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
TPGX 090202FR-JZ:TT010	●	0.2	280	0.06	0.5	165	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
TPGX 090202FL-JZ:TT010	●	0.2	280	0.06	0.5	165	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																				
WCGX 020102FL-JZ:TT010	●	0.2	330	0.06	0.5	195	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–

FINISHING – NAVIGATOR

FM			**FM** chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.
NF2			**NF2** chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.
UR			**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.
W -FM			**W-FM** chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.
W -UR			**W-UR** chip breaker has wiper edge and is designed for finishing of Steels and Cast irons. It features positive rake angle without T-land. It's also conditionally suitable for Stainless steels.

FM

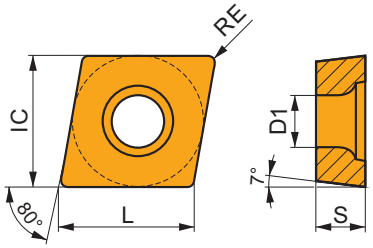


FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

PRAMET

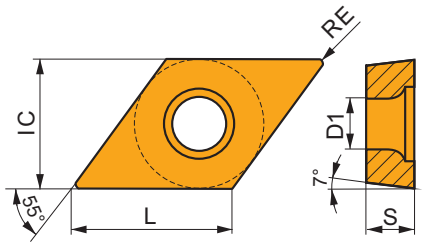
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



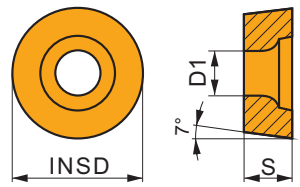
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



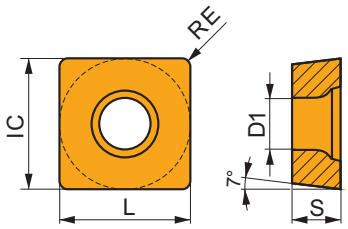
RCMT

	IC (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



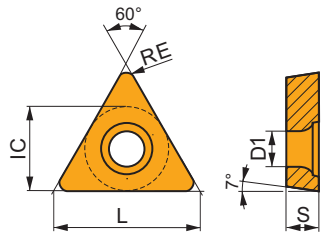
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



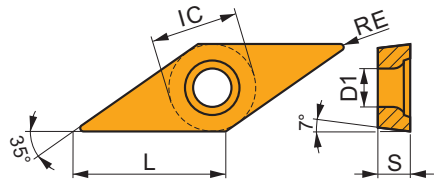
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



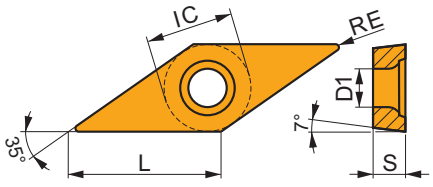
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



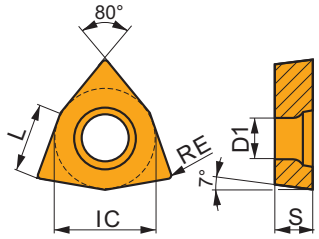
VCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



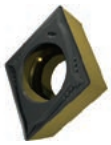
WCMT

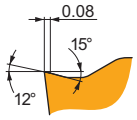
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



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

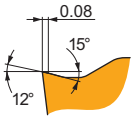




FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

CCMT 060202E-FM:T7325	●	0.2	◪	210	0.10	1.0	■	160	0.09	1.0		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 060202E-FM:T7335	●	0.2	◪	210	0.10	1.0	■	160	0.09	1.0		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 060202E-FM:T8315	●	0.2	◪	195	0.10	1.0	■	115	0.09	1.0	◪	185	0.10	1.0	◪	585	0.12	1.0		–	–	–		–	–	–
CCMT 060202E-FM:T8415	●	0.2	■	240	0.10	1.0	■	125	0.09	1.0	◪	215	0.10	1.0	◪	600	0.12	1.0		–	–	–		–	–	–
CCMT 060202E-FM:T8430	●	0.2	■	230	0.10	1.0	■	125	0.09	1.0	◪	185	0.10	1.0	◪	630	0.12	1.0		–	–	–		–	–	–
CCMT 060202E-FM:T9325	●	0.2	■	285	0.10	1.0	■	170	0.09	1.0	◪	270	0.10	1.0		–	–	–		–	–	–		–	–	–
CCMT 060202E-FM:T9415	●	0.2	■	335	0.10	1.0		–	–	–	◪	315	0.10	1.0		–	–	–		–	–	–		–	–	–
CCMT 060204E-FM:T7325	●	0.4	◪	200	0.15	1.0	■	155	0.15	1.0		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 060204E-FM:T7335	●	0.4	◪	195	0.15	1.0	■	150	0.15	1.0		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 060204E-FM:T8315	●	0.4	◪	185	0.15	1.0	■	110	0.14	1.0	◪	175	0.15	1.0	◪	555	0.18	1.0		–	–	–		–	–	–
CCMT 060204E-FM:T8415	●	0.4	■	225	0.15	1.0	■	115	0.14	1.0	◪	205	0.15	1.0	◪	570	0.18	1.0		–	–	–		–	–	–
CCMT 060204E-FM:T8430	●	0.4	■	205	0.15	1.0	■	110	0.14	1.0	◪	170	0.15	1.0	◪	570	0.18	1.0		–	–	–		–	–	–
CCMT 060204E-FM:T9315	●	0.4	■	285	0.15	1.0		–	–	–	◪	270	0.15	1.0		–	–	–		–	–	–		–	–	–
CCMT 060204E-FM:T9325	●	0.4	■	250	0.15	1.0	■	150	0.15	1.0	◪	235	0.15	1.0		–	–	–		–	–	–		–	–	–
CCMT 060204E-FM:T9415	●	0.4	■	310	0.15	1.0		–	–	–	◪	290	0.15	1.0		–	–	–		–	–	–		–	–	–
CCMT 060208E-FM:T7325	●	0.8	◪	220	0.20	1.0	■	170	0.18	1.0		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 060208E-FM:T8430	⬢	0.8	■	220	0.20	1.0	■	120	0.18	1.0	◪	180	0.20	1.0	◪	600	0.24	1.0		–	–	–		–	–	–
CCMT 060208E-FM:T9325	●	0.8	■	265	0.20	1.0	■	155	0.18	1.0	◪	250	0.20	1.0		–	–	–		–	–	–		–	–	–
CCMT 060208E-FM:T9415	●	0.8	■	335	0.20	1.0		–	–	–	◪	315	0.20	1.0		–	–	–		–	–	–		–	–	–
CCMT 09T302E-FM:T7325	●	0.2	◪	205	0.10	1.2	■	155	0.09	1.2		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 09T302E-FM:T7335	●	0.2	◪	205	0.10	1.2	■	155	0.09	1.2		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 09T302E-FM:T8315	●	0.2	◪	190	0.10	1.2	■	110	0.09	1.2	◪	180	0.10	1.2	◪	570	0.12	1.2		–	–	–		–	–	–
CCMT 09T302E-FM:T8415	●	0.2	■	230	0.10	1.2	■	120	0.09	1.2	◪	210	0.10	1.2	◪	585	0.12	1.2		–	–	–		–	–	–
CCMT 09T302E-FM:T8430	●	0.2	■	225	0.10	1.2	■	120	0.09	1.2	◪	185	0.10	1.2	◪	615	0.12	1.2		–	–	–		–	–	–
CCMT 09T302E-FM:T9325	●	0.2	■	275	0.10	1.2	■	165	0.09	1.2	◪	260	0.10	1.2		–	–	–		–	–	–		–	–	–
CCMT 09T302E-FM:T9415	●	0.2	■	330	0.10	1.2		–	–	–	◪	310	0.10	1.2		–	–	–		–	–	–		–	–	–
CCMT 09T304E-FM:T7325	●	0.4	◪	195	0.15	1.2	■	150	0.15	1.2		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 09T304E-FM:T7335	●	0.4	◪	190	0.15	1.2	■	145	0.15	1.2		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 09T304E-FM:T8315	●	0.4	◪	180	0.15	1.2	■	105	0.14	1.2	◪	170	0.15	1.2	◪	540	0.18	1.2		–	–	–		–	–	–
CCMT 09T304E-FM:T8415	●	0.4	■	220	0.15	1.2	■	115	0.14	1.2	◪	200	0.15	1.2	◪	555	0.18	1.2		–	–	–		–	–	–
CCMT 09T304E-FM:T8430	●	0.4	■	200	0.15	1.2	■	110	0.14	1.2	◪	165	0.15	1.2	◪	555	0.18	1.2		–	–	–		–	–	–
CCMT 09T304E-FM:T9315	●	0.4	■	275	0.15	1.2		–	–	–	◪	260	0.15	1.2		–	–	–		–	–	–		–	–	–
CCMT 09T304E-FM:T9325	●	0.4	■	245	0.15	1.2	■	145	0.15	1.2	◪	230	0.15	1.2		–	–	–		–	–	–		–	–	–
CCMT 09T304E-FM:T9415	●	0.4	■	305	0.15	1.2		–	–	–	◪	285	0.15	1.2		–	–	–		–	–	–		–	–	–
CCMT 09T308E-FM:T7325	●	0.8	◪	215	0.20	1.2	■	165	0.18	1.2		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 09T308E-FM:T7335	●	0.8	◪	205	0.20	1.2	■	155	0.18	1.2		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 09T308E-FM:T8315	●	0.8	◪	195	0.20	1.2	■	115	0.18	1.2	◪	185	0.20	1.2	◪	585	0.24	1.2		–	–	–		–	–	–
CCMT 09T308E-FM:T8415	●	0.8	■	240	0.20	1.2	■	125	0.18	1.2	◪	215	0.20	1.2	◪	600	0.24	1.2		–	–	–		–	–	–
CCMT 09T308E-FM:T8430	⬢	0.8	■	210	0.20	1.2	■	115	0.18	1.2	◪	175	0.20	1.2	◪	585	0.24	1.2		–	–	–		–	–	–
CCMT 09T308E-FM:T9325	●	0.8	■	260	0.20	1.2	■	155	0.18	1.2	◪	245	0.20	1.2		–	–	–		–	–	–		–	–	–
CCMT 09T308E-FM:T9415	●	0.8	■	330	0.20	1.2		–	–	–	◪	310	0.20	1.2		–	–	–		–	–	–		–	–	–
CCMT 120404E-FM:T7325	●	0.4	◪	190	0.15	1.7	■	145	0.15	1.7		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 120404E-FM:T7335	●	0.4	◪	185	0.15	1.7	■	140	0.15	1.7		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 120404E-FM:T8315	●	0.4	◪	170	0.15	1.7	■	100	0.14	1.7	◪	160	0.15	1.7	◪	510	0.18	1.7		–	–	–		–	–	–
CCMT 120404E-FM:T8415	●	0.4	■	210	0.15	1.7	■	110	0.14	1.7	◪	190	0.15	1.7	◪	525	0.18	1.7		–	–	–		–	–	–
CCMT 120404E-FM:T8430	●	0.4	■	195	0.15	1.7	■	105	0.14	1.7	◪	160	0.15	1.7	◪	540	0.18	1.7		–	–	–		–	–	–
CCMT 120404E-FM:T9325	●	0.4	■	240	0.15	1.7	■	140	0.15	1.7	◪	225	0.15	1.7		–	–	–		–	–	–		–	–	–
CCMT 120404E-FM:T9415	●	0.4	■	295	0.15	1.7		–	–	–	◪	280	0.15	1.7		–	–	–		–	–	–		–	–	–
CCMT 120408E-FM:T7325	●	0.8	◪	205	0.20	1.7	■	155	0.18	1.7		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 120408E-FM:T7335	●	0.8	◪	200	0.20	1.7	■	155	0.18	1.7		–	–	–		–	–	–		–	–	–		–	–	–
CCMT 120408E-FM:T8315	●	0.8	◪	190	0.20	1.7	■	110	0.18	1.7	◪	180	0.20	1.7	◪	570	0.24	1.7		–	–	–		–	–	–
CCMT 120408E-FM:T8415	●	0.8	■	230	0.20	1.7	■	120	0.18	1.7	◪	210	0.20	1.7	◪	585	0.24	1.7		–	–	–		–	–	–
CCMT 120408E-FM:T8430	⬢	0.8	■	205	0.20	1.7	■	110	0.18	1.7	◪	170	0.20	1.7	◪	570	0.24	1.7		–	–	–		–	–	–
CCMT 120408E-FM:T9325	●	0.8	■	250	0.20	1.7	■	150	0.18	1.7	◪	235	0.20	1.7		–	–	–		–	–	–		–	–	–
CCMT 120408E-FM:T9415	●	0.8	■	315	0.20	1.7		–	–	–	◪	295	0.20	1.7		–	–	–		–	–	–		–	–	–
CCMT 120412E-FM:T8430	⬢	1.2	■	190	0.27	1.7	■	105	0.24	1.7	◪	155	0.27	1.7	◪	525	0.32	1.7		–	–	–		–	–	–
CCMT 120412E-FM:T9325	⬢	1.2	■	235	0.27	1.7	■	140	0.24	1.7	◪	220	0.27	1.7		–	–	–		–	–	–		–	–	–

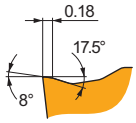
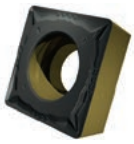
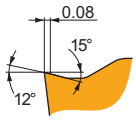
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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

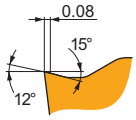
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

DCMT 070202E-FM:T7325	●	0.2	◪	175	0.10	0.8	■	135	0.09	0.8		–	–	–		–	–	–	–	–	–	–	–	–
DCMT 070202E-FM:T8315	●	0.2	◪	160	0.10	0.8	■	95	0.09	0.8	◪	150	0.10	0.8	◪	480	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T8415	●	0.2	■	190	0.10	0.8	■	100	0.09	0.8	◪	170	0.10	0.8	◪	480	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T8430	●	0.2	■	185	0.10	0.8	■	100	0.09	0.8	◪	150	0.10	0.8	◪	510	0.12	0.8	–	–	–	–	–	–
DCMT 070202E-FM:T9325	●	0.2	■	230	0.10	0.8	■	135	0.09	0.8	◪	215	0.10	0.8		–	–	–	–	–	–	–	–	–
DCMT 070202E-FM:T9415	●	0.2	■	275	0.10	0.8		–	–	–	◪	260	0.10	0.8		–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T7325	●	0.4	◪	155	0.17	0.8	■	120	0.15	0.8		–	–	–		–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T7335	●	0.4	◪	155	0.17	0.8	■	120	0.15	0.8		–	–	–		–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T8315	●	0.4	◪	160	0.12	0.8	■	95	0.11	0.8	◪	150	0.12	0.8	◪	480	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T8415	●	0.4	■	190	0.12	0.8	■	100	0.11	0.8	◪	170	0.12	0.8	◪	480	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T8430	●	0.4	■	185	0.12	0.8	■	100	0.11	0.8	◪	150	0.12	0.8	◪	510	0.14	0.8	–	–	–	–	–	–
DCMT 070204E-FM:T9325	●	0.4	■	190	0.18	0.8	■	110	0.16	0.8	◪	180	0.18	0.8		–	–	–	–	–	–	–	–	–
DCMT 070204E-FM:T9415	●	0.4	■	275	0.12	0.8		–	–	–	◪	260	0.12	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T7325	●	0.2	◪	175	0.10	0.8	■	135	0.09	0.8		–	–	–		–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T8315	●	0.2	◪	160	0.10	0.8	■	95	0.09	0.8	◪	150	0.10	0.8	◪	480	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T8415	●	0.2	■	190	0.10	0.8	■	100	0.09	0.8	◪	170	0.10	0.8	◪	480	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T8430	●	0.2	■	185	0.10	0.8	■	100	0.09	0.8	◪	150	0.10	0.8	◪	510	0.12	0.8	–	–	–	–	–	–
DCMT 11T302E-FM:T9325	●	0.2	■	230	0.10	0.8	■	135	0.09	0.8	◪	215	0.10	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T302E-FM:T9415	●	0.2	■	275	0.10	0.8		–	–	–	◪	260	0.10	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T7325	●	0.4	◪	155	0.17	0.8	■	120	0.15	0.8		–	–	–		–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T7335	●	0.4	◪	155	0.17	0.8	■	120	0.15	0.8		–	–	–		–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T8315	●	0.4	◪	160	0.12	0.8	■	95	0.11	0.8	◪	150	0.12	0.8	◪	480	0.14	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T8415	●	0.4	■	190	0.12	0.8	■	100	0.11	0.8	◪	170	0.12	0.8	◪	480	0.14	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T8430	●	0.4	■	155	0.17	0.8	■	85	0.15	0.8	◪	130	0.17	0.8	◪	435	0.20	0.8	–	–	–	–	–	–
DCMT 11T304E-FM:T9310	●	0.4	■	285	0.12	0.8		–	–	–	◪	270	0.12	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9315	●	0.4	■	255	0.12	0.8		–	–	–	◪	240	0.12	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9325	●	0.4	■	190	0.18	0.8	■	110	0.16	0.8	◪	180	0.18	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM:T9415	●	0.4	■	275	0.12	0.8		–	–	–	◪	260	0.12	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T7325	●	0.8	◪	185	0.17	0.8	■	140	0.15	0.8		–	–	–		–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T7335	●	0.8	◪	180	0.17	0.8	■	140	0.15	0.8		–	–	–		–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T8315	●	0.8	◪	170	0.17	0.8	■	100	0.15	0.8	◪	160	0.17	0.8	◪	510	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T8415	●	0.8	■	210	0.17	0.8	■	110	0.15	0.8	◪	190	0.17	0.8	◪	525	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T8430	●	0.8	■	190	0.17	0.8	■	105	0.15	0.8	◪	155	0.17	0.8	◪	525	0.20	0.8	–	–	–	–	–	–
DCMT 11T308E-FM:T9310	●	0.8	■	285	0.17	0.8		–	–	–	◪	270	0.17	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9315	●	0.8	■	260	0.17	0.8		–	–	–	◪	245	0.17	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9325	●	0.8	■	235	0.17	0.8	■	140	0.15	0.8	◪	220	0.17	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM:T9415	●	0.8	■	290	0.17	0.8		–	–	–	◪	275	0.17	0.8		–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM:T8430	●	1.2	■	175	0.22	1.2	■	95	0.22	1.2	◪	140	0.22	1.2	◪	480	0.26	1.2	–	–	–	–	–	–
DCMT 11T312E-FM:T9325	●	1.2	■	210	0.22	1.2	■	125	0.22	1.2	◪	195	0.22	1.2		–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM:T9415	●	1.2	■	265	0.22	1.2		–	–	–	◪	250	0.22	1.2		–	–	–	–	–	–	–	–	–

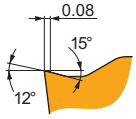
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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** chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																	
RCMT 0602MOE-FM:T7325		–	215	0.45	1.2	165	0.41	1.2	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-FM:T8430		–	200	0.45	1.2	110	0.41	1.2	165	0.45	1.2	555	0.54	1.2	–	–	–	–	–	–
RCMT 0602MOE-FM:T9325		–	235	0.45	1.2	140	0.41	1.2	220	0.45	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-FM:T9415		–	320	0.45	1.2	–	–	–	300	0.45	1.2	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-FM:T7325		–	190	0.60	1.6	145	0.54	1.6	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-FM:T8430		–	175	0.60	1.6	95	0.54	1.6	140	0.60	1.6	480	0.72	1.6	–	–	–	–	–	–
RCMT 0803MOE-FM:T9325		–	200	0.60	1.6	120	0.54	1.6	190	0.60	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-FM:T9415		–	280	0.60	1.6	–	–	–	265	0.60	1.6	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-FM:T7325		–	185	0.65	1.7	140	0.59	1.7	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-FM:T8430		–	170	0.65	1.7	90	0.59	1.7	135	0.65	1.7	465	0.78	1.7	–	–	–	–	–	–
RCMT 10T3MOE-FM:T9325		–	195	0.65	1.7	115	0.59	1.7	185	0.65	1.7	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-FM:T9415		–	275	0.65	1.7	–	–	–	260	0.65	1.7	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-FM:T7325		–	175	0.70	1.8	135	0.63	1.8	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-FM:T8430		–	155	0.70	1.8	85	0.63	1.8	130	0.70	1.8	435	0.84	1.8	–	–	–	–	–	–
RCMT 1204MOE-FM:T9325		–	190	0.70	1.8	110	0.63	1.8	180	0.70	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-FM:T9415		–	260	0.70	1.8	–	–	–	245	0.70	1.8	–	–	–	–	–	–	–	–	–
			**FM** chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																	
SCMT 09T304E-FM:T7325		0.4	205	0.15	1.2	155	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T7335		0.4	200	0.15	1.2	155	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T8315		0.4	190	0.15	1.2	110	0.14	1.2	180	0.15	1.2	570	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T8415		0.4	230	0.15	1.2	120	0.14	1.2	210	0.15	1.2	585	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T8430		0.4	210	0.15	1.2	115	0.14	1.2	175	0.15	1.2	585	0.18	1.2	–	–	–	–	–	–
SCMT 09T304E-FM:T9325		0.4	260	0.15	1.2	155	0.15	1.2	245	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM:T9415		0.4	320	0.15	1.2	–	–	–	300	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T7325		0.8	225	0.20	1.2	175	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T7335		0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T8315		0.8	205	0.20	1.2	120	0.18	1.2	190	0.20	1.2	615	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T8415		0.8	250	0.20	1.2	130	0.18	1.2	225	0.20	1.2	630	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T8430		0.8	225	0.20	1.2	120	0.18	1.2	185	0.20	1.2	615	0.24	1.2	–	–	–	–	–	–
SCMT 09T308E-FM:T9325		0.8	275	0.20	1.2	165	0.18	1.2	260	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM:T9415		0.8	350	0.20	1.2	–	–	–	330	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T7325		0.4	195	0.15	1.6	150	0.15	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T8315		0.4	185	0.15	1.6	110	0.14	1.6	175	0.15	1.6	555	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T8415		0.4	225	0.15	1.6	115	0.14	1.6	205	0.15	1.6	570	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T8430		0.4	205	0.15	1.6	110	0.14	1.6	170	0.15	1.6	570	0.18	1.6	–	–	–	–	–	–
SCMT 120404E-FM:T9325		0.4	250	0.15	1.6	150	0.15	1.6	235	0.15	1.6	–	–	–	–	–	–	–	–	–
SCMT 120404E-FM:T9415		0.4	315	0.15	1.6	–	–	–	295	0.15	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T7325		0.8	215	0.20	1.6	165	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T7335		0.8	210	0.20	1.6	160	0.18	1.6	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T8315		0.8	200	0.20	1.6	120	0.18	1.6	190	0.20	1.6	600	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T8415		0.8	245	0.20	1.6	125	0.18	1.6	220	0.20	1.6	615	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T8430		0.8	220	0.20	1.6	120	0.18	1.6	180	0.20	1.6	600	0.24	1.6	–	–	–	–	–	–
SCMT 120408E-FM:T9325		0.8	265	0.20	1.6	155	0.18	1.6	250	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-FM:T9415		0.8	340	0.20	1.6	–	–	–	320	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-FM:T8430		1.2	200	0.27	1.6	110	0.24	1.6	165	0.27	1.6	555	0.32	1.6	–	–	–	–	–	–
SCMT 120412E-FM:T9325		1.2	245	0.27	1.6	145	0.24	1.6	230	0.27	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-FM:T9415		1.2	320	0.27	1.6	–	–	–	300	0.27	1.6	–	–	–	–	–	–	–	–	–

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

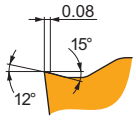
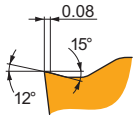
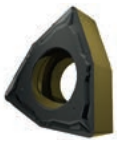
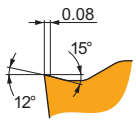
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

TCMT 110202E-FM:T7325	●	0.2	◪	185	0.10	0.8	■	140	0.09	0.8		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T7335	●	0.2	◪	185	0.10	0.8	■	140	0.09	0.8		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T8315	●	0.2	◪	170	0.10	0.8	■	100	0.09	0.8	◪	160	0.10	0.8	◪	510	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T8415	●	0.2	■	200	0.10	0.8	■	105	0.09	0.8	◪	185	0.10	0.8	◪	510	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T8430	●	0.2	■	195	0.10	0.8	■	105	0.09	0.8	◪	160	0.10	0.8	◪	540	0.12	0.8	–	–	–	–	–	–
TCMT 110202E-FM:T9325	●	0.2	■	245	0.10	0.8	■	145	0.09	0.8	◪	230	0.10	0.8		–	–	–	–	–	–	–	–	–
TCMT 110202E-FM:T9415	●	0.2	■	290	0.10	0.8		–	–	–	◪	275	0.10	0.8		–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T7325	●	0.4	◪	160	0.19	0.8	■	120	0.17	0.8		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T7335	●	0.4	◪	155	0.19	0.8	■	120	0.17	0.8		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T8315	●	0.4	◪	170	0.12	0.8	■	100	0.11	0.8	◪	160	0.12	0.8	◪	510	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T8415	●	0.4	■	210	0.12	0.8	■	110	0.11	0.8	◪	190	0.12	0.8	◪	525	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T8430	●	0.4	■	195	0.12	0.8	■	105	0.11	0.8	◪	160	0.12	0.8	◪	540	0.14	0.8	–	–	–	–	–	–
TCMT 110204E-FM:T9315	●	0.4	■	270	0.12	0.8		–	–	–	◪	255	0.12	0.8		–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T9325	●	0.4	■	205	0.18	0.8	■	120	0.16	0.8	◪	190	0.18	0.8		–	–	–	–	–	–	–	–	–
TCMT 110204E-FM:T9415	●	0.4	■	295	0.12	0.8		–	–	–	◪	280	0.12	0.8		–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T7325	●	0.8	◪	195	0.17	0.8	■	150	0.15	0.8		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T8430	●	0.8	■	200	0.17	0.8	■	110	0.15	0.8	◪	165	0.17	0.8	◪	555	0.20	0.8	–	–	–	–	–	–
TCMT 110208E-FM:T9325	●	0.8	■	250	0.17	0.8	■	150	0.15	0.8	◪	235	0.17	0.8		–	–	–	–	–	–	–	–	–
TCMT 110208E-FM:T9415	●	0.8	■	310	0.17	0.8		–	–	–	◪	290	0.17	0.8		–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T7325	●	0.4	◪	150	0.19	1.7	■	115	0.17	1.7		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T7335	●	0.4	◪	145	0.19	1.7	■	110	0.17	1.7		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T8315	●	0.4	◪	155	0.12	1.7	■	90	0.11	1.7	◪	145	0.12	1.7	◪	465	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8415	●	0.4	■	190	0.12	1.7	■	100	0.11	1.7	◪	170	0.12	1.7	◪	480	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8430	●	0.4	■	180	0.12	1.7	■	95	0.11	1.7	◪	145	0.12	1.7	◪	495	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T9325	●	0.4	■	190	0.18	1.7	■	110	0.16	1.7	◪	180	0.18	1.7		–	–	–	–	–	–	–	–	–
TCMT 16T304E-FM:T9415	●	0.4	■	270	0.12	1.7		–	–	–	◪	255	0.12	1.7		–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T7325	●	0.8	◪	180	0.17	1.7	■	140	0.15	1.7		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T7335	●	0.8	◪	175	0.17	1.7	■	135	0.15	1.7		–	–	–		–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T8315	●	0.8	◪	170	0.17	1.7	■	100	0.15	1.7	◪	160	0.17	1.7	◪	510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8415	●	0.8	■	210	0.17	1.7	■	110	0.15	1.7	◪	190	0.17	1.7	◪	525	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8430	●	0.8	■	185	0.17	1.7	■	100	0.15	1.7	◪	150	0.17	1.7	◪	510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T9325	●	0.8	■	230	0.17	1.7	■	135	0.15	1.7	◪	215	0.17	1.7		–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM:T9415	●	0.8	■	285	0.17	1.7		–	–	–	◪	270	0.17	1.7		–	–	–	–	–	–	–	–	–
																			

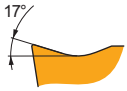
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

VBMT 110302E-FM:T7325	●	0.2	◪	160	0.10	0.8	■	120	0.09	0.8		–	–	–		–	–	–	–	–	–	–	–	–
VBMT 110302E-FM:T8315	●	0.2	◪	145	0.10	0.8	■	85	0.09	0.8	◪	135	0.10	0.8	◪	435	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T8415	●	0.2	◪	180	0.10	0.8	■	90	0.09	0.8	◪	160	0.10	0.8	◪	450	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T8430	●	0.2	■	170	0.10	0.8	■	90	0.09	0.8	◪	135	0.10	0.8	◪	465	0.12	0.8	–	–	–	–	–	–
VBMT 110302E-FM:T9325	●	0.2	■	210	0.10	0.8	■	125	0.09	0.8	◪	195	0.10	0.8		–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T7325	●	0.4	◪	140	0.19	0.8	■	105	0.17	0.8		–	–	–		–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T7335	●	0.4	◪	135	0.19	0.8	■	105	0.17	0.8		–	–	–		–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T8315	●	0.4	◪	145	0.12	0.8	■	85	0.11	0.8	◪	135	0.12	0.8	◪	435	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T8415	●	0.4	■	180	0.12	0.8	■	90	0.11	0.8	◪	160	0.12	0.8	◪	450	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T8430	●	0.4	■	170	0.12	0.8	■	90	0.11	0.8	◪	135	0.12	0.8	◪	465	0.14	0.8	–	–	–	–	–	–
VBMT 110304E-FM:T9325	●	0.4	■	175	0.19	0.8	■	105	0.17	0.8	◪	165	0.19	0.8		–	–	–	–	–	–	–	–	–
VBMT 110304E-FM:T9415	●	0.4	■	255	0.12	0.8		–	–	–	◪	240	0.12	0.8		–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T7325	●	0.8	◪	170	0.17	0.8	■	130	0.15	0.8		–	–	–		–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T8430	●	0.8	■	175	0.17	0.8	■	95	0.15	0.8	◪	140	0.17	0.8	◪	480	0.20	0.8	–	–	–	–	–	–
VBMT 110308E-FM:T9315	●	0.8	■	240	0.17	0.8		–	–	–	◪	225	0.17	0.8		–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T9325	●	0.8	■	215	0.17	0.8	■	125	0.15	0.8	◪	200	0.17	0.8		–	–	–	–	–	–	–	–	–
VBMT 110308E-FM:T9415	●	0.8	■	270	0.17	0.8		–	–	–	◪	255	0.17	0.8		–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T7325	●	0.2	◪	150	0.10	1.2	■	115	0.09	1.2		–	–	–		–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T8430	●	0.2	■	165	0.10	1.2	■	90	0.09	1.2	◪	135	0.10	1.2	◪	450	0.12	1.2	–	–	–	–	–	–
VBMT 160402E-FM:T9325	●	0.2	■	205	0.10	1.2	■	120	0.09	1.2	◪	190	0.10	1.2		–	–	–	–	–	–	–	–	–
VBMT 160402E-FM:T9415	●	0.2	■	245	0.10	1.2		–	–	–	◪	230	0.10	1.2		–	–	–	–	–	–	–	–	–

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																			
VBMT 160404E-FM:T5315	●	0.4	225	0.12	1.2	–	–	–	210	0.12	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T7325	●	0.4	130	0.19	1.2	100	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T7335	●	0.4	130	0.19	1.2	100	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T8315	●	0.4	140	0.12	1.2	80	0.11	1.2	130	0.12	1.2	420	0.14	1.2	–	–	–	–	–	–	–
VBMT 160404E-FM:T8415	●	0.4	170	0.12	1.2	90	0.11	1.2	155	0.12	1.2	435	0.14	1.2	–	–	–	–	–	–	–
VBMT 160404E-FM:T8430	●	0.4	165	0.12	1.2	90	0.11	1.2	135	0.12	1.2	450	0.14	1.2	–	–	–	–	–	–	–
VBMT 160404E-FM:T9315	●	0.4	225	0.12	1.2	–	–	–	210	0.12	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T9325	●	0.4	165	0.19	1.2	95	0.17	1.2	155	0.19	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM:T9415	●	0.4	245	0.12	1.2	–	–	–	230	0.12	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T5315	●	0.8	235	0.17	1.2	–	–	–	220	0.17	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T7325	●	0.8	165	0.17	1.2	125	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T7335	●	0.8	160	0.17	1.2	120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T8315	●	0.8	150	0.17	1.2	90	0.15	1.2	140	0.17	1.2	450	0.20	1.2	–	–	–	–	–	–	–
VBMT 160408E-FM:T8415	●	0.8	185	0.17	1.2	95	0.15	1.2	165	0.17	1.2	465	0.20	1.2	–	–	–	–	–	–	–
VBMT 160408E-FM:T8430	●	0.8	170	0.17	1.2	90	0.15	1.2	135	0.17	1.2	465	0.20	1.2	–	–	–	–	–	–	–
VBMT 160408E-FM:T9315	●	0.8	230	0.17	1.2	–	–	–	215	0.17	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T9325	●	0.8	205	0.17	1.2	120	0.15	1.2	190	0.17	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM:T9415	●	0.8	260	0.17	1.2	–	–	–	245	0.17	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T7325	●	1.2	160	0.22	1.2	120	0.22	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T8430	●	1.2	155	0.22	1.2	85	0.22	1.2	130	0.22	1.2	435	0.26	1.2	–	–	–	–	–	–	–
VBMT 160412E-FM:T9315	●	1.2	215	0.22	1.2	–	–	–	200	0.22	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T9325	●	1.2	195	0.22	1.2	115	0.22	1.2	185	0.22	1.2	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM:T9415	●	1.2	245	0.22	1.2	–	–	–	230	0.22	1.2	–	–	–	–	–	–	–	–	–	–
 																			
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																			
VCMT 160404E-FM:T7325	●	0.4	125	0.19	1.2	95	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160404E-FM:T8430	●	0.4	150	0.12	1.2	80	0.11	1.2	125	0.12	1.2	420	0.14	1.2	–	–	–	–	–	–	–
VCMT 160404E-FM:T9325	●	0.4	155	0.19	1.2	90	0.17	1.2	145	0.19	1.2	–	–	–	–	–	–	–	–	–	–
VCMT 160404E-FM:T9415	●	0.4	230	0.12	1.2	–	–	–	215	0.12	1.2	–	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T7325	●	0.8	155	0.17	1.2	120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T8430	●	0.8	155	0.17	1.2	85	0.15	1.2	130	0.17	1.2	435	0.20	1.2	–	–	–	–	–	–	–
VCMT 160408E-FM:T9325	●	0.8	195	0.17	1.2	115	0.15	1.2	185	0.17	1.2	–	–	–	–	–	–	–	–	–	–
VCMT 160408E-FM:T9415	●	0.8	245	0.17	1.2	–	–	–	230	0.17	1.2	–	–	–	–	–	–	–	–	–	–
 																			
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																			
WCMT 06T304E-FM:T8315	●	0.4	180	0.15	1.2	105	0.14	1.2	170	0.15	1.2	540	0.18	1.2	–	–	–	–	–	–	–
WCMT 06T304E-FM:T8415	●	0.4	220	0.15	1.2	115	0.14	1.2	200	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–	–
WCMT 06T304E-FM:T8430	●	0.4	200	0.15	1.2	110	0.14	1.2	165	0.15	1.2	555	0.18	1.2	–	–	–	–	–	–	–
WCMT 06T304E-FM:T9325	●	0.4	245	0.15	1.2	145	0.15	1.2	230	0.15	1.2	–	–	–	–	–	–	–	–	–	–
WCMT 06T304E-FM:T9415	●	0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T7325	●	0.8	215	0.20	1.2	165	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T7335	●	0.8	205	0.20	1.2	155	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T8315	●	0.8	195	0.20	1.2	115	0.18	1.2	185	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–	–
WCMT 06T308E-FM:T8415	●	0.8	240	0.20	1.2	125	0.18	1.2	215	0.20	1.2	600	0.24	1.2	–	–	–	–	–	–	–
WCMT 06T308E-FM:T8430	◆	0.8	210	0.20	1.2	115	0.18	1.2	175	0.20	1.2	585	0.24	1.2	–	–	–	–	–	–	–
WCMT 06T308E-FM:T9325	●	0.8	260	0.20	1.2	155	0.18	1.2	245	0.20	1.2	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-FM:T9415	●	0.8	330	0.20	1.2	–	–	–	310	0.20	1.2	–	–	–	–	–	–	–	–	–	–
WCMT 080404E-FM:T8430	●	0.4	195	0.15	1.7	105	0.14	1.7	160	0.15	1.7	540	0.18	1.7	–	–	–	–	–	–	–
WCMT 080404E-FM:T9325	●	0.4	240	0.15	1.7	140	0.15	1.7	225	0.15	1.7	–	–	–	–	–	–	–	–	–	–
WCMT 080408E-FM:T8430	◆	0.8	205	0.20	1.7	110	0.18	1.7	170	0.20	1.7	570	0.24	1.7	–	–	–	–	–	–	–
WCMT 080408E-FM:T9325	●	0.8	250	0.20	1.7	150	0.18	1.7	235	0.20	1.7	–	–	–	–	–	–	–	–	–	–
WCMT 080408E-FM:T9415	●	0.8	315	0.20	1.7	–	–	–	295	0.20	1.7	–	–	–	–	–	–	–	–	–	–
WCMT 080412E-FM:T8430	◆	1.2	190	0.27	1.7	105	0.24	1.7	155	0.27	1.7	525	0.32	1.7	–	–	–	–	–	–	–
WCMT 080412E-FM:T9325	◆	1.2	235	0.27	1.7	140	0.24	1.7	220	0.27	1.7	–	–	–	–	–	–	–	–	–	–

NF2

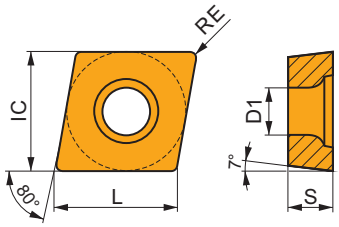


NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.

PRAMET

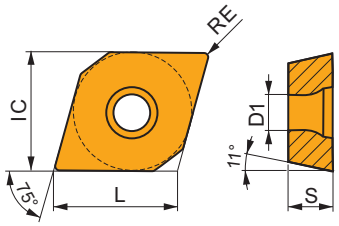
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97



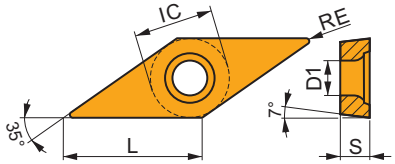
EPMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.560	2.50	5.70	2.38



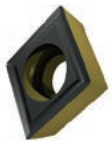
VCGT

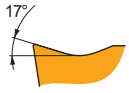
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18



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

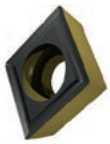
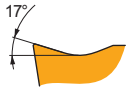
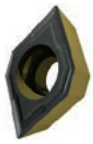
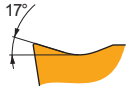
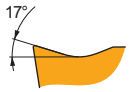
Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CCMT 060202E-NF2:T6310	●	0.2	170	0.10	0.8	120	0.09	0.8	135	0.10	0.8	510	0.12	0.8	50	0.08	0.6	–	–	–
CCMT 060202E-NF2:T7325	●	0.2	195	0.10	0.8	150	0.09	0.8	–	–	–	–	–	–	60	0.08	0.6	–	–	–
CCMT 060202E-NF2:T8415	●	0.2	220	0.10	0.8	115	0.09	0.8	200	0.10	0.8	555	0.12	0.8	50	0.08	0.6	–	–	–
CCMT 060202E-NF2:T8430	●	0.2	210	0.10	0.8	115	0.09	0.8	175	0.10	0.8	585	0.12	0.8	45	0.08	0.6	–	–	–
CCMT 060202E-NF2:T9325	●	0.2	260	0.10	0.8	155	0.09	0.8	245	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCMT 060204E-NF2:T6310	●	0.4	170	0.12	0.8	120	0.11	0.8	135	0.12	0.8	510	0.14	0.8	50	0.11	0.6	–	–	–
CCMT 060204E-NF2:T7325	●	0.4	200	0.12	0.8	155	0.11	0.8	–	–	–	–	–	–	65	0.11	0.6	–	–	–
CCMT 060204E-NF2:T8415	●	0.4	220	0.12	0.8	115	0.11	0.8	200	0.12	0.8	555	0.14	0.8	50	0.11	0.6	–	–	–
CCMT 060204E-NF2:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	570	0.14	0.8	45	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9325	●	0.4	255	0.12	0.8	150	0.11	0.8	240	0.12	0.8	–	–	–	55	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9335	●	0.4	220	0.12	0.8	130	0.11	0.8	–	–	–	–	–	–	45	0.11	0.6	–	–	–
CCMT 060204E-NF2:T9415	●	0.4	315	0.12	0.8	–	–	–	295	0.12	0.8	–	–	–	–	–	–	–	–	–
CCMT 080304E-NF2:T5315	●	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-NF2:T7325	●	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	60	0.11	0.8	–	–	–
CCMT 080304E-NF2:T7335	●	0.4	190	0.12	1.0	145	0.11	1.0	–	–	–	–	–	–	60	0.11	0.8	–	–	–
CCMT 080304E-NF2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	55	0.11	0.8	–	–	–
CCMT 080304E-NF2:T9335	●	0.4	215	0.12	1.2	125	0.11	1.2	–	–	–	–	–	–	45	0.11	1.0	–	–	–
CCMT 080304E-NF2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-NF2:H07	●	0.8	–	–	–	95	0.13	1.2	150	0.14	1.2	485	0.17	1.2	45	0.13	1.0	–	–	–
CCMT 080308E-NF2:T5315	●	0.8	295	0.17	1.0	–	–	–	280	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-NF2:T7325	●	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.14	0.8	–	–	–
CCMT 080308E-NF2:T7335	●	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.14	0.8	–	–	–
CCMT 080308E-NF2:T9325	●	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	55	0.14	0.8	–	–	–
CCMT 09T304E-NF2:H07	●	0.4	–	–	–	85	0.11	1.2	135	0.12	1.2	430	0.14	1.2	40	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T6310	●	0.4	165	0.12	1.2	115	0.11	1.2	130	0.12	1.2	495	0.14	1.2	45	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T7325	●	0.4	190	0.12	1.2	145	0.11	1.2	–	–	–	–	–	–	60	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T8415	●	0.4	215	0.12	1.2	110	0.11	1.2	195	0.12	1.2	540	0.14	1.2	45	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T8430	●	0.4	200	0.12	1.2	110	0.11	1.2	165	0.12	1.2	555	0.14	1.2	40	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T9325	●	0.4	250	0.12	1.2	150	0.11	1.2	235	0.12	1.2	–	–	–	55	0.11	1.0	–	–	–
CCMT 09T304E-NF2:T9415	●	0.4	300	0.12	1.2	–	–	–	285	0.12	1.2	–	–	–	–	–	–	–	–	–



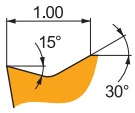


NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.																			
CCMT 09T308E-NF2:H07	0.8	–	–	–	95	0.13	1.2	150	0.14	1.2	485	0.17	1.2	45	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T6310	0.8	190	0.14	1.2	135	0.13	1.2	150	0.14	1.2	570	0.17	1.2	55	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T7325	0.8	215	0.14	1.2	165	0.13	1.2	–	–	–	–	–	–	65	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T8415	0.8	245	0.14	1.2	125	0.13	1.2	220	0.14	1.2	615	0.17	1.2	55	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T8430	0.8	225	0.14	1.2	120	0.13	1.2	185	0.14	1.2	615	0.17	1.2	45	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9325	0.8	275	0.14	1.2	165	0.13	1.2	260	0.14	1.2	–	–	–	60	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9335	0.8	235	0.14	1.2	140	0.13	1.2	–	–	–	–	–	–	50	0.13	1.0	–	–	–
CCMT 09T308E-NF2:T9415	0.8	340	0.14	1.2	–	–	–	320	0.14	1.2	–	–	–	–	–	–	–	–	–
 																			
NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.																			
EPMT 050202E-NF2:H07	0.2	–	–	–	80	0.09	0.8	125	0.10	0.8	405	0.12	0.8	40	0.07	0.6	–	–	–
EPMT 050202E-NF2:T7325	0.2	215	0.07	0.8	165	0.06	0.8	–	–	–	–	–	–	65	0.06	0.6	–	–	–
EPMT 050202E-NF2:T7335	0.2	220	0.07	0.8	170	0.06	0.8	–	–	–	–	–	–	70	0.06	0.6	–	–	–
EPMT 050202E-NF2:T9325	0.2	305	0.07	0.8	180	0.06	0.8	285	0.07	0.8	–	–	–	65	0.06	0.6	–	–	–
EPMT 050202E-NF2:T9335	0.2	200	0.10	0.8	120	0.09	0.8	–	–	–	–	–	–	45	0.07	0.6	–	–	–
EPMT 050202E-NF2:T9415	0.2	355	0.05	0.8	–	–	–	335	0.05	0.8	–	–	–	–	–	–	–	–	–
EPMT 050202E-NF2:TT010	0.2	345	0.05	0.5	205	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
 																			
NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.																			
VCGT 130302E-NF2:H07	0.2	–	–	–	60	0.09	1.0	95	0.10	1.0	310	0.12	1.0	30	0.07	0.8	–	–	–
VCGT 130302E-NF2:T6310	0.2	125	0.07	1.0	90	0.06	1.0	100	0.07	1.0	375	0.08	1.0	35	0.06	0.8	–	–	–
VCGT 130302E-NF2:T7325	0.2	150	0.07	1.0	115	0.06	1.0	–	–	–	–	–	–	45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T7335	0.2	150	0.07	1.0	115	0.06	1.0	–	–	–	–	–	–	45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T8415	0.2	160	0.07	1.0	85	0.06	1.0	145	0.07	1.0	405	0.08	1.0	35	0.06	0.8	–	–	–
VCGT 130302E-NF2:T9325	0.2	210	0.07	1.0	125	0.06	1.0	195	0.07	1.0	–	–	–	45	0.06	0.8	–	–	–
VCGT 130302E-NF2:T9335	0.2	155	0.10	1.0	90	0.09	1.0	–	–	–	–	–	–	30	0.07	0.8	–	–	–
VCGT 130302E-NF2:TT010	0.2	240	0.05	0.5	140	0.05	0.5	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:H07	0.4	–	–	–	60	0.11	1.0	95	0.12	1.0	310	0.14	1.0	30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T5315	0.4	195	0.12	1.0	–	–	–	185	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:T6310	0.4	115	0.12	1.0	80	0.11	1.0	90	0.12	1.0	345	0.14	1.0	30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T7325	0.4	135	0.12	1.0	105	0.11	1.0	–	–	–	–	–	–	40	0.08	0.8	–	–	–
VCGT 130304E-NF2:T7335	0.4	135	0.12	1.0	105	0.11	1.0	–	–	–	–	–	–	40	0.08	0.8	–	–	–
VCGT 130304E-NF2:T8415	0.4	150	0.12	1.0	75	0.11	1.0	135	0.12	1.0	375	0.14	1.0	30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T9325	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	35	0.08	0.8	–	–	–
VCGT 130304E-NF2:T9335	0.4	150	0.12	1.0	90	0.11	1.0	–	–	–	–	–	–	30	0.11	0.8	–	–	–
VCGT 130304E-NF2:T9415	0.4	225	0.10	1.0	–	–	–	210	0.10	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-NF2:TT010	0.4	245	0.06	0.5	145	0.06	0.5	–	–	–	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:T5315	0.8	205	0.17	1.0	–	–	–	190	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:T6310	0.8	125	0.17	1.0	90	0.15	1.0	100	0.17	1.0	375	0.20	1.0	35	0.12	0.8	–	–	–
VCGT 130308E-NF2:T7325	0.8	145	0.17	1.0	110	0.15	1.0	–	–	–	–	–	–	45	0.12	0.8	–	–	–
VCGT 130308E-NF2:T7335	0.8	140	0.17	1.0	105	0.15	1.0	–	–	–	–	–	–	45	0.12	0.8	–	–	–
VCGT 130308E-NF2:T8415	0.8	160	0.17	1.0	85	0.15	1.0	145	0.17	1.0	405	0.20	1.0	35	0.12	0.8	–	–	–
VCGT 130308E-NF2:T9325	0.8	180	0.17	1.0	105	0.15	1.0	170	0.17	1.0	–	–	–	40	0.12	0.8	–	–	–
VCGT 130308E-NF2:T9335	0.8	155	0.18	1.0	90	0.16	1.0	–	–	–	–	–	–	30	0.16	0.8	–	–	–
VCGT 130308E-NF2:T9415	0.8	225	0.17	1.0	–	–	–	210	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2:TT010	0.8	245	0.10	0.8	145	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–

UR

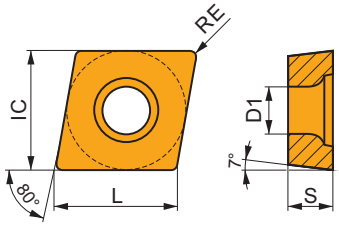


UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

PRAMET

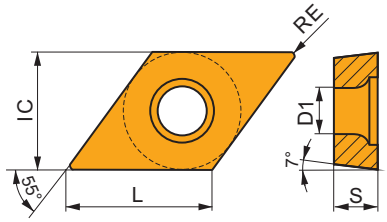
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



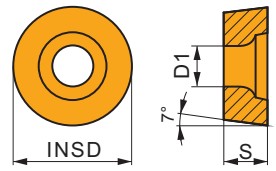
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



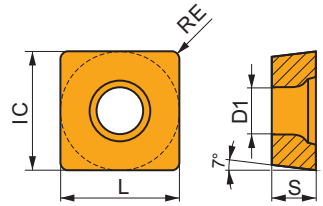
RCMT

	INSD (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



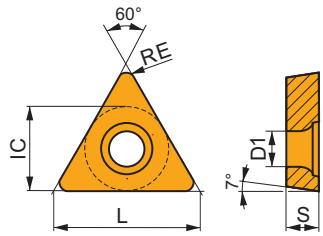
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



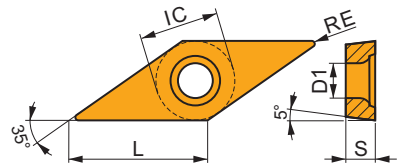
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



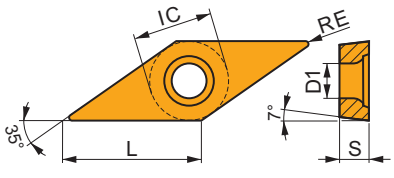
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.10	2.38
1604	9.525	4.40	16.60	4.76



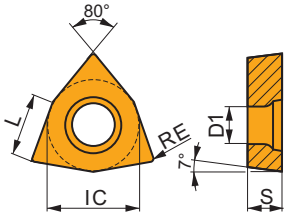
VCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76

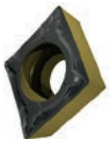
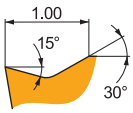


WCMT

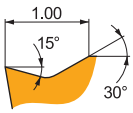
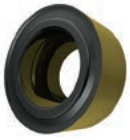
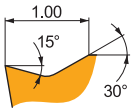
	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97



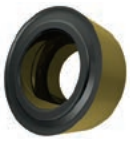
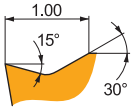
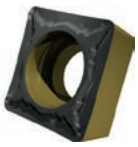
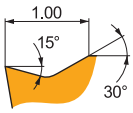
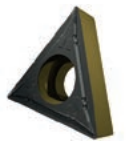
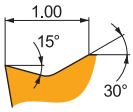
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																				
CCMT 060202E-UR:T8315	●	0.2	170	0.10	0.8	100	0.09	0.8	160	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T8415	●	0.2	210	0.10	0.8	110	0.09	0.8	190	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T8430	●	0.2	200	0.10	0.8	110	0.09	0.8	165	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T9325	●	0.2	250	0.10	0.8	150	0.09	0.8	235	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:T9415	●	0.2	295	0.10	0.8	–	–	–	280	0.10	0.8	–	–	–	–	–	–	–	–	–
CCMT 060202E-UR:TT310	●	0.2	275	0.10	0.5	165	0.09	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T5315	●	0.4	245	0.15	1.0	–	–	–	230	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T7325	●	0.4	170	0.15	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T7335	●	0.4	170	0.15	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8315	●	0.4	160	0.15	1.0	95	0.14	1.0	150	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8415	●	0.4	190	0.15	1.0	100	0.14	1.0	170	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T8430	●	0.4	175	0.15	1.0	95	0.14	1.0	140	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T9325	●	0.4	215	0.15	1.0	125	0.15	1.0	200	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:T9415	●	0.4	270	0.15	1.0	–	–	–	255	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060204E-UR:TT310	●	0.4	255	0.15	0.5	150	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T5315	●	0.8	270	0.20	1.0	–	–	–	255	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T8430	⬌	0.8	185	0.20	1.0	100	0.18	1.0	150	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T9325	●	0.8	230	0.20	1.0	135	0.18	1.0	215	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T9415	●	0.8	290	0.20	1.0	–	–	–	275	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T6310	●	0.2	160	0.10	1.0	115	0.09	1.0	125	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T8415	●	0.2	200	0.10	1.0	105	0.09	1.0	185	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:T8430	●	0.2	195	0.10	1.0	105	0.09	1.0	160	0.10	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T302E-UR:TT310	●	0.2	255	0.10	1.0	150	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T5315	●	0.4	245	0.15	1.2	–	–	–	230	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T7325	●	0.4	170	0.15	1.2	130	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T7335	●	0.4	165	0.15	1.2	125	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8315	●	0.4	155	0.15	1.2	90	0.14	1.2	145	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8415	●	0.4	190	0.15	1.2	100	0.14	1.2	170	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T8430	●	0.4	175	0.15	1.2	95	0.14	1.2	140	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9315	●	0.4	235	0.15	1.2	–	–	–	220	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9325	●	0.4	215	0.15	1.2	125	0.15	1.2	200	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T9415	●	0.4	265	0.15	1.2	–	–	–	250	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:TT310	●	0.4	235	0.15	1.2	140	0.14	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T5315	●	0.8	265	0.20	1.2	–	–	–	250	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T7325	●	0.8	185	0.20	1.2	140	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T7335	●	0.8	175	0.20	1.2	135	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8315	●	0.8	170	0.20	1.2	100	0.18	1.2	160	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8415	●	0.8	200	0.20	1.2	105	0.18	1.2	185	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T8430	⬌	0.8	185	0.20	1.2	100	0.18	1.2	150	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T9325	●	0.8	225	0.20	1.2	135	0.18	1.2	210	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T9415	●	0.8	285	0.20	1.2	–	–	–	270	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:TT310	●	0.8	255	0.20	1.2	150	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T5315	●	0.4	235	0.15	1.7	–	–	–	220	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T7325	●	0.4	160	0.15	1.7	120	0.15	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T8430	●	0.4	170	0.15	1.7	90	0.14	1.7	135	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T9325	●	0.4	205	0.15	1.7	120	0.15	1.7	190	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T9415	●	0.4	255	0.15	1.7	–	–	–	240	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T5315	●	0.8	255	0.20	1.7	–	–	–	240	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T7325	●	0.8	175	0.20	1.7	135	0.18	1.7	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T8430	⬌	0.8	180	0.20	1.7	95	0.18	1.7	145	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T9325	●	0.8	215	0.20	1.7	125	0.18	1.7	200	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T9415	●	0.8	275	0.20	1.7	–	–	–	260	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T5315	●	1.2	240	0.27	1.7	–	–	–	225	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T8430	⬌	1.2	165	0.27	1.7	90	0.24	1.7	135	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T9325	⬌	1.2	205	0.27	1.7	120	0.24	1.7	190	0.27	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T9415	●	1.2	265	0.27	1.7	–	–	–	250	0.27	1.7	–	–	–	–	–	–	–	–	–

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																			
DCMT 070202E-UR:T7325	0.2	150	0.10	0.8	115	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8315	0.2	135	0.10	0.8	80	0.09	0.8	125	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8415	0.2	165	0.10	0.8	85	0.09	0.8	150	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T8430	0.2	155	0.10	0.8	85	0.09	0.8	130	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T9325	0.2	200	0.10	0.8	120	0.09	0.8	190	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070202E-UR:T9415	0.2	235	0.10	0.8	–	–	–	220	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T7325	0.4	135	0.17	0.8	105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8315	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8415	0.4	165	0.12	0.8	85	0.11	0.8	150	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T8430	0.4	155	0.12	0.8	85	0.11	0.8	130	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T9325	0.4	165	0.18	0.8	95	0.16	0.8	155	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-UR:T9415	0.4	240	0.12	0.8	–	–	–	225	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T7325	0.2	150	0.10	0.8	115	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T8430	0.2	155	0.10	0.8	85	0.09	0.8	130	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T9325	0.2	200	0.10	0.8	120	0.09	0.8	190	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:T9415	0.2	235	0.10	0.8	–	–	–	220	0.10	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T302E-UR:TT310	0.2	210	0.10	0.8	125	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T5315	0.4	220	0.12	0.8	–	–	–	205	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T7325	0.4	135	0.17	0.8	105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T7335	0.4	130	0.17	0.8	100	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8315	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8415	0.4	165	0.12	0.8	85	0.11	0.8	150	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T8430	0.4	155	0.12	0.8	85	0.11	0.8	130	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T9325	0.4	165	0.18	0.8	95	0.16	0.8	155	0.18	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:T9415	0.4	240	0.12	0.8	–	–	–	225	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-UR:TT310	0.4	210	0.12	0.8	125	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T5315	0.8	230	0.17	0.8	–	–	–	215	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T7325	0.8	160	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T7335	0.8	155	0.17	0.8	120	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8315	0.8	145	0.17	0.8	85	0.15	0.8	135	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8415	0.8	180	0.17	0.8	90	0.15	0.8	160	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T8430	0.8	165	0.17	0.8	90	0.15	0.8	135	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T9325	0.8	200	0.17	0.8	120	0.15	0.8	190	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T9415	0.8	250	0.17	0.8	–	–	–	235	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:TT310	0.8	225	0.17	0.8	135	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR:T9325	1.2	180	0.22	1.2	105	0.20	1.2	170	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 11T312E-UR:T9415	1.2	230	0.22	1.2	–	–	–	215	0.22	1.2	–	–	–	–	–	–	–	–	–
 																			
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																			
RCMT 0602MOE-UR:T6310	–	170	0.40	1.2	120	0.36	1.2	135	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T8415	–	220	0.40	1.2	115	0.36	1.2	200	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T8430	–	180	0.40	1.2	95	0.36	1.2	145	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T9325	–	215	0.40	1.2	125	0.36	1.2	200	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0602MOE-UR:T9415	–	285	0.40	1.2	–	–	–	270	0.40	1.2	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T6310	–	160	0.45	1.6	115	0.41	1.6	125	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T7325	–	180	0.45	1.6	140	0.41	1.6	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T8415	–	200	0.45	1.6	105	0.41	1.6	185	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T8430	–	170	0.45	1.6	90	0.41	1.6	135	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T9325	–	200	0.45	1.6	120	0.41	1.6	190	0.45	1.6	–	–	–	–	–	–	–	–	–
RCMT 0803MOE-UR:T9415	–	265	0.45	1.6	–	–	–	250	0.45	1.6	–	–	–	–	–	–	–	–	–

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	P			M			K			N			S			H		
		(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)	vc (m/min)	f (mm/rev)	ap (mm)
																				
RCMT 10T3MOE-UR:T6310		–	160	0.50	1.4	115	0.45	1.4	125	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T7325		–	175	0.50	1.4	135	0.45	1.4	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T8415		–	200	0.50	1.4	105	0.45	1.4	185	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T8430		–	165	0.50	1.4	90	0.45	1.4	135	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T9325		–	190	0.50	1.4	110	0.45	1.4	180	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 10T3MOE-UR:T9415		–	260	0.50	1.4	–	–	–	245	0.50	1.4	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T6310		–	150	0.55	1.8	105	0.50	1.8	120	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T8415		–	190	0.55	1.8	100	0.49	1.8	170	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T8430		–	145	0.55	1.8	80	0.50	1.8	120	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T9315		–	200	0.55	1.8	–	–	–	190	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T9325		–	180	0.55	1.8	105	0.50	1.8	170	0.55	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204MOE-UR:T9415		–	245	0.55	1.8	–	–	–	230	0.55	1.8	–	–	–	–	–	–	–	–	–
																				
SCMT 09T304E-UR:T8430		0.4	180	0.15	1.2	95	0.14	1.2	145	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-UR:T9325		0.4	225	0.15	1.2	135	0.15	1.2	210	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T304E-UR:T9415		0.4	280	0.15	1.2	–	–	–	265	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T5315		0.8	280	0.20	1.2	–	–	–	265	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T8430		0.8	190	0.20	1.2	105	0.18	1.2	155	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T9325		0.8	235	0.20	1.2	140	0.18	1.2	220	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:T9415		0.8	300	0.20	1.2	–	–	–	285	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR:TT310		0.8	270	0.20	1.2	160	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T5315		0.8	270	0.20	1.6	–	–	–	255	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T8430		0.8	185	0.20	1.6	100	0.18	1.6	150	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T9325		0.8	230	0.20	1.6	135	0.18	1.6	215	0.20	1.6	–	–	–	–	–	–	–	–	–
SCMT 120412E-UR:T8430		1.2	175	0.27	1.6	95	0.24	1.6	140	0.27	1.6	–	–	–	–	–	–	–	–	–
																				
TCMT 110204E-UR:T7325		0.4	135	0.19	0.8	105	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T8430		0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T9325		0.4	175	0.18	0.8	105	0.16	0.8	165	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-UR:T9415		0.4	255	0.12	0.8	–	–	–	240	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T8430		0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T9325		0.4	175	0.18	0.8	105	0.16	0.8	165	0.18	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:T9415		0.4	255	0.12	0.8	–	–	–	240	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T304E-UR:TT310		0.4	225	0.12	0.8	135	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T5315		0.8	245	0.17	0.8	–	–	–	230	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T7325		0.8	170	0.17	0.8	130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T8430		0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T9325		0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-UR:T9415		0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–	–	–

UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

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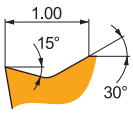
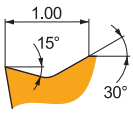
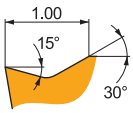
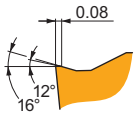
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																				
VBMT 110202E-UR:TT310	●	0.2	■ 195	0.10	0.8	◪ 115	0.09	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 110204E-UR:T8430	●	0.4	■ 145	0.12	0.8	◪ 80	0.11	0.8	◪ 120	0.12	0.8	–	–	–	–	–	–	–	–	–
VBMT 110204E-UR:T9325	●	0.4	■ 150	0.19	0.8	◪ 90	0.17	0.8	◪ 140	0.19	0.8	–	–	–	–	–	–	–	–	–
VBMT 160402E-UR:T8430	●	0.2	■ 140	0.10	1.2	◪ 75	0.09	1.2	◪ 115	0.10	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T5315	●	0.4	◪ 195	0.12	1.2	–	–	–	■ 185	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T7325	●	0.4	◪ 115	0.19	1.2	◪ 85	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T8430	●	0.4	■ 140	0.12	1.2	◪ 75	0.11	1.2	◪ 115	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T9325	●	0.4	■ 145	0.18	1.2	◪ 85	0.16	1.2	◪ 135	0.18	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:T9415	●	0.4	■ 210	0.12	1.2	–	–	–	◪ 195	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-UR:TT310	●	0.4	■ 185	0.12	1.2	◪ 110	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T5315	●	0.8	◪ 205	0.17	1.2	–	–	–	■ 190	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T7325	●	0.8	◪ 140	0.17	1.2	◪ 105	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T8430	●	0.8	■ 145	0.17	1.2	◪ 80	0.15	1.2	◪ 120	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T9310	●	0.8	■ 220	0.17	1.2	–	–	–	◪ 205	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T9325	●	0.8	■ 180	0.17	1.2	◪ 105	0.15	1.2	◪ 170	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T9415	●	0.8	■ 225	0.17	1.2	–	–	–	◪ 210	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:TT310	●	0.8	■ 200	0.17	1.2	◪ 120	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR:T8430	●	1.2	■ 135	0.22	1.2	◪ 75	0.20	1.2	◪ 110	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR:T9325	●	1.2	■ 170	0.22	1.2	◪ 100	0.20	1.2	◪ 160	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR:T9415	●	1.2	■ 210	0.22	1.2	–	–	–	◪ 195	0.22	1.2	–	–	–	–	–	–	–	–	–
																				
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																				
VCMT 110304E-UR:T7325	●	0.4	◪ 110	0.19	0.8	◪ 85	0.17	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 110304E-UR:T8430	●	0.4	■ 135	0.12	0.8	◪ 75	0.11	0.8	◪ 110	0.12	0.8	–	–	–	–	–	–	–	–	–
VCMT 110304E-UR:T9325	●	0.4	■ 140	0.19	0.8	◪ 80	0.17	0.8	◪ 130	0.19	0.8	–	–	–	–	–	–	–	–	–
VCMT 110304E-UR:T9415	●	0.4	■ 210	0.12	0.8	–	–	–	◪ 195	0.12	0.8	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T7325	●	0.8	◪ 140	0.17	0.8	◪ 105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T8430	●	0.8	■ 140	0.17	0.8	◪ 75	0.15	0.8	◪ 115	0.17	0.8	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T9325	●	0.8	■ 175	0.17	0.8	◪ 105	0.15	0.8	◪ 165	0.17	0.8	–	–	–	–	–	–	–	–	–
VCMT 110308E-UR:T9415	●	0.8	■ 220	0.17	0.8	–	–	–	◪ 205	0.17	0.8	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T7325	●	0.4	◪ 110	0.19	1.2	◪ 85	0.17	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T8430	●	0.4	■ 130	0.12	1.2	◪ 70	0.11	1.2	◪ 105	0.12	1.2	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T9325	●	0.4	■ 135	0.19	1.2	◪ 80	0.17	1.2	◪ 125	0.19	1.2	–	–	–	–	–	–	–	–	–
VCMT 160404E-UR:T9415	●	0.4	■ 200	0.12	1.2	–	–	–	◪ 190	0.12	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T7325	●	0.8	◪ 135	0.17	1.2	◪ 105	0.15	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T8430	●	0.8	■ 135	0.17	1.2	◪ 75	0.15	1.2	◪ 110	0.17	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T9325	●	0.8	■ 170	0.17	1.2	◪ 100	0.15	1.2	◪ 160	0.17	1.2	–	–	–	–	–	–	–	–	–
VCMT 160408E-UR:T9415	●	0.8	■ 210	0.17	1.2	–	–	–	◪ 195	0.17	1.2	–	–	–	–	–	–	–	–	–
																				
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																				
WCMT 06T308E-UR:T7325	●	0.8	◪ 185	0.20	1.2	◪ 140	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 06T308E-UR:T9325	●	0.8	■ 225	0.20	1.2	◪ 135	0.18	1.2	◪ 210	0.20	1.2	–	–	–	–	–	–	–	–	–

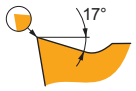
W -FM



W-FM chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.

PRAMET

W -UR



W-UR chip breaker has wiper edge and is designed for finishing of Steels and Cast irons. It features positive rake angle without T-land. It's also conditionally suitable for Stainless steels.

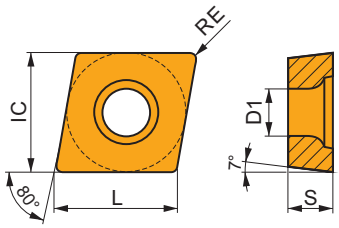
PRAMET

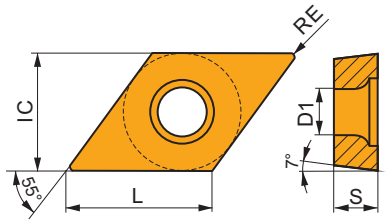
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97

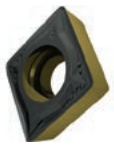
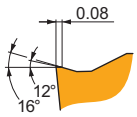
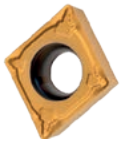
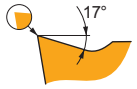
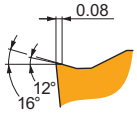
DCMX

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97

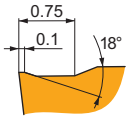
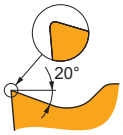
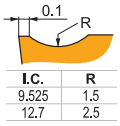




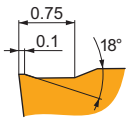
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			**W-FM** chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.																	
CCMT 060204W-FM:T8430	●	0.4	165	0.30	0.8	90	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 060204W-FM:T9325	●	0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 060204W-FM:T9415	●	0.4	250	0.30	0.8	–	–	–	235	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T8430	●	0.4	165	0.30	0.8	90	0.27	0.8	135	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T9325	●	0.4	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
CCMT 09T304W-FM:T9415	●	0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308W-FM:T8430	●	0.8	170	0.40	1.0	90	0.36	1.0	135	0.40	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308W-FM:T9325	●	0.8	200	0.40	1.0	120	0.36	1.0	190	0.40	1.0	–	–	–	–	–	–	–	–	–
			**W-UR** chip breaker has wiper edge and is designed for finishing of Steels and Cast irons. It features positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																	
CCMT 060204W-UR:TT310	●	0.4	255	0.15	0.5	150	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
			**W-FM** chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.																	
DCMX 11T304W-FM:T7325	●	0.4	130	0.30	0.8	100	0.27	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T8430	●	0.4	130	0.30	0.8	70	0.27	0.8	105	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T9325	●	0.4	155	0.30	0.8	90	0.27	0.8	145	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T304W-FM:T9415	●	0.4	200	0.30	0.8	–	–	–	190	0.30	0.8	–	–	–	–	–	–	–	–	–
DCMX 11T308W-FM:T8430	●	0.8	130	0.40	1.0	70	0.36	1.0	105	0.40	1.0	–	–	–	–	–	–	–	–	–
DCMX 11T308W-FM:T9325	●	0.8	160	0.40	1.0	95	0.36	1.0	150	0.40	1.0	–	–	–	–	–	–	–	–	–

MEDIUM – NAVIGATOR

FM2			**FM2** chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.
SI			**SI** chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.
RF	 I.C. / R 9.525 / 1.5 12.7 / 2.5		**RF** chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.
.CMW			**.CMW** flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

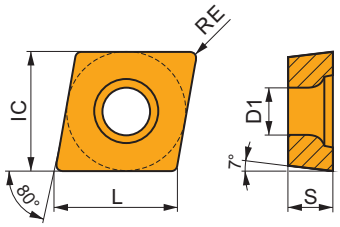
FM2



FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

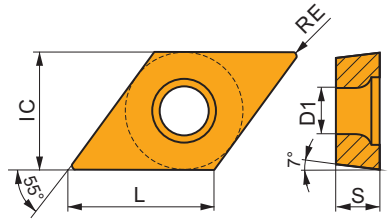
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



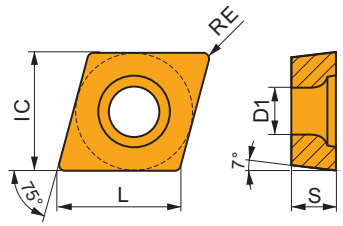
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



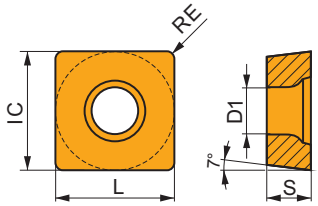
ECMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



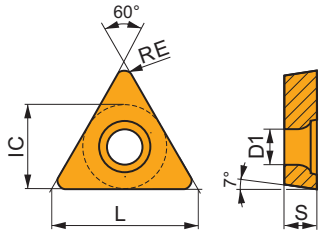
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97



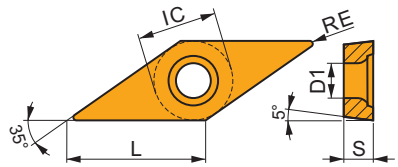
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



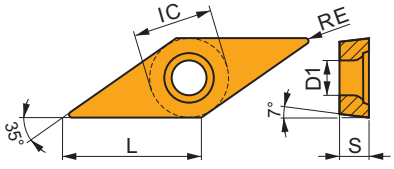
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76

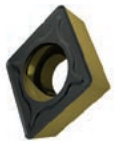
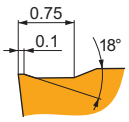
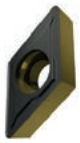
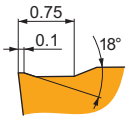


VCGT

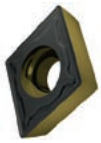
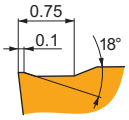
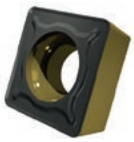
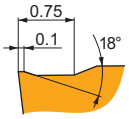
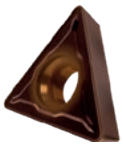
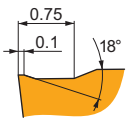
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18



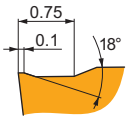
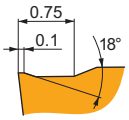
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			**FM2** chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																	
CCMT 080304E-FM2:T8430	●	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9335	●	0.4	215	0.12	1.0	125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 080304E-FM2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T8430	●●	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T9325	●●	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 080308E-FM2:T9335	●●	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T6310	●	0.4	165	0.12	1.0	115	0.11	1.0	130	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T8430	●	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-FM2:T9415	●	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T6310	●●	0.8	180	0.17	1.0	125	0.15	1.0	145	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T7325	●●	0.8	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T8430	●●	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9325	●●	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9335	●●	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-FM2:T9415	●	0.8	320	0.17	1.0	–	–	–	300	0.17	1.0	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T7325	●●	0.8	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T8430	●●	0.8	190	0.20	1.5	105	0.18	1.5	155	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T9325	●●	0.8	235	0.20	1.5	140	0.18	1.5	220	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-FM2:T9335	●●	0.8	200	0.20	1.5	120	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
			**FM2** chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																	
DCMT 070204E-FM2:T6310	●	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T7325	●	0.4	160	0.12	0.8	120	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T8430	●	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T9325	●	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 070204E-FM2:T9415	●	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T6310	●	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T7325	●	0.4	160	0.12	0.8	120	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T8430	●	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9325	●	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9335	●	0.4	175	0.12	0.8	105	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-FM2:T9415	●	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T6310	●●	0.8	150	0.17	0.8	105	0.15	0.8	120	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T7325	●●	0.8	170	0.17	0.8	130	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T8430	●●	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9325	●●	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9335	●●	0.8	180	0.17	0.8	105	0.15	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-FM2:T9415	●●	0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM2:T8430	●●	1.2	155	0.22	1.2	85	0.20	1.2	130	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 11T312E-FM2:T9325	●●	1.2	190	0.22	1.2	110	0.20	1.2	180	0.22	1.2	–	–	–	–	–	–	–	–	–
DCMT 150408E-FM2:T9325	●●	0.8	185	0.20	1.5	110	0.18	1.5	175	0.20	1.5	–	–	–	–	–	–	–	–	–
DCMT 150408E-FM2:T9335	●●	0.8	160	0.20	1.5	95	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

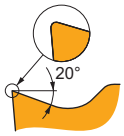
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																				
ECMT 060204E-FM2:T7325	●	0.4	180	0.12	0.8	140	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 060204E-FM2:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	–	–	–	–	–	–
ECMT 060204E-FM2:T9325	●	0.4	255	0.12	0.8	150	0.11	0.8	240	0.12	0.8	–	–	–	–	–	–	–	–	–
ECMT 060204E-FM2:T9335	●	0.4	220	0.12	0.8	130	0.11	0.8	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 060204E-FM2:T9415	●	0.4	285	0.12	0.8	–	–	–	270	0.12	0.8	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T5315	●	0.4	280	0.12	1.0	–	–	–	265	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T7325	●	0.4	170	0.12	1.0	130	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T8430	●	0.4	205	0.12	1.0	110	0.11	1.0	170	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T9325	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T9335	●	0.4	215	0.12	1.0	125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080304E-FM2:T9415	●	0.4	275	0.12	1.0	–	–	–	260	0.12	1.0	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T7325	●●●	0.8	185	0.17	1.0	140	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T8430	●●●	0.8	210	0.17	1.0	115	0.15	1.0	175	0.17	1.0	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T9325	●●●	0.8	260	0.17	1.0	155	0.15	1.0	245	0.17	1.0	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T9335	●●●	0.8	225	0.17	1.0	135	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
ECMT 080308E-FM2:T9415	●	0.8	290	0.17	1.0	–	–	–	275	0.17	1.0	–	–	–	–	–	–	–	–	–
																				
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																				
SCMT 09T304E-FM2:T8430	●	0.4	220	0.12	1.0	120	0.11	1.0	180	0.12	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T304E-FM2:T9325	●	0.4	265	0.12	1.0	155	0.11	1.0	250	0.12	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM2:T8430	●●●	0.8	225	0.17	1.0	120	0.15	1.0	185	0.17	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM2:T9325	●●●	0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	–	–	–	–	–	–	–	–	–
SCMT 09T308E-FM2:T9415	●	0.8	340	0.17	1.0	–	–	–	320	0.17	1.0	–	–	–	–	–	–	–	–	–
																				
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																				
TCMT 110204E-FM2:T8430	●	0.4	180	0.12	0.8	95	0.11	0.8	145	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110204E-FM2:T9325	●	0.4	220	0.12	0.8	130	0.11	0.8	205	0.12	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM2:T8430	●	0.8	185	0.17	0.8	100	0.15	0.8	150	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 110208E-FM2:T9325	●	0.8	225	0.17	0.8	135	0.15	0.8	210	0.17	0.8	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T7325	●	0.8	170	0.20	1.0	130	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T8430	●●●	0.8	170	0.20	1.0	90	0.18	1.0	135	0.20	1.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T9325	●	0.8	205	0.20	1.0	120	0.18	1.0	190	0.20	1.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-FM2:T9335	●	0.8	175	0.20	1.0	105	0.18	1.0	–	–	–	–	–	–	–	–	–	–	–	–

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	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)
			**FM2** chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																	
VBMT 160404E-FM2:T6310	●	0.4	■ 120	0.12	1.2	◪ 85	0.11	1.2	■ 95	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T7325	●	0.4	◪ 140	0.12	1.2	◪ 105	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T8430	●	0.4	■ 145	0.12	1.2	◪ 80	0.11	1.2	◪ 120	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9325	●	0.4	■ 185	0.12	1.2	◪ 110	0.11	1.2	◪ 175	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9335	●	0.4	■ 155	0.12	1.2	◪ 90	0.11	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160404E-FM2:T9415	●	0.4	■ 220	0.12	1.2	–	–	–	◪ 205	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T6310	●	0.8	■ 125	0.20	1.2	◪ 90	0.18	1.2	■ 100	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T7325	●	0.8	◪ 145	0.20	1.2	◪ 110	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T8430	●	0.8	■ 140	0.20	1.2	◪ 75	0.18	1.2	◪ 115	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9325	●	0.8	■ 175	0.20	1.2	◪ 105	0.18	1.2	◪ 165	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9335	●	0.8	■ 150	0.20	1.2	◪ 90	0.18	1.2	–	–	–	–	–	–	–	–	–	–	–	–
VBMT 160408E-FM2:T9415	●	0.8	■ 220	0.20	1.2	–	–	–	◪ 205	0.20	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T8430	●	1.2	■ 145	0.22	1.2	◪ 80	0.20	1.2	◪ 120	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9315	●	1.2	■ 195	0.22	1.2	–	–	–	◪ 185	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9325	●	1.2	■ 175	0.22	1.2	◪ 105	0.20	1.2	◪ 165	0.22	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-FM2:T9415	●	1.2	■ 225	0.22	1.2	–	–	–	◪ 210	0.22	1.2	–	–	–	–	–	–	–	–	–
			**FM2** chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																	
VCGT 130308E-FM2:T8430	●	0.8	■ 145	0.17	1.0	◪ 80	0.15	1.0	◪ 120	0.17	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FM2:T9325	●	0.8	■ 180	0.17	1.0	◪ 105	0.15	1.0	◪ 170	0.17	1.0	–	–	–	–	–	–	–	–	–

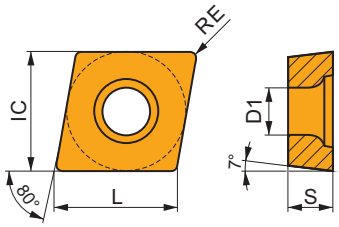
SI



SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.

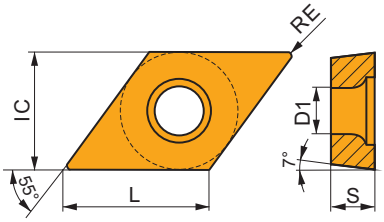
CCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



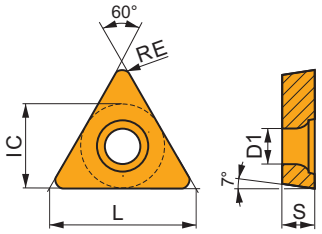
DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97

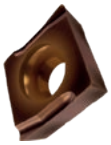
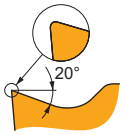
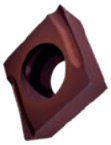
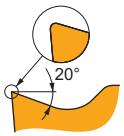


TCGT

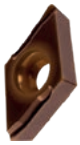
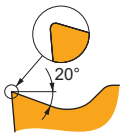
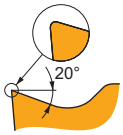
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38



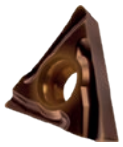
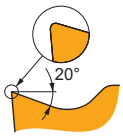
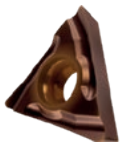
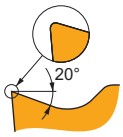
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																			
CCGT 060202ER-SI:T8430	0.2	260	0.10	0.8	140	0.09	0.8	215	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCGT 060204ER-SI:T8315	0.4	225	0.12	0.8	135	0.11	0.8	210	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 060204ER-SI:T8430	0.4	260	0.12	0.8	140	0.11	0.8	215	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 09T304ER-SI:T8315	0.4	205	0.17	0.8	120	0.15	0.8	190	0.17	0.8	–	–	–	50	0.15	0.6	–	–	–
CCGT 09T304ER-SI:T8430	0.4	230	0.17	0.8	125	0.15	0.8	185	0.17	0.8	–	–	–	45	0.15	0.6	–	–	–
CCGT 120408ER-SI:T8430	0.8	230	0.24	1.0	125	0.22	1.0	185	0.24	1.0	–	–	–	45	0.22	0.8	–	–	–
  																			
SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																			
CCGT 060202EL-SI:T8430	0.2	260	0.10	0.8	140	0.09	0.8	215	0.10	0.8	–	–	–	55	0.08	0.6	–	–	–
CCGT 060204EL-SI:T8315	0.4	225	0.12	0.8	135	0.11	0.8	210	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 060204EL-SI:T8415	0.4	275	0.12	0.8	140	0.11	0.8	250	0.12	0.8	–	–	–	60	0.10	0.6	–	–	–
CCGT 060204EL-SI:T8430	0.4	260	0.12	0.8	140	0.11	0.8	215	0.12	0.8	–	–	–	55	0.10	0.6	–	–	–
CCGT 09T304EL-SI:T8315	0.4	205	0.17	0.8	120	0.15	0.8	190	0.17	0.8	–	–	–	50	0.15	0.6	–	–	–
CCGT 09T304EL-SI:T8415	0.4	250	0.17	0.8	130	0.15	0.8	225	0.17	0.8	–	–	–	55	0.15	0.6	–	–	–
CCGT 09T304EL-SI:T8430	0.4	230	0.17	0.8	125	0.15	0.8	185	0.17	0.8	–	–	–	45	0.15	0.6	–	–	–
CCGT 120408EL-SI:T8430	0.8	230	0.24	1.0	125	0.22	1.0	185	0.24	1.0	–	–	–	45	0.22	0.8	–	–	–

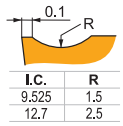
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
DCGT 11T304ER-SI:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
DCGT 11T308ER-SI:T8430	●	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	–	–	–	40	0.18	0.8	–	–	–
																				
SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
DCGT 11T304EL-SI:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
DCGT 11T308EL-SI:T8430	●	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	–	–	–	40	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	Interrupted/ Continuous cut	RE	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)
																				
SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
TCGT 110202ER-SI:T8315	●	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110202ER-SI:T8430	●	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110204ER-SI:T8430	●	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
																				
SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
TCGT 110202EL-SI:T8315	●	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110202EL-SI:T8415	●	0.2	230	0.10	0.8	120	0.09	0.8	210	0.10	0.8	–	–	–	50	0.08	0.6	–	–	–
TCGT 110202EL-SI:T8430	●	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
TCGT 110204EL-SI:T8315	●	0.4	195	0.12	0.8	115	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–
TCGT 110204EL-SI:T8415	●	0.4	230	0.12	0.8	120	0.11	0.8	210	0.12	0.8	–	–	–	50	0.10	0.6	–	–	–
TCGT 110204EL-SI:T8430	●	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	–	–	–	45	0.10	0.6	–	–	–

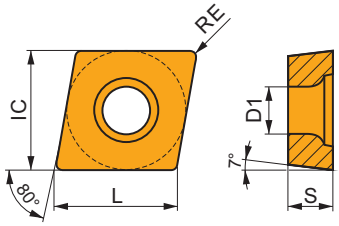
RF



RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

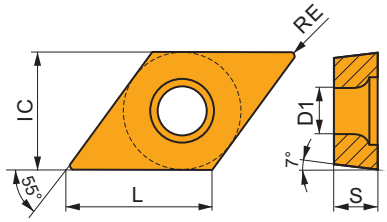
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



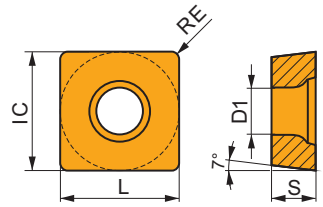
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



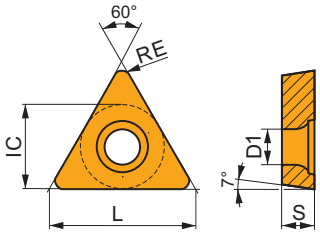
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



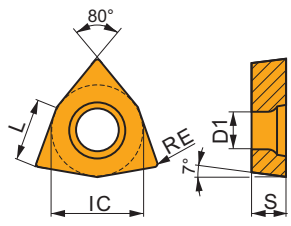
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

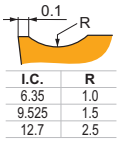
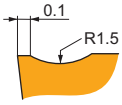
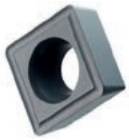
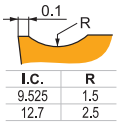
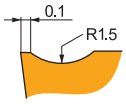
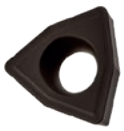
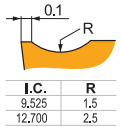


WCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



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	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)
	 I.C. 6.35, 9.525, 12.7 — R 1.0, 1.5, 2.5		**RF** chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.																	
CCMT 060202E-RF:T7335	●	0.2	150	0.15	1.0	115	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-RF:T5315	●	0.4	235	0.15	1.0	–	–	–	220	0.15	1.0	–	–	–	–	–	–	45	0.11	0.3
CCMT 060204E-RF:T7335	●	0.4	160	0.15	1.0	120	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 060204E-RF:T9325	●	0.4	205	0.15	1.0	120	0.15	1.0	190	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-RF:T7335	●	0.4	135	0.20	1.5	105	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T304E-RF:T9325	●	0.4	175	0.20	1.5	105	0.18	1.5	165	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 09T308E-RF:T5315	●	0.8	245	0.20	1.5	–	–	–	230	0.20	1.5	–	–	–	–	–	–	45	0.14	0.7
CCMT 09T308E-RF:T7335	●	0.8	165	0.20	1.5	125	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 09T308E-RF:T9325	●	0.8	210	0.20	1.5	125	0.18	1.5	195	0.20	1.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-RF:T5315	●	0.8	230	0.22	2.2	–	–	–	215	0.22	2.2	–	–	–	–	–	–	45	0.13	0.7
CCMT 120408E-RF:T7335	●	0.8	150	0.22	2.2	115	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
CCMT 120408E-RF:T9325	●	0.8	195	0.22	2.2	115	0.22	2.2	185	0.22	2.2	–	–	–	–	–	–	–	–	–
			**RF** chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.																	
DCMT 11T304E-RF:T5315	●	0.4	175	0.20	0.8	–	–	–	165	0.20	0.8	–	–	–	–	–	–	35	0.14	0.3
DCMT 11T304E-RF:T7335	●	0.4	115	0.20	0.8	85	0.18	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T304E-RF:T9325	●	0.4	150	0.20	0.8	90	0.18	0.8	140	0.20	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-RF:T5315	●	0.8	205	0.20	0.8	–	–	–	190	0.20	0.8	–	–	–	–	–	–	40	0.10	0.7
DCMT 11T308E-RF:T7335	●	0.8	140	0.20	0.8	105	0.18	0.8	–	–	–	–	–	–	–	–	–	–	–	–
DCMT 11T308E-RF:T9325	●	0.8	175	0.20	0.8	105	0.18	0.8	165	0.20	0.8	–	–	–	–	–	–	–	–	–
	 I.C. 9.525, 12.7 — R 1.5, 2.5		**RF** chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.																	
SCMT 09T308E-RF:T5315	●	0.8	255	0.20	1.5	–	–	–	240	0.20	1.5	–	–	–	–	–	–	50	0.10	0.7
SCMT 09T308E-RF:T9325	●	0.8	220	0.20	1.5	130	0.18	1.5	205	0.20	1.5	–	–	–	–	–	–	–	–	–
SCMT 120408E-RF:T5315	●	0.8	240	0.22	2.2	–	–	–	225	0.22	2.2	–	–	–	–	–	–	45	0.13	0.7
SCMT 120408E-RF:T7335	●	0.8	160	0.22	2.2	120	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-RF:T9325	●	0.8	205	0.22	2.2	120	0.22	2.2	190	0.22	2.2	–	–	–	–	–	–	–	–	–
			**RF** chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.																	
TCMT 16T308E-RF:T9325	●	0.8	175	0.20	1.5	105	0.18	1.5	165	0.20	1.5	–	–	–	–	–	–	–	–	–
	 I.C. 9.525, 12.700 — R 1.5, 2.5		**RF** chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.																	
WCMT 06T308E-RF:T7335	●	0.8	165	0.20	1.5	125	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
WCMT 080412E-RF:T7335	◆	1.2	160	0.22	2.2	120	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–

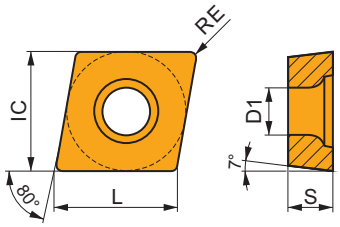
.CMW

.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

PRAMET

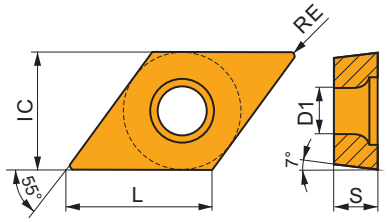
CCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



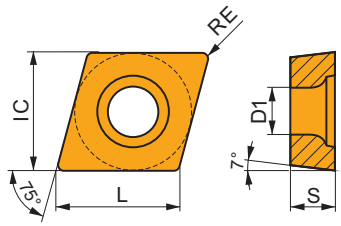
DCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



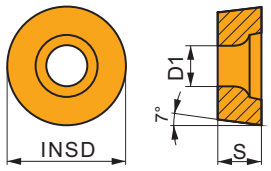
ECMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



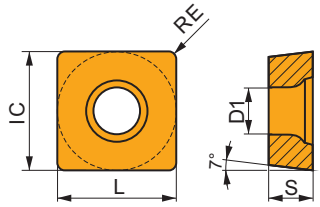
RCMW

	INSD (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76



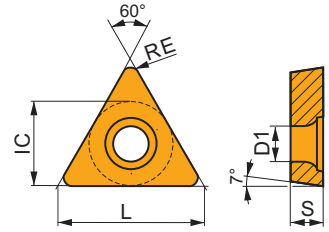
SCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



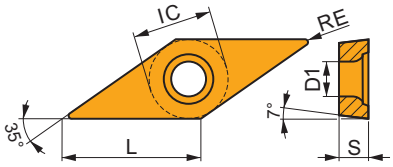
TCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



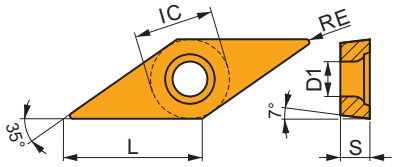
VCGW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

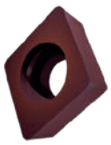
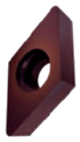


VCMW

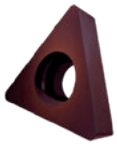
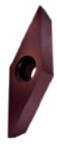
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



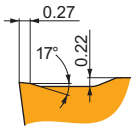
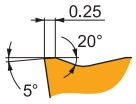
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
		(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)	vc (m/min)	f (mm/rev)	ap (mm)
																				
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
CCMW 060202:T5305	●	0.2	–	–	–	–	–	–	230	0.08	2.0	–	–	–	–	–	–	45	0.08	0.2
CCMW 060204:T5305	●	0.4	–	–	–	–	–	–	230	0.10	2.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 060204:T5315	●	0.4	–	–	–	–	–	–	195	0.10	2.0	–	–	–	–	–	–	40	0.10	0.3
CCMW 060204:T6310	●	0.4	–	–	–	–	–	–	95	0.10	2.0	–	–	–	–	–	–	20	0.10	0.3
CCMW 060204:T8415	●	0.4	–	–	–	–	–	–	145	0.10	2.0	–	–	–	–	–	–	25	0.10	0.3
CCMW 09T304:T5305	●	0.4	–	–	–	–	–	–	215	0.10	3.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 09T304:T5315	●	0.4	–	–	–	–	–	–	190	0.10	3.0	–	–	–	–	–	–	40	0.10	0.3
CCMW 09T304:T6310	●	0.4	–	–	–	–	–	–	95	0.10	3.0	–	–	–	–	–	–	20	0.10	0.3
CCMW 09T304:T8415	●	0.4	–	–	–	–	–	–	135	0.10	3.0	–	–	–	–	–	–	25	0.10	0.3
CCMW 09T308:T5305	●	0.8	–	–	–	–	–	–	200	0.20	3.0	–	–	–	–	–	–	40	0.11	0.7
CCMW 09T308:T5315	●	0.8	–	–	–	–	–	–	180	0.20	3.0	–	–	–	–	–	–	35	0.11	0.7
CCMW 09T308:T6310	●	0.8	–	–	–	–	–	–	90	0.20	3.0	–	–	–	–	–	–	20	0.11	0.7
CCMW 09T308:T8415	●	0.8	–	–	–	–	–	–	135	0.20	3.0	–	–	–	–	–	–	25	0.11	0.7
CCMW 120404:T5305	●	0.4	–	–	–	–	–	–	210	0.10	4.0	–	–	–	–	–	–	45	0.10	0.3
CCMW 120404:T5315	●	0.4	–	–	–	–	–	–	185	0.10	4.0	–	–	–	–	–	–	35	0.10	0.3
CCMW 120408:T5305	●	0.8	–	–	–	–	–	–	195	0.20	4.0	–	–	–	–	–	–	40	0.11	0.7
CCMW 120408:T5315	●	0.8	–	–	–	–	–	–	175	0.20	4.0	–	–	–	–	–	–	35	0.11	0.7
																				
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
DCMW 070202:T5305	●	0.2	–	–	–	–	–	–	200	0.08	0.8	–	–	–	–	–	–	40	0.08	0.2
DCMW 070204:T5305	●	0.4	–	–	–	–	–	–	195	0.10	0.8	–	–	–	–	–	–	40	0.10	0.3
DCMW 070204:T6310	●	0.4	–	–	–	–	–	–	85	0.10	0.8	–	–	–	–	–	–	20	0.10	0.3
DCMW 070204:T8415	●	0.4	–	–	–	–	–	–	125	0.10	0.8	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T304:T5305	●	0.4	–	–	–	–	–	–	190	0.10	1.2	–	–	–	–	–	–	40	0.10	0.3
DCMW 11T304:T5315	●	0.4	–	–	–	–	–	–	165	0.10	1.2	–	–	–	–	–	–	35	0.10	0.3
DCMW 11T304:T6310	●	0.4	–	–	–	–	–	–	80	0.10	1.2	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T304:T8415	●	0.4	–	–	–	–	–	–	120	0.10	1.2	–	–	–	–	–	–	20	0.10	0.3
DCMW 11T308:T5305	●	0.8	–	–	–	–	–	–	185	0.18	1.2	–	–	–	–	–	–	35	0.11	0.7
DCMW 11T308:T5315	●	0.8	–	–	–	–	–	–	160	0.18	1.2	–	–	–	–	–	–	30	0.11	0.7
DCMW 11T308:T6310	●	0.8	–	–	–	–	–	–	80	0.18	1.2	–	–	–	–	–	–	20	0.11	0.7
DCMW 11T308:T8415	●	0.8	–	–	–	–	–	–	125	0.18	1.2	–	–	–	–	–	–	20	0.11	0.7
																				
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
ECMW 060204:H07	●	0.4	–	–	–	–	–	–	100	0.10	2.0	–	–	–	–	–	–	–	–	–
ECMW 080304:H07	●	0.4	–	–	–	–	–	–	100	0.10	2.5	–	–	–	–	–	–	–	–	–
																				
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
RCMW 0602MO:T5305	●	–	–	–	–	–	–	–	280	0.25	0.6	–	–	–	–	–	–	55	0.17	0.4
RCMW 0602MO:T5315	●	–	–	–	–	–	–	–	250	0.25	0.6	–	–	–	–	–	–	50	0.17	0.4
RCMW 0803MO:T5305	●	–	–	–	–	–	–	–	255	0.30	0.8	–	–	–	–	–	–	50	0.17	0.5
RCMW 0803MO:T5315	●	–	–	–	–	–	–	–	230	0.30	0.8	–	–	–	–	–	–	45	0.17	0.5
RCMW 10T3MO:T5305	●	–	–	–	–	–	–	–	225	0.40	1.0	–	–	–	–	–	–	45	0.20	0.7
RCMW 10T3MO:T5315	●	–	–	–	–	–	–	–	200	0.40	1.0	–	–	–	–	–	–	40	0.20	0.7
RCMW 1204MO:T5305	●	–	–	–	–	–	–	–	205	0.45	1.2	–	–	–	–	–	–	40	0.20	0.8

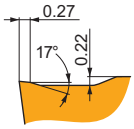
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
		(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)	vc (m/min)	f (mm/rev)	ap (mm)
																				
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
SCMW 09T304:T5305	●	0.4	–	–	–	–	–	–	■ 240	0.10	2.0	–	–	–	–	–	–	◩ 50	0.10	0.3
SCMW 09T304:T5315	●	0.4	–	–	–	–	–	–	■ 205	0.10	2.0	–	–	–	–	–	–	◩ 40	0.10	0.3
SCMW 09T308:T5305	●	0.8	–	–	–	–	–	–	■ 220	0.20	2.0	–	–	–	–	–	–	◩ 45	0.11	0.7
SCMW 09T308:T5315	●●	0.8	–	–	–	–	–	–	■ 190	0.20	2.0	–	–	–	–	–	–	◩ 40	0.11	0.7
SCMW 120408:T5305	●	0.8	–	–	–	–	–	–	■ 205	0.20	4.0	–	–	–	–	–	–	◩ 40	0.11	0.7
SCMW 120408:T5315	●●	0.8	–	–	–	–	–	–	■ 185	0.20	4.0	–	–	–	–	–	–	◩ 35	0.11	0.7
																				
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
TCMW 110204:T5305	●	0.4	–	–	–	–	–	–	■ 200	0.10	1.2	–	–	–	–	–	–	◩ 40	0.10	0.3
TCMW 110204:T5315	●	0.4	–	–	–	–	–	–	■ 180	0.10	1.2	–	–	–	–	–	–	◩ 35	0.10	0.3
TCMW 16T304:T5305	●	0.4	–	–	–	–	–	–	■ 195	0.10	1.5	–	–	–	–	–	–	◩ 40	0.10	0.3
TCMW 16T304:T5315	●	0.4	–	–	–	–	–	–	■ 175	0.10	1.5	–	–	–	–	–	–	◩ 35	0.10	0.3
TCMW 16T308:T5305	●	0.8	–	–	–	–	–	–	■ 190	0.18	1.5	–	–	–	–	–	–	◩ 40	0.11	0.7
TCMW 16T308:T5315	●	0.8	–	–	–	–	–	–	■ 165	0.18	1.5	–	–	–	–	–	–	◩ 35	0.11	0.7
TCMW 16T308:T6310	●	0.8	–	–	–	–	–	–	■ 85	0.18	1.5	–	–	–	–	–	–	◩ 20	0.11	0.7
TCMW 16T308:T8415	●●	0.8	–	–	–	–	–	–	■ 125	0.18	1.5	–	–	–	–	–	–	◩ 20	0.11	0.7
																				
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
VCGW 130302:T5305	●	0.2	–	–	–	–	–	–	■ 170	0.08	1.3	–	–	–	–	–	–	◩ 35	0.08	0.2
VCGW 130304:T5305	●	0.4	–	–	–	–	–	–	■ 165	0.10	1.3	–	–	–	–	–	–	◩ 35	0.10	0.3
																				
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
VCMW 110302:T5305	●	0.2	–	–	–	–	–	–	■ 170	0.08	1.2	–	–	–	–	–	–	◩ 35	0.08	0.2
VCMW 110304:T5305	●	0.4	–	–	–	–	–	–	■ 165	0.10	1.2	–	–	–	–	–	–	◩ 35	0.10	0.3
VCMW 110304:T6310	●	0.4	–	–	–	–	–	–	■ 70	0.10	1.2	–	–	–	–	–	–	◩ 15	0.10	0.3
VCMW 110304:T8415	●	0.4	–	–	–	–	–	–	■ 105	0.10	1.2	–	–	–	–	–	–	◩ 20	0.10	0.3
VCMW 160404:T5305	●	0.4	–	–	–	–	–	–	■ 165	0.10	1.5	–	–	–	–	–	–	◩ 35	0.10	0.3
VCMW 160404:T6310	●	0.4	–	–	–	–	–	–	■ 70	0.10	1.5	–	–	–	–	–	–	◩ 15	0.10	0.3
VCMW 160404:T8415	●	0.4	–	–	–	–	–	–	■ 100	0.10	1.5	–	–	–	–	–	–	◩ 15	0.10	0.3
VCMW 160408:T5305	●	0.8	–	–	–	–	–	–	■ 155	0.18	1.5	–	–	–	–	–	–	◩ 30	0.11	0.7
VCMW 160408:T5315	●	0.8	–	–	–	–	–	–	■ 135	0.18	1.5	–	–	–	–	–	–	◩ 25	0.11	0.7
VCMW 160408:T6310	●	0.8	–	–	–	–	–	–	■ 70	0.18	1.5	–	–	–	–	–	–	◩ 15	0.11	0.7
VCMW 160408:T8415	●	0.8	–	–	–	–	–	–	■ 100	0.18	1.5	–	–	–	–	–	–	◩ 15	0.11	0.7

ROUGHING – NAVIGATOR

RM			**RM** chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.
RM3			**RM3** chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

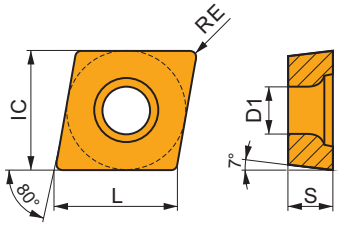
RM



RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

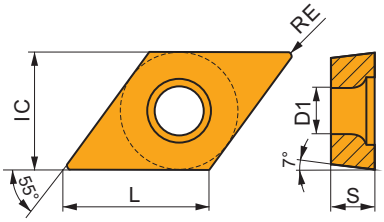
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



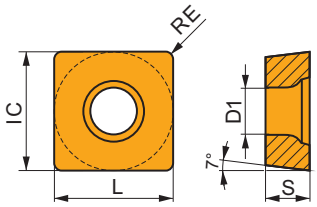
DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



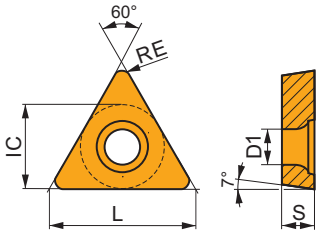
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



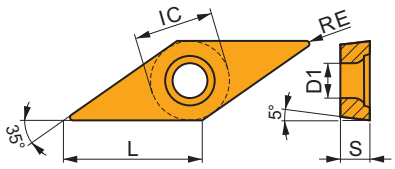
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

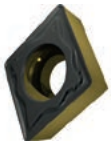
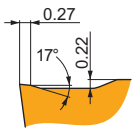
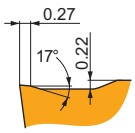


VBMT

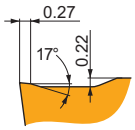
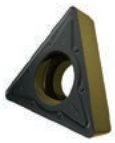
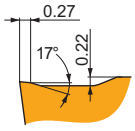
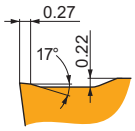
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76



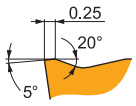
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.																				
CCMT 09T304E-RM:T5305	●	0.4	260	0.25	2.2	–	–	–	245	0.25	2.2	–	–	–	–	–	–	50	0.18	0.3
CCMT 09T304E-RM:T5315	●	0.4	235	0.25	2.2	–	–	–	220	0.25	2.2	–	–	–	–	–	–	45	0.18	0.3
CCMT 09T304E-RM:T7335	●	0.4	160	0.25	2.2	120	0.23	2.2	–	–	–	–	–	–	50	0.18	1.8	–	–	–
CCMT 09T304E-RM:T8430	●	0.4	155	0.25	2.2	85	0.23	2.2	130	0.25	2.2	–	–	–	30	0.18	1.8	25	0.18	0.3
CCMT 09T304E-RM:T9325	●	0.4	195	0.25	2.2	115	0.23	2.2	185	0.25	2.2	–	–	–	40	0.18	1.8	–	–	–
CCMT 09T304E-RM:T9415	●	0.4	255	0.25	2.2	–	–	–	240	0.25	2.2	–	–	–	–	–	–	50	0.18	0.3
CCMT 09T308E-RM:T5305	●	0.8	290	0.30	2.2	–	–	–	275	0.30	2.2	–	–	–	–	–	–	55	0.15	0.7
CCMT 09T308E-RM:T5315	⬢	0.8	265	0.30	2.2	–	–	–	250	0.30	2.2	–	–	–	–	–	–	50	0.15	0.7
CCMT 09T308E-RM:T7335	⬢	0.8	175	0.30	2.2	135	0.27	2.2	–	–	–	–	–	–	55	0.24	1.8	–	–	–
CCMT 09T308E-RM:T8430	⬢	0.8	180	0.30	2.2	95	0.27	2.2	145	0.30	2.2	–	–	–	35	0.24	1.8	30	0.15	0.7
CCMT 09T308E-RM:T9325	⬢	0.8	215	0.30	2.2	125	0.27	2.2	200	0.30	2.2	–	–	–	45	0.24	1.8	–	–	–
CCMT 09T308E-RM:T9415	⬢	0.8	285	0.30	2.2	–	–	–	270	0.30	2.2	–	–	–	–	–	–	55	0.15	0.7
CCMT 120408E-RM:T5305	●	0.8	290	0.30	2.7	–	–	–	275	0.30	2.7	–	–	–	–	–	–	55	0.15	0.7
CCMT 120408E-RM:T5315	⬢	0.8	260	0.30	2.7	–	–	–	245	0.30	2.7	–	–	–	–	–	–	50	0.15	0.7
CCMT 120408E-RM:T7335	⬢	0.8	175	0.30	2.7	135	0.27	2.7	–	–	–	–	–	–	55	0.24	2.2	–	–	–
CCMT 120408E-RM:T8430	⬢	0.8	175	0.30	2.7	95	0.27	2.7	140	0.30	2.7	–	–	–	35	0.24	2.2	30	0.15	0.7
CCMT 120408E-RM:T9325	⬢	0.8	210	0.30	2.7	125	0.27	2.7	195	0.30	2.7	–	–	–	45	0.24	2.2	–	–	–
CCMT 120408E-RM:T9415	⬢	0.8	280	0.30	2.7	–	–	–	265	0.30	2.7	–	–	–	–	–	–	55	0.15	0.7
CCMT 120412E-RM:T8430	⬢	1.2	180	0.33	2.7	95	0.30	2.7	145	0.33	2.7	–	–	–	35	0.23	2.2	30	0.17	1.0
CCMT 120412E-RM:T9325	⬢	1.2	215	0.33	2.7	125	0.30	2.7	200	0.33	2.7	–	–	–	45	0.23	2.2	–	–	–
CCMT 120412E-RM:T9415	⬢	1.2	280	0.33	2.7	–	–	–	265	0.33	2.7	–	–	–	–	–	–	55	0.17	1.0
																				
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.																				
DCMT 11T304E-RM:T5305	●	0.4	250	0.20	1.0	–	–	–	235	0.20	1.0	–	–	–	–	–	–	50	0.14	0.3
DCMT 11T304E-RM:T5315	●	0.4	220	0.20	1.0	–	–	–	205	0.20	1.0	–	–	–	–	–	–	40	0.14	0.3
DCMT 11T304E-RM:T7335	●	0.4	145	0.20	1.0	110	0.18	1.0	–	–	–	–	–	–	45	0.14	0.8	–	–	–
DCMT 11T304E-RM:T8430	●	0.4	150	0.20	1.0	80	0.18	1.0	125	0.20	1.0	–	–	–	30	0.14	0.8	25	0.14	0.3
DCMT 11T304E-RM:T9325	●	0.4	185	0.20	1.0	110	0.18	1.0	175	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
DCMT 11T304E-RM:T9415	●	0.4	235	0.20	1.0	–	–	–	220	0.20	1.0	–	–	–	–	–	–	45	0.14	0.3
DCMT 11T308E-RM:T5305	●	0.8	270	0.27	0.8	–	–	–	255	0.27	0.8	–	–	–	–	–	–	50	0.14	0.7
DCMT 11T308E-RM:T5315	●	0.8	240	0.27	0.8	–	–	–	225	0.27	0.8	–	–	–	–	–	–	45	0.14	0.7
DCMT 11T308E-RM:T7335	●	0.8	165	0.27	0.8	125	0.24	0.8	–	–	–	–	–	–	50	0.19	0.6	–	–	–
DCMT 11T308E-RM:T8430	⬢	0.8	165	0.27	0.8	90	0.24	0.8	135	0.27	0.8	–	–	–	35	0.19	0.6	25	0.14	0.7
DCMT 11T308E-RM:T9325	●	0.8	200	0.27	0.8	120	0.24	0.8	190	0.27	0.8	–	–	–	45	0.19	0.6	–	–	–
DCMT 11T308E-RM:T9415	●	0.8	255	0.27	1.0	–	–	–	240	0.27	1.0	–	–	–	–	–	–	50	0.14	0.7
DCMT 11T312E-RM:T8430	⬢	1.2	170	0.27	1.2	90	0.24	1.2	135	0.27	1.2	–	–	–	35	0.19	1.2	25	0.14	0.9
DCMT 11T312E-RM:T9315	●	1.2	225	0.27	1.2	–	–	–	210	0.27	1.2	–	–	–	–	–	–	45	0.14	0.9
DCMT 11T312E-RM:T9325	⬢	1.2	200	0.27	1.2	120	0.24	1.2	190	0.27	1.2	–	–	–	45	0.19	1.2	–	–	–
DCMT 11T312E-RM:T9415	●	1.2	260	0.27	1.2	–	–	–	245	0.27	1.2	–	–	–	–	–	–	50	0.14	0.9
DCMT 150408E-RM:T8430	⬢	0.8	150	0.27	1.9	80	0.24	1.9	125	0.27	1.9	–	–	–	30	0.22	1.5	25	0.14	0.7
DCMT 150408E-RM:T9325	●	0.8	180	0.27	1.9	105	0.24	1.9	170	0.27	1.9	–	–	–	40	0.22	1.5	–	–	–
DCMT 150408E-RM:T9415	●	0.8	235	0.27	1.9	–	–	–	220	0.27	1.9	–	–	–	–	–	–	45	0.14	0.7

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.																			
SCMT 09T308E-RM:T5315	0.8	275	0.30	2.0	–	–	–	260	0.30	2.0	–	–	–	–	–	–	55	0.15	0.7
SCMT 09T308E-RM:T7335	0.8	190	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	60	0.24	1.6	–	–	–
SCMT 09T308E-RM:T8430	0.8	190	0.30	2.0	105	0.27	2.0	155	0.30	2.0	–	–	–	40	0.24	1.6	30	0.15	0.7
SCMT 09T308E-RM:T9325	0.8	230	0.30	2.0	135	0.27	2.0	215	0.30	2.0	–	–	–	50	0.24	1.6	–	–	–
SCMT 09T308E-RM:T9415	0.8	295	0.30	2.0	–	–	–	280	0.30	2.0	–	–	–	–	–	–	55	0.15	0.7
SCMT 120408E-RM:T5305	0.8	305	0.30	2.3	–	–	–	285	0.30	2.3	–	–	–	–	–	–	60	0.15	0.7
SCMT 120408E-RM:T5315	0.8	275	0.30	2.3	–	–	–	260	0.30	2.3	–	–	–	–	–	–	55	0.15	0.7
SCMT 120408E-RM:T7335	0.8	185	0.30	2.3	140	0.27	2.3	–	–	–	–	–	–	60	0.24	1.8	–	–	–
SCMT 120408E-RM:T8430	0.8	190	0.30	2.3	105	0.27	2.3	155	0.30	2.3	–	–	–	40	0.24	1.8	30	0.15	0.7
SCMT 120408E-RM:T9325	0.8	225	0.30	2.3	135	0.27	2.3	210	0.30	2.3	–	–	–	50	0.24	1.8	–	–	–
SCMT 120408E-RM:T9415	0.8	295	0.30	2.3	–	–	–	280	0.30	2.3	–	–	–	–	–	–	55	0.15	0.7
 																			
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.																			
TCMT 16T308E-RM:T5305	0.8	265	0.27	1.9	–	–	–	250	0.27	1.9	–	–	–	–	–	–	50	0.14	0.7
TCMT 16T308E-RM:T5315	0.8	235	0.27	1.9	–	–	–	220	0.27	1.9	–	–	–	–	–	–	45	0.14	0.7
TCMT 16T308E-RM:T7335	0.8	155	0.27	1.9	120	0.24	1.9	–	–	–	–	–	–	50	0.19	1.5	–	–	–
TCMT 16T308E-RM:T8430	0.8	165	0.27	1.9	90	0.24	1.9	135	0.27	1.9	–	–	–	35	0.19	1.5	25	0.14	0.7
TCMT 16T308E-RM:T9325	0.8	195	0.27	1.9	115	0.24	1.9	185	0.27	1.9	–	–	–	40	0.19	1.5	–	–	–
TCMT 16T308E-RM:T9415	0.8	250	0.27	1.9	–	–	–	235	0.27	1.9	–	–	–	–	–	–	50	0.14	0.7
TCMT 16T312E-RM:T5305	1.2	280	0.27	1.9	–	–	–	265	0.27	1.9	–	–	–	–	–	–	55	0.14	0.9
TCMT 16T312E-RM:T5315	1.2	250	0.27	1.9	–	–	–	235	0.27	1.9	–	–	–	–	–	–	50	0.14	0.9
TCMT 16T312E-RM:T8430	1.2	170	0.27	1.9	90	0.24	1.9	135	0.27	1.9	–	–	–	35	0.19	1.5	25	0.14	0.9
TCMT 16T312E-RM:T9325	1.2	205	0.27	1.9	120	0.24	1.9	190	0.27	1.9	–	–	–	45	0.19	1.5	–	–	–
TCMT 16T312E-RM:T9415	1.2	265	0.27	1.9	–	–	–	250	0.27	1.9	–	–	–	–	–	–	50	0.14	0.9
 																			
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.																			
VBMT 160404E-RM:T5305	0.4	270	0.12	1.2	–	–	–	255	0.12	1.2	–	–	–	–	–	–	50	0.12	0.3
VBMT 160404E-RM:T5315	0.4	235	0.12	1.2	–	–	–	220	0.12	1.2	–	–	–	–	–	–	45	0.12	0.3
VBMT 160404E-RM:T7335	0.4	140	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	45	0.16	1.0	–	–	–
VBMT 160404E-RM:T8430	0.4	170	0.12	1.2	90	0.11	1.2	135	0.12	1.2	–	–	–	35	0.11	1.0	25	0.12	0.3
VBMT 160404E-RM:T9325	0.4	170	0.20	1.2	100	0.18	1.2	160	0.20	1.2	–	–	–	35	0.18	1.0	–	–	–
VBMT 160404E-RM:T9415	0.4	255	0.12	1.2	–	–	–	240	0.12	1.2	–	–	–	–	–	–	50	0.12	0.3
VBMT 160408E-RM:T5305	0.8	285	0.17	1.2	–	–	–	270	0.17	1.2	–	–	–	–	–	–	55	0.11	0.7
VBMT 160408E-RM:T5315	0.8	250	0.17	1.2	–	–	–	235	0.17	1.2	–	–	–	–	–	–	50	0.11	0.7
VBMT 160408E-RM:T7335	0.8	155	0.20	1.2	120	0.18	1.2	–	–	–	–	–	–	50	0.18	1.0	–	–	–
VBMT 160408E-RM:T8430	0.8	175	0.17	1.2	95	0.15	1.2	140	0.17	1.2	–	–	–	35	0.12	1.0	30	0.11	0.7
VBMT 160408E-RM:T9325	0.8	200	0.20	1.2	120	0.18	1.2	190	0.20	1.2	–	–	–	45	0.18	1.0	–	–	–
VBMT 160408E-RM:T9415	0.8	270	0.17	1.2	–	–	–	255	0.17	1.2	–	–	–	–	–	–	50	0.12	0.7
VBMT 160412E-RM:T7335	1.2	150	0.27	1.2	115	0.24	1.2	–	–	–	–	–	–	45	0.19	1.0	–	–	–
VBMT 160412E-RM:T8430	1.2	155	0.27	1.2	85	0.24	1.2	130	0.27	1.2	–	–	–	30	0.19	1.0	25	0.14	0.9
VBMT 160412E-RM:T9325	1.2	185	0.27	1.2	110	0.24	1.2	175	0.27	1.2	–	–	–	40	0.19	1.0	–	–	–
VBMT 160412E-RM:T9415	1.2	240	0.27	1.2	–	–	–	225	0.27	1.2	–	–	–	–	–	–	45	0.14	0.9

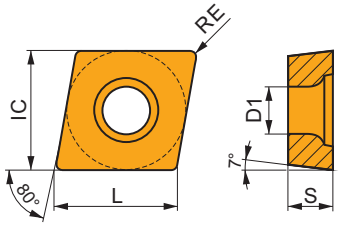
RM3



RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

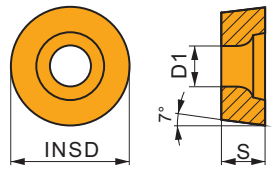
CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.50	12.90	4.76



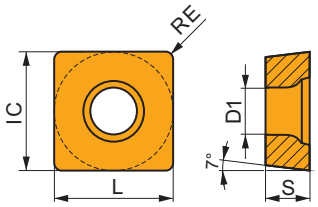
RCMT

	INSD (mm)	D1 (mm)	S (mm)
0803	8.000	3.40	3.18
1204	12.000	4.40	4.76
1606	16.000	5.50	6.35



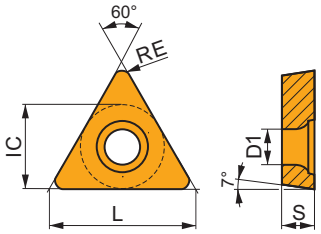
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.50	12.70	4.76

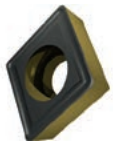
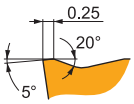
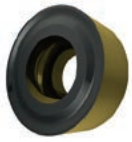
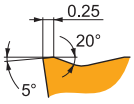
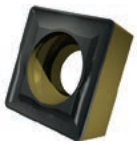
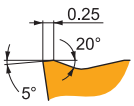
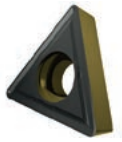
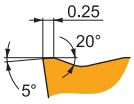


TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97

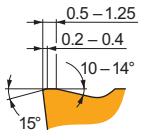


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
		(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)	vc (m/min)	f (mm/rev)	ap (mm)
			**RM3** chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.																	
CCMT 120404E-RM3:T9325	●	0.4	165	0.25	2.5	95	0.25	2.5	155	0.25	2.5	–	–	–	–	–	–	–	–	–
CCMT 120404E-RM3:T9415	●	0.4	215	0.25	2.5	–	–	–	200	0.25	2.5	–	–	–	–	–	–	40	0.13	0.3
CCMT 120408E-RM3:T6310	⬢	0.8	145	0.27	2.5	100	0.27	2.5	115	0.27	2.5	–	–	–	–	–	–	25	0.14	0.7
CCMT 120408E-RM3:T9325	⬢	0.8	195	0.27	2.5	115	0.27	2.5	185	0.27	2.5	–	–	–	–	–	–	–	–	–
CCMT 120408E-RM3:T9415	●	0.8	250	0.27	2.5	–	–	–	235	0.27	2.5	–	–	–	–	–	–	50	0.14	0.7
CCMT 120412E-RM3:T9415	⬢	1.2	255	0.30	2.5	–	–	–	240	0.30	2.5	–	–	–	–	–	–	50	0.15	1.0
			**RM3** chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.																	
RCMT 0803M0E-RM3:T9415	⬢	–	275	0.50	1.3	–	–	–	260	0.50	1.3	–	–	–	–	–	–	55	0.25	0.5
RCMT 1204M0E-RM3:H07	⬢	–	–	–	–	65	0.54	1.8	105	0.60	1.8	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-RM3:T7325	⬢	–	165	0.60	1.8	125	0.54	1.8	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1204M0E-RM3:T8430	✱	–	150	0.60	1.8	80	0.54	1.8	125	0.60	1.8	–	–	–	–	–	–	25	0.30	0.8
RCMT 1204M0E-RM3:T9415	⬢	–	255	0.60	1.8	–	–	–	240	0.60	1.8	–	–	–	–	–	–	50	0.30	0.8
RCMT 1606M0E-RM3:T7325	⬢	–	160	0.65	2.0	120	0.59	2.0	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1606M0E-RM3:T8430	✱	–	145	0.65	2.0	80	0.59	2.0	120	0.65	2.0	–	–	–	–	–	–	25	0.33	1.1
RCMT 1606M0E-RM3:T9415	⬢	–	245	0.65	2.0	–	–	–	230	0.65	2.0	–	–	–	–	–	–	45	0.33	1.1
			**RM3** chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.																	
SCMT 120408E-RM3:T8430	⬢	0.8	170	0.27	2.3	90	0.27	2.3	135	0.27	2.3	–	–	–	–	–	–	25	0.14	0.7
SCMT 120408E-RM3:T9325	⬢	0.8	205	0.27	2.3	120	0.27	2.3	190	0.27	2.3	–	–	–	–	–	–	–	–	–
SCMT 120408E-RM3:T9335	⬢	0.8	175	0.27	2.3	105	0.27	2.3	–	–	–	–	–	–	–	–	–	–	–	–
SCMT 120408E-RM3:T9415	⬢	0.8	265	0.27	2.3	–	–	–	250	0.27	2.3	–	–	–	–	–	–	50	0.14	0.7
SCMT 120412E-RM3:T9325	⬢	1.2	205	0.30	2.3	120	0.27	2.3	190	0.30	2.3	–	–	–	–	–	–	–	–	–
			**RM3** chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.																	
TCMT 16T304E-RM3:T6310	●	0.4	115	0.20	2.0	80	0.20	2.0	90	0.20	2.0	–	–	–	–	–	–	20	0.14	0.3
TCMT 16T304E-RM3:T8415	●	0.4	150	0.20	2.0	75	0.20	2.0	135	0.20	2.0	–	–	–	–	–	–	25	0.14	0.3
TCMT 16T304E-RM3:T8430	●	0.4	130	0.20	2.0	70	0.20	2.0	105	0.20	2.0	–	–	–	–	–	–	20	0.14	0.3
TCMT 16T304E-RM3:T9325	●	0.4	145	0.25	2.0	85	0.25	2.0	135	0.25	2.0	–	–	–	–	–	–	–	–	–
TCMT 16T304E-RM3:T9335	●	0.4	125	0.25	2.0	75	0.25	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T304E-RM3:T9415	●	0.4	205	0.20	2.0	–	–	–	190	0.20	2.0	–	–	–	–	–	–	40	0.14	0.3
TCMT 16T308E-RM3:T6310	●	0.8	125	0.27	2.0	90	0.27	2.0	100	0.27	2.0	–	–	–	–	–	–	25	0.14	0.7
TCMT 16T308E-RM3:T8415	●	0.8	160	0.27	2.0	85	0.27	2.0	145	0.27	2.0	–	–	–	–	–	–	25	0.14	0.7
TCMT 16T308E-RM3:T8430	⬢	0.8	135	0.27	2.0	75	0.27	2.0	110	0.27	2.0	–	–	–	–	–	–	20	0.14	0.7
TCMT 16T308E-RM3:T9325	●	0.8	170	0.27	2.0	100	0.27	2.0	160	0.27	2.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM3:T9335	●	0.8	145	0.27	2.0	85	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM3:T9415	●	0.8	220	0.27	2.0	–	–	–	205	0.27	2.0	–	–	–	–	–	–	40	0.14	0.7

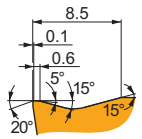
HEAVY ROUGHING – NAVIGATOR

OR



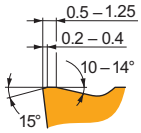
OR chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Steels, Cast irons, and conditionally for Super-alloys.

DR4



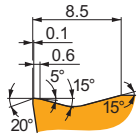
DR4 chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

OR



OR chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Steels, Cast irons, and conditionally for Super-alloys.

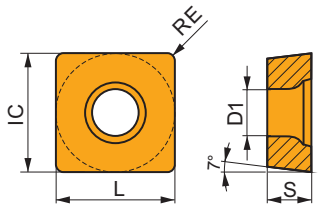
DR4



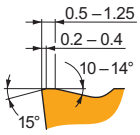
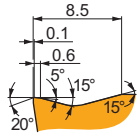
DR4 chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2509	25.400	8.70	25.40	9.53
3809	38.100	8.70	38.10	9.53



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

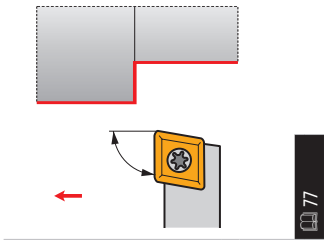
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
OR chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Steels, Cast irons, and conditionally for Super-alloys.																			
SCMT 250924E-OR:T9226	2.4	80	1.00	10.0	45	0.90	10.0	75	1.00	10.0	–	–	–	15	0.70	8.0	–	–	–
SCMT 250924E-OR:T9325	2.4	90	1.00	10.0	50	0.90	10.0	85	1.00	10.0	–	–	–	20	0.70	8.0	–	–	–
SCMT 250924E-OR:T9335	2.4	70	1.00	10.0	40	0.90	10.0	–	–	–	–	–	–	15	0.70	8.0	–	–	–
SCMT 380932E-OR:6635	3.2	60	1.20	18.0	35	1.08	18.0	–	–	–	–	–	–	15	1.08	9.9	–	–	–
SCMT 380932E-OR:T9315	3.2	85	1.20	18.0	–	–	–	80	1.20	18.0	–	–	–	–	–	–	–	–	–
SCMT 380932E-OR:T9325	3.2	80	1.20	18.0	45	1.08	18.0	75	1.20	18.0	–	–	–	15	1.08	9.9	–	–	–
SCMT 380932E-OR:T9335	3.2	60	1.20	18.0	35	1.08	18.0	–	–	–	–	–	–	10	1.08	9.9	–	–	–
 																			
DR4 chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																			
SCMT 380932E-DR4:T9335	3.2	50	1.33	16.0	30	1.20	16.0	–	–	–	–	–	–	–	–	–	–	–	–

CC

ISO TURNING – EXTERNAL – NAVIGATOR

SCAC(RL) EXT 90°

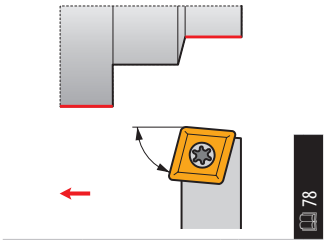
CC..



77

SCBC(RL) EXT 75°

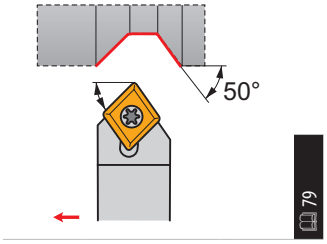
CC..



78

SCDCR EXT 45°

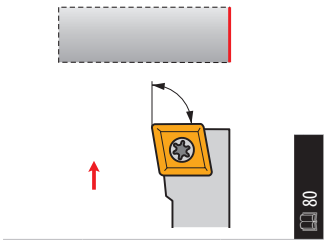
CC..



79

SCFC(RL) EXT 90°

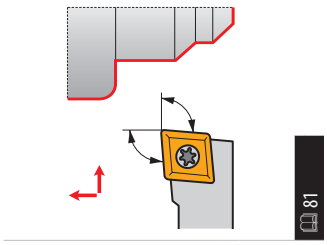
CC..



80

SCLC(RL) EXT 95°

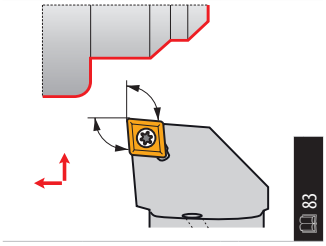
CC..



81

C.-SCLC(RL) EXT 95°

CC..



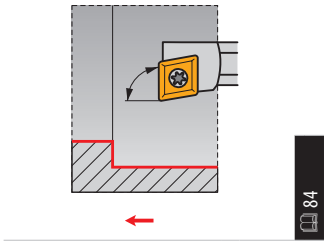
83

CC

ISO TURNING – INTERNAL – NAVIGATOR

SCFC(RL) INT 90°

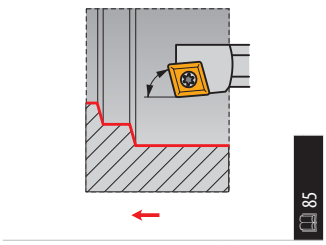
CC..



84

SCKC(RL) INT 75°

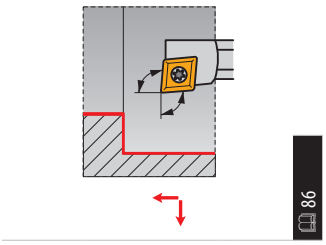
CC..



85

SCLC(RL) INT 45°

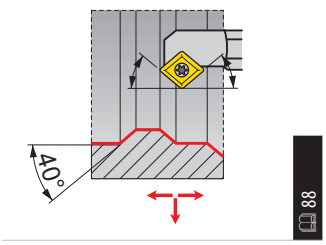
CC..



86

SCXC(RL) INT 90°

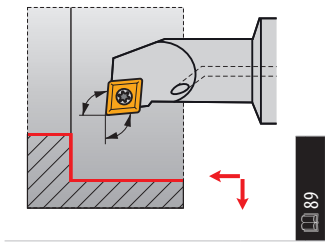
CC..



88

C.-SCLC(RL) INT 95°

CC..



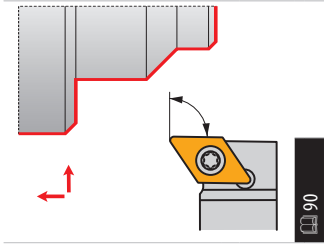
89

DC

ISO TURNING – EXTERNAL – NAVIGATOR

SDFC(RL) EXT 91°

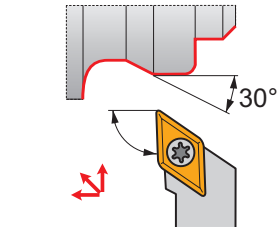
DC..



90

SDJC(RL) EXT 93°

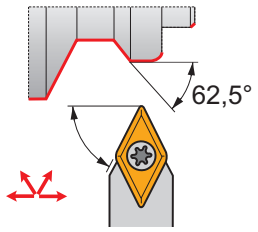
DC..



91

SDNCN EXT 62°30´

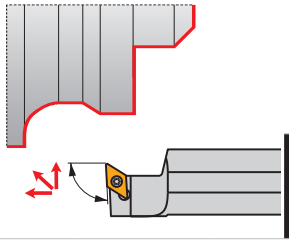
DC..



93

SDUCL EXT 93°

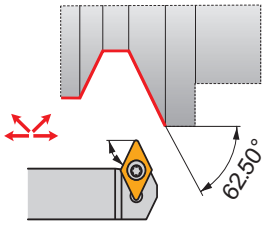
DC..



94

SDXC(RL) EXT 62°30´

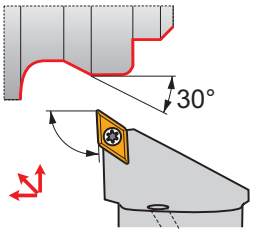
DC..



95

C.-SDJC(RL) EXT 93°

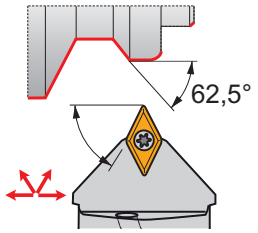
DC..



96

C.-SDNCN EXT 62°30´

DC..



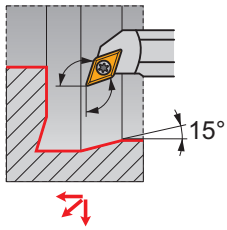
97

DC

ISO TURNING – INTERNAL – NAVIGATOR

SDQC(RL) INT 95°

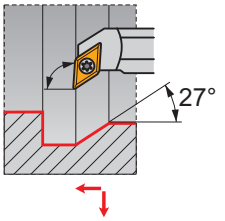
DC..



98

SDUC(RL) INT 93°

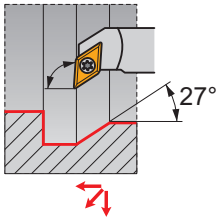
DC..



99

SDUC(RL)-E INT 62°30´

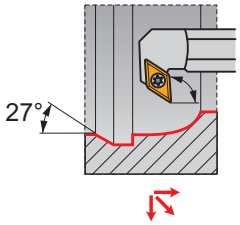
DC..



100

SDZC(RL) INT 90°

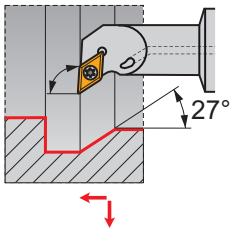
DC..



101

C.-SDUC(RL) INT 93°

DC..



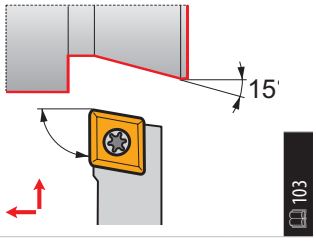
102

EC

ISO TURNING – EXTERNAL – NAVIGATOR

SEGC(RL) EXT 90°

EC..

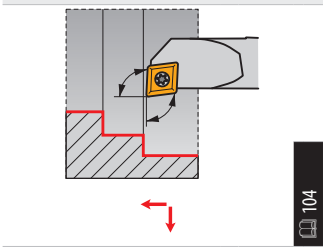


EC

ISO TURNING – INTERNAL – NAVIGATOR

SEUC(RL) INT 93°

EC..

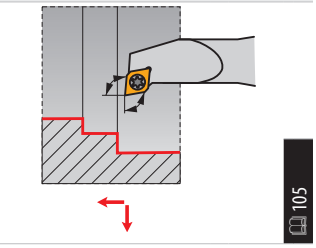


EP

ISO TURNING – INTERNAL – NAVIGATOR

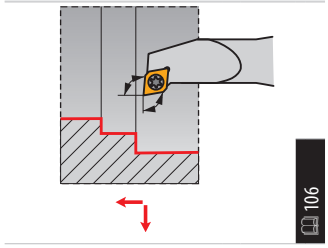
SELP(RL) INT 95°

EP..



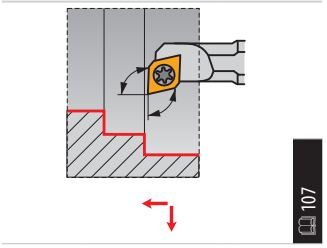
SELP(RL)-E INT 95°

EP..



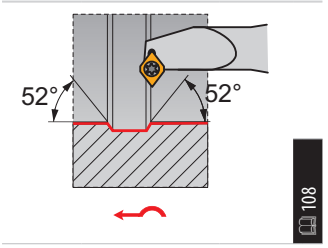
SEUP(RL) INT 93°

EP..



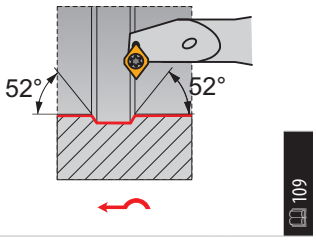
SEXP(RL) INT 52°30´

EP..



SEXP(RL)-E INT 52°30´

EP..

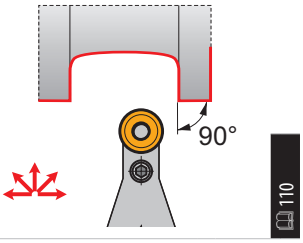


RC

ISO TURNING – EXTERNAL – NAVIGATOR

PRDCN EXT

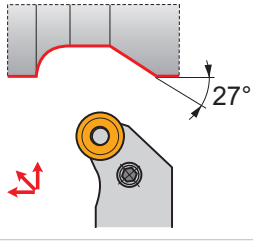
RC..



110

PRSC(RL) EXT

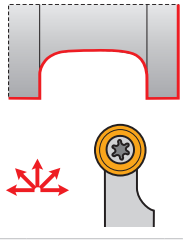
RC..



111

SRDC(RL) EXT

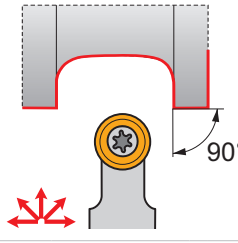
RC..



112

SRDCN EXT

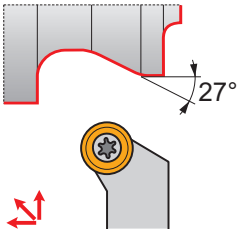
RC..



113

SRCS(RL) EXT

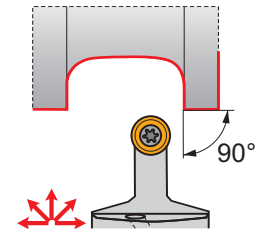
RC..



114

C.-SRDCN EXT

RC..



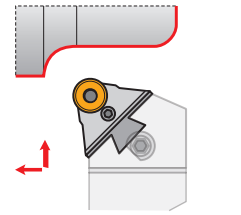
116

RC

ISO TURNING – HEAVY ROUGHING – NAVIGATOR

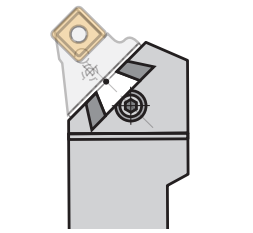
KHP-RSCR/L

RC..



117

DKH(RL)



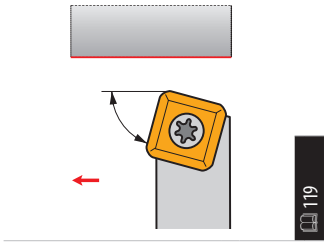
118

SC

ISO TURNING – EXTERNAL – NAVIGATOR

SSBC(RL) EXT 75°

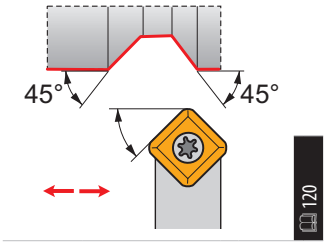
SC..



119

SSDCN EXT 45°

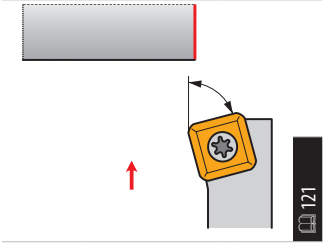
SC..



120

SSKC(RL) EXT 75°

SC..



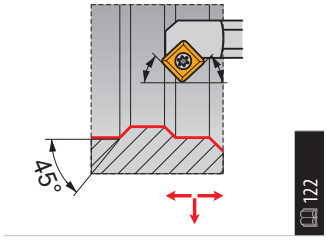
121

SC

ISO TURNING – INTERNAL – NAVIGATOR

SSSC(RL) INT 45°

SC..



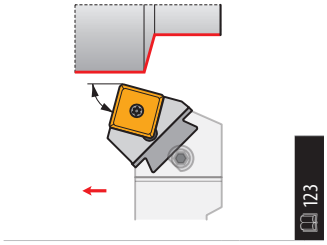
122

SC

ISO TURNING – HEAVY ROUGHING – NAVIGATOR

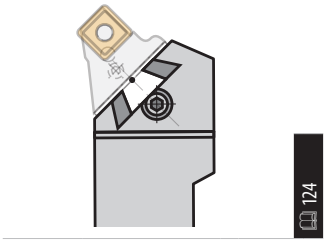
KHS-SBCR 75°

SC..



123

DKH(RL)



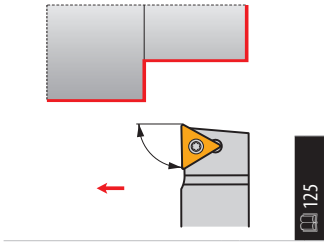
124

TC

ISO TURNING – EXTERNAL – NAVIGATOR

STAC(RL) EXT 90°

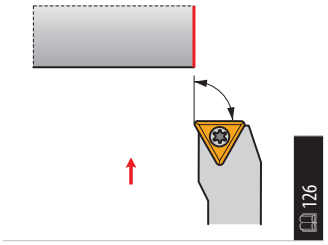
TC..



125

STFC(RL) EXT 90°

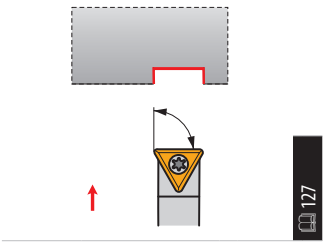
TC..



126

STFC(RL)-A EXT 90°

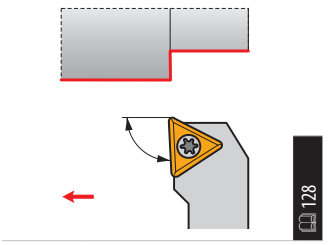
TC..



127

STJC(RL) EXT 93°

TC..



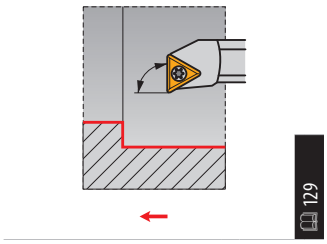
128

TC

ISO TURNING – INTERNAL – NAVIGATOR

STFC(RL) INT 90°

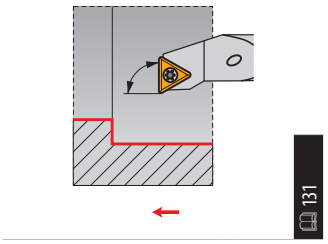
TC..



129

STFC(RL)-E INT 90°

TC..



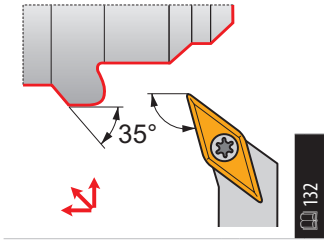
131

VB

ISO TURNING – EXTERNAL – NAVIGATOR

SVHB(C)(RL) EXT 107°30´

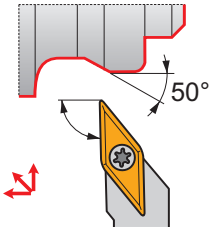
VB, VC..



132

SVJB(C)(RL) EXT 93°

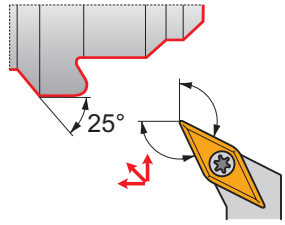
VB, VC..



133

SVPB(C)(RL) EXT 117°30´

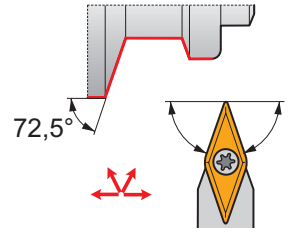
VB, VC..



135

SVVB(C)N EXT 72°30´

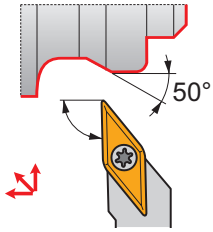
VB, VC..



136

SVXB(C)(RL) EXT 98°

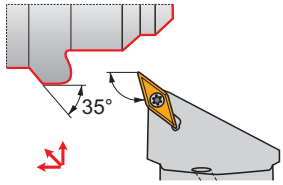
VB, VC..



137

C.-SVHB(RL) EXT 107°30´

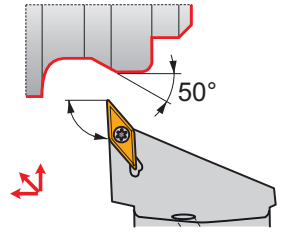
VB, VC..



138

C.-SVJB(RL) EXT 93°

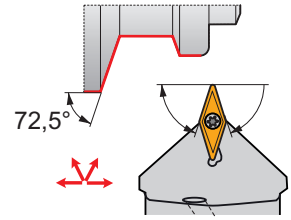
VB, VC..



139

C.-SVVBN EXT 72°30´

VB, VC..



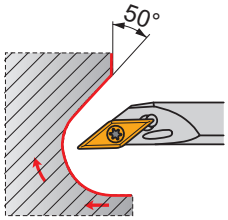
140

VB

ISO TURNING – INTERNAL – NAVIGATOR

SVJB(RL) INT 93°

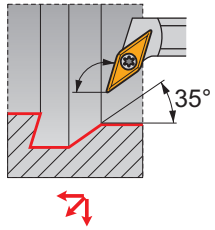
VB, VC..



141

SVQB(C)(RL) INT 107°30´

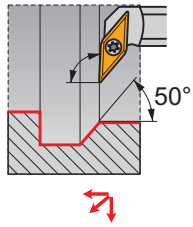
VB, VC..



142

SVUB(C)(RL) INT 93°

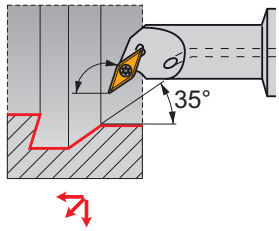
VB, VC..



143

C.-SVQB(C)(RL) INT 108°

VB, VC..



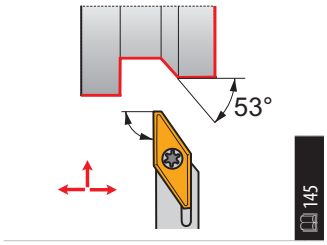
144

VC

ISO TURNING – EXTERNAL – NAVIGATOR

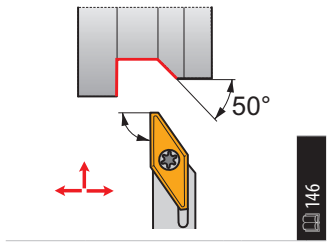
SVAC(RL)-DC EXT 90°

VC..



SVJC(RL)-DC EXT 93°

VC..

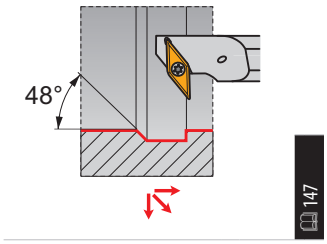


VC

ISO TURNING – INTERNAL – NAVIGATOR

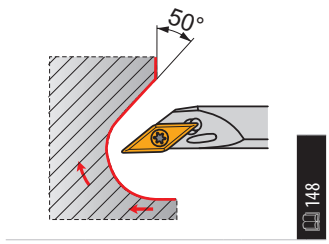
SVLC(RL) INT 95°

VC..



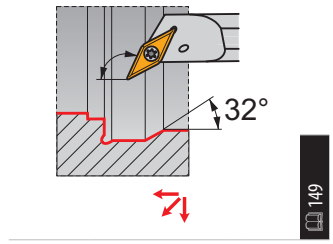
SVJB(RL) INT 93°

VB, VC..



SVXC(RL)-E INT 113°

VC..

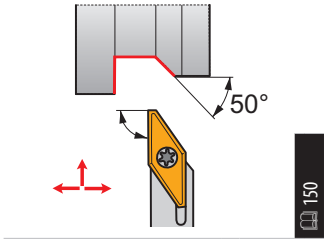


WC

ISO TURNING – EXTERNAL – NAVIGATOR

SWLC(RL) EXT 95°

WC..

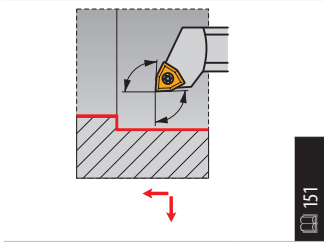


WC

ISO TURNING – INTERNAL – NAVIGATOR

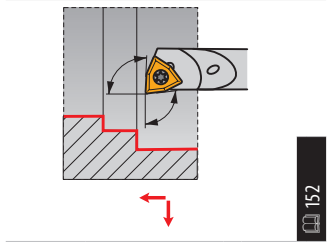
SWLC(RL) INT 95°

WC..



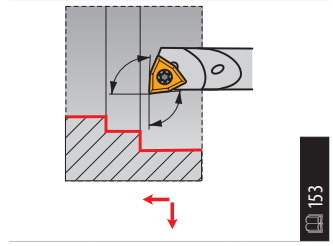
SWUC(RL) INT 93°

WC..



SWUC(RL)-E INT 93°

WC..



SCAC(RL) EXT

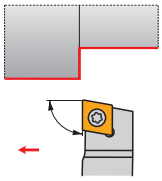
P M K N S H

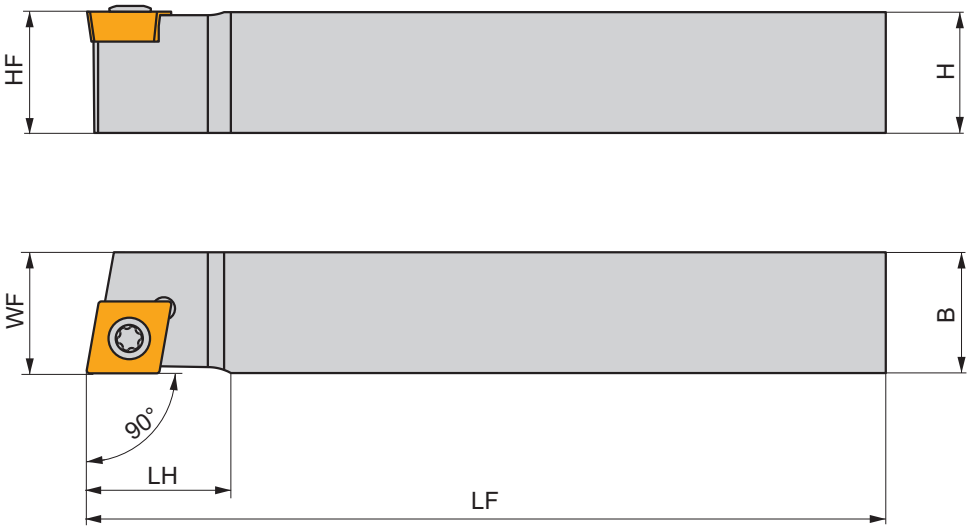
PRAMET

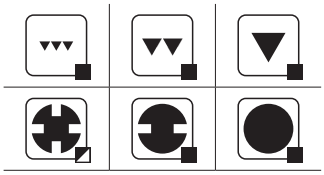
S

External Screw Lock Tool Holder with 90° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 90° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal, taper and chamfer turning. with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SCACR 0808 D 06	8	8	8	8.5	60	–	0	0	0.04	GI045	S07
	SCACR 1010 E 06	10	10	10	10.5	70	–	0	0	0.08	GI045	S07
	SCACR 1212 F 09	12	12	12	12.5	80	–	0	0	0.11	GI041	S04
	SCACR 1212 K 09-S	12	12	12	12	125	19.0	0	0	0.14	GI041	S04
	SCACR 1616 H 09	16	16	16	16.5	100	–	0	0	0.22	GI041	S04
	SCACR 1616 K 09-S	16	16	16	16	125	19.0	0	0	0.24	GI041	S04
L	SCACL 0808 D 06	8	8	8	8.5	60	–	0	0	0.05	GI045	S07
	SCACL 1010 E 06	10	10	10	10.5	70	–	0	0	0.06	GI045	S07
	SCACL 1212 F 09	12	12	12	12.5	80	–	0	0	0.12	GI041	S04
	SCACL 1212 K 09-S	12	12	12	12	125	19.0	0	0	0.14	GI041	S04
	SCACL 1616 H 09	16	16	16	16.5	100	–	0	0	0.22	GI041	S04
	SCACL 1616 K 09-S	16	16	16	16	125	19.0	0	0	0.24	GI041	S04

GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SCBC(RL) EXT

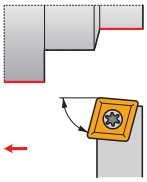
P M K N S H

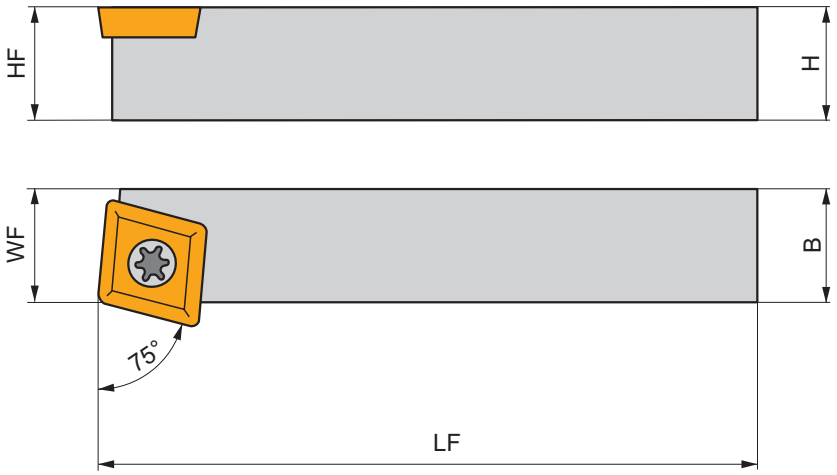
PRAMET

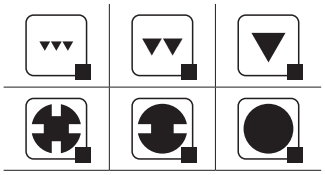
S

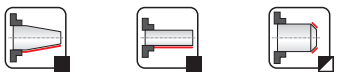
External Screw Lock Tool Holder with 75° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 75° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal without shoulder and chamfer turning. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCBCR 1212 F 09	12	12	12	11	80	0	0	0.10	GI041	S08
	SCBCR 1616 H 09	16	16	16	13	100	0	0	0.20	GI041	S08
	SCBCR 2020 K 12-M-A	20	20	20	17	125	0	0	0.45	GI011	SC20
	SCBCR 2525 M 12-M-A	25	25	25	22	150	0	0	0.61	GI011	SC20
L	SCBCL 1212 F 09	12	12	12	11	80	0	0	0.10	GI041	S08
	SCBCL 1616 H 09	16	16	16	13	100	0	0	0.22	GI041	S08
	SCBCL 2020 K 12-M-A	20	20	20	17	125	0	0	0.43	GI011	SC20
	SCBCL 2525 M 12-M-A	25	25	25	22	150	0	0	0.75	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SCDCR EXT

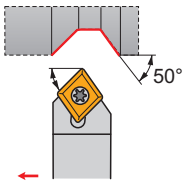
P M K N S H

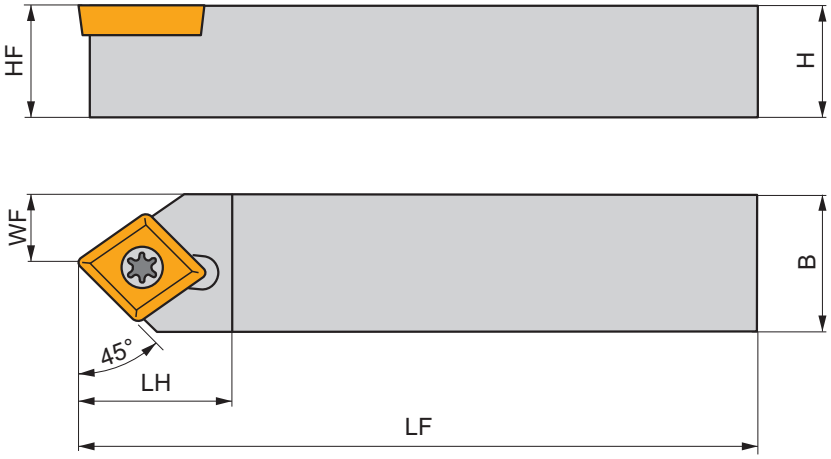
PRAMET

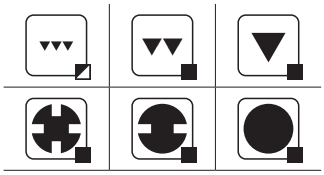
S

External Screw Lock Tool Holder with 45° Cutting Angle for CC.. Inserts

External right hand tool holder with 45° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal without shoulder, taper, multi-directional copy, and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SCDCR 1010 E 06	10	10	10	5.11	70	11.0	0	0	0.06	GI045	SC21

GI045	CC.. 0602..

SC21	5513 020-03	0.8 Nm	M 2.5	6.5	PT-8001

SCFC(RL) EXT

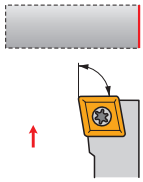
P M K N S H

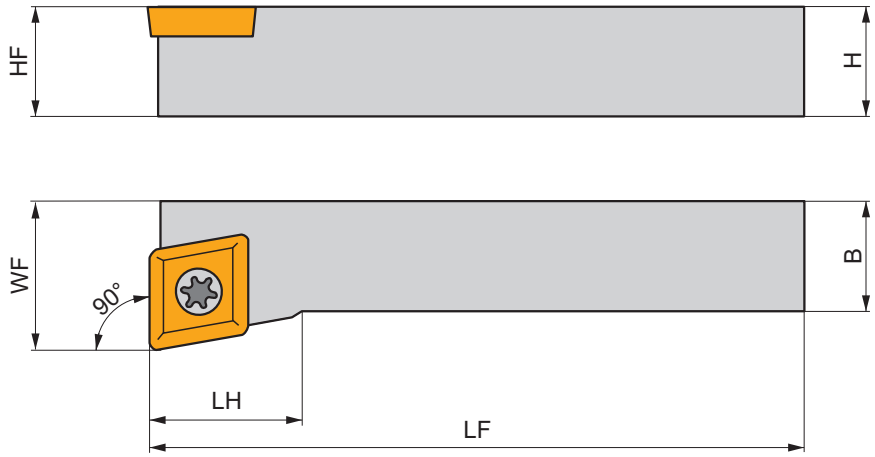
PRAMET

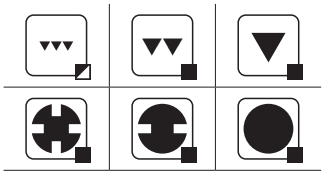
S

External Screw Lock Tool Holder with 90° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 90° cutting angle for screw type positive CC.. inserts. Suited for external face and longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SCFCR 0808 D 06	8	8	8	10	60	8.0	0	0	0.04	GI045	S07
	SCFCR 1010 E 06	10	10	10	12	70	8.0	0	0	0.07	GI045	S07
	SCFCR 1212 F 09	12	12	12	16	80	16.0	0	0	0.12	GI041	S04
	SCFCR 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S04
L	SCFCL 1010 E 06	10	10	10	12	70	8.0	0	0	0.06	GI045	S07
	SCFCL 1212 F 09	12	12	12	16	80	16.0	0	0	0.10	GI041	S04
	SCFCL 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S04

GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SCLC(RL) EXT

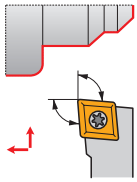
P M K N S H

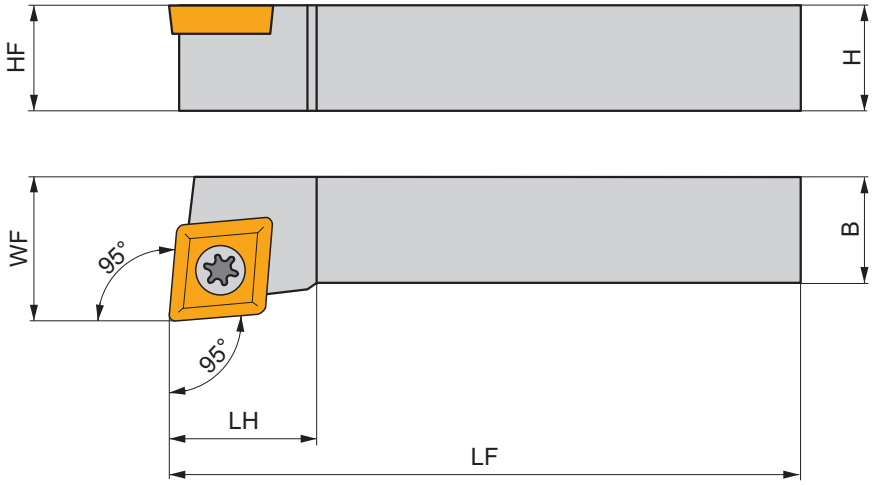
PRAMET

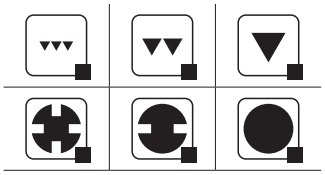
S

External Screw Lock Tool Holder with 95° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 95° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal shoulder, taper and chamfer turning. with some usable for sliding head machines. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	SCLCR 0808 D 06	8	8	8	10	60	8.0	0	0	0.05	GI045	S01
	SCLCR 1010 E 06	10	10	10	12	70	8.0	0	0	0.09	GI045	S01
	SCLCR 1010 E 08	10	10	10	12	70	13.2	0	0	0.03	GI232	SC22
	SCLCR 1212 F 08	12	12	12	16	80	13.4	0	0	0.01	GI232	SC22
	SCLCR 1212 F 09	12	12	12	16	80	16.0	0	0	0.12	GI041	S08
	SCLCR 1212 K 09-S	12	12	12	12	125	21.3	0	0	0.13	GI041	S08
	SCLCR 1616 H 08	16	16	16	20	100	15.2	0	0	0.22	GI232	SC22
	SCLCR 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S08
	SCLCR 1616 K 09-S	16	16	16	16	125	21.3	0	0	0.24	GI041	S08
	SCLCR 2020 K 12-M-A	20	20	20	25	125	20.0	0	0	0.43	GI011	SC20
	SCLCR 2525 M 12-M-A	20	25	20	32	150	20.0	0	0	0.77	GI011	SC20
L	SCLCL 0808 D 06	8	8	8	10	60	8.0	0	0	0.06	GI045	S01
	SCLCL 1010 E 06	10	10	10	12	70	8.0	0	0	0.06	GI045	S01
	SCLCL 1212 F 08	12	12	12	16	80	13.4	0	0	0.03	GI232	SC22
	SCLCL 1212 F 09	12	12	12	16	80	16.0	0	0	0.10	GI041	S08
	SCLCL 1212 K 09-S	12	12	12	12	125	21.3	0	0	0.13	GI041	S08
	SCLCL 1616 H 08	16	16	16	20	100	15.2	0	0	0.23	GI232	SC22
	SCLCL 1616 H 09	16	16	16	20	100	16.0	0	0	0.22	GI041	S08
	SCLCL 1616 K 09-S	16	16	16	16	125	21.3	0	0	0.24	GI041	S08
	SCLCL 2020 K 12-M-A	20	20	20	25	125	20.0	0	0	0.40	GI011	SC20
	SCLCL 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.77	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..

GI232	CC.. 0803..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
SC22	5513 020-04	1.5	M 3	7.2	–	–	PT-8003	–
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

C.-SCLC(RL) EXT

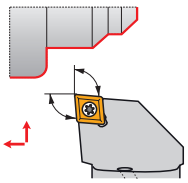
P M K N S H

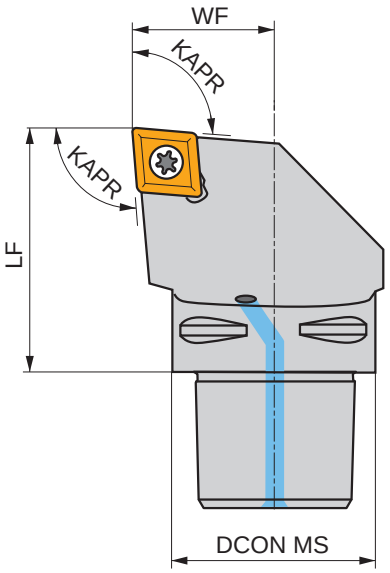
PRAMET

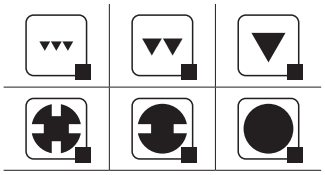
S

External PSC Quick Change Tool, Screw Lock, 95° Cutting Angle for CC.. Inserts

External Right/Left hand tool, through coolant, with 95° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal turning with shoulder, taper and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SCLCR-22040-09	32	22	40	95	0	0	✓	0.21	GI041	C-SC09S
	C4-SCLCR-27050-09	40	27	50	95	0	0	✓	0.39	GI041	C-SC09S
	C4-SCLCR-27050-12	40	27	50	95	0	0	✓	0.40	GI011	C-SC12-1
	C5-SCLCR-35060-12	50	35	60	95	0	0	✓	0.72	GI011	C-SC12-2
L	C3-SCLCL-22040-09	32	22	40	95	0	0	✓	0.21	GI041	C-SC09S
	C4-SCLCL-27050-09	40	27	50	95	0	0	✓	0.39	GI041	C-SC09S
	C5-SCLCL-35060-12	50	35	60	95	0	0	✓	0.72	GI011	C-SC12-2

GI011	CC.. 1204..
GI041	CC.. 09T3..

		Nm						
C-SC09S	US 2001-T15P	3.0	M 3.5	12.1	SCS 232-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SC12-1	US 2018-T15P	3.0	M 4	14	SCS 232-02	MS 9003	FLAG T15P/4	CN 034-01
C-SC12-2	US 2018-T15P	3.0	M 4	14	SCS 232-02	MS 9003	FLAG T15P/4	CN 034-02

SCFC(RL) INT

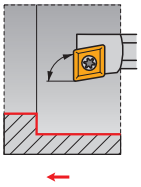
P M K N S H

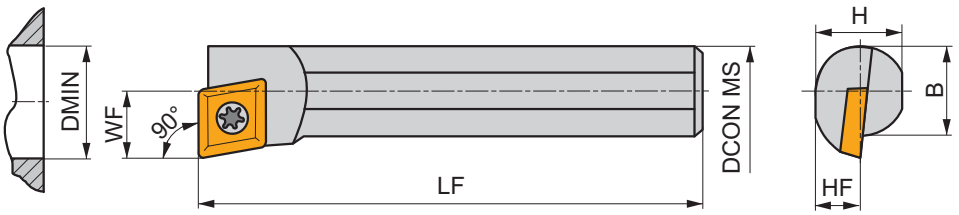
PRAMET

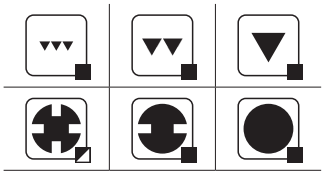
S

Internal Screw Lock Boring Bar with 90° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar with 90° cutting angle for screw type CC.. inserts. Suited for internal face and longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S10H-SCFCR 06	10	13	7	9	9.5	100	-10	0	0.08	GI045	S06
	S12K-SCFCR 06	12	16	9	11	11.5	125	-7	0	0.11	GI045	S06
L	S10H-SCFCL 06	10	13	7	9	9.5	100	-10	0	0.08	GI045	S06
	S12K-SCFCL 06	12	16	9	11	11.5	125	-7	0	0.13	GI045	S06

GI045	CC.. 0602..

S06	US 2505-T07P	0.9	M 2.5	5.2	FLAG T07P

SCKC(RL) INT

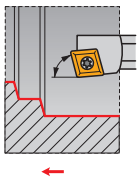
P M K N S H

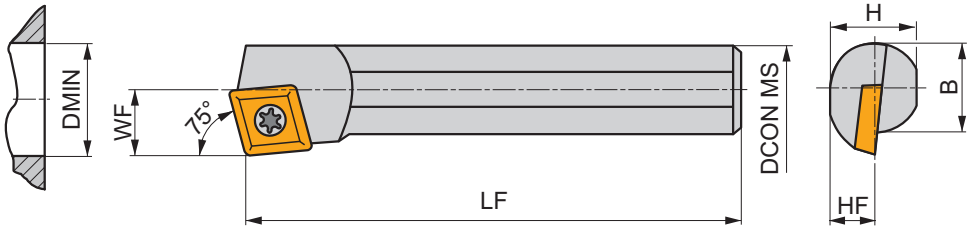
PRAMET

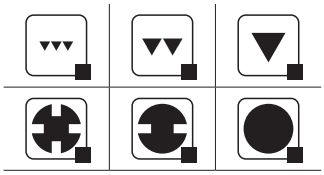
S

Internal Screw Lock Boring Bar with 75° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar with 75° cutting angle for screw type CC.. inserts. Suited for internal longitudinal turning without shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S08F-SCKCR 06	8	11	6	7.2	7.6	80	-12	0	0.03	GI045	S02
	S12K-SCKCR 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S02
	S16M-SCKCR 09-A	16	20	11	14.5	15	150	-8	0	0.25	GI041	S05
	S20S-SCKCR 09	20	25	13	18.5	18.5	250	-5	0	0.60	GI041	S08
	S25T-SCKCR 09	25	32	17	23	23	300	-3	0	1.15	GI041	S08
	S32U-SCKCR 12-A	32	40	22	30	30	350	-10	0	2.10	GI011	SC20
L	S20S-SCKCL 09	20	25	13	18.5	18.5	250	-5	0	0.60	GI041	S08

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S05	US 4008-T15P	3.5	M 4	8	–	–	FLAG T15P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SCLC(RL) INT

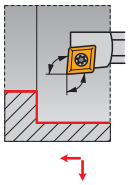
P M K N S H

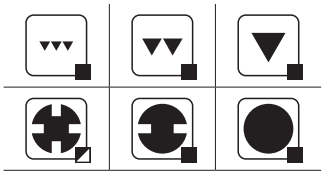
PRAMET

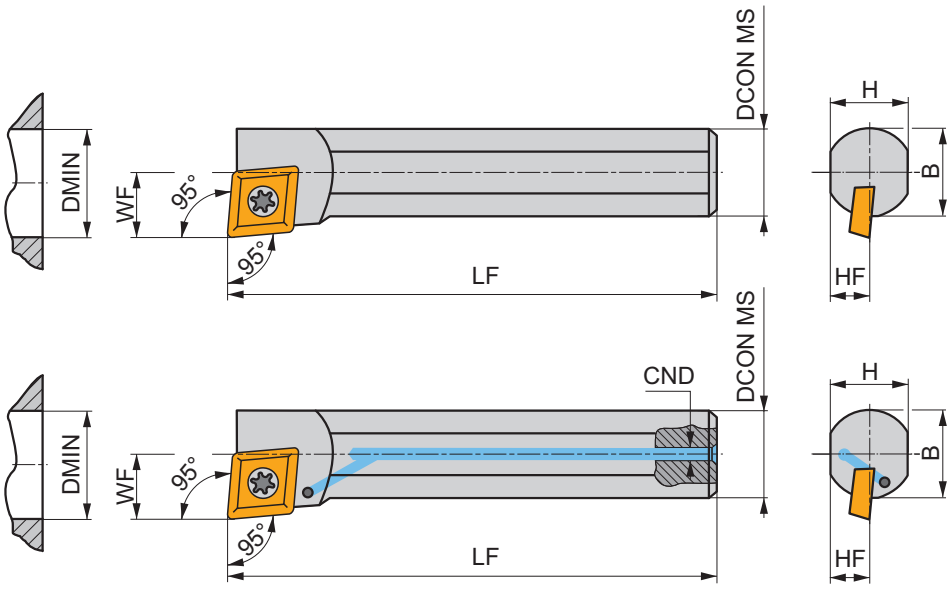
S

Internal Screw Lock Boring Bar with 95° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 95° cutting angle for screw type CC.. inserts. For internal longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A08H-SCLCR 06	8	11	6	7.2	7.6	100	3.5	-13	0	✓	0.03	GI045	S02
	S08F-SCLCR 06	8	11	6	7.2	7.6	80	–	-13	0	–	0.05	GI045	S02
	A10H-SCLCR 06	10	13	7	9	–	100	4	-10	0	✓	0.07	GI045	S02
	S10H-SCLCR 06	10	13	7	9	9.5	100	–	-10	0	–	0.07	GI045	S02
	A12K-SCLCR 06	12	16	9	11	–	125	5	-8	0	✓	0.09	GI045	S01
	S12K-SCLCR 06	12	16	9	11	11.5	125	–	-8	0	–	0.12	GI045	S01
	S16M-SCLCR 06	16	20	11	14.5	15	150	–	-8	0	–	0.25	GI045	S01
	A10K-SCLCR 08	10	12	6	9	9.5	125	4	-14	0	✓	0.09	GI232	SC22
	A12M-SCLCR 08	12	16	9	11	11.5	150	5	-5	0	✓	0.14	GI232	SC22
	A16R-SCLCR 08	16	20	11	14	15	200	6	-8	0	✓	0.28	GI232	SC22
	A16M-SCLCR 09-A	16	20	11	14.5	–	150	6	-8	0	✓	0.22	GI041	S05
	S16M-SCLCR 09-A	16	20	11	14.5	15	150	–	-8	0	–	0.25	GI041	S05
	A20Q-SCLCR 09	20	25	13	18	–	180	8	-5	0	✓	0.37	GI041	S08
	S20S-SCLCR 09	20	25	13	18	18.5	250	–	-5	0	–	0.59	GI041	S08
	A25R-SCLCR 09	25	32	17	23	23	200	8	-3	0	✓	0.60	GI041	S08
	S25T-SCLCR 09	25	32	17	23	23	300	–	-3	0	–	1.08	GI041	S08
	A32S-SCLCR 12-A	32	40	22	30	30	250	8	-10	0	✓	1.35	GI011	SC20
	S32U-SCLCR 12-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI011	SC20
L	A08H-SCLCL 06	8	11	6	7.2	7.6	100	–	-13	0	✓	0.05	GI045	S02
	S08F-SCLCL 06	8	11	6	7.2	7.6	80	–	-13	0	–	0.05	GI045	S02
	A10H-SCLCL 06	10	13	7	9	–	100	4	-10	0	✓	0.06	GI045	S02
	S10H-SCLCL 06	10	13	7	9	9.5	100	–	-10	0	–	0.06	GI045	S02
	A12K-SCLCL 06	12	16	9	11	–	125	5	-8	0	✓	0.10	GI045	S01
	S12K-SCLCL 06	12	16	9	11	11.5	125	–	-8	0	–	0.11	GI045	S01
	S16M-SCLCL 06	16	20	11	14.5	15	150	–	-8	0	–	0.24	GI045	S01
	A10K-SCLCL 08	10	12	6	9	9.5	125	4	-14	0	✓	0.00	GI232	SC22
	A12M-SCLCL 08	12	16	9	11	11.5	150	5	-5	0	✓	0.14	GI232	SC22

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
L	**A16R-SCLCL 08**	16	20	11	14	15	200	6	-8	0	✓	0.30	GI232	SC22
	A16M-SCLCL 09-A	16	20	11	14.5	–	150	6	-8	0	✓	0.22	GI041	S05
	S16M-SCLCL 09-A	16	20	11	14.5	15	150	–	-8	0	–	0.24	GI041	S05
	A20Q-SCLCL 09	20	25	13	18	–	180	8	-5	0	✓	0.37	GI041	S08
	S20S-SCLCL 09	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI041	S08
	A25R-SCLCL 09	25	32	17	23	23	200	8	-3	0	✓	0.67	GI041	S08
	S25T-SCLCL 09	25	32	17	23	23	300	–	-3	0	–	1.08	GI041	S08
	A32S-SCLCL 12-A	32	40	22	30	30	250	8	-10	0	✓	1.35	GI011	SC20
	S32U-SCLCL 12-A	32	40	22	30	30	350	–	-10	0	–	2.00	GI011	SC20

GI011	CC.. 1204..
GI041	CC.. 09T3..
GI045	CC.. 0602..
GI232	CC.. 0803..

		Nm						
SC20	US 5012-T15P	5.0	M 5	12.2	SCN 120304	MS 5008	FLAG T15P	HXK 5
SC22	5513 020-04	1.5	M 3	7.2	–	–	PT-8003	–
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S05	US 4008-T15P	3.5	M 4	8	–	–	FLAG T15P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SCXC(RL) INT

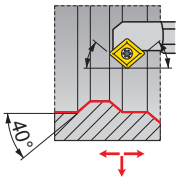
P M K N S H

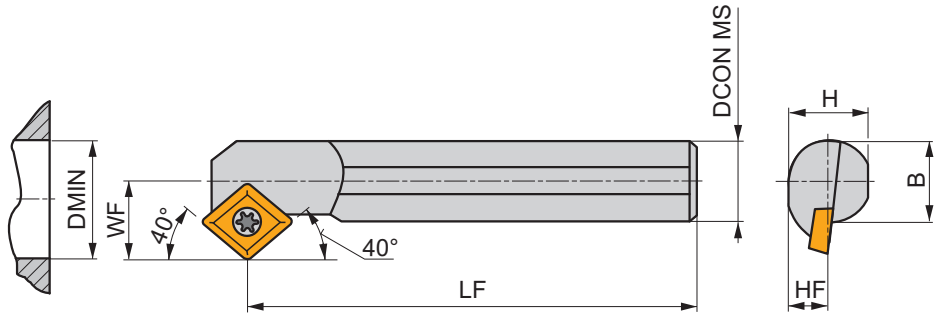
PRAMET

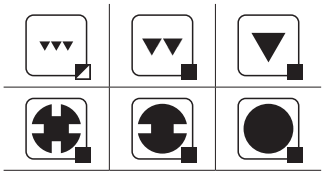
S

Internal Screw Lock Boring Bar with 40° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar, 40° cutting angle for screw type CC.. inserts. Suited for internal front and back chamfering, longitudinal turning without shoulder and taper turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**S10H-SCXCR 06**	10	13	7	9	9.5	100	-10	0	0.06	GI045	S06
	S12K-SCXCR 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S06
	S16Q-SCXCR 06	16	20	11	14.5	15	180	-7	0	0.29	GI045	S07
L	**S10H-SCXCL 06**	10	13	7	9	9.5	100	-10	0	0.06	GI045	S06
	S12K-SCXCL 06	12	16	9	11	11.5	125	-8	0	0.11	GI045	S06
	S16Q-SCXCL 06	16	20	11	14.5	15	180	-7	0	0.30	GI045	S07

GI045	CC.. 0602..

		Nm			
S06	US 2505-T07P	0.9	M 2.5	5.2	FLAG T07P
S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

C.-SCLC(RL) INT

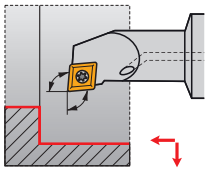
P M K N S H

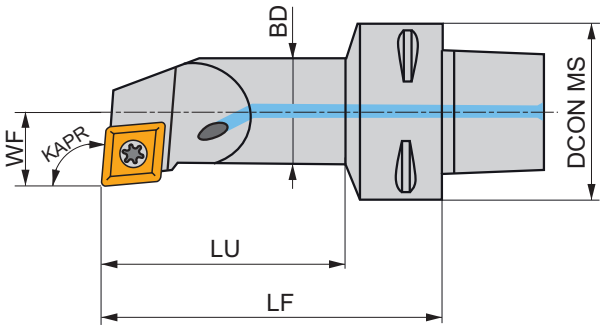
PRAMET

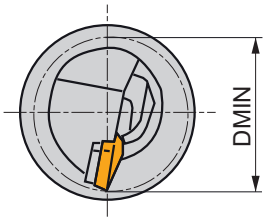
S

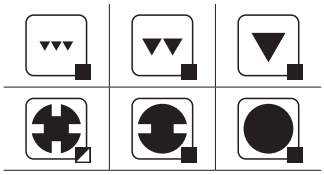
Internal PSC Quick Change Tool, Screw Lock, 95° Cutting Angle for CC.. Inserts

Internal Right/Left hand tool, through coolant, with 95° cutting angle for screw type CC.. inserts. Suited for a wide range of internal turning applications. Polygon Shank Coupling with choice of lengths. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SCLCR-11065-09	32	20	11	65	48	16	95	-8.4	0	✓	0.21	GI041	SC09M
	C3-SCLCR-13075-09	32	25	13	75	58	20	95	-5.8	0	✓	0.26	GI041	SC09M
	C4-SCLCR-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	0.36	GI041	SC09M
	C4-SCLCR-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	0.41	GI041	SC09M
	C4-SCLCR-17090-09	40	32	17	90	68	25	95	-3.4	0	✓	0.50	GI041	SC09M
	C5-SCLCR-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	0.55	GI041	SC09M
	C5-SCLCR-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	0.60	GI041	SC09M
L	C4-SCLCL-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	0.36	GI041	SC09M
	C4-SCLCL-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	0.41	GI041	SC09M
	C5-SCLCL-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	0.55	GI041	SC09M
	C5-SCLCL-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	0.60	GI041	SC09M

GI041	CC.. 09T3..

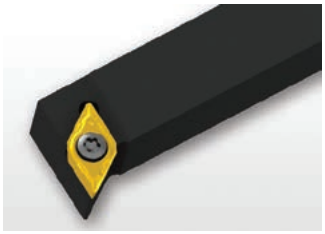
		Nm			
SC09M	US 2009-T15P	3.0	M 3.5	8.1	FLAG T15P/3,5

SDFC(RL) EXT

P M K N S H

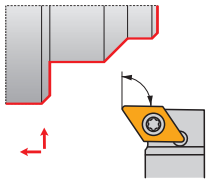
PRAMET

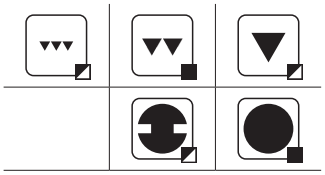
S

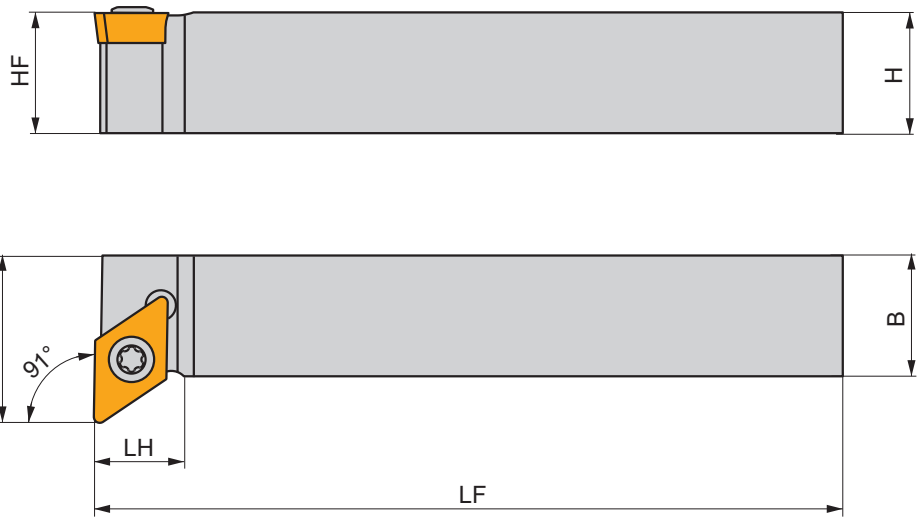


External Screw Lock Tool Holder with 91° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 91° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, face, taper and chamfer turning. and usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SDFCR 1212 K 07-S	12	12	12	16	125	8.8	0	0	0.14	GI052	S01
	SDFCR 1616 K 11-S	16	16	16	22	125	11.9	0	0	0.25	GI012	S08
L	SDFCL 1212 K 07-S	12	12	12	16	125	8.8	0	0	0.14	GI052	S01
	SDFCL 1616 K 11-S	16	16	16	22	125	11.9	0	0	0.25	GI012	S08

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm			
S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P
S08	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

SDJC(RL) EXT

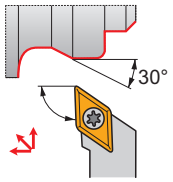
P M K N S H

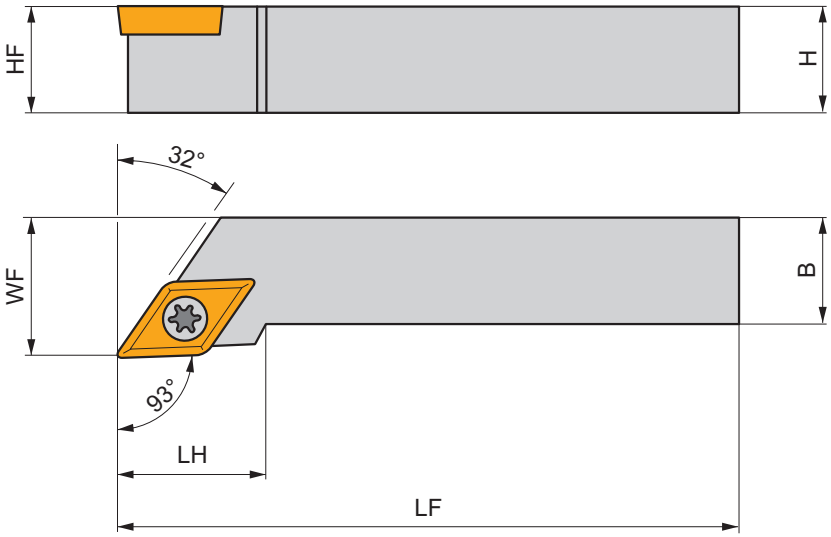
PRAMET

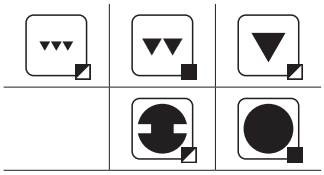
S

External Screw Lock Tool Holder with 93° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 93° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, taper and chamfer turning. with some usable for sliding head machines. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	SDJCR 0808 D 07	8	8	8	10	60	14.0	0	0	0.05	GI052	S01
	SDJCR 1010 E 07	10	10	10	12	70	14.0	0	0	0.06	GI052	S01
	SDJCR 1212 F 07	12	12	12	16	80	14.0	0	0	0.11	GI052	S01
	SDJCR 1212 F 11	12	12	12	16	80	20.0	0	0	0.10	GI012	S08
	SDJCR 1212 K 07-S	12	12	12	12	125	18.2	0	0	0.13	GI052	S01
	SDJCR 1212 K 11-S	12	12	12	12	125	22.6	0	0	0.13	GI012	S08
	SDJCR 1616 H 11	16	16	16	20	100	20.0	0	0	0.22	GI012	S08
	SDJCR 1616 K 11-S	16	16	16	16	125	22.6	0	0	0.23	GI012	S08
	SDJCR 2020 K 11-M-A	20	20	20	25	125	20.0	0	0	0.40	GI012	SD10
	SDJCR 2525 M 11-M-A	25	25	25	32	150	20.0	0	0	0.74	GI012	SD10
	SDJCR 2525 M 15	25	25	25	32	150	28.0	0	0	0.74	GI243	SD11
L	SDJCL 0808 D 07	8	8	8	10	60	14.0	0	0	0.04	GI052	S01
	SDJCL 1010 E 07	10	10	10	12	70	14.0	0	0	0.07	GI052	S01
	SDJCL 1212 F 07	12	12	12	16	80	14.0	0	0	0.11	GI052	S01
	SDJCL 1212 F 11	12	12	12	16	80	20.0	0	0	0.11	GI012	S08
	SDJCL 1212 K 07-S	12	12	12	12	125	18.2	0	0	0.13	GI052	S01
	SDJCL 1212 K 11-S	12	12	12	12	125	22.6	0	0	0.13	GI012	S08
	SDJCL 1616 H 11	16	16	16	20	100	20.0	0	0	0.20	GI012	S08
	SDJCL 1616 K 11-S	16	16	16	16	125	22.6	0	0	0.23	GI012	S08
	SDJCL 2020 K 11-M-A	20	20	20	25	125	20.0	0	0	0.41	GI012	SD10
	SDJCL 2525 M 11-M-A	25	25	25	32	150	20.0	0	0	0.74	GI012	SD10
	SDJCL 2525 M 15	25	25	25	32	150	28.0	0	0	0.07	GI243	SD11

GI012	DC.. 11T3..
GI052	DC.. 0702..
GI243	DC.. 1504..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
SD11	US 64518-T15P	5.0	M 4.5	18	SDN 150304	MS 4512	FLAG T15P	HXK 5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SDNCN EXT

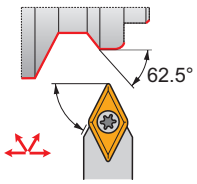
P M K N S H

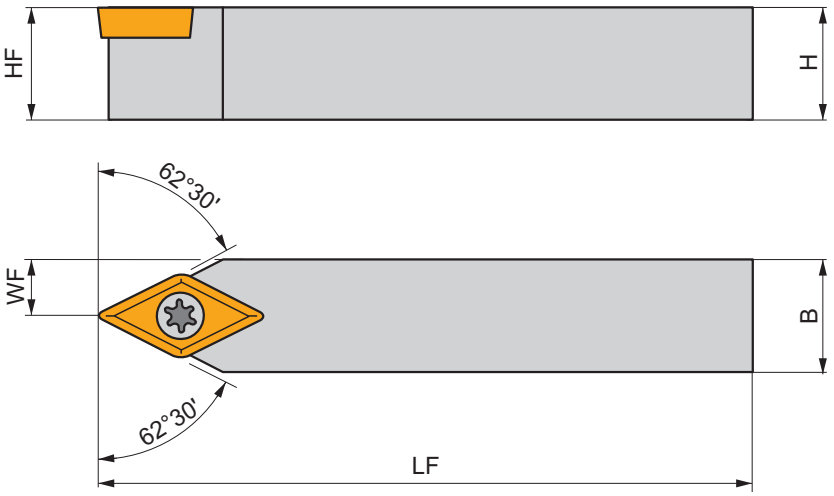
PRAMET

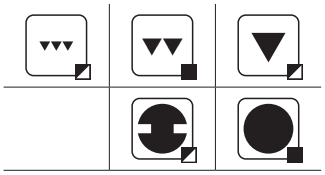
S

External Screw Lock Tool Holder with 62.5° Cutting Angle for DC.. Inserts

External neutral tool holder with 62.5° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
N	**SDNCN 0808 D 07**	8	8	8	4	60	0	0	0.05	GI052	S01
	SDNCN 1010 E 07	10	10	10	5	70	0	0	0.07	GI052	S01
	SDNCN 1212 F 07	12	12	12	6	80	0	0	0.11	GI052	S01
	SDNCN 1212 F 11	12	12	12	6	80	0	0	0.11	GI012	S08
	SDNCN 1616 H 11	16	16	16	8	100	0	0	0.20	GI012	S08
	SDNCN 2020 K 11-M-A	20	20	20	10	125	0	0	0.35	GI012	SD10
	SDNCN 2525 M 11-M-A	25	25	25	12.5	150	0	0	0.70	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SDUCL EXT

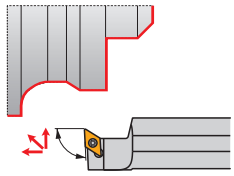
P M K N S H

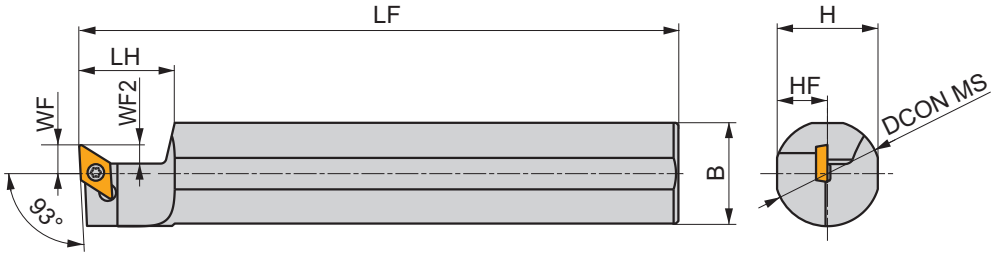
PRAMET

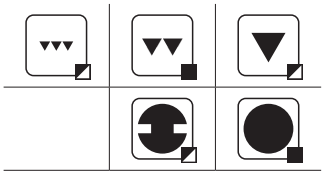
S

External Screw Lock Tool Holder with 93° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 93° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, face turning, taper and chamfer turning. and usable for sliding head machines. Body treated for longer tool life.







	Product	DCON MS (mm)	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	WF2 (mm)	LAMS (°)	GAMO (°)	kg		
L	**S20K-SDUCL07-S**	20	19	19	9.5	6	125	18.0	4	0	0	0.23	GI052	S01
	S22K-SDUCL07-S	22	21	21	10.5	6	125	18.0	4	0	0	0.27	GI052	S01

GI052	DC.. 0702..

S01	US 2506-T07P	0.9 Nm	M 2.5	6.3	FLAG T07P

SDXC(RL) EXT

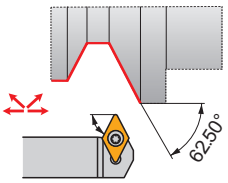
P M K N S H

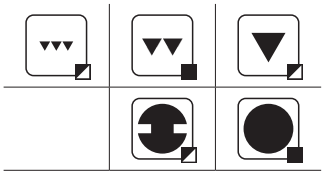
PRAMET

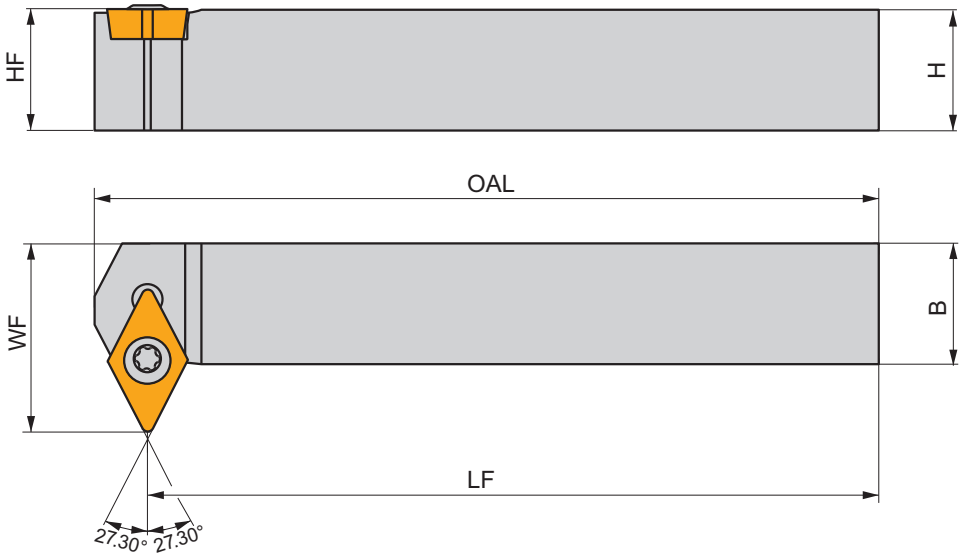
S

External Screw Lock Tool Holder with 62.5° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 62.5° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, taper and chamfer turning. and usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LAMS (°)	GAMO (°)	kg		
R	SDXCR 1212 K 07-S	12	12	12	18	125	130	0	0	0.15	GI052	S01
	SDXCR 1616 K 11-S	16	16	16	25	125	132	0	0	0.26	GI012	S08
L	SDXCL 1212 K 07-S	12	12	12	18	125	130	0	0	0.15	GI052	S01
	SDXCL 1616 K 11-S	16	16	16	25	125	132	0	0	0.26	GI012	S08

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm			
S01	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P
S08	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P

C.-SDJC(RL) EXT

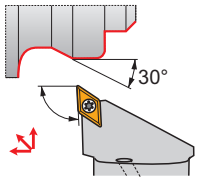
P M K N S H

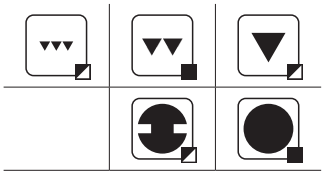
PRAMET

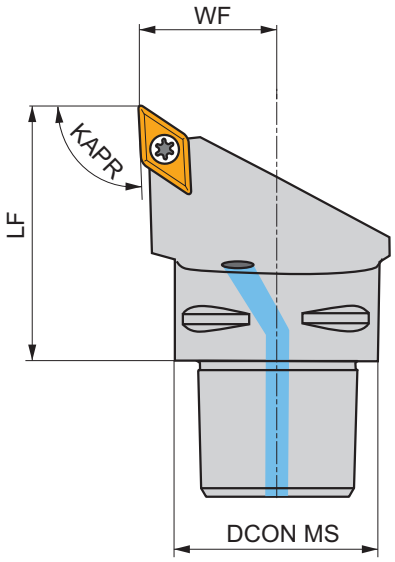
S

External PSC Quick Change Tool, Screw Lock, 93° Cutting Angle for DC.. Inserts

External Right/Left hand tool, through coolant, with 93° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal turning with shoulder, copy, taper and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SDJCR-22040-11	32	22	40	93	0	0	✓	0.20	GI012	C-SD11V-1
	C4-SDJCR-27050-11	40	27	50	93	0	0	✓	0.38	GI012	C-SD11V-1
	C5-SDJCR-35060-11	50	35	60	93	0	0	✓	0.69	GI012	C-SD11V-2
L	C3-SDJCL-22040-11	32	22	40	93	0	0	✓	0.20	GI012	C-SD11V-1
	C4-SDJCL-27050-11	40	27	50	93	0	0	✓	0.38	GI012	C-SD11V-1
	C5-SDJCL-35060-11	50	35	60	93	0	0	✓	0.70	GI012	C-SD11V-2

GI012	DC.. 11T3..

		Nm						
C-SD11V-1	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SD11V-2	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SDNCN EXT

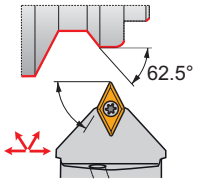
P M K N S H

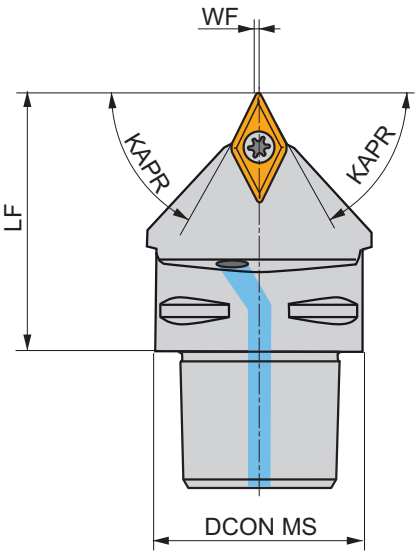
PRAMET

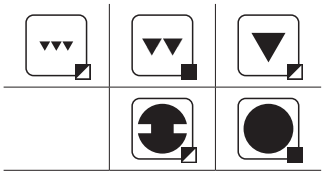
S

External PSC Quick Change Tool, Screw Lock, 62.5° Cutting Angle, DC.. Inserts

External Right/Left hand tool, through coolant, with 62.5° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal turning without shoulder, copy, taper and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
N	C4-SDNCN-00050-11	40	0.5	50	62.5	0	0	✓	0.35	GI012	C-SD11V-1
	C5-SDNCN-00060-11	50	0.5	60	62.5	0	0	✓	0.62	GI012	C-SD11V-2

GI012	DC.. 11T3..

		Nm						
C-SD11V-1	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SD11V-2	US 2001-T15P	3.0	M 3.5	12.1	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

SDQC(RL) INT

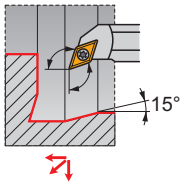
P M K N S H

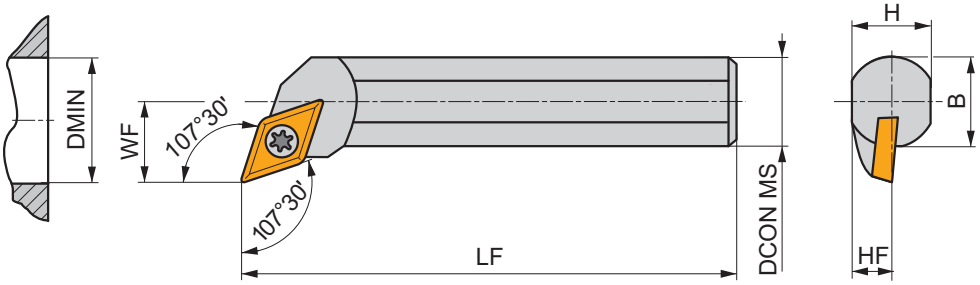
PRAMET

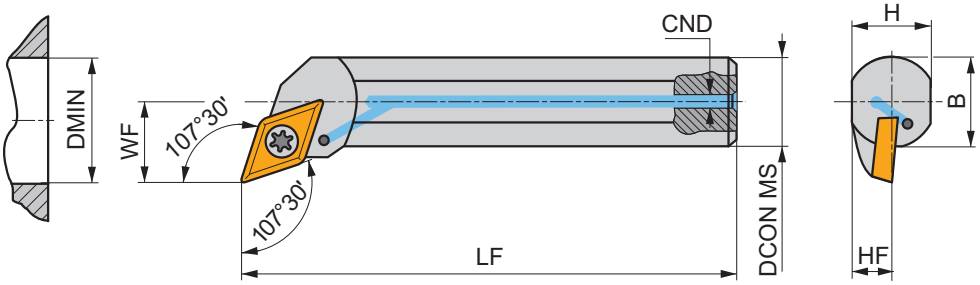
S

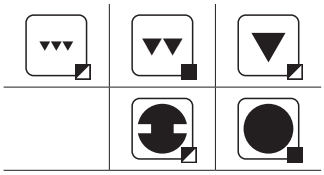
Internal Screw Lock Boring Bar with 107.5° Cutting Angle for DC.. Inserts

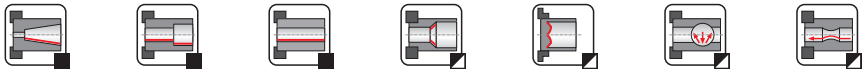
Internal Right/Left hand boring bar, through coolant available, 107.5° cutting angle for screw type DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A10H-SDQCR 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDQCR 07	12	16	9	11	–	125	5	-7	0	✓	0.10	GI052	S02
	A16M-SDQCR 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDQCR 11	20	25	13	18	–	180	8	-5	0	✓	0.36	GI012	S08
	S20S-SDQCR 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDQCR 11	25	32	17	23	23	200	8	-3	0	✓	0.65	GI012	S08
	S25T-SDQCR 11	25	32	17	23	23	300	–	-3	0	–	1.08	GI012	S08
	A32S-SDQCR 11-A	32	40	22	30	30	250	8	-10	0	✓	1.25	GI012	SD10
	S32U-SDQCR 11-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI012	SD10
L	A10H-SDQCL 07	10	13	7	9	–	100	4	-10	0	✓	0.06	GI052	S02
	A12K-SDQCL 07	12	16	9	11	–	125	5	-7	0	✓	0.11	GI052	S02
	A16M-SDQCL 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDQCL 11	20	25	13	18	–	180	8	-5	0	✓	0.37	GI012	S08
	S20S-SDQCL 11	20	25	13	18	18.5	250	–	-5	0	–	0.63	GI012	S08
	A25R-SDQCL 11	25	32	17	23	23	200	8	-3	0	✓	0.64	GI012	S08
	S25T-SDQCL 11	25	32	17	23	23	300	–	-3	0	–	1.15	GI012	S08
	A32S-SDQCL 11-A	32	40	22	30	30	250	8	-10	0	✓	1.32	GI012	SD10
	S32U-SDQCL 11-A	32	40	22	30	30	350	–	-10	0	–	2.08	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SDUC(RL) INT

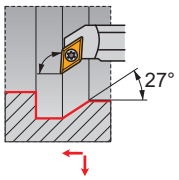
P M K N S H

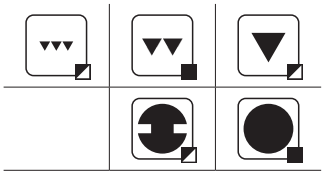
PRAMET

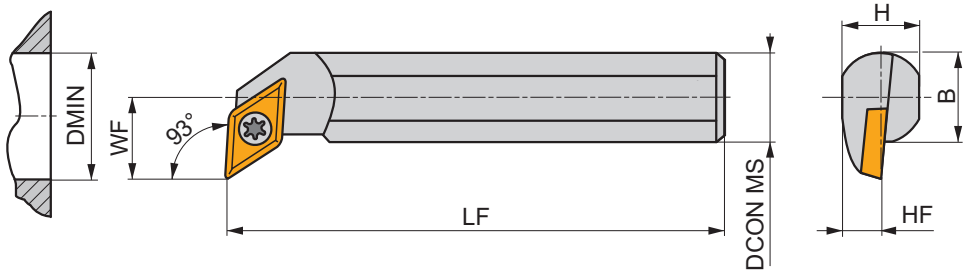
S

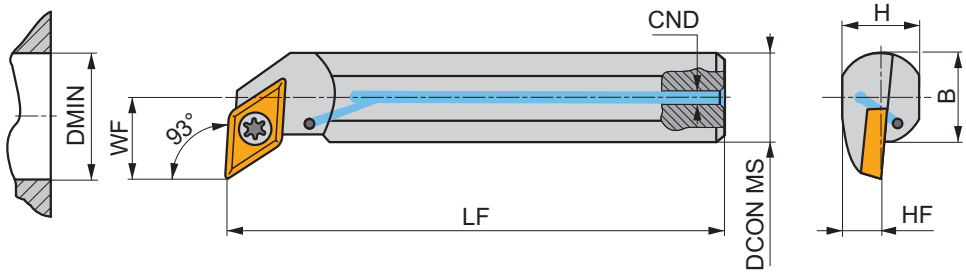
Internal Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 93° cutting angle for screw type DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		kg		
R	A10H-SDUCR 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDUCR 07	12	16	9	11	–	125	5	-7	0	✓	0.12	GI052	S02
	A16M-SDUCR 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDUCR 11	20	25	13	18	–	180	8	-3	0	✓	0.37	GI012	S08
	S20S-SDUCR 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDUCR 11	25	32	17	23	23	200	8	-3	0	✓	0.60	GI012	S08
	S25T-SDUCR 11	25	32	17	23	23	300	–	-3	0	–	1.09	GI012	S08
	A32S-SDUCR 11-A	32	40	22	30	30	250	8	-10	0	✓	1.30	GI012	SD10
	S32U-SDUCR 11-A	32	40	22	30	30	350	–	-10	0	–	2.10	GI012	SD10
L	A10H-SDUCL 07	10	13	7	9	–	100	4	-10	0	✓	0.07	GI052	S02
	A12K-SDUCL 07	12	16	9	11	–	125	5	-7	0	✓	0.11	GI052	S02
	A16M-SDUCL 07	16	20	11	14.5	–	150	6	-7	0	✓	0.22	GI052	S01
	A20Q-SDUCL 11	20	25	13	18	–	180	8	-3	0	✓	0.37	GI012	S08
	S20S-SDUCL 11	20	25	13	18	18.5	250	–	-5	0	–	0.60	GI012	S08
	A25R-SDUCL 11	25	32	17	23	23	200	8	-3	0	✓	0.66	GI012	S08
	S25T-SDUCL 11	25	32	17	23	23	300	–	-3	0	–	1.09	GI012	S08
	A32S-SDUCL 11-A	32	40	22	30	30	250	8	-10	0	✓	0.00	GI012	SD10
	S32U-SDUCL 11-A	32	40	22	30	30	350	–	-10	0	–	2.09	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

SDUC(RL)-E INT

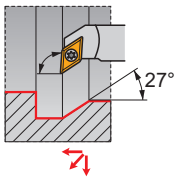
P M K N S H

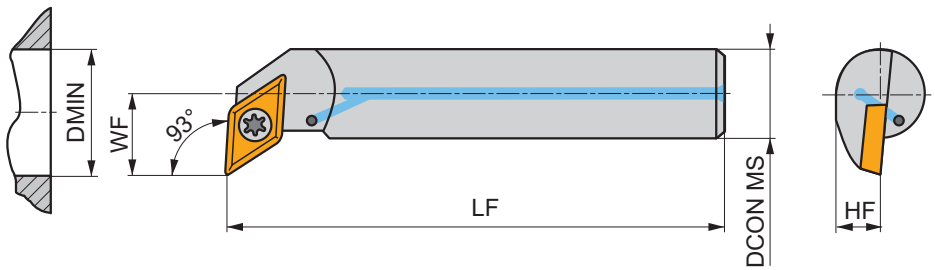
PRAMET

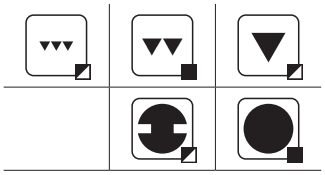
S

Internal Carbide Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, 93° cutting angle for screw type positive DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. For tool overhang >3xD.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	E10M-SDUCR 07-ER	10	15	9	5.6	150	-5	0	✓	0.14	GI052	SD21
	E12Q-SDUCR 07-ER	12	18	11	6.5	150	-5	0	✓	0.26	GI052	SD21
	E16R-SDUCR 07-ER	16	22	13	8.5	150	-5	0	✓	0.49	GI052	SD21
L	E10M-SDUCL 07-ER	10	15	9	5.6	150	-5	0	✓	0.15	GI052	SD21
	E12Q-SDUCL 07-ER	12	18	11	6.5	150	-5	0	✓	0.26	GI052	SD21
	E16R-SDUCL 07-ER	16	22	13	8.5	150	-5	0	✓	0.50	GI052	SD21

GI052	DC.. 0702..

SD21	5513 020-03	0.8	M 2.5	6.5	PT-8001

SDZC(RL) INT

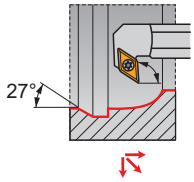
P M K N S H

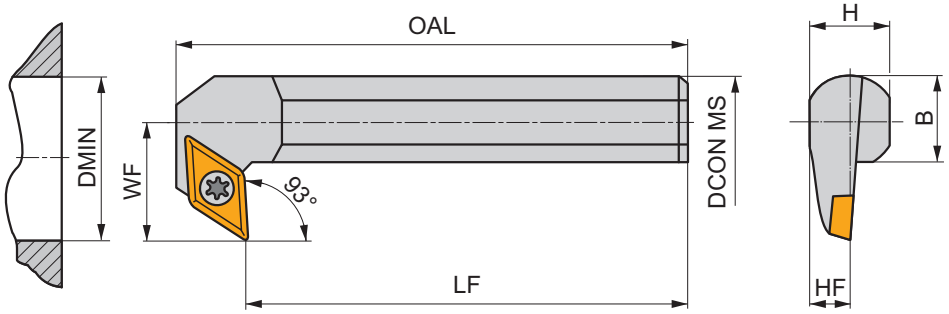
PRAMET

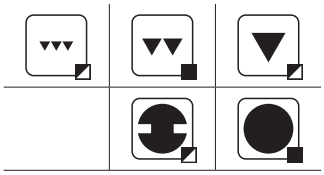
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand boring bar with 93° cutting angle for screw type DC.. inserts. Suited for internal longitudinal back turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	OAL (mm)	LAMS (°)	GAMO (°)	kg		
R	S16M-SDZCR 07-93	16	27	17	14.5	15	150	163	-4	0	0.26	GI052	S01
	S20Q-SDZCR 11-93	20	35	22	18	18.5	180	198	-5	0	0.49	GI012	S08
	S25R-SDZCR 11-93	25	42	27	23	23	200	218	-3	0	0.79	GI012	S08
	S32S-SDZCR 11-93-A	32	53	35	30	30	250	268	-6	0	1.62	GI012	SD10
	S40T-SDZCR 11-93-A	40	65	43	38	38	300	322	-5	0	3.00	GI012	SD10
L	S16M-SDZCL 07-93	16	27	17	14.5	15	150	163	-4	0	0.27	GI052	S01
	S20Q-SDZCL 11-93	20	35	22	18	18.5	180	198	-5	0	0.48	GI012	S08
	S25R-SDZCL 11-93	25	42	27	23	23	200	218	-3	0	0.80	GI012	S08
	S32S-SDZCL 11-93-A	32	53	35	30	30	250	268	-6	0	1.60	GI012	SD10
	S40T-SDZCL 11-93-A	40	65	43	38	38	300	322	-5	0	3.00	GI012	SD10

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	10.6	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–

C.-SDUC(RL) INT

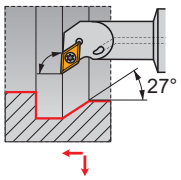
P M K N S H

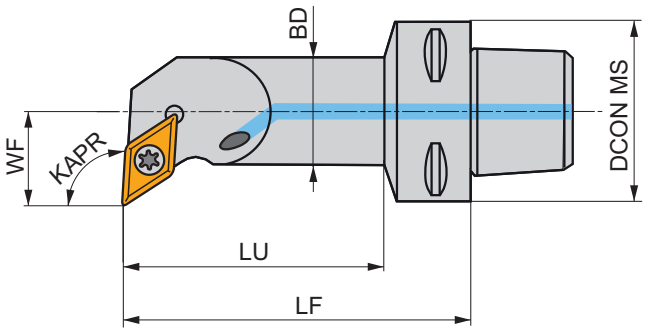
PRAMET

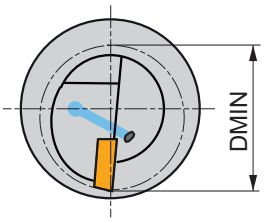
S

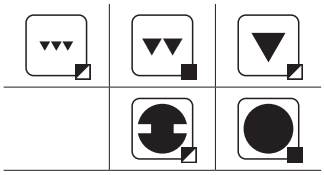
Internal PSC Quick Change Tool, Screw Lock, 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand tool, through coolant, with 93°cutting angle for screw type DC.. inserts. Suited for a wide range of internal turning applications. Polygon Shank Coupling with choice of lengths. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SDUCR-11065-07	50	20	11	65	48	16	93	-4.3	0	✓	0.20	GI052	SV11
	C4-SDUCR-11070-07	40	20	11	70	47	16	93	-4.3	0	✓	0.35	GI052	SV11
	C4-SDUCR-13080-11	40	25	13	80	57	20	93	-5.8	0	✓	0.41	GI012	SC09M
	C4-SDUCR-17090-11	40	32	17	90	68	25	93	-3.4	0	✓	0.49	GI012	SV16
	C5-SDUCR-13080-11	50	25	13	80	56	20	93	-5.8	0	✓	0.60	GI012	SC09M
	C5-SDUCR-17090-11	50	32	17	90	67	25	93	-3.4	0	✓	0.68	GI012	SV16
L	C4-SDUCL-11070-07	40	20	11	70	47	16	93	-4.3	0	✓	0.35	GI052	SV11
	C4-SDUCL-13080-11	40	25	13	80	57	20	93	-5.8	0	✓	0.41	GI012	SC09M
	C4-SDUCL-17090-11	40	32	17	90	68	25	93	-3.4	0	✓	0.49	GI012	SV16
	C5-SDUCL-13080-11	50	25	13	80	56	20	93	-5.8	0	✓	0.60	GI012	SC09M

GI012	DC.. 11T3..
GI052	DC.. 0702..

		Nm				
SC09M	US 2009-T15P	3.0	M 3.5	8.1	FLAG T15P/3,5	–
SV11	US 2003-T07P	0.8	M 2.5	6.5	–	FLAG T07P
SV16	US 2010-T15P	3.0	M 3.5	10.1	–	FLAG T15P/3,5

SEGC(RL) EXT

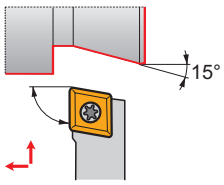
P M K N S H

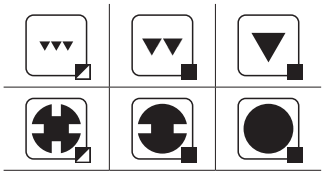
PRAMET

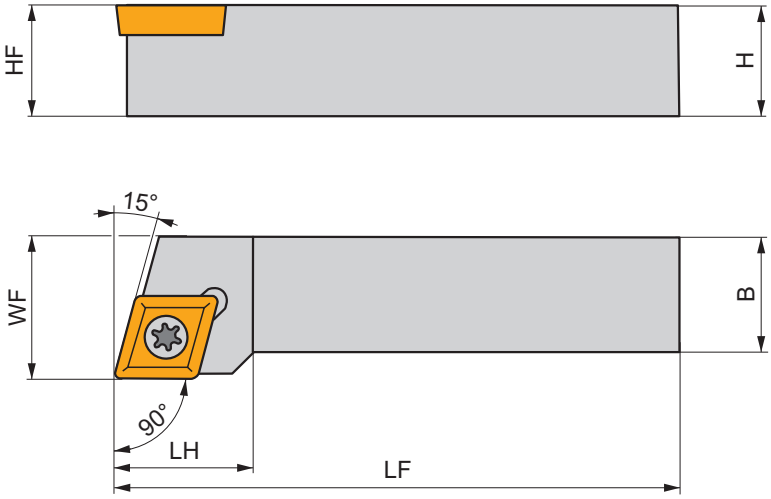
S

External Screw Lock Tool Holder with 90° Cutting Angle for EC.. Inserts

External Right/Left hand tool holder with 90° cutting angle for screw type positive EC.. inserts. Suited for external face and longitudinal turning with shoulder, taper, chamfer and face turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**SEGCR 1212 N 08**	12	12	12	16	160	12.0	0	0	0.15	GI210	SE08
	SEGCR 1616 H 08	16	16	16	20	100	12.0	0	0	0.22	GI210	SE08
L	**SEGCL 1212 N 08**	12	12	12	16	160	12.0	0	0	0.22	GI210	SE08
	SEGCL 1616 H 08	16	16	16	20	100	12.0	0	0	2.14	GI210	SE08

GI210	EC.. 0803..

SE08	416.1-832	3.6	M 3	8.5	PT-8002

SEUC(RL) INT

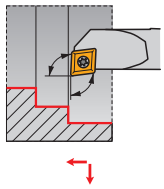
P M K N S H

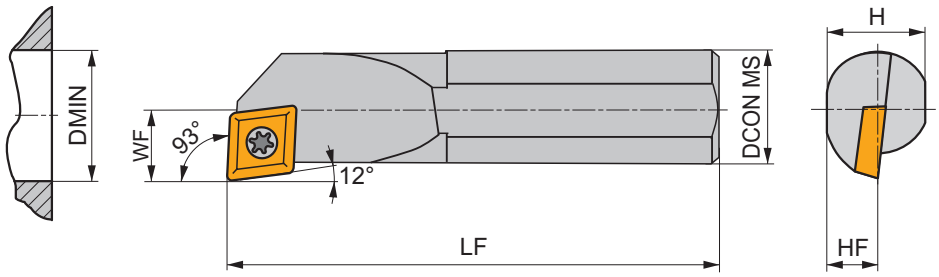
PRAMET

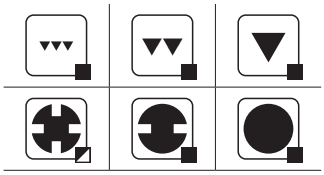
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for EC.. Inserts

Internal Right/Left hand boring bar with 93° cutting angle for screw type EC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S08K-SEUCR 06	8	11	7	7	3.5	125	-5	0	0.06	GI213	SE23
	S10M-SEUCR 06	10	13	8	9	4.5	150	-5	0	0.10	GI213	SE23
	S12M-SEUCR 08	12	15	9	11	5.5	150	-5	0	0.14	GI210	SE24
	S16R-SEUCR 08	16	20	11	15	7.5	200	-5	0	0.32	GI210	SE24
	S20S-SEUCR 08	20	25	13	18	9	250	-5	0	0.58	GI210	SE24
	S25T-SEUCR 08	25	32	17	23	11.5	300	-4	0	1.06	GI210	SE24
L	S08K-SEUCL 06	8	11	7	7	3.5	125	-5	0	0.06	GI213	SE23
	S10M-SEUCL 06	10	13	8	9	4.5	150	-5	0	0.10	GI213	SE23
	S12M-SEUCL 08	12	15	9	11	5.5	150	-5	0	0.14	GI210	SE24
	S16R-SEUCL 08	16	20	11	15	7.5	200	-5	0	0.32	GI210	SE24
	S20S-SEUCL 08	20	25	13	18	9	250	-5	0	0.58	GI210	SE24

GI210	EC.. 0803..
GI213	EC.. 0602..

		Nm			
SE23	5513 020-03	0.8	M 2.5	6.5	PT-8001
SE24	416.1-832	3.6	M 3	8.5	PT-8003

SELP(RL) INT

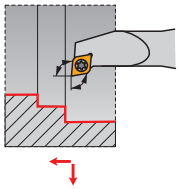
P M K N S H

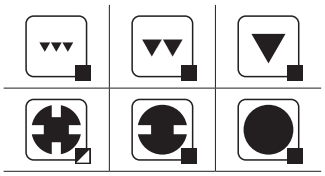
PRAMET

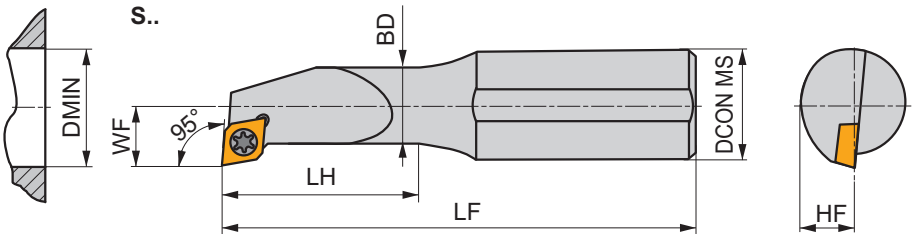
S

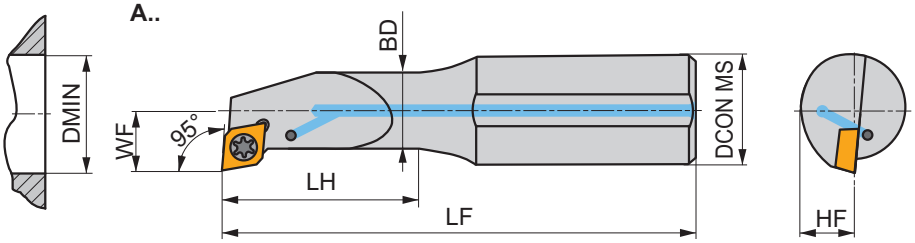
Internal Screw Lock Boring Bar with 95° Cutting Angle for EP.. Inserts

Internal Right/Left hand boring bar, through coolant available, with 95° cutting angle for screw type EP.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	S0608H-SELPR 05	8	8	6	4.5	100	20.0	-10	0	–	0.04	GI212	SE21
	S0810J-SELPR 05	10	11	8	6	110	26.0	-5	0	–	0.06	GI212	SE22
	S1012K-SELPR 05	12	13	10	7	125	32.0	-5	0	–	0.11	GI212	SE22
	A1216M-SELPR 05	16	16	12	9	150	40.0	-2	0	✓	0.18	GI212	SE22
	S1216M-SELPR 05	16	16	12	9	150	40.0	-2	0	–	0.21	GI212	SE22
L	S0608H-SELPL 05	8	8	6	4.5	100	20.0	-10	0	–	0.04	GI212	SE21
	S0810J-SELPL 05	10	11	8	6	110	26.0	-5	0	–	0.06	GI212	SE22
	S1012K-SELPL 05	12	13	10	7	125	32.0	-5	0	–	0.11	GI212	SE22
	S1216M-SELPL 05	16	16	12	9	150	40.0	-2	0	–	0.21	GI212	SE22

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

SELP(RL)-E INT

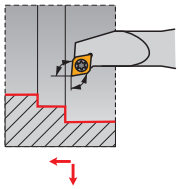
P M K N S H

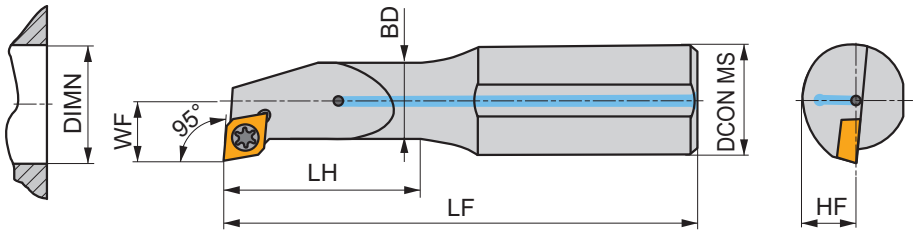
PRAMET

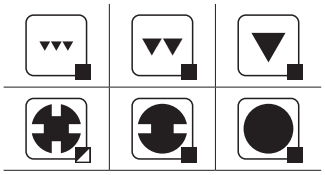
S

Internal Carbide Screw Lock Boring Bar with 95° Cutting Angle for EP.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, with 95° cutting angle for screw type EP.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. For tool overhang >3xD.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	E0608H-SELPR 05	8	8	6	4.5	100	28.0	-10	0	✓	0.06	GI212	SE22
	E0810J-SELPR 05	10	11	8	6	110	36.0	-5	0	✓	0.10	GI212	SE22
	E1012K-SELPR 05	12	13	10	7	125	44.0	-5	0	✓	0.17	GI212	SE22
L	E0608H-SELPL 05	8	8	6	4.5	100	28.0	-10	0	✓	0.06	GI212	SE22
	E0810J-SELPL 05	10	11	8	6	110	36.0	-5	0	✓	0.10	GI212	SE22
	E1216M-SELPL 05	16	16	12	9	150	55.0	-2	0	✓	0.33	GI212	SE22

GI212	EP.. 0502..

		Nm			
SE22	28588	0.8	M 2.2	5.6	MA2-8304

SEUP(RL) INT

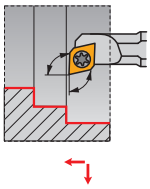
P M K N S H

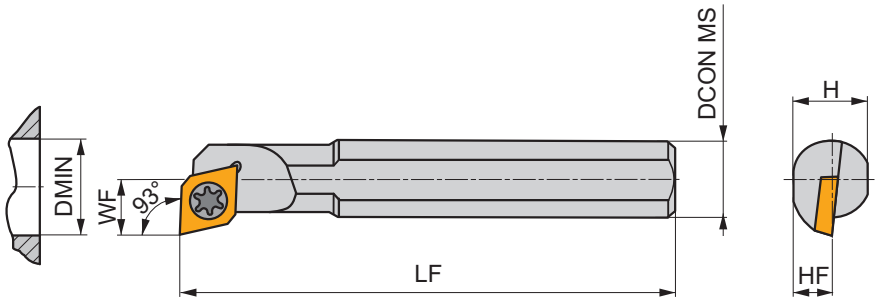
PRAMET

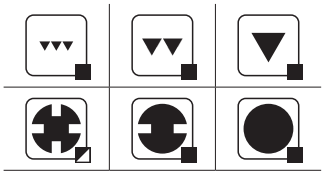
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for EP.. Inserts

Internal Right/Left hand boring bar with 93° cutting angle for screw type EP..inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	S06H-SEUPR 05	6	8.3	5	5.4	2.7	100	-7	0	0.04	GI212	SE21
L	S06H-SEUPL 05	6	8.3	5	5.4	2.7	100	-7	0	0.05	GI212	SE21

GI212	EP.. 0502..

SE21	28992	0.8 Nm	M 2.2	4.2	MA2-8304

SEXP(RL) INT

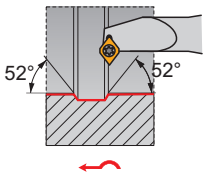
P M K N S H

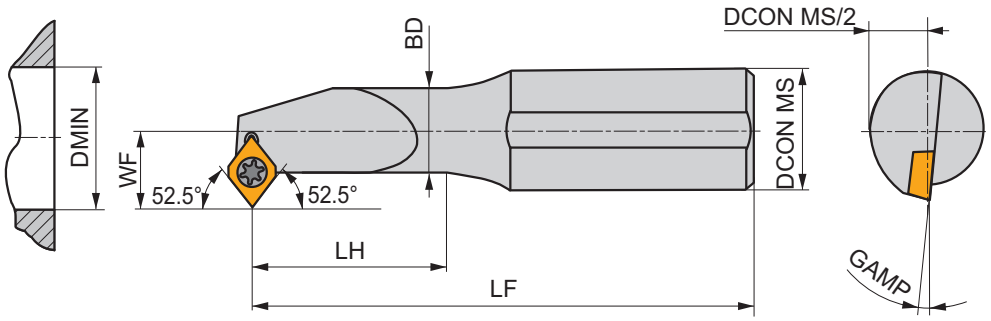
PRAMET

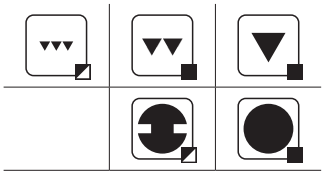
S

Internal Screw Lock Boring Bar with 52.5° Cutting Angle for EP.. Inserts

Internal Right/Left hand boring bar, 52.5° cutting angle for screw type EP.. inserts. For internal back chamfer, taper, multi-directional, chamfer and longitudinal turning without shoulder. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)	kg		
R	S0608H-SEXPR 05	8	9.5	6	5.5	100	20.0	-7	0.04	GI212	SE21
	S0810J-SEXPR 05	10	11	8	6	110	26.0	-5	0.06	GI212	SE22
	S1012K-SEXPR 05	12	13	10	7	125	32.0	-5	0.11	GI212	SE22
	S1216M-SEXPR 05	16	16	12	9	150	40.0	-2	0.21	GI212	SE22
L	S0608H-SEXPL 05	8	9.5	6	5.5	100	20.0	-7	0.04	GI212	SE21
	S0810J-SEXPL 05	10	11	8	6	110	26.0	-5	0.06	GI212	SE22
	S1012K-SEXPL 05	12	13	10	7	125	32.0	-5	0.11	GI212	SE22
	S1216M-SEXPL 05	16	16	12	9	150	40.0	-2	0.21	GI212	SE22

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

SEXP(RL)-E INT

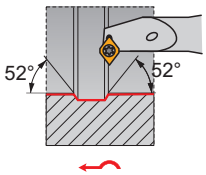
P M K N S H

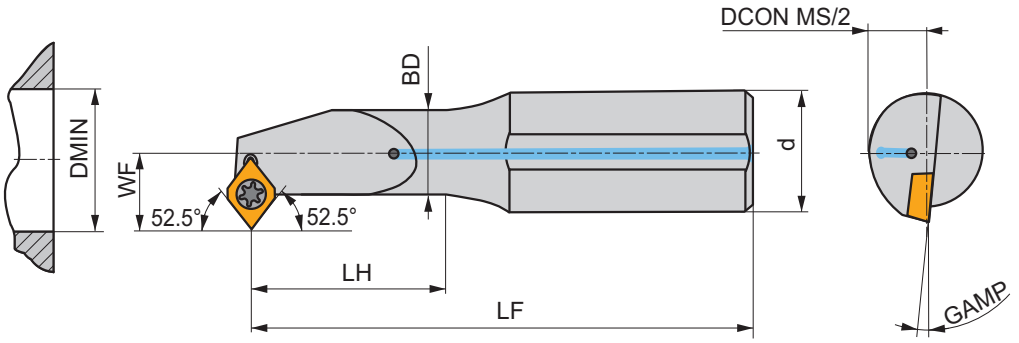
PRAMET

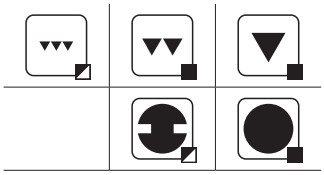
S

Internal Carbide Screw Lock Boring Bar, 52.5° Cutting Angle for EP.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, 52.5° cutting angle for screw type EP.. inserts. For internal back chamfer, taper, multi-directional, chamfer and longitudinal turning without shoulder. For overhang > 3xD.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R	E0608H-SEXPR 05	8	9.5	6	5.5	100	28.0	-7	✓	0.07	GI212	SE21
	E0810J-SEXPR 05	10	11	8	6	110	36.0	-5	✓	0.10	GI212	SE22
	E1012K-SEXPR 05	12	13	10	7	125	44.0	-5	✓	0.16	GI212	SE22
	E1216M-SEXPR 05	16	16	12	9	150	55.0	-2	✓	0.32	GI212	SE22
L	E0608H-SEXPL 05	8	9.5	6	5.5	100	28.0	-7	✓	0.06	GI212	SE21

GI212	EP.. 0502..

		Nm			
SE21	28992	0.8	M 2.2	4.2	MA2-8304
SE22	28588	0.8	M 2.2	5.6	MA2-8304

PRDCN EXT

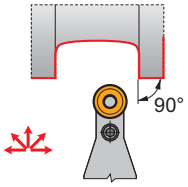
P M K N S H

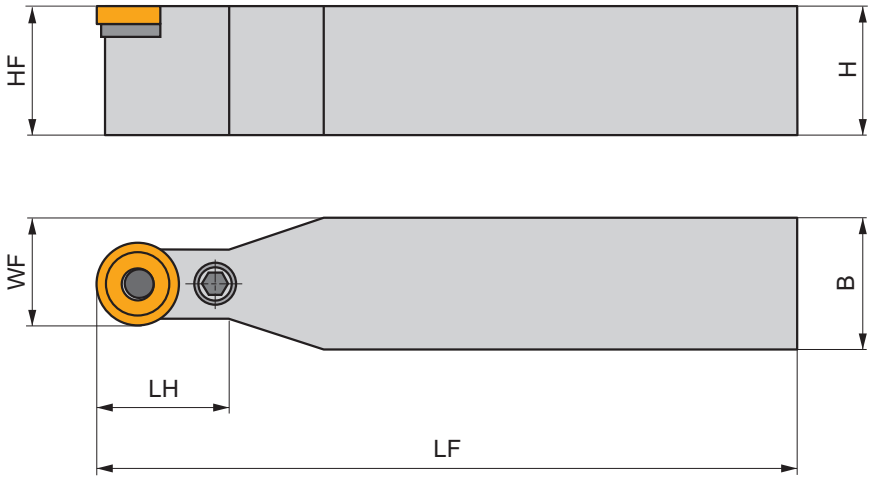
PRAMET

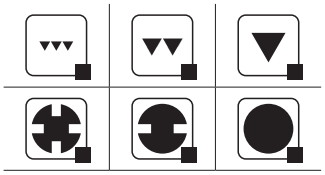
P

External Lever Lock Tool Holder for Round RC.. Inserts

External neutral lever lock tool holder for positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy turning up to 90°, taper and chamfer turning. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
N	**PRDCN 3225 P 16**	32	25	32	20.5	170	34.0	0	0	0.80	GI090	PR01
	PRDCN 3232 P 20	32	32	32	26	170	42.0	0	0	1.16	GI069	PR03
	PRDCN 4040 S 20	40	40	40	30	250	40.0	0	0	2.82	GI069	PR03
	PRDCN 4040 S 25	40	40	40	32.5	250	40.0	0	0	2.75	GI122	PR02
	PRDCN 5050 V 32	50	50	50	41	400	52.0	0	0	7.30	GI096	PR04

GI069	RCMX 2006M0
GI090	RCMX 1606M0
GI096	RCMX 3209M0
GI122	RCMX 2507M0

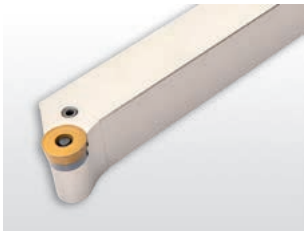
				Nm					
PR01	PRS 816	CL 116	CS 706	2.0	M 6x1	20.7	TR 16	MT 05	HXK 2.5
PR02	PRS 825	CL 125	CS 710	3.5	M 10x1	30.4	TR 19	MT 06	HXK 4
PR03	PRS 820	CL 120	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3
PR04	PRS 832	CL 132	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

PRSC(RL) EXT

P M K N S H

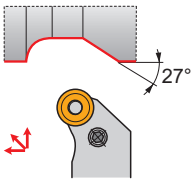
PRAMET

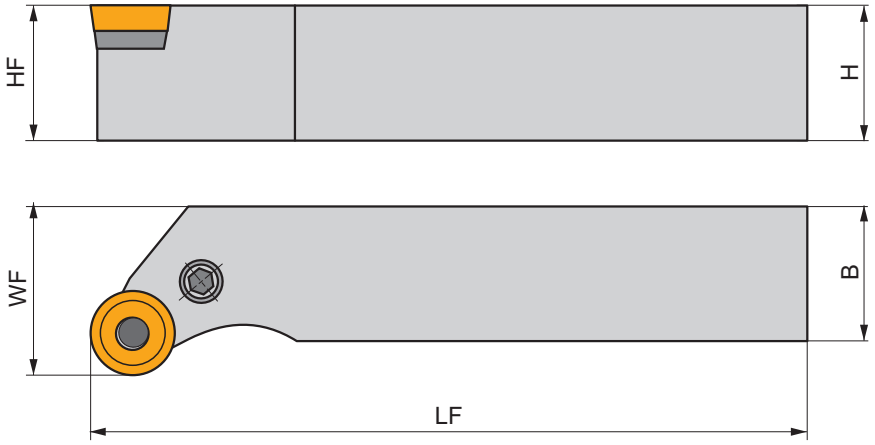
P

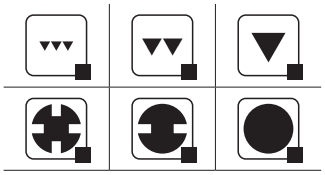


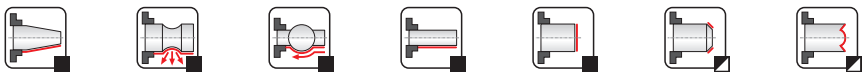
External Lever Lock Tool Holder for Round RC.. Inserts

External Right/Left hand lever lock tool holder for positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy turning up to 27°, taper and chamfer turning, including face copy turning. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	**PRSCR 3225 P 16**	32	25	32	32	170	0	0	1.05	GI090	PR01
	PRSCR 3232 P 20	32	32	32	40	170	0	0	1.29	GI069	PR03
	PRSCR 4040 S 16	40	40	40	50	250	0	0	3.00	GI090	PR01
	PRSCR 4040 S 25	40	40	40	50	250	0	0	3.04	GI122	PR02
L	**PRSCL 3225 P 16**	32	25	32	32	170	0	0	0.90	GI090	PR01
	PRSCL 4040 S 16	40	40	40	50	250	0	0	2.38	GI090	PR01
	PRSCL 3232 P 20	32	32	32	40	170	0	0	1.32	GI069	PR03
	PRSCL 4040 S 25	40	40	40	50	250	0	0	3.06	GI122	PR02

GI069	RCMX 2006M0
GI090	RCMX 1606M0
GI122	RCMX 2507M0

				Nm					
PR01	PRS 816	CL 116	CS 706	2.0	M 6x1	20.7	TR 16	MT 05	HXK 2.5
PR02	PRS 825	CL 125	CS 710	3.5	M 10x1	30.4	TR 19	MT 06	HXK 4
PR03	PRS 820	CL 120	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

SRDC(RL) EXT

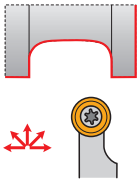
P M K N S H

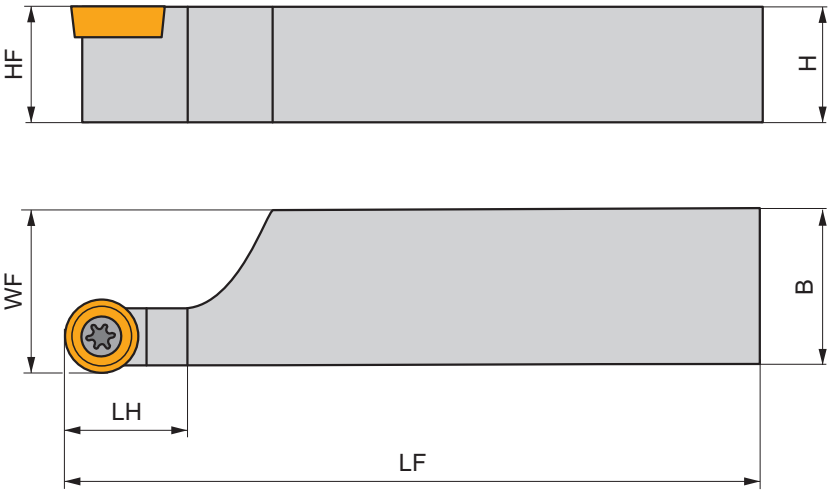
PRAMET

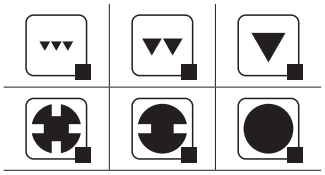
S

External Screw Lock Tool Holder for Round RC.. Inserts

External Right/Left hand tool holder for screw type positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SRDCR 2020 K 08-A	20	20	20	20.5	125	20.0	0	0	0.36	GI051	SR21
	SRDCR 2525 M 08-A	25	25	25	25.5	150	20.0	0	0	0.66	GI051	SR21
	SRDCR 3225 P 08-A	32	25	32	25.5	170	20.0	0	0	0.95	GI051	SR21
L	SRDCL 2020 K 08-A	20	20	20	20.5	125	20.0	0	0	0.37	GI051	SR21
	SRDCL 2525 M 08-A	25	25	25	25.5	150	20.0	0	0	0.66	GI051	SR21
	SRDCL 3225 P 08-A	32	25	32	25.5	170	20.0	0	0	0.96	GI051	SR21

GI051	RC.. 0803M0

		Nm			
SR21	5513 020-04	1.5	M 3	7.2	PT-8002

SRDCN EXT

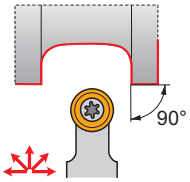
P M K N S H

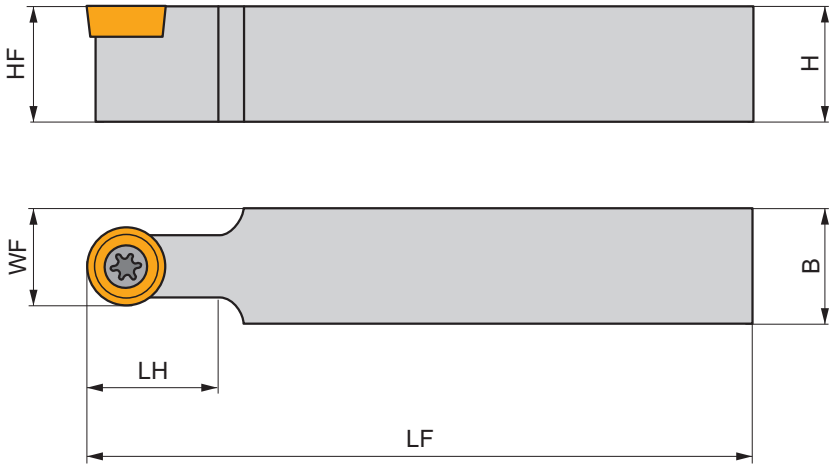
PRAMET

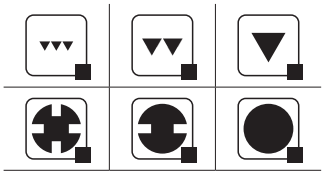
S

External Screw Lock Tool Holder for Round RC.. Inserts

External neutral tool holder for screw type positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
N	**SRDCN 1212 F 06**	12	12	12	9	80	12.0	0	0	0.10	GI054	S01
	SRDCN 1616 H 06	16	16	16	11	100	12.0	0	0	0.20	GI054	S01
	SRDCN 2020 K 08	20	20	20	14	125	20.0	0	0	0.37	GI051	S03
	SRDCN 2020 K 1003-M-A	20	20	20	15	125	25.0	0	0	0.38	GI064	SR10
	SRDCN 2020 K 10-M-A	20	20	20	15	125	25.0	0	0	0.37	GI013	SR10
	SRDCN 2525 M 10-M-A	25	25	25	17.5	150	25.0	0	0	0.67	GI013	SR10
	SRDCN 2525 M 12-M-A	25	25	25	18.5	150	30.0	0	0	0.08	GI014	SR12
	SRDCN 3225 P 10-M	32	25	32	17.5	170	25.0	0	0	0.90	GI013	SR10
	SRDCN 3225 P 12-M	32	25	32	18.5	170	30.0	0	0	0.90	GI014	SR12
	SRDCN 3225 P 16-M	32	25	32	20.5	170	32.0	0	0	1.00	GI161	SR16

GI013	RC.. 10T3M0
GI014	RC.. 1204M0
GI051	RC.. 0803M0
GI054	RC.. 0602M0
GI064	RC.. 1003M0
GI161	RC.. 1606M0

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S03	US 3007-T09P	2.0	M 3	7.3	–	–	FLAG T09P	–
SR10	US 3510-T15P	3.0	M 3.5	10.6	SRN 100300	MS 3510	FLAG T15P	HXK 3.5
SR12	US 3510-T15P	3.0	M 3.5	10.6	SRN 120300	MS 3510	FLAG T15P	HXK 3.5
SR16	US 5018-T20P	5.0	M 5	18.2	SRN 16T3M0	MS 5015	FLAG T20P	HXK 5

SRSC(RL) EXT

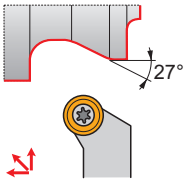
P M K N S H

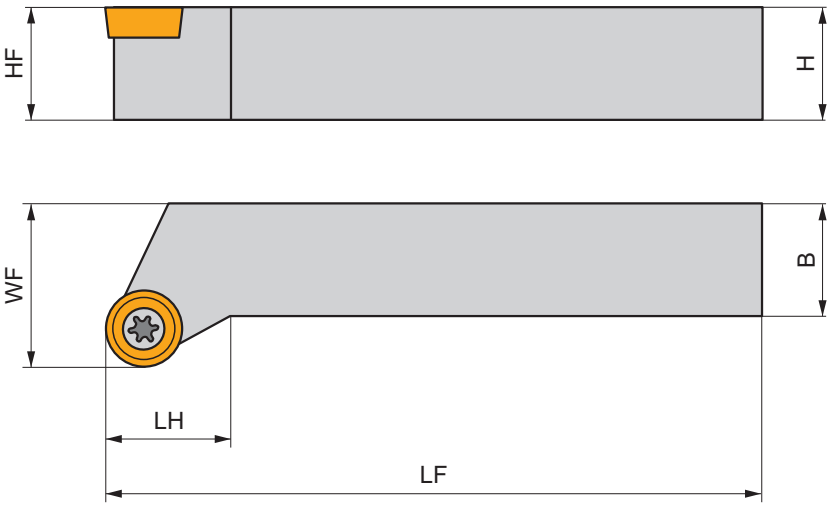
PRAMET

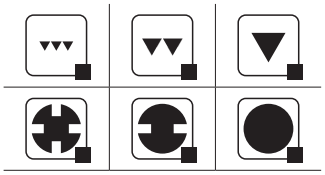
S

External Screw Lock Tool Holder for Round RC.. Inserts

External Right/Left hand tool holder for screw type positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	SRSCR 1212 F 06	12	12	12	16	80	12.0	0	0	0.09	GI054	S01
	SRSCR 1616 H 06	16	16	16	20	100	12.0	0	0	0.21	GI054	S01
	SRSCR 2020 K 08	20	20	20	25	125	20.0	0	0	0.40	GI051	S03
	SRSCR 2020 K 10-M-A	20	20	20	25	125	20.0	0	0	0.41	GI013	SR10
	SRSCR 2525 M 10-M-A	25	25	25	32	150	20.0	0	0	0.75	GI013	SR10
	SRSCR 3225 P 10-M	32	25	32	32	170	20.0	0	0	1.06	GI013	SR10
	SRSCR 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.75	GI014	SR12
	SRSCR 3225 P 16-M	32	25	32	32	170	20.0	0	0	1.08	GI161	SR16
L	SRSCL 1212 F 06	12	12	12	16	80	12.0	0	0	0.10	GI054	S01
	SRSCL 1616 H 06	16	16	16	20	100	12.0	0	0	0.22	GI054	S01
	SRSCL 2020 K 08	20	20	20	25	125	20.0	0	0	0.45	GI051	S03
	SRSCL 2020 K 10-M-A	20	20	20	25	125	20.0	0	0	0.42	GI013	SR10
	SRSCL 2525 M 10-M-A	25	25	25	32	150	20.0	0	0	0.74	GI013	SR10
	SRSCL 3225 P 10-M	32	25	32	32	170	20.0	0	0	1.06	GI013	SR10
	SRSCL 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	0.75	GI014	SR12
	SRSCL 3225 P 16-M	32	25	32	32	170	20.0	0	0	1.08	GI161	SR16

GI013	RC.. 10T3M0
GI014	RC.. 1204M0
GI051	RC.. 0803M0
GI054	RC.. 0602M0
GI161	RC.. 1606M0

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S03	US 3007-T09P	2.0	M 3	7.3	–	–	FLAG T09P	–
SR10	US 3510-T15P	3.0	M 3.5	10.6	SRN 100300	MS 3510	FLAG T15P	HXK 3.5
SR12	US 3510-T15P	3.0	M 3.5	10.6	SRN 120300	MS 3510	FLAG T15P	HXK 3.5
SR16	US 5018-T20P	5.0	M 5	18.2	SRN 16T3M0	MS 5015	FLAG T20P	HXK 5

C.-SRDCN EXT

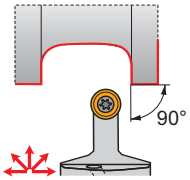
P M K N S H

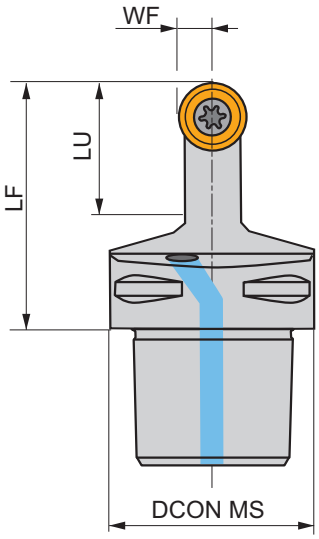
PRAMET

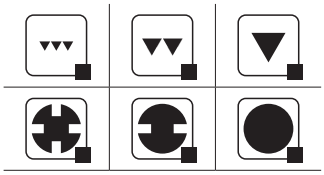
S

External PSC Quick Change Tool, Screw Lock for RC.. Inserts

External neutral tool, through coolant, for screw type positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy, taper and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	LU (mm)	LAMS (°)	GAMO (°)		kg		
N	C4-SRDCN-00050-12A	40	6	50	28	0	0	✓	0.32	GI014	C-SR12V-1
	C5-SRDCN-00060-10A	50	5	60	25	0	0	✓	0.56	GI013	C-SR10V
	C5-SRDCN-00060-12A	50	6	60	28	0	0	✓	0.56	GI014	C-SR12V-2

GI013	RC.. 10T3M0
GI014	RC.. 1204M0

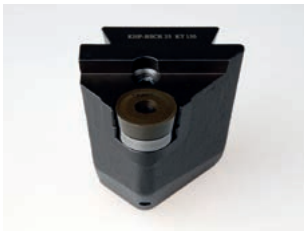
		Nm						
C-SR10V	US 2010-T15P	3.0	M 3.5	10.1	SRS 110-01	MS 9001	FLAG T15P/3,5	CN 034-02
C-SR12V-1	US 2001-T15P	3.0	M 3.5	12.1	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-01
C-SR12V-2	US 2001-T15P	3.0	M 3.5	12.1	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-02

KHP-RSC(RL)

P M K

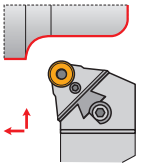
PRAMET

P

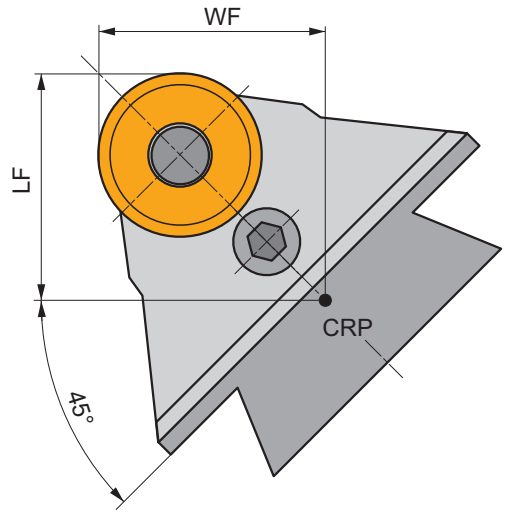


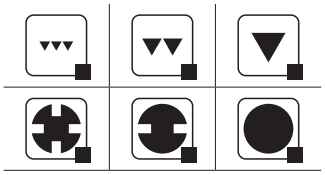
Modular KHP Lever Lock Turning Cartridge for RC.. Inserts

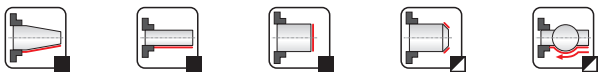
Dovetailed Right/Left hand lever lock turning cartridge for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, taper and chamfer turning with positive RC.. inserts. Tool holder treated for longer tool life.



DKHR+KHP-RSCR







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-RSCR 20**	35	45	0	0	1.25	GI069	PRP90
	KHP-RSCL 20	35	45	0	0	1.30	GI069	PRP90

GI069	RCMX 2006M0

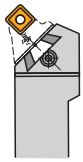
PRP90	RCU 200400	CL 120	US 36	6.0 Nm	M 8x1	26	NT 07	MT 07	HXK 4

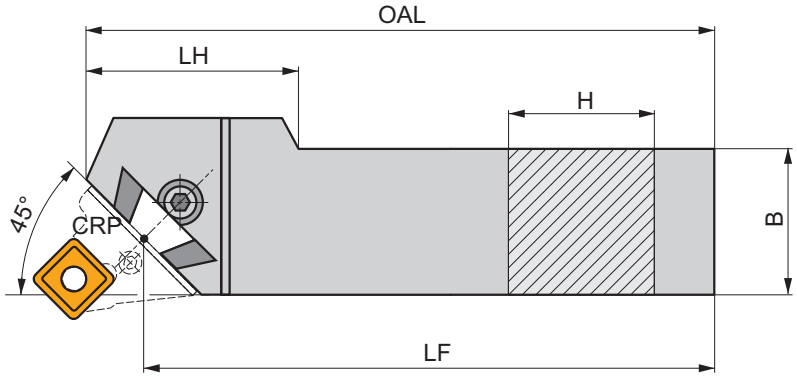
DKH(RL)

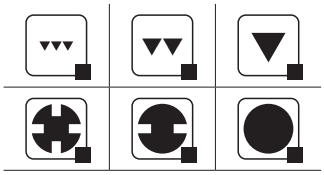
PRAMET

External Tool Holder Shank for KHP/KHS Heavy Turning Cartridges

Dovetailed Right/Left hand modular tool shank for KHP/KHS cartridges. Suited for heavy turning applications. Body treated for longer tool life.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

SSBC(RL) EXT

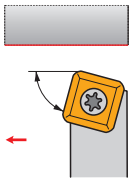
P M K N S H

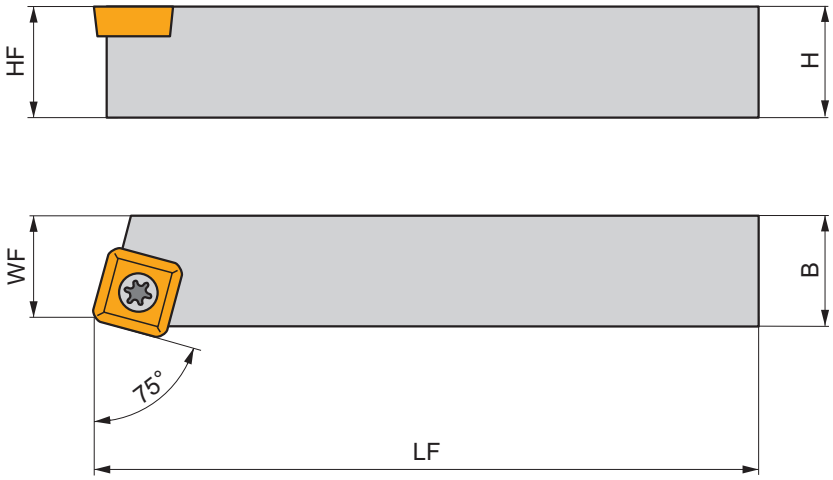
PRAMET

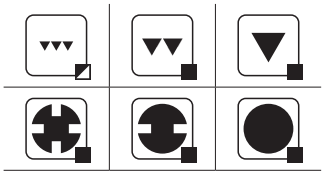
S

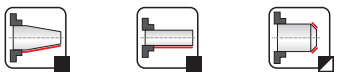
External Screw Lock Tool Holder with 75° Cutting Angle for SC.. Inserts

External Right/Left hand tool holder for screw type positive SC.. inserts. Suited for external longitudinal turning without shoulder, taper and chamfer turning. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	SSBCR 1212 F 09	12	12	12	11	80	0	0	0.10	GI053	S08
	SSBCR 1616 H 09	16	16	16	13	100	0	0	0.20	GI053	S08
	SSBCR 2020 K 12-M-A	20	20	20	17	125	0	0	0.40	GI015	SS20
	SSBCR 2525 M 12-M-A	25	25	25	22	150	0	0	0.76	GI015	SS20
	SSBCR 4040 S 25	40	40	40	35	250	0	0	3.01	GI131	SS25
	SSBCR 5050 T 25	50	50	50	43	300	0	0	5.65	GI131	SS25
	SSBCR 5050 T 38-A	50	50	50	43	300	0	0	4.84	GI164	SS38A
	SSBCR 6060 V 38-A	60	60	60	53	400	0	0	11.10	GI164	SS38A
L	SSBCL 1212 F 09	12	12	12	11	80	0	0	0.10	GI053	S08
	SSBCL 1616 H 09	16	16	16	13	100	0	0	0.22	GI053	S08
	SSBCL 2020 K 12-M-A	20	20	20	17	125	0	0	0.40	GI015	SS20
	SSBCL 2525 M 12-M-A	25	25	25	22	150	0	0	0.70	GI015	SS20
	SSBCL 4040 S 25	40	40	40	35	250	0	0	3.01	GI131	SS25
	SSBCL 5050 T 25	50	50	50	43	300	0	0	5.65	GI131	SS25
	SSBCL 5050 T 38-A	50	50	50	43	300	0	0	5.78	GI164	SS38A
	SSBCL 6060 V 38-A	60	60	60	53	400	0	0	11.16	GI164	SS38A

GI015	SC.. 1204..
GI053	SC.. 09T3..
GI131	SC.. 2509..
GI164	SC.. 3809..

		Nm							
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5	–
SS25	US 8025-T30P	13.0	M 8	24.2	SSN 250620	MS 8020	–	HXK 5	SDR T30P
SS38A	US 8025-T30P	13.0	M 8	24.2	SSN 380920	MS 8020	–	HXK 5	SDR T30P

SSDCN EXT

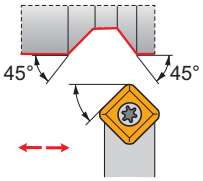
P M K N S H

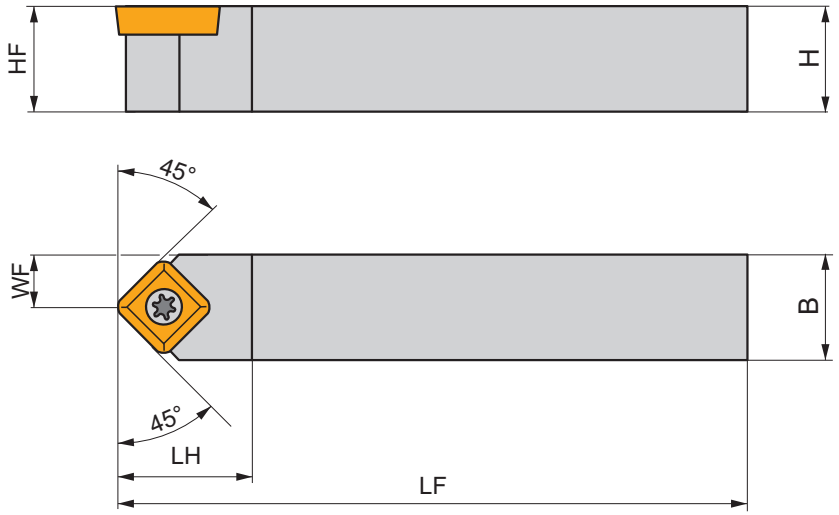
PRAMET

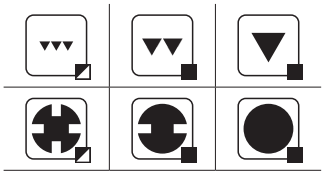
S

External Screw Lock Tool Holder with 45° Cutting Angle for SC.. Inserts

External neutral tool holder for screw type positive SC.. inserts. Suited for external longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	SSDCN 1212 F 09	12	12	12	6	80	–	0	0	0.11	GI053	S08
	SSDCN 1616 H 09	16	16	16	8	100	–	0	0	0.20	GI053	S08
	SSDCN 2020 K 12-M-A	20	20	20	10	125	–	0	0	0.41	GI015	SS20
	SSDCN 2525 M 12-M-A	25	25	25	12.5	150	–	0	0	0.74	GI015	SS20

GI015	SC.. 1204..
GI053	SC.. 09T3..

		Nm						
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5

SSKC(RL) EXT

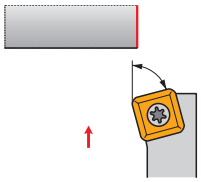
P M K N S H

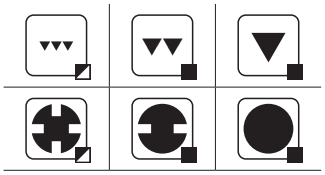
PRAMET

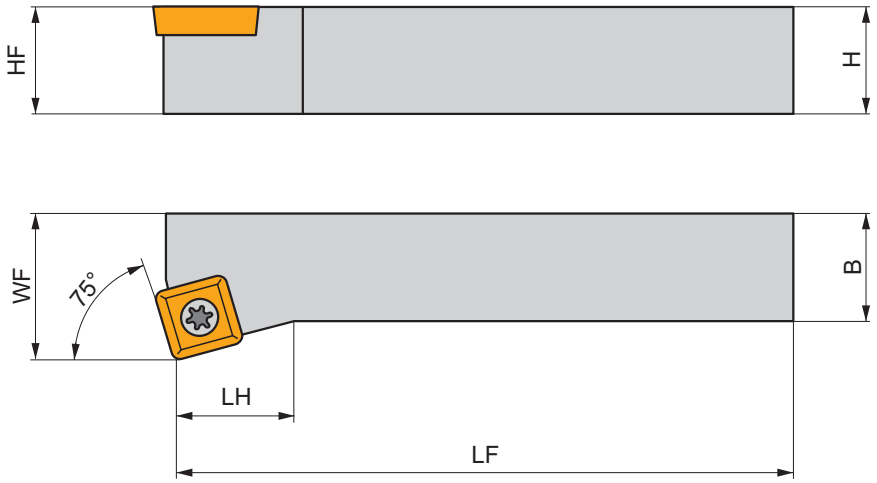
S

Ext. Screw Lock Tool Holder, 75° (Face Turning) Cutting Angle for SC.. Insert

External Right/Left hand tool holder for screw type positive SC.. inserts. Suited for external face turning without shoulder and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SSKCR 1212 F 09	12	12	12	16	80	32.0	0	0	0.10	GI053	S08
	SSKCR 1616 H 09	16	16	16	20	100	32.0	0	0	0.25	GI053	S08
	SSKCR 2020 K 12-M-A	20	20	20	25	125	36.0	0	0	0.75	GI015	SS20
	SSKCR 2525 M 12-M-A	25	25	25	32	150	36.0	0	0	0.75	GI015	SS20

GI015	SC.. 1204..
GI053	SC.. 09T3..

		Nm						
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SS20	US 5012-T15P	5.0	M 5	12.2	SSN 120304	MS 5008	FLAG T15P	HXK 5

SSSC(RL) INT

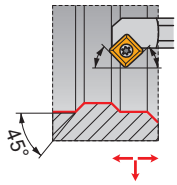
P M K N S H

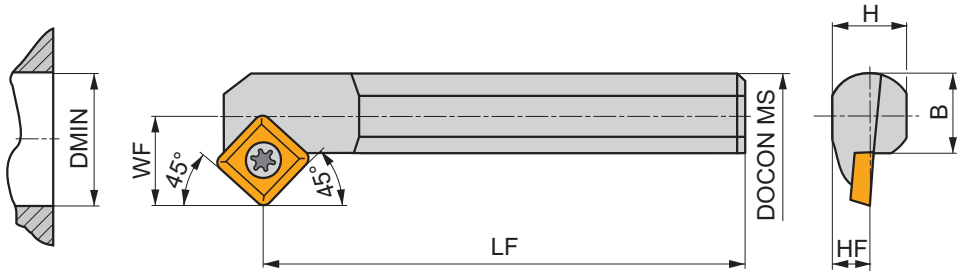
PRAMET

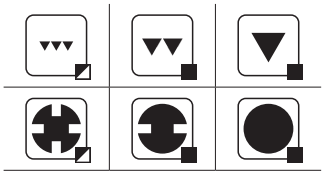
S

Internal Screw Lock Boring Bar with 45° Cutting Angle for SC.. Inserts

Internal Right/Left hand boring bar with 45° cutting angle for screw type SC.. inserts. For internal back chamfer, taper, multi-directional, chamfer and longitudinal turning without shoulder. Body treated for longer tool life.





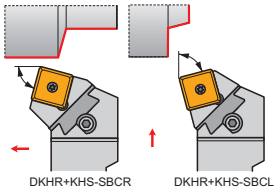


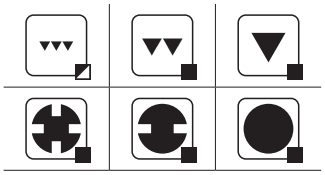
	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**S20S-SSSCR 09**	20	25	13	18	18.5	250	-5	0	0.61	GI053	S04
	S25T-SSSCR 09	25	32	17	23	23	300	-3	0	1.10	GI053	S04
L	**S20S-SSSCL 09**	20	25	13	18	18.5	250	-5	0	0.05	GI053	S04
	S25T-SSSCL 09	25	32	17	23	23	300	-3	0	1.10	GI053	S04

GI053	SC.. 09T3..

S04	US 3510-T15P	3.0 Nm	M 3.5	10.6	FLAG T15P

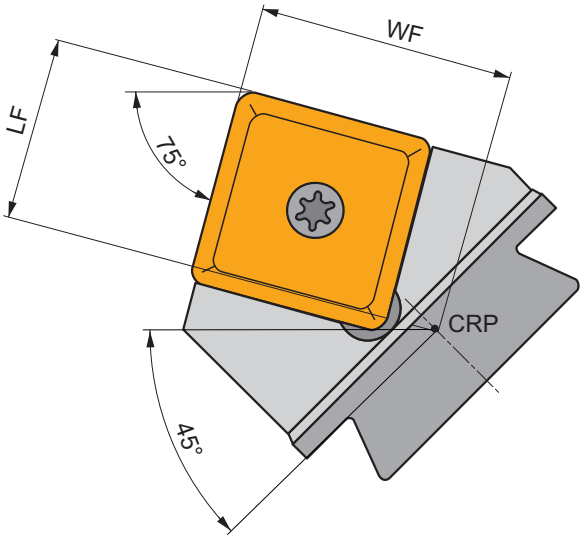
KHS-SBC(RL)





Modular KHS Screw Clamp Turning Cartridge 75° Cutting Angle for SC.. Inserts

Dovetailed Right/Left hand screw lock turning cartridge, 75° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, taper and chamfer turning with positive SC.. inserts Tool holder treated for longer tool life.



	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	KHS-SBCR 25	47	36	0	0	1.50	GI131	SS26
	KHS-SBCR 38-A	47	36	0	0	1.47	GI164	SS38
L	KHS-SBCL 25	47	36	0	0	1.45	GI131	SS26
	KHS-SBCL 38-A	47	36	0	0	1.48	GI164	SS38

GI131	SC.. 2509..
GI164	SC.. 3809..

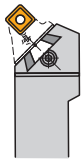
		Nm						
SS26	US 8025-T30P	13.0	M 8	24.2	SSN 250620	MS 8020	SDR T30P	HXK 5
SS38	US 8025-T30P	13.0	M 8	24.2	SSN 380620	MS 8020	SDR T30P	HXK 5

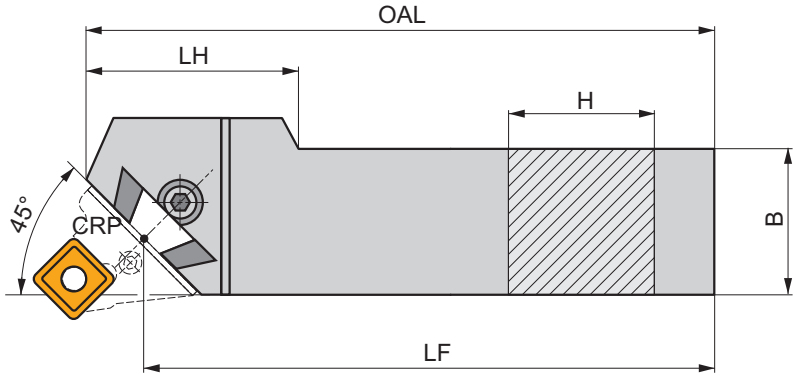
DKH(RL)

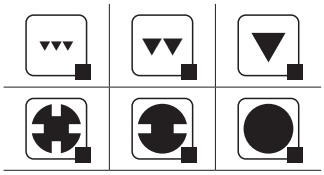
PRAMET

External Tool Holder Shank for KHP/KHS Heavy Turning Cartridges

Dovetailed Right/Left hand modular tool shank for KHP/KHS cartridges. Suited for heavy turning applications. Body treated for longer tool life.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

STAC(RL) EXT

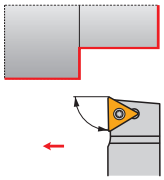
P M K N S H

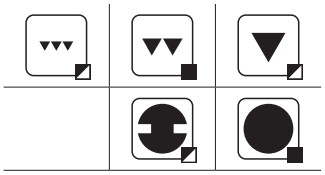
PRAMET

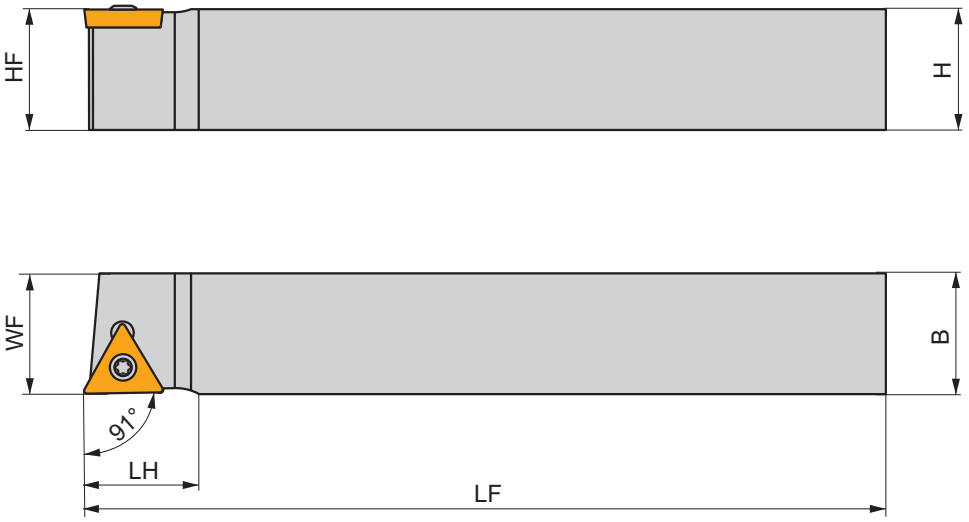
S

External Screw Lock Tool Holder with 91° Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for external longitudinal shoulder, taper and chamfer turning and usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	STACR 1212 K 11-S	12	12	12	12	125	15.2	0	0	0.14	GI056	S01
	STACR 1616 K 11-S	16	16	16	16	125	15.2	0	0	0.25	GI056	S01
L	STACL 1212 K 11-S	12	12	12	12	125	15.2	0	0	0.14	GI056	S01
	STACL 1616 K 11-S	16	16	16	16	125	15.2	0	0	0.25	GI056	S01

GI056	TC.. 1102..

S01	US 2506-T07P	0.9 Nm	M 2.5	6.3	FLAG T07P

STFC(RL) EXT

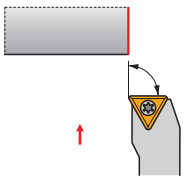
P M K N S H

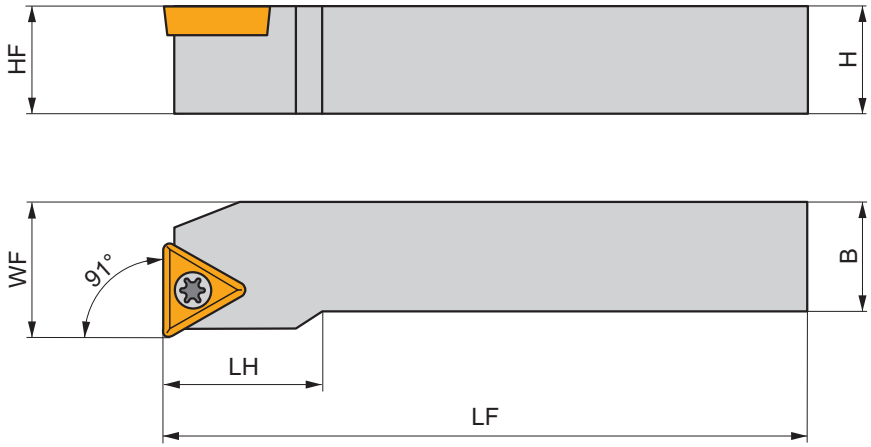
PRAMET

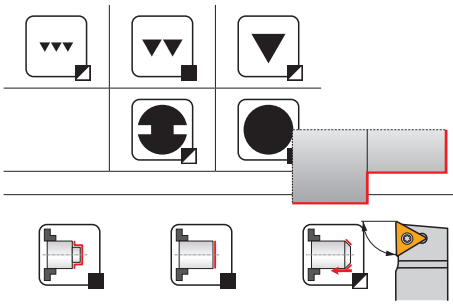
S

Ext. Screw Lock Tool Holder, 91° (Face Turning) Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for external face turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	STFCR 1616 H 11	16	16	16	20	100	18.0	0	0	0.20	GI056	S01
	STFCR 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.40	GI016	ST10
	STFCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10
L	STFCL 1616 H 11	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STFCL 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.40	GI016	ST10
	STFCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5

STFC(RL)-A EXT

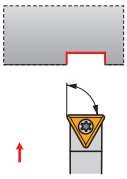
P M K N S H

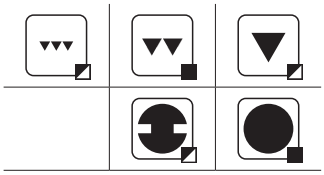
PRAMET

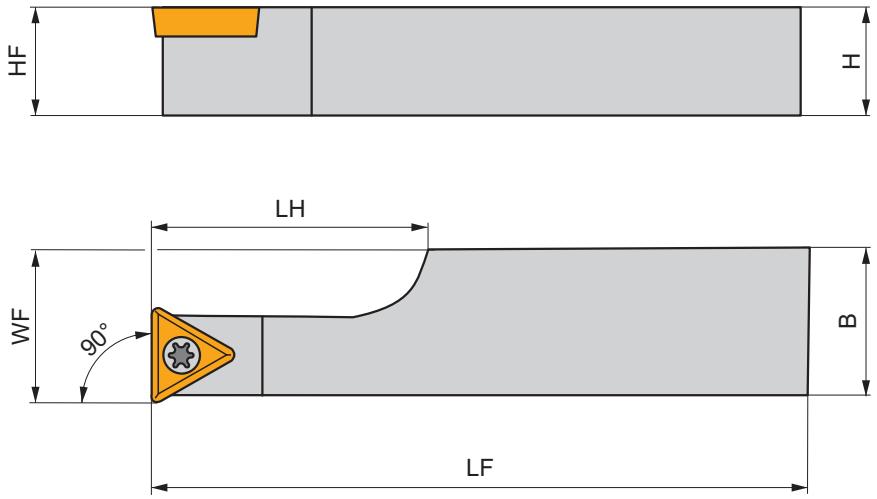
S

Ext. Screw Lock Tool Holder, 90° (Face Turning) Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for left and right-sided external face turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	STFCR 2020 K 11-A	20	20	20	25	125	21.3	0	0	0.37	GI056	ST21
L	STFCL 2020 K 11-A	20	20	20	25	125	21.3	0	0	0.36	GI056	ST21

GI056	TC.. 1102..

ST21	5513 020-03	0.8 Nm	M 2.5	6.5	PT-8001

STJC(RL) EXT

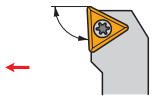
P M K N S H

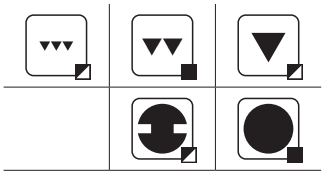
PRAMET

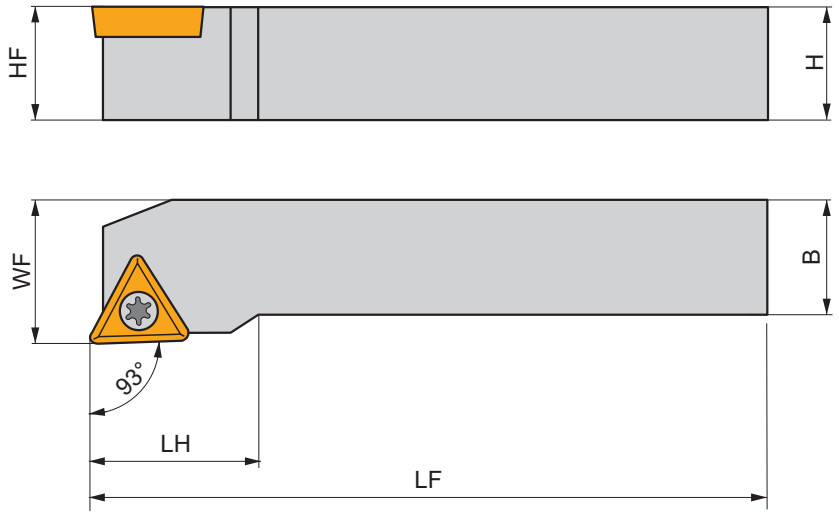
S

External Screw Lock Tool Holder with 93° Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for external longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**STJCR 1616 H 11**	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STJCR 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.43	GI016	ST10
	STJCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.76	GI016	ST10
L	**STJCL 1616 H 11**	16	16	16	20	100	18.0	0	0	0.22	GI056	S01
	STJCL 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	0.43	GI016	ST10
	STJCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.75	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5

STFC(RL) INT

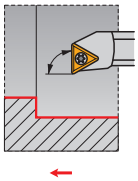
P M K N S H

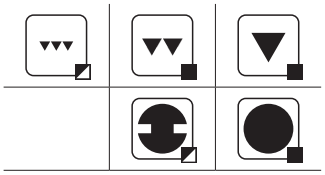
PRAMET

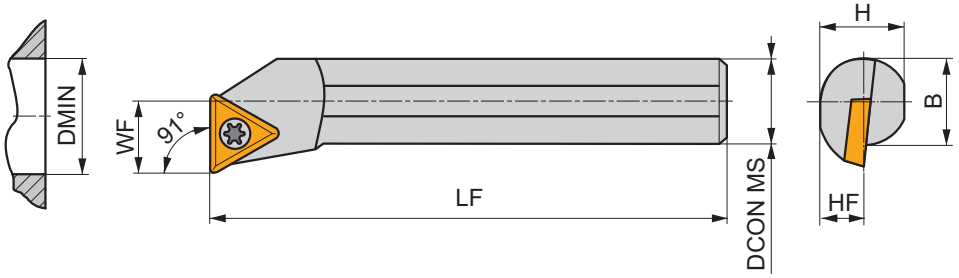
S

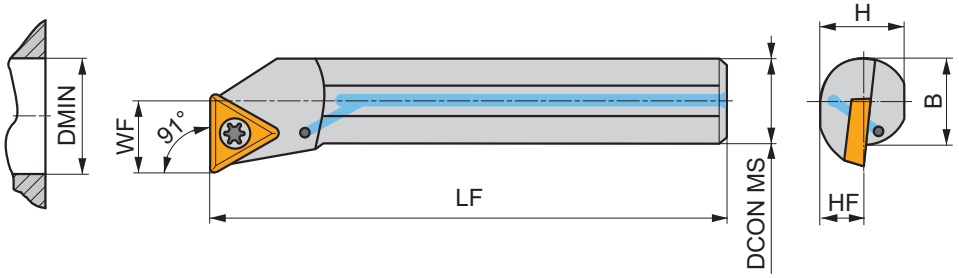
Internal Screw Lock Boring Bar with 91° Cutting Angle for TC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 91° cutting angle for screw type TC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A06F-STFCR 06	6	8.5	4.5	5	–	80	-12	0	✓	0.02	GI217	ST12
	A08H-STFCR 06	8	11	5.9	7	–	100	-10	0	✓	0.05	GI217	ST13
	A10K-STFCR 09	10	13	7	9	–	125	-9	0	✓	0.06	GI218	ST14
	A12M-STFCR 09	12	16	9	11	–	150	-6.5	0	✓	0.12	GI218	ST14
	S10H-STFCR 11	10	13	7	9	9.5	100	-10	0	–	0.08	GI056	S02
	A12M-STFCR 11	12	16	9	11	11.5	150	-10	0	✓	0.14	GI056	S01
	S12K-STFCR 11	12	16	9	11	11.5	125	-7	0	–	0.13	GI056	S01
	A16R-STFCR 11	16	20	11	14.5	15	200	-7	0	✓	0.30	GI056	S01
	S16M-STFCR 11	16	20	11	14.5	15	150	-7	0	–	0.24	GI056	S01
	A20S-STFCR 11	20	25	13	18	18.5	250	-7	0	✓	0.53	GI056	S01
	S20Q-STFCR 11	20	25	13	18	18.5	180	-7	0	–	0.40	GI056	S01
	A25R-STFCR 16	25	32	17	23	23	200	-3	0	✓	0.66	GI016	S08
	S25T-STFCR 16	25	32	17	23	23	300	-3	0	–	1.08	GI016	S08
	A32S-STFCR 16	32	40	22	30	30	250	-10	0	✓	1.35	GI016	ST10
	S32U-STFCR 16-A	32	40	22	30	30	350	-10	0	–	2.10	GI016	ST10
L	A06F-STFCL 06	6	8.5	4.5	5	–	80	-12	0	✓	0.03	GI217	ST12
	A08H-STFCL 06	8	11	5.9	7	–	100	-10	0	✓	0.05	GI217	ST13
	A10K-STFCL 09	10	13	7	9	–	125	-9	0	✓	0.06	GI218	ST14
	A12M-STFCL 09	12	16	9	11	–	150	-6.5	0	✓	0.03	GI218	ST14
	S10H-STFCL 11	10	13	7	9	9.5	100	-10	0	–	0.06	GI056	S02
	A12M-STFCL 11	12	16	9	11	11.5	150	-10	0	✓	0.12	GI056	S01
	S12K-STFCL 11	12	16	9	11	11.5	125	-7	0	–	0.12	GI056	S01
	A16R-STFCL 11	16	20	11	14.5	15	200	-7	0	✓	0.00	GI056	S01
	S16M-STFCL 11	16	20	11	14.5	15	150	-7	0	–	0.24	GI056	S01
	A20S-STFCL 11	20	25	13	18	18.5	250	-7	0	✓	0.00	GI056	S01
	S20Q-STFCL 11	20	25	13	18	18.5	180	-7	0	–	0.42	GI056	S01
	A25R-STFCL 16	25	32	17	23	23	200	-3	0	✓	0.00	GI016	S08

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
L	**S25T-STFCL 16**	25	32	17	23	23	300	-3	0	–	1.08	GI016	S08
	A32S-STFCL 16	32	40	22	30	30	250	-10	0	✓	1.36	GI016	ST10
	S32U-STFCL 16-A	32	40	22	30	30	350	-10	0	–	2.06	GI016	ST10

GI016	TC.. 16T3..
GI056	TC.. 1102..
GI217	TC.. 06T1..
GI218	TC.. 0902..

		Nm							
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–	–
S02	US 2505-T07P	0.9	M 2.5	5.2	–	–	FLAG T07P	–	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
ST10	US 3510-T15P	3.0	M 3.5	10.6	STN 160308	MS 3510	FLAG T15P	HXK 3.5	–
ST12	5513 020-28	0.6	M 2	4.2	–	–	–	–	PT-8000
ST13	5513 020-27	0.6	M 2	4.9	–	–	–	–	PT-8000
ST14	5513 020-05	0.8	M 2.2	6.4	–	–	–	–	PT-8001

STFC(RL)-E INT

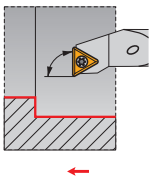
P M K N S H

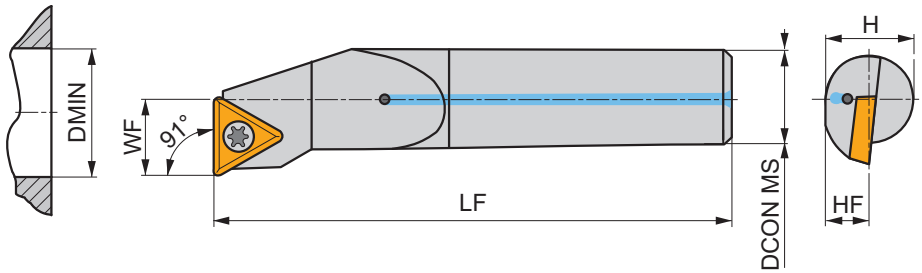
PRAMET

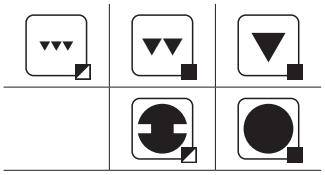
S

Internal Carbide Screw Lock Boring Bar with 91° Cutting Angle for TC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, with 91° cutting angle for screw type TC.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. For tool overhang >3xD.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	E06H-STFCR 06-R	6	8.5	4.5	6	3	100	-10	0	✓	0.05	GI217	ST22
	E08K-STFCR 06-R	8	11	5.9	8	4	125	-10	0	✓	0.09	GI217	ST23
	E10M-STFCR 09-R	10	13	7	10	5	150	-8	0	✓	0.15	GI218	ST24
	E12Q-STFCR 09-R	12	16	9	12	6	180	-6	0	✓	0.26	GI218	ST24
	E16R-STFCR 11-R	16	20	11	16	8	200	-5	0	✓	0.48	GI056	ST21
L	E06H-STFCL 06-R	6	8.5	4.5	6	3	100	-10	0	✓	0.05	GI217	ST22
	E08K-STFCL 06-R	8	11	5.9	8	4	125	-10	0	✓	0.09	GI217	ST23
	E10M-STFCL 09-R	10	13	7	10	5	150	-8	0	✓	0.15	GI218	ST24
	E12Q-STFCL 09-R	12	16	9	12	6	180	-6	0	✓	0.26	GI218	ST24
	E16R-STFCL 11-R	16	20	11	16	8	200	-5	0	✓	0.48	GI056	ST21

GI056	TC.. 1102..
GI217	TC.. 06T1..
GI218	TC.. 0902..

		Nm			
ST21	5513 020-03	0.8	M 2.5	6.5	PT-8001
ST22	5513 020-28	0.6	M 2	4.2	PT-8000
ST23	5513 020-27	0.6	M 2	4.9	PT-8000
ST24	5513 020-05	0.8	M 2.2	6.4	PT-8001

SVHB(C)(RL) EXT

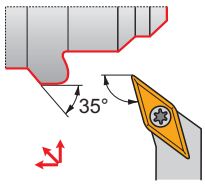
P M K N S H

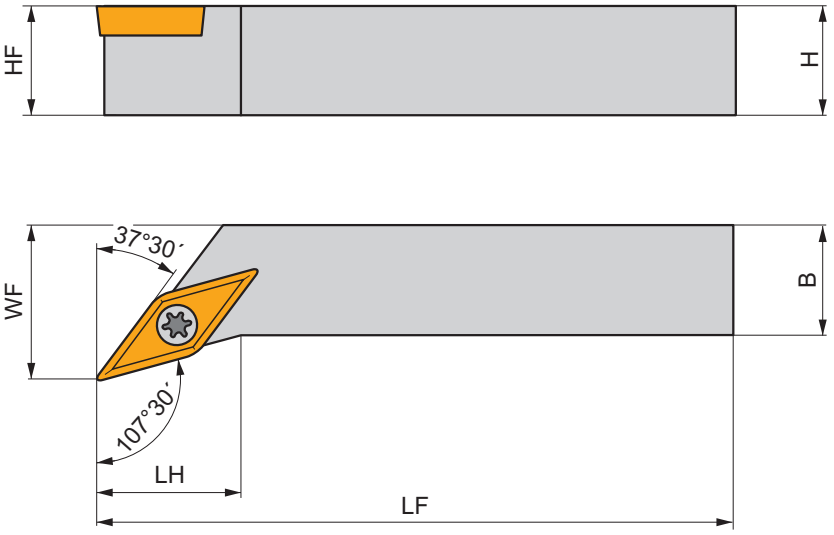
PRAMET

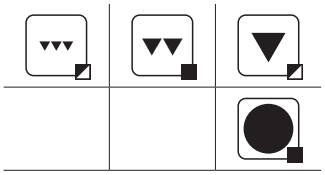
S

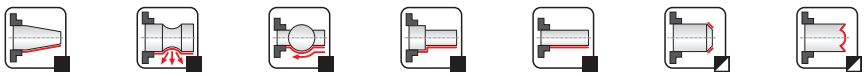
Ext. Screw Lock Tool Holder with 107.5° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external face and longitudinal turning with shoulder, taper, face and longitudinal copy turning up to 35° and chamfer turning. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	SVHBR 1616 H 11	16	16	16	20	100	14.0	0	0	0.20	GI194	S01
	SVHCR 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.39	GI017	SV10
	SVHCR 2525 M 16-M-A	25	25	25	32	150	20.0	0	0	0.71	GI017	SV10
L	SVHBL 1616 H 11	16	16	16	20	100	14.0	0	0	0.19	GI194	S01
	SVHCL 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVHCL 2525 M 16-M-A	25	25	25	32	150	20.0	0	0	0.07	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5

SVJB(C)(RL) EXT

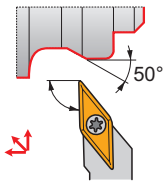
P M K N S H

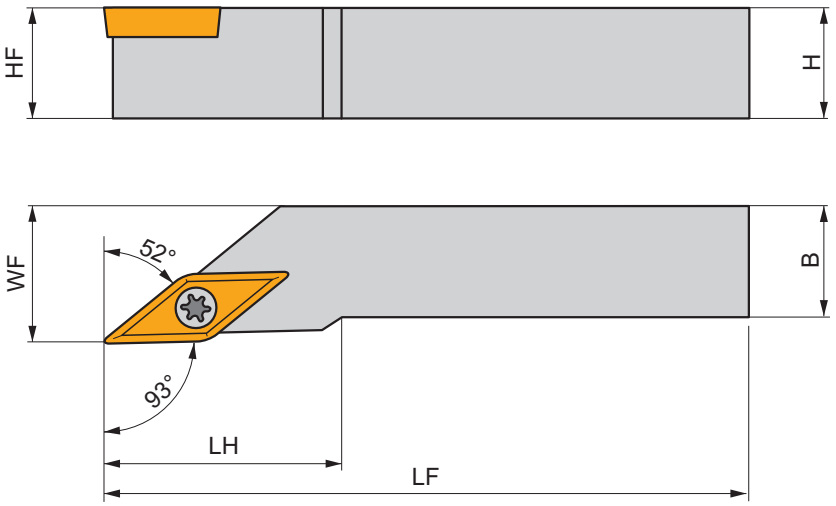
PRAMET

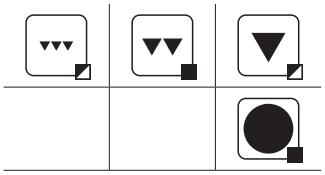
S

External Screw Lock Tool Holder with 93° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external longitudinal shoulder, taper, chamfer and copy turning up to 50° with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SVJBR 1212 F 11	12	12	12	16	80	20.0	0	0	0.09	GI194	S01
	SVJBR 1212 K 11-S	12	12	12	12	125	25.6	0	0	0.13	GI194	S01
	SVJBR 1616 H 11	16	16	16	20	100	20.0	0	0	0.20	GI194	S01
	SVJBR 1616 K 11-S	16	16	16	16	125	25.6	0	0	0.22	GI194	S01
	SVJCR 1212 N 13	12	12	12	16	160	27.0	0	0	0.19	GI211	SV21
	SVJCR 1616 H 13	16	16	16	20	100	30.0	0	0	0.20	GI211	SV21
	SVJCR 2020 K 13	20	20	20	25	125	30.0	0	0	0.37	GI211	SV22
	SVJCR 2020 K 16-M-A	20	20	20	25	125	28.0	0	0	0.35	GI017	SV10
	SVJCR 2525 M 13	25	25	25	32	150	30.0	0	0	0.67	GI211	SV22
	SVJCR 2525 M 16-M-A	25	25	25	32	150	32.0	0	0	0.66	GI017	SV10
	SVJCR 3225 P 16-M-A	32	25	32	32	170	32.0	0	0	0.99	GI017	SV10
L	SVJBL 1212 F 11	12	12	12	16	80	20.0	0	0	0.09	GI194	S01
	SVJBL 1212 K 11-S	12	12	12	12	125	25.6	0	0	0.13	GI194	S01
	SVJBL 1616 H 11	16	16	16	20	100	20.0	0	0	0.19	GI194	S01
	SVJBL 1616 K 11-S	16	16	16	16	125	25.6	0	0	0.22	GI194	S01
	SVJCL 1212 N 13	12	12	12	16	160	27.0	0	0	0.19	GI211	SV21
	SVJCL 1616 H 13	16	16	16	20	100	30.0	0	0	0.20	GI211	SV21
	SVJCL 2020 K 13	20	20	20	25	125	30.0	0	0	0.37	GI211	SV22
	SVJCL 2020 K 16-M-A	20	20	20	25	125	28.0	0	0	0.38	GI017	SV10
	SVJCL 2525 M 13	25	25	25	32	150	30.0	0	0	0.67	GI211	SV22
	SVJCL 2525 M 16-M-A	25	25	25	32	150	32.0	0	0	0.68	GI017	SV10
	SVJCL 3225 P 16-M-A	32	25	32	32	170	32.0	0	0	0.99	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

								
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

SVPB(C)(RL) EXT

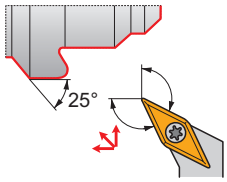
P M K N S H

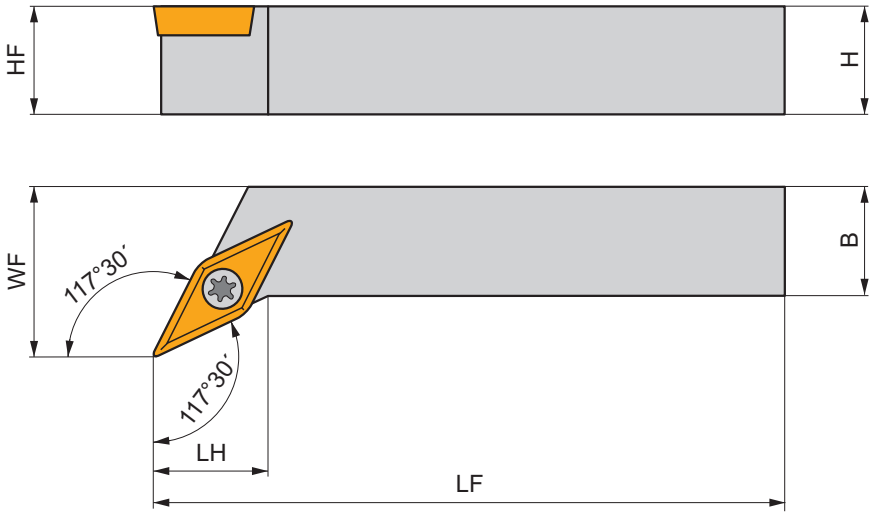
PRAMET

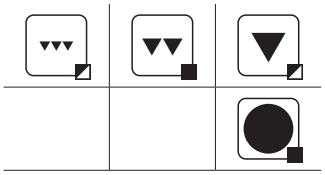
S

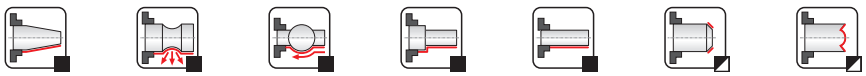
External Screw Lock Tool Holder, 117.5° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external face and longitudinal turning with shoulder, taper, face copy turning up to 25° and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SVPBR 1616 H 11	16	16	16	20	100	12.0	0	0	0.20	GI194	S01
	SVPBR 2020 K 11	20	20	20	25	125	12.0	0	0	0.40	GI194	S01
	SVPCR 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVPCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.73	GI017	SV10
	SVPCR 3225 P 16-M-A	32	25	32	32	170	25.0	0	0	1.03	GI017	SV10
L	SVPBL 1616 H 11	16	16	16	20	100	12.0	0	0	0.20	GI194	S01
	SVPBL 2020 K 11	20	20	20	25	125	12.0	0	0	0.39	GI194	S01
	SVPCL 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	0.40	GI017	SV10
	SVPCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	0.70	GI017	SV10
	SVPCL 3225 P 16-M-A	32	25	32	32	170	25.0	0	0	1.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5

SVVB(C)N EXT

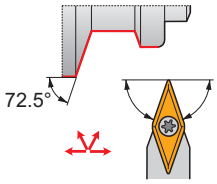
P M K N S H

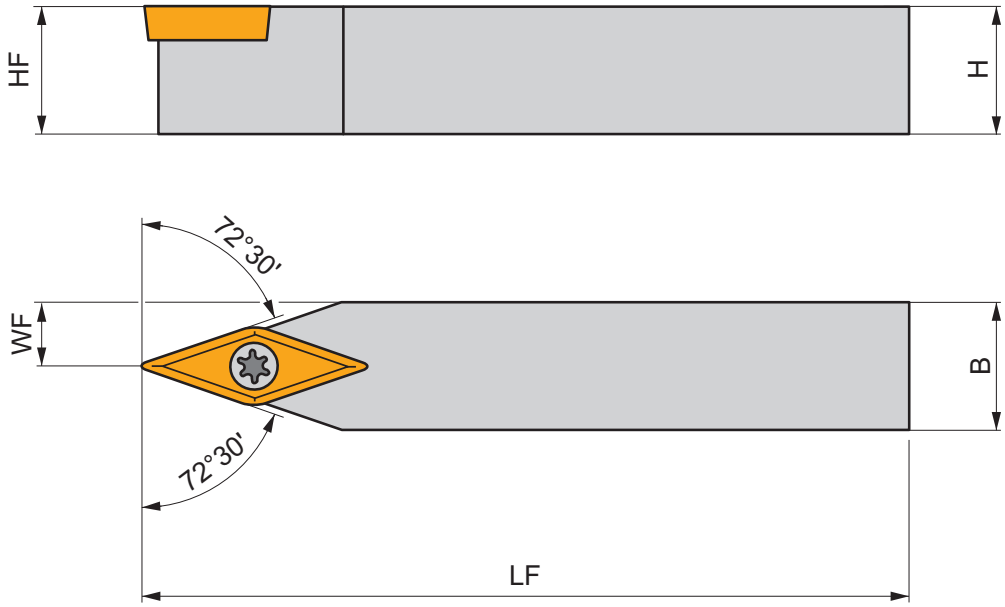
PRAMET

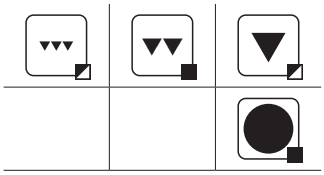
S

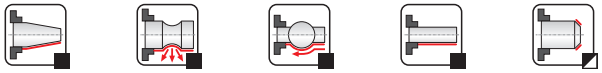
External Screw Lock Tool Holder, 72.5° Cutting Angle for VB/VC.. Inserts

External neutral tool holder for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning without shoulder, taper, copy turning up to 72.5° and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	SVVBN 1212 F 11	12	12	12	6	80	–	0	0	0.10	GI194	S01
	SVVBN 1616 H 11	16	16	16	8	100	–	0	0	0.20	GI194	S01
	SVVBN 2020 K 11	20	20	20	10	125	–	0	0	0.36	GI194	S01
	SVVCN 1212 N 13	12	12	12	6	160	–	0	0	0.19	GI211	SV21
	SVVCN 1616 H 13	16	16	16	8	100	–	0	0	0.20	GI211	SV21
	SVVCN 2020 K 13	20	20	20	10	125	–	0	0	0.36	GI211	SV22
	SVVCN 2525 M 13	25	25	25	12.5	150	–	0	0	0.66	GI211	SV22
	SVVCN 2020 K 16-M-A	20	20	20	10	125	–	0	0	0.34	GI017	SV10
	SVVCN 2525 M 16-M-A	25	25	25	12.5	150	–	0	0	0.67	GI017	SV10
	SVVCN 3225 P 16-M-A	32	25	32	12.5	170	–	0	0	0.97	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

SVXB(C)(RL) EXT

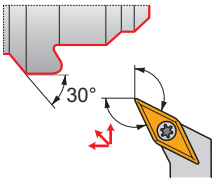
P M K N S H

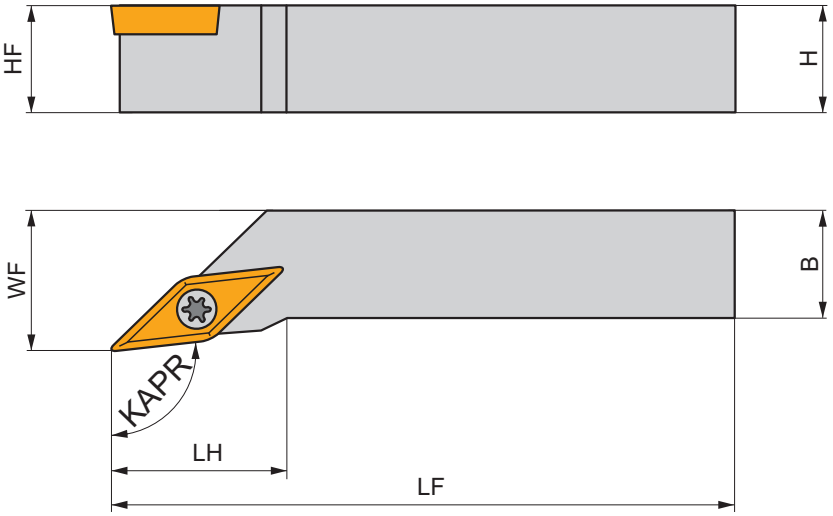
PRAMET

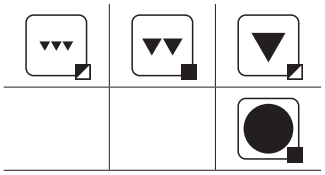
S

External Screw Lock Tool Holder 98/113° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning with shoulder, taper, copy turning up to 30° and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	KAPR (°)	LAMS (°)	GAMO (°)	kg		
R	SVXBR 1212 F 11	12	12	12	16	80	20.0	98	0	0	0.09	GI194	S01
	SVXBR 1616 H 11	16	16	16	20	100	14.0	98	0	0	0.19	GI194	S01
	SVXCR 2020 K 13	20	20	20	25	125	12.0	113	0	0	0.41	GI211	SV22
	SVXCR 2020 K 16-M-A	20	20	20	25	125	28.0	98	0	0	0.38	GI017	SV10
	SVXCR 2525 M 16-M-A	25	25	25	32	150	32.0	98	0	0	0.68	GI017	SV10
	SVXCR 3225 P 16-M-A	32	25	32	32	170	32.0	98	0	0	1.00	GI017	SV10
L	SVXBL 1212 F 11	12	12	12	16	80	20.0	98	0	0	0.09	GI194	S01
	SVXBL 1616 H 11	16	16	16	20	100	14.0	98	0	0	0.19	GI194	S01
	SVXCL 2020 K 13	20	20	20	25	125	12.0	113	0	0	0.38	GI211	SV22
	SVXCL 2020 K 16-M-A	20	20	20	25	125	28.0	98	0	0	0.38	GI017	SV10
	SVXCL 2525 M 16-M-A	25	25	25	32	150	32.0	98	0	0	0.69	GI017	SV10
	SVXCL 3225 P 16-M-A	32	25	32	32	170	32.0	98	0	0	0.99	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

C.-SVHB(RL) EXT

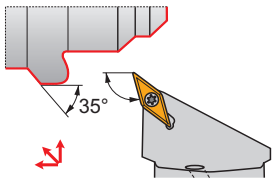
P M K N S H

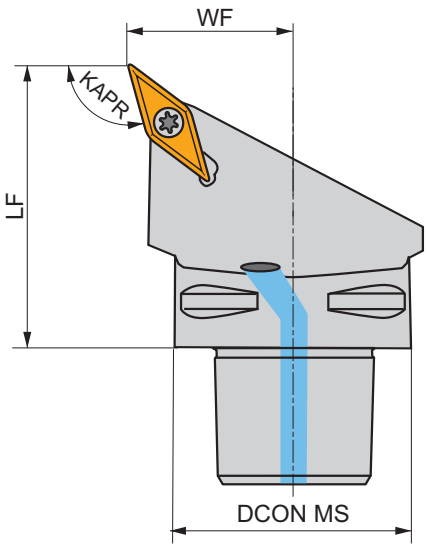
PRAMET

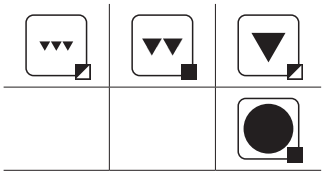
S

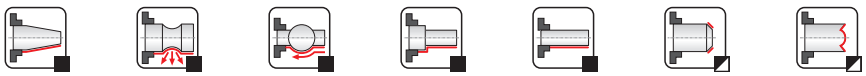
Ext. PSC Quick Change Tool, Screw Lock, 107.5° Cutting Angle, VB/VC.. Inserts

External Right/Left hand tool, through coolant, for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning with shoulder, taper, copy turning up to 35° and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-SVHBR-27050-16	40	27	50	107.5	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVHBR-35060-16	50	35	60	107.5	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVHBR-45065-16	63	45	65	107.5	0	0	✓	1.13	GI017	C-SV16S-2
L	C4-SVHBL-27050-16	40	27	50	107.5	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVHBL-35060-16	50	35	60	107.5	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVHBL-45065-16	63	45	65	107.5	0	0	✓	1.12	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..

		Nm						
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SVJB(RL) EXT

P M K N S H

PRAMET

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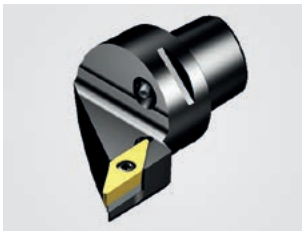
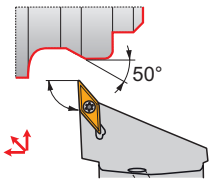
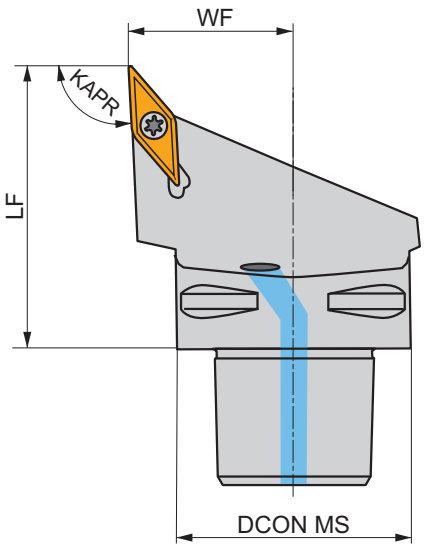
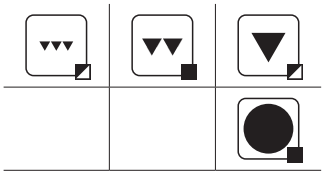


Ext. PSC Quick Change Tool, Screw Lock, 93° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool, through coolant, for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning with shoulder, taper, copy turning up to 50° and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C3-SVJBR-22040-11-B1	32	22	40	93	0	0	✓	0.17	GI194	C-SV11
	C4-SVJBR-27050-11-B1	40	27	50	93	0	0	✓	0.34	GI194	C-SV11
	C4-SVJBR-27050-16	40	27	50	93	0	0	✓	0.35	GI017	C-SV16S-1
	C5-SVJBR-35060-16	50	35	60	93	0	0	✓	0.63	GI017	C-SV16S-2
	C6-SVJBR-45065-16	63	45	65	93	0	0	✓	1.11	GI017	C-SV16S-2
L	C4-SVJBL-27050-16	40	27	50	93	0	0	✓	0.34	GI017	C-SV16S-1
	C5-SVJBL-35060-16	50	35	60	93	0	0	✓	0.64	GI017	C-SV16S-2
	C6-SVJBL-45065-16	63	45	65	93	0	0	✓	1.11	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..

		Nm						
C-SV11	US 2003-T07P	0.8	M 2.5	6.5	–	–	FLAG T07P	CN 034-01
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SVVBN EXT

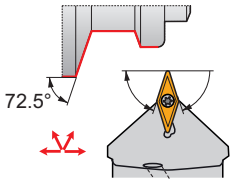
P M K N S H

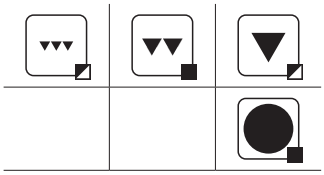
PRAMET

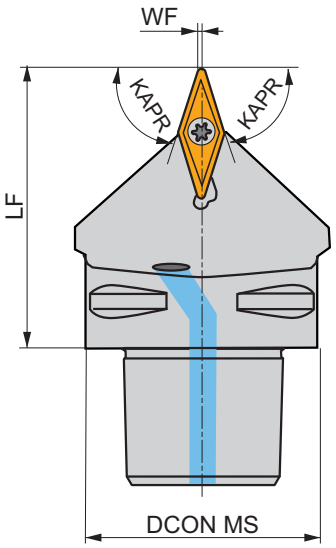
S

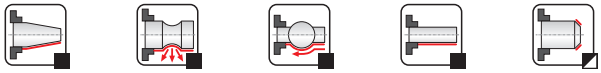
Ext. PSC Quick Change Tool, Screw Lock, 72.5° Cutting Angle, VB/VC.. Inserts

External neutral tool, through coolant, for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning without shoulder, taper, copy turning up to 72.5° and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
N	**C4-SVVBN-00050-16**	40	0.6	50	72.5	0	0	✓	0.32	GI017	C-SV16S-1
	C5-SVVBN-00060-16	50	0.6	60	72.5	0	0	✓	0.56	GI017	C-SV16S-2
	C6-SVVBN-00065-16	63	0.6	65	72.5	0	0	✓	0.99	GI017	C-SV16S-2

GI017	VB.. 1604..	VC.. 1604..

		Nm						
C-SV16S-1	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	12.1	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

SVJB(RL) INT

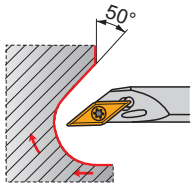
P M K N S H

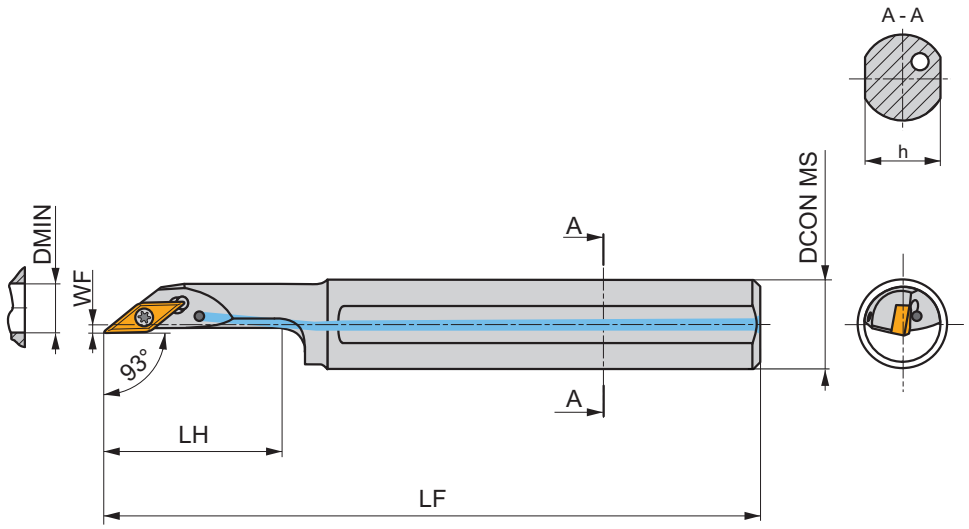
PRAMET

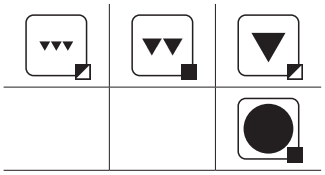
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for VB/VC.. Inserts

Internal Right/Left hand boring bar, through coolant, with 93° cutting angle for screw type VB.. VC.. inserts. Suited for face copy turning under 50°. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A20R-SVJBR 11	20	25	2	18	200	40.0	-5	-5	✓	0.40	GI194	S07
	A25S-SVJBR 11	25	32	3.5	23	250	50.0	-5	-5	✓	0.81	GI194	S07
L	A20R-SVJBL 11	20	25	2	18	200	40.0	-5	-5	✓	0.41	GI194	S07
	A25S-SVJBL 11	25	32	3.5	23	250	50.0	-5	-5	✓	0.81	GI194	S07

GI194	VB.. 1103..	VC.. 1103..

S07	US 2506-T07P	0.9	M 2.5	6.3	FLAG T07P

SVQB(C)(RL) INT

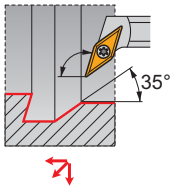
P M K N S H

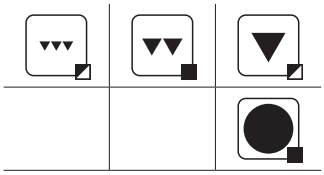
PRAMET

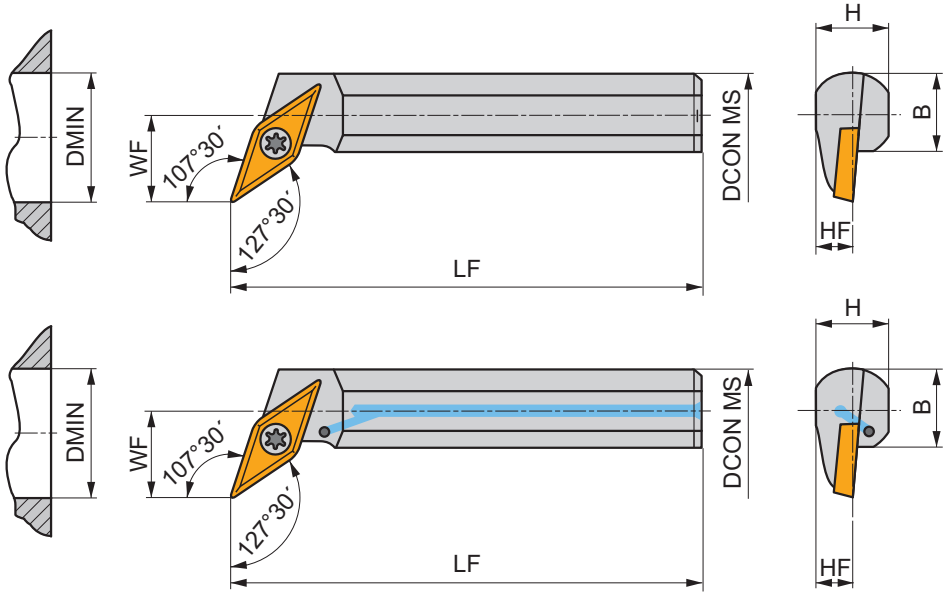
S

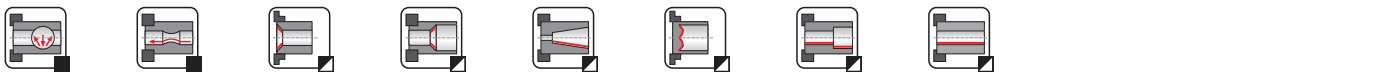
Internal Screw Lock Boring Bar with 107.5° Cutting Angle for VB/VC.. Inserts

Internal Right/Left hand boring bar, through coolant available, with 107.5° cutting angle for screw type VB../VC.. inserts. Suited for a wide range of internal turning operations.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16R-SVQBR 11	16	20	11	14.5	15	200	-5	0	✓	0.33	GI194	S01
	A20S-SVQBR 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A16R-SVQCR 13	16	21	11	15	15	200	-6	0	✓	0.29	GI211	SV21
	A20S-SVQCR 13	20	25	13	18	18.5	250	-4	0	✓	0.12	GI211	SV21
	S25T-SVQCR 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVQCR 16	32	40	22	30	30	350	-5	0	–	2.07	GI017	S08
	S40V-SVQCR 16-A	40	50	27	38	38	400	-5	0	–	3.80	GI017	SV10
L	A16R-SVQBL 11	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVQBL 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A16R-SVQCL 13	16	21	11	15	15	200	-6	0	✓	0.29	GI211	SV21
	A20S-SVQCL 13	20	25	13	18	18.5	250	-4	0	✓	0.54	GI211	SV21
	S25T-SVQCL 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVQCL 16	32	40	22	30	30	350	-5	0	–	2.07	GI017	S08
	S40V-SVQCL 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–

SVUB(C)(RL) INT

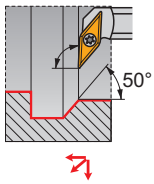
P M K N S H

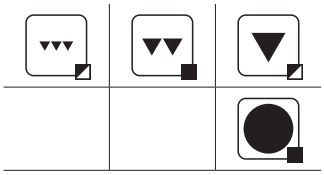
PRAMET

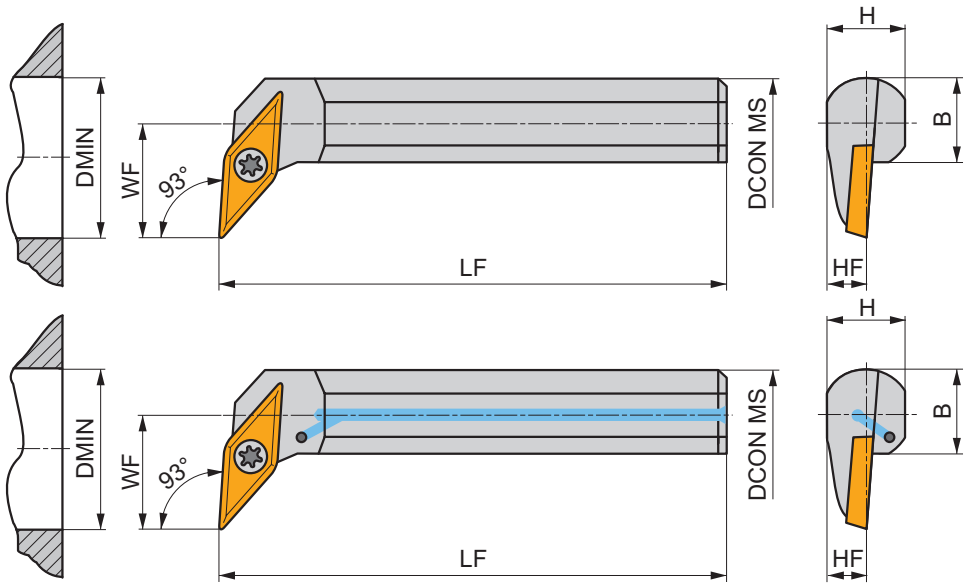
S

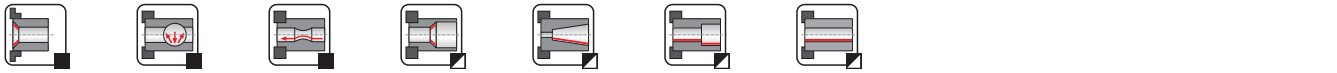
Internal Screw Lock Boring Bar with 93° Cutting Angle for VB/VC.. Inserts

Internal Right/Left hand boring bar, through coolant available, with 93° cutting angle for screw type VB../VC.. inserts. For a wide range of internal turning operations and copying under 50°. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16R-SVUBR 11	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVUBR 11	20	25	13	18	18.8	250	-4	0	✓	0.57	GI194	S01
	A20S-SVUCR 13	20	25	13	19	18.5	250	-4	2	✓	0.54	GI211	SV21
	A25T-SVUCR 13	25	32	17	24	23	300	-2	2	✓	0.96	GI211	SV22
	A32T-SVUCR 13	32	40	22	30	30	300	-1	2	✓	1.66	GI211	SV22
	S25T-SVUCR 16	25	32	17	23	23	300	-7	0	–	1.08	GI017	S08
	S32U-SVUCR 16	32	40	22	30	30	350	-5	0	–	2.10	GI017	S08
	S40V-SVUCR 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10
L	A16R-SVUBL 11	16	20	11	14.5	15	200	-5	0	✓	0.32	GI194	S01
	A20S-SVUBL 11	20	25	13	18	18.5	250	-4	0	✓	0.57	GI194	S01
	A20S-SVUCL 13	20	25	13	19	18.5	250	-4	2	✓	0.32	GI211	SV21
	A25T-SVUCL 13	25	32	17	24	23	300	-2	2	✓	0.96	GI211	SV22
	A32T-SVUCL 13	32	40	22	30	30	300	-1	2	✓	1.66	GI211	SV22
	S25T-SVUCL 16	25	32	17	23	23	300	-7	0	–	1.09	GI017	S08
	S32U-SVUCL 16	32	40	22	30	30	350	-5	0	–	2.10	GI017	S08
	S40V-SVUCL 16-A	40	50	27	38	38	400	-5	0	–	4.10	GI017	SV10

GI017	VB.. 1604..	VC.. 1604..
GI194	VB.. 1103..	VC.. 1103..
GI211	–	VC.. 1303..

		Nm						
S01	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–
SV10	US 3512-T15P	3.0	M 3.5	12.6	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

C.-SVQB(RL) INT

P M K N S H

PRAMET

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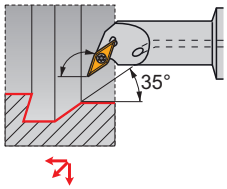
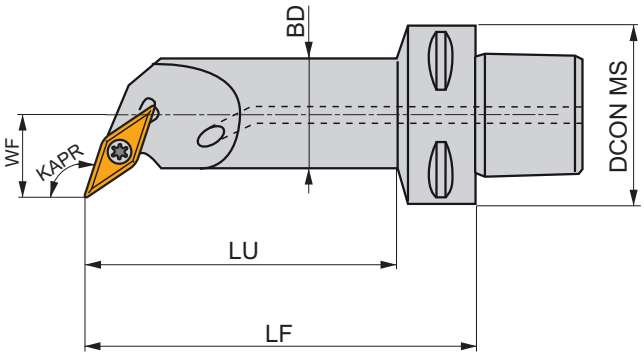
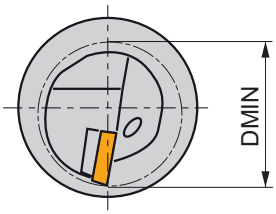
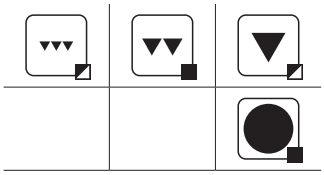
Int. PSC Quick Change Tool, Screw Lock, 107.5° Cutting Angle, VB/VC.. Inserts

Internal Right/Left hand tool, through coolant, with 107.5° cutting angle for screw type VB.. or VC.. inserts. Suited for a wide range of internal turning operations. Polygon Shank Coupling with choice of lengths. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-SVQBR-18090-16	40	33	18	90	68	25	107.5	-7.2	0	✓	0.48	GI017	SV16
	C5-SVQBR-18090-16	50	33	18	90	67	25	107.5	-7.2	0	✓	0.67	GI017	SV16
L	C4-SVQBL-18090-16	40	33	18	90	68	25	107.5	-7.2	0	✓	0.48	GI017	SV16
	C5-SVQBL-18090-16	50	33	18	90	67	25	107.5	-7.2	0	✓	0.68	GI017	SV16

GI017	VB.. 1604..	VC.. 1604..

SV16	US 2010-T15P	3.0 Nm	M 3.5	10.1	FLAG T15P/3,5

SVAC(RL)-DC EXT

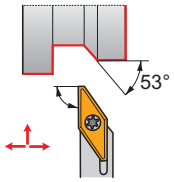
P M K N S H

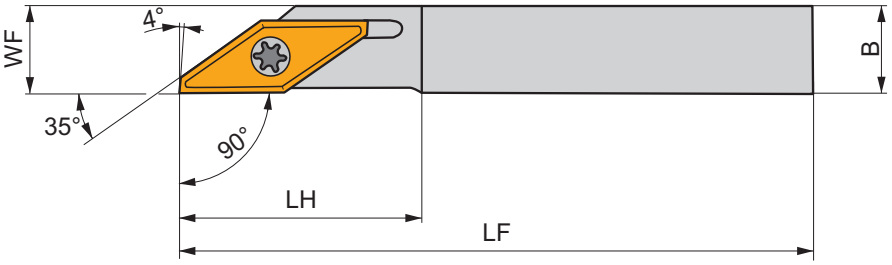
PRAMET

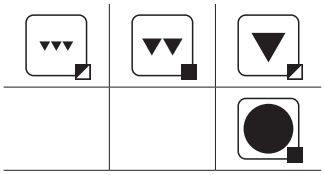
S

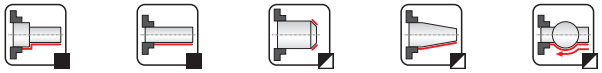
Ext. Screw Lock Swiss Style Tool Holder, 90° Cutting Angle for VCGX 13 Inserts

External Right/Left hand tool holder for screw type positive VCGX 13 Swiss style inserts. Suited for external face and longitudinal turning with shoulder, taper, copy turning up to 53° and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	SVACR 1010 L 13-DC	10	10	10	10	140	25.0	0	0	0.12	GI222	SV20
	SVACR 1212 L 13-DC	12	12	12	12	140	25.0	0	0	0.17	GI222	SV20
	SVACR 1616 M 13-DC	16	16	16	16	150	25.0	0	0	0.29	GI222	SV20
	SVACR 2020 M 13-DC	20	20	20	20	150	25.0	0	0	0.46	GI222	SV20
L	SVACL 1212 L 13-DC	12	12	12	12	140	25.0	0	0	0.19	GI222	SV20
	SVACL 1616 M 13-DC	16	16	16	16	150	25.0	0	0	0.29	GI222	SV20
	SVACL 2020 M 13-DC	20	20	20	20	150	25.0	0	0	0.43	GI222	SV20
	SVACL 2525 M 13-DC	25	25	25	25	150	25.0	0	0	0.67	GI222	SV20

GI222	VCGX 1303..

		Nm			
SV20	5513 020-24	1.5	M 3	8.5	PT-8002

SVJC(RL)-DC EXT

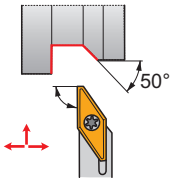
P M K N S H

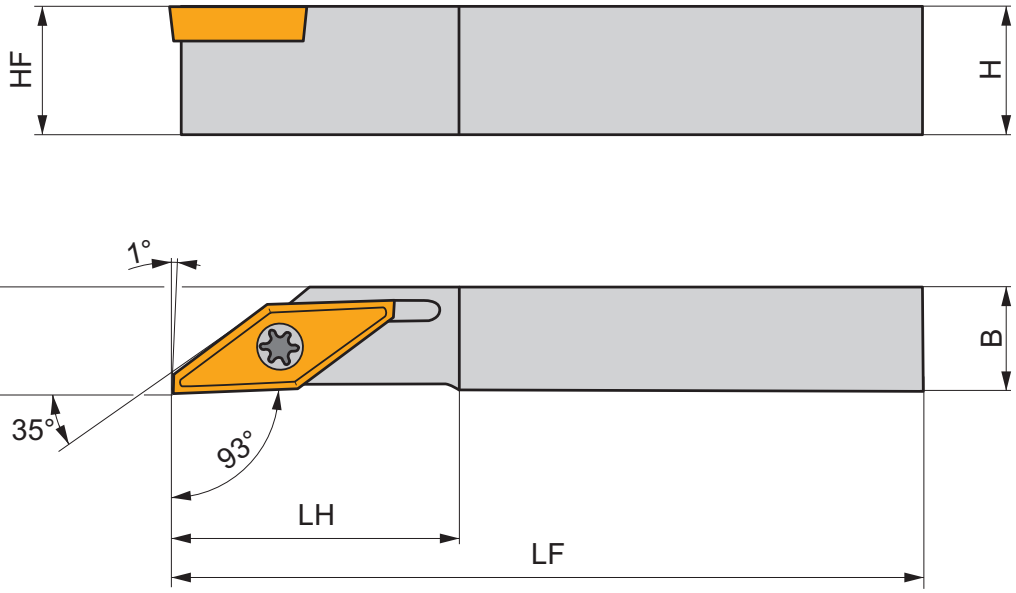
PRAMET

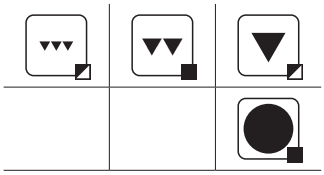
S

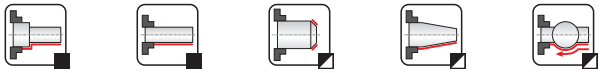
Ext. Screw Lock Swiss Style Tool Holder, 93° Cutting Angle for VCGX Insert

External Right/Left hand tool holder for screw type positive VCGX 13 Swiss style inserts. Suited for external face and longitudinal turning with shoulder, taper, copy turning up to 50° and chamfer turning. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	SVJCR 1212 L 13-DC	12	12	12	–	140	25.0	0	0	0.17	GI222	SV20
	SVJCR 1616 M 13-DC	16	16	16	–	150	25.0	0	0	0.29	GI222	SV20
	SVJCR 2020 M 13-DC	20	20	20	–	150	25.0	0	0	0.45	GI222	SV20
	SVJCR 2525 M 13-DC	25	25	25	–	150	25.0	0	0	0.68	GI222	SV20
L	SVJCL 1212 L 13-DC	12	12	12	–	140	25.0	0	0	0.17	GI222	SV20
	SVJCL 1616 M 13-DC	16	16	16	–	150	25.0	0	0	0.30	GI222	SV20
	SVJCL 2020 M 13-DC	20	20	20	–	150	25.0	0	0	0.47	GI222	SV20
	SVJCL 2525 M 13-DC	25	25	25	–	150	25.0	0	0	0.69	GI222	SV20

GI222	VCGX 1303..

		Nm			
SV20	5513 020-24	1.5	M 3	8.5	PT-8002

SVLC(RL) INT

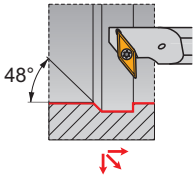
P M K N S H

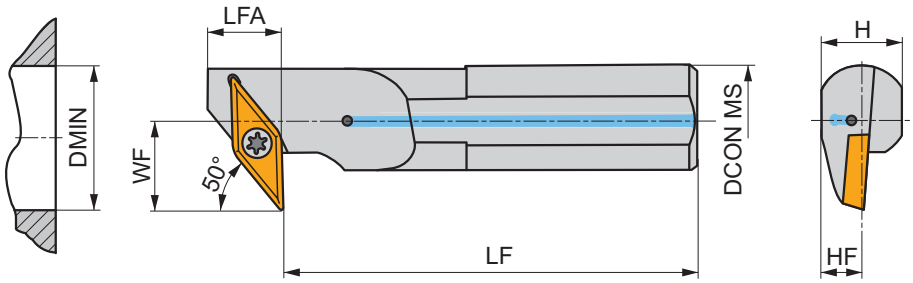
PRAMET

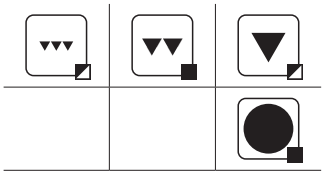
S

Internal Screw Lock Boring Bar with 50° Cutting Angle for VC.. Inserts

Internal Right/Left hand boring bar, through coolant, with 50° cutting angle for screw type VC.. inserts. Suited for a wide range of internal pulling turning operations and copying under 48°. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	HF (mm)	LFA (mm)	LAMS (°)	GAMO (°)		kg		
R	**A20S-SVLCR 13-X**	20	27	15	18	250	9	15	-4	-2	✓	0.57	GI211	SV21
	A25T-SVLCR 13-X	25	35	20	24	300	12	18	-2	-2	✓	1.01	GI211	SV22
	A32T-SVLCR 13-X	32	43	25	30	300	15	18	-1	-2	✓	1.75	GI211	SV22
L	**A20S-SVLCL 13-X**	20	27	15	18	250	9	15	-4	-2	✓	0.57	GI211	SV21
	A25T-SVLCL 13-X	25	35	20	24	300	12	18	-2	-2	✓	0.05	GI211	SV22
	A32T-SVLCL 13-X	32	43	25	30	300	15	18	-1	-2	✓	1.75	GI211	SV22

GI211	VC.. 1303..

		Nm						
SV21	5513 020-24	1.5	M 3	8.5	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	10.3	DAP 0331	DVT 0332	PT-8002	174.1-870

SVXC(RL) INT

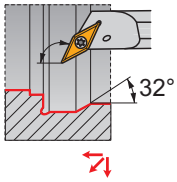
P M K N S H

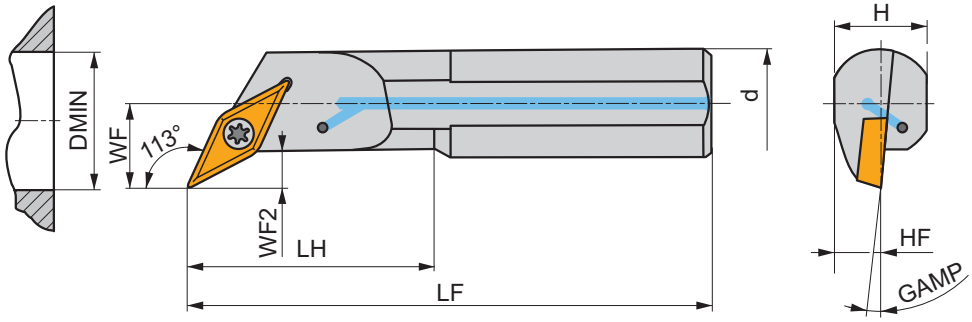
PRAMET

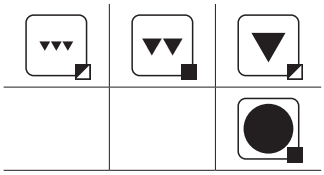
S

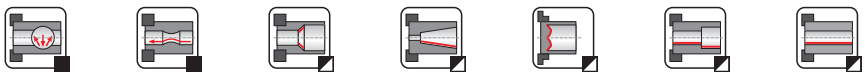
Internal Screw Lock Boring Bar with 113° Cutting Angle for VC.. Inserts

Internal Right/Left hand boring bar, through coolant, with 113° cutting angle for screw type VC.. inserts. Suited for a wide range of internal turning operations and copying under 32° . Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	HF (mm)	LH (mm)	WF2 (mm)	GAMP (°)		kg		
R	A10H-SVXCR 07	10	12.5	7	9	100	4.5	22.0	3	-10	✓	0.06	GI234	SV23
	A12K-SVXCR 07	12	15.5	9	11	125	5.5	28.0	3	-8	✓	0.11	GI234	SV23
	A16M-SVXCR 07	16	17.5	11	15	150	7.5	36.0	3	-6	✓	0.19	GI234	SV23
L	A10H-SVXCL 07	10	12.5	7	9	100	4.5	22.0	3	-10	✓	0.06	GI234	SV23
	A12K-SVXCL 07	12	15.5	9	11	125	5.5	28.0	3	-8	✓	0.11	GI234	SV23
	A16M-SVXCL 07	16	17.5	11	15	150	7.5	36.0	3	-6	✓	0.20	GI234	SV23

GI234	VC.. 0702..

SV23	DVF 3584	0.6	M 2	5.5	DMD 1650

SVXC(RL)-E INT

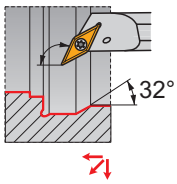
P M K N S H

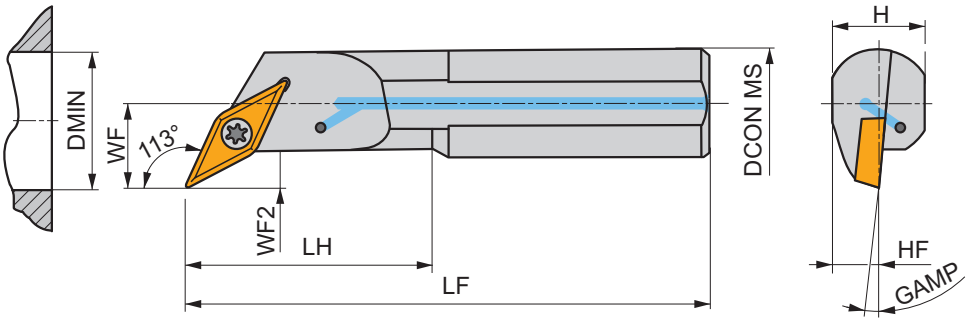
PRAMET

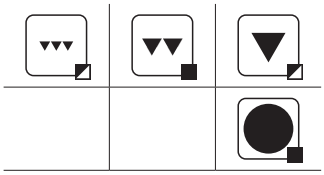
S

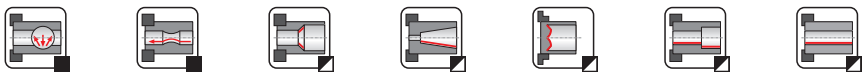
Internal Carbide Screw Lock Boring Bar, 113° Cutting Angle for VC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, with 113° cutting angle for screw type VC.. inserts. Suited for a wide range of internal turning operations and copying under 32° . For tool overhang >3xD.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	WF2 (mm)	GAMP (°)		kg		
R	**E10H-SVXCR 07**	10	12.5	7	9	4.5	100	22.0	3	-10	✓	0.10	GI234	SV23
	E12K-SVXCR 07	12	15.5	9	11	5.5	125	28.0	3	-8	✓	0.18	GI234	SV23
	E16M-SVXCR 07	16	17.5	11	15	7.5	150	36.0	3	-6	✓	0.33	GI234	SV23
L	**E10H-SVXCL 07**	10	12.5	7	9	4.5	100	22.0	3	-10	✓	0.10	GI234	SV23
	E16M-SVXCL 07	16	17.5	11	15	7.5	150	36.0	3	-6	✓	0.33	GI234	SV23

GI234	VC.. 0702..

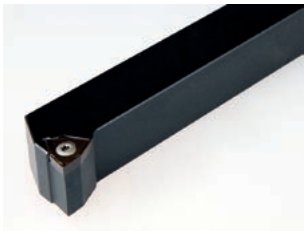
SV23	DVF 3584	0.6 Nm	M 2	5.5	DMD 1650

SWLC(RL) EXT

P M K N S H

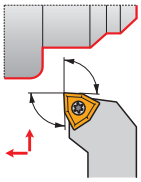
PRAMET

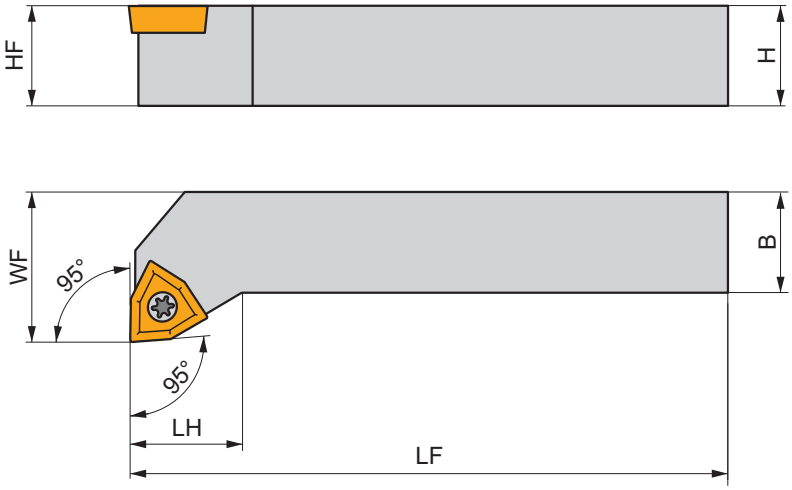
S

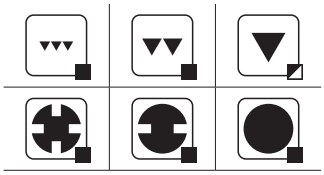


External Screw Lock Tool Holder with 95° Cutting Angle for WC.. Inserts

External Right/Left hand tool holder for screw type positive screw type WC.. inserts. Suited for face and longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	SWLCR 1616 H 06	16	16	16	20	100	15.0	0	0	0.23	GI055	S04
	SWLCR 2020 K 06	20	20	20	25	125	15.0	0	0	0.42	GI055	S04
	SWLCR 2525 M 08	25	25	25	32	150	20.0	0	0	0.76	GI049	S09
L	SWLCL 1616 H 06	16	16	16	20	100	15.0	0	0	0.23	GI055	S04
	SWLCL 2020 K 06	20	20	20	25	125	15.0	0	0	0.40	GI055	S04
	SWLCL 2525 M 08	25	25	25	32	150	20.0	0	0	0.75	GI049	S09

GI049	WC.. 0804..
GI055	WC.. 06T3..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S09	US 4512-T15P	5.0	M 4.5	12.2	FLAG T15P

SWLC(RL) INT

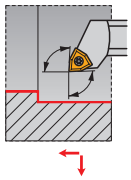
P M K N S H

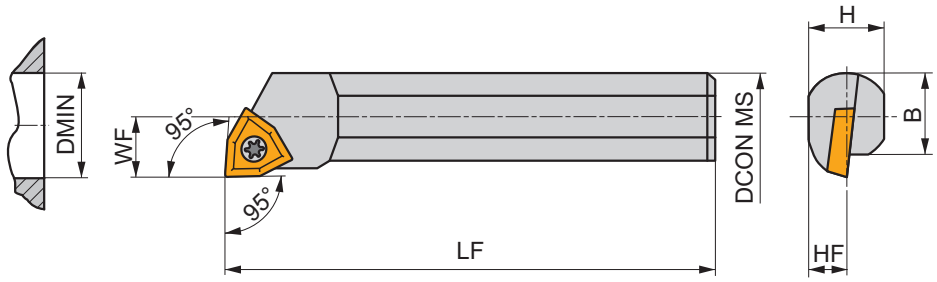
PRAMET

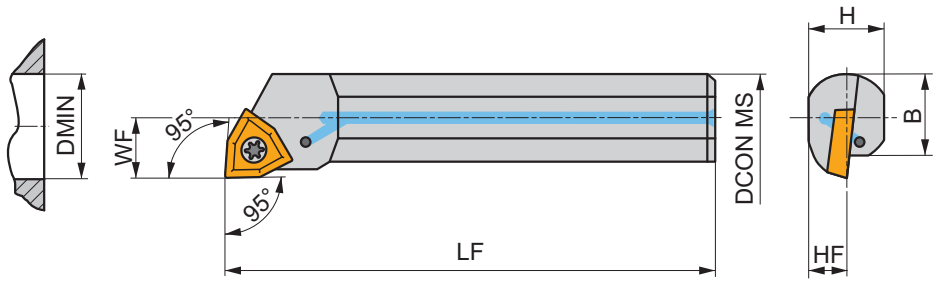
S

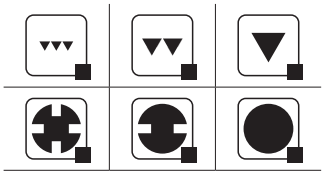
Internal Screw Lock Boring Bar with 95° Cutting Angle for WC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 95° cutting angle for screw type WC.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A20Q-SWLCR 06	20	25	13	18	18.5	180	-7	0	✓	0.37	GI055	S04
	S20S-SWLCR 06	20	25	13	18	18.5	250	-7	0	–	0.60	GI055	S04
	S25T-SWLCR 06	25	32	17	23	23	300	-7	0	–	1.12	GI055	S04
	A25R-SWLCR 08	25	32	17	23	23	200	-7	0	✓	0.70	GI049	S04
	A32S-SWLCR 08	32	40	22	30	30	250	-5	0	✓	1.32	GI049	S09
	S32U-SWLCR 08	32	40	22	30	30	350	-5	0	–	2.05	GI049	S09
L	A20Q-SWLCL 06	20	25	13	18	18.5	180	-7	0	✓	0.00	GI055	S04
	S20S-SWLCL 06	20	25	13	18	18.5	250	-7	0	–	0.60	GI055	S04
	A25R-SWLCL 06	25	32	17	23	23	200	-7	0	✓	0.66	GI055	S04

GI049	WC.. 0804..
GI055	WC.. 06T3..

		Nm			
S04	US 3510-T15P	3.0	M 3.5	10.6	FLAG T15P
S09	US 4512-T15P	5.0	M 4.5	12.2	FLAG T15P

SWUC(RL) INT

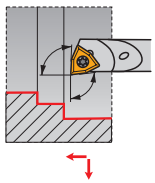
P M K N S H

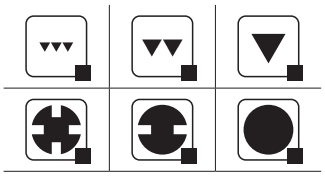
PRAMET

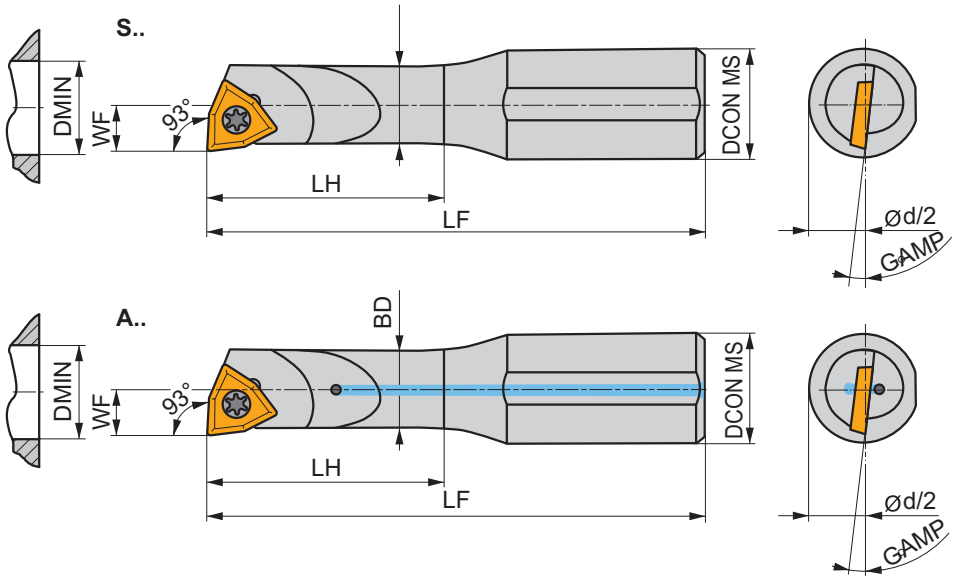
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for WC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 93° cutting angle for screw type WC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R	A0508H-SWUCR 02	8	5.8	5	2.9	100	18.0	-17	✓	0.04	GI221	SW21
	S0508H-SWUCR 02	8	5.8	5	2.9	100	18.0	-17	–	0.03	GI221	SW21
	A0608H-SWUCR 02	8	7.8	6	3.9	100	24.0	-12	✓	0.04	GI221	SW21
	S0608H-SWUCR 02	8	7.8	6	3.9	100	24.0	-12	–	0.04	GI221	SW21
L	A0508H-SWUCL 02	8	5.8	5	2.9	100	18.0	-17	✓	0.04	GI221	SW21
	S0508H-SWUCL 02	8	5.8	5	2.9	100	18.0	-17	–	0.04	GI221	SW21
	A0608H-SWUCL 02	8	7.8	6	3.9	100	24.0	-12	✓	0.04	GI221	SW21
	S0608H-SWUCL 02	8	7.8	6	3.9	100	24.0	-12	–	0.04	GI221	SW21

GI221	WC.. 0201..

SW21	T20.037	0.6	M 2	3.7	DMD 1650

SWUC(RL)-E INT

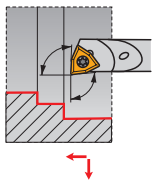
P M K N S H

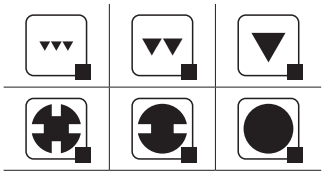
PRAMET

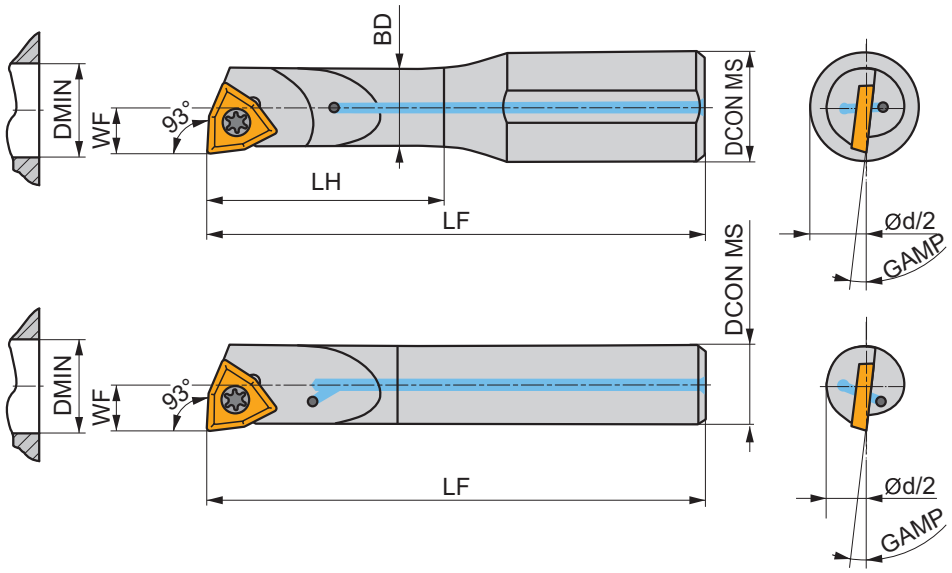
S

Internal carbide Screw Lock Boring Bar with 93° Cutting Angle for WC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, with 93° cutting angle for screw type WC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. For tool overhang >3xD.





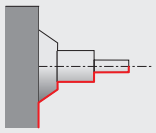


	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		kg		
R	E0508H-SWUCR 02	8	5.8	5	2.9	100	24.0	-17	✓	0.06	GI221	SW21
	E05F-SWUCR 02	5	5.8	–	2.9	85	–	-17	✓	0.03	GI221	SW21
	E0608H-SWUCR 02	8	7.8	6	3.9	100	32.0	-12	✓	0.06	GI221	SW21
	E06G-SWUCR 02	6	7.8	–	3.9	95	–	-12	✓	0.04	GI221	SW21
L	E0508H-SWUCL 02	8	5.8	5	2.9	100	24.0	-17	✓	0.06	GI221	SW21
	E05F-SWUCL 02	5	5.8	–	2.9	85	–	-17	✓	0.03	GI221	SW21
	E0608H-SWUCL 02	8	7.8	6	3.9	100	32.0	-12	✓	0.06	GI221	SW21
	E06G-SWUCL 02	6	7.8	–	3.9	95	–	-12	✓	0.04	GI221	SW21

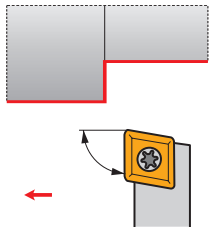
GI221	WC.. 0201..

SW21	T20.037	0.6	M 2	3.7	DMD 1650

ISO TURNING – EXTERNAL
LONG AND UNSTABLE COMPONENTS (positive inserts)

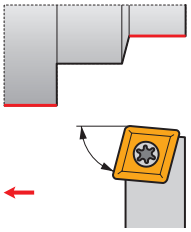


SCAC(RL) EXT 90°
CC..



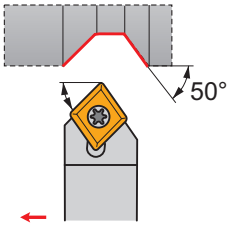
77

SCBC(RL) EXT 75°
CC..



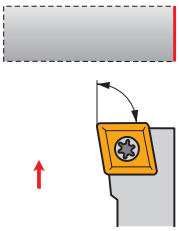
78

SCDCR EXT 45°
CC..



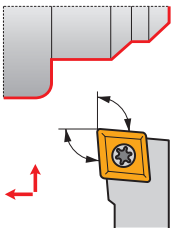
79

SCFC(RL) EXT 90°
CC..



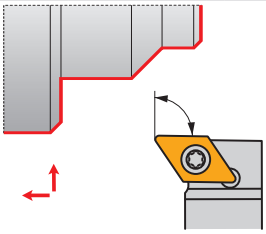
80

SCLC(RL) EXT 95°
CC..



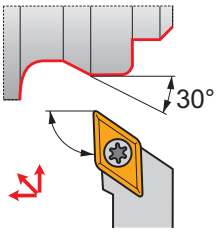
81

SDFC(RL) EXT 91°
DC..



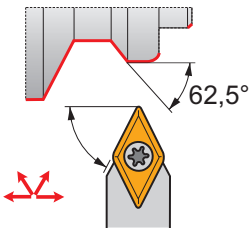
90

SDJC(RL) EXT 93°
DC..



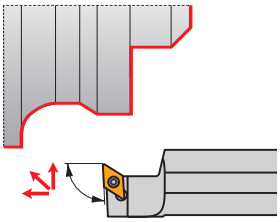
91

SDNCN EXT 62°30´
DC..



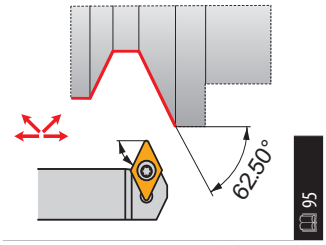
93

SDUCL EXT 93°
DC..



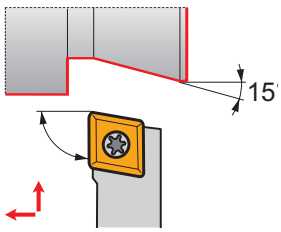
94

SDXC(RL) EXT 62°30´
DC..



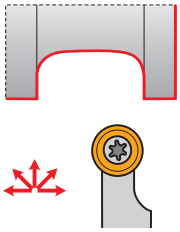
95

SEGC(RL) EXT 90°
EC..



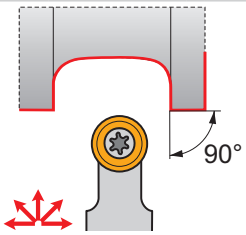
103

SRDC(RL) EXT
RC..



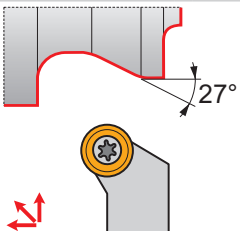
112

SRDCN EXT
RC..



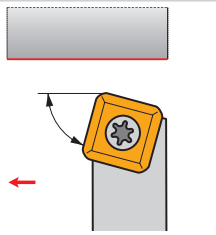
113

SRSC (RL) EXT
RC..



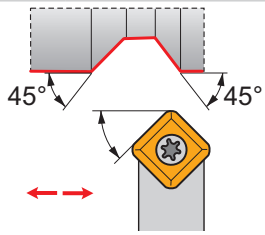
114

SSBC(RL) EXT 75°
SC..



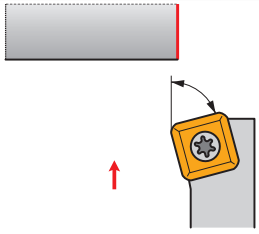
119

SSDCN EXT 45°
SC..



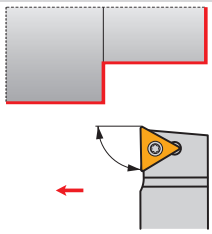
120

SSKC(RL) EXT 75°
SC..



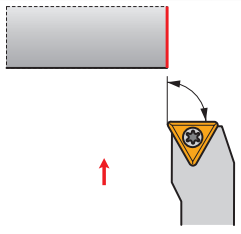
121

STAC(RL) EXT 90°
TC..



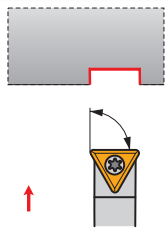
125

STFC(RL) EXT 90°
TC..



126

STFC(RL)-A EXT 90°
TC..



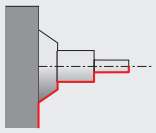
127

S CLAMPING DESIGNATION

TOOLS – NAVIGATOR

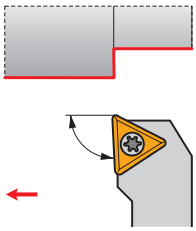
ISO TURNING – EXTERNAL

LONG AND UNSTABLE COMPONENTS (positive inserts)



STJC(RL) EXT 93°

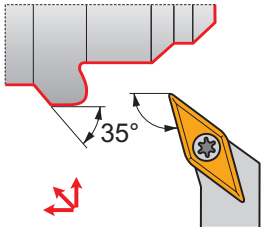
TC..



128

SVHB(C)(RL) EXT 107°30´

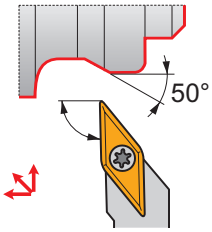
VB, VC..



132

SVJB(C)(RL) EXT 93°

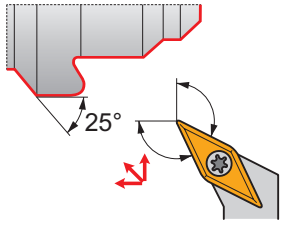
VB, VC..



133

SVPB(C)(RL) EXT 117°30´

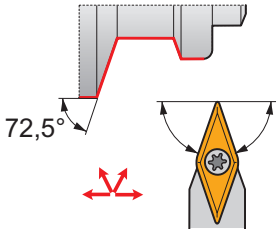
VB, VC..



135

SVVB(C)N EXT 72°30´

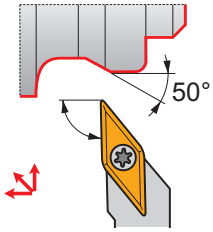
VB, VC..



136

SVXB(C)(RL) EXT 98°

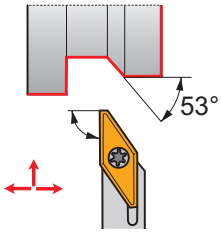
VB, VC..



137

SVAC(RL)-DC EXT 90°

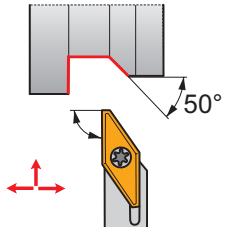
VC..



145

SVJC(RL)-DC EXT 93°

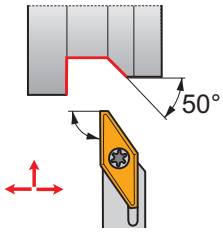
VC..



146

SWLC(RL) EXT 95°

WC..



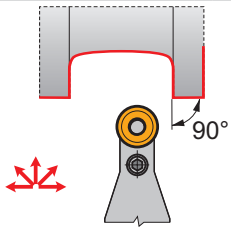
150

P CLAMPING DESIGNATION

TOOLS – NAVIGATOR

PRDCN EXT

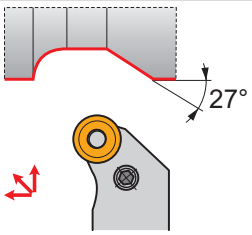
RC..



110

PRSC(RL) EXT

RC..



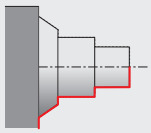
111

KHP / DKH CLAMPING DESIGNATION

TOOLS – NAVIGATOR

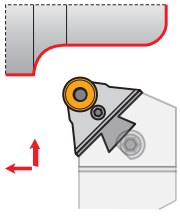
ISO TURNING – HEAVY ROUGHING – EXTERNAL

HEAD (KH)



KHP-RSCR/L

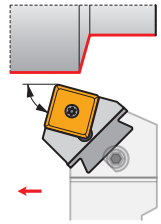
RC..



117

KHS-SBCR 75°

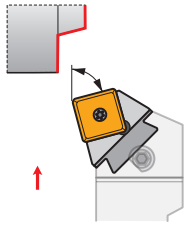
SC..



123

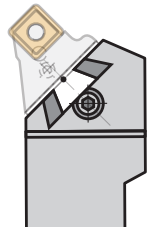
KHS-SBCL 75°

SC..



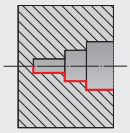
123

DKH(RL)

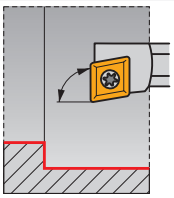


118, 124

ISO TURNING – INTERNAL
LONG AND UNSTABLE COMPONENTS (positive inserts)

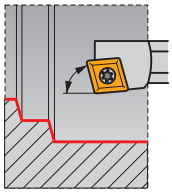


SCFC(RL) INT 90°
CC..



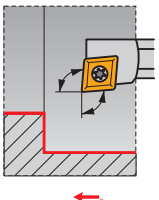
84

SCKC(RL) INT 75°
CC..



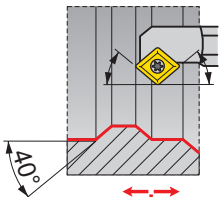
85

SCLC(RL) INT 45°
CC..



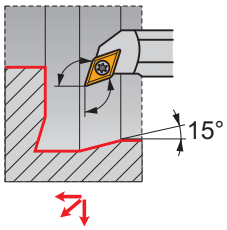
86

SCXC(RL) INT 90°
CC..



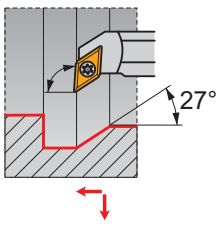
88

SDQC(RL) INT 95°
DC..



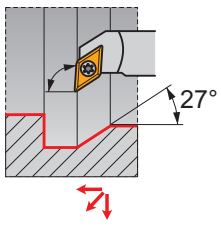
98

SDUC(RL) INT 93°
DC..



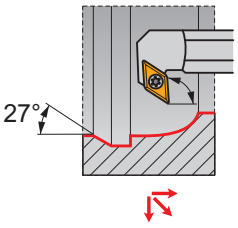
99

SDUC(RL)-E INT 62°30´
DC..



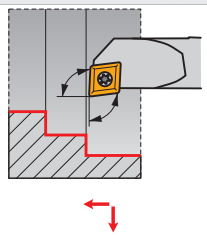
100

SDZC(RL) INT 90°
DC..



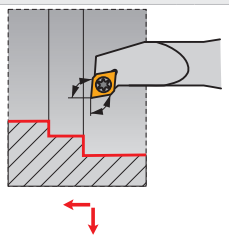
101

SEUC(RL) INT 93°
EC..



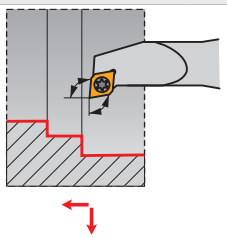
104

SELP(RL) INT 95°
EP..



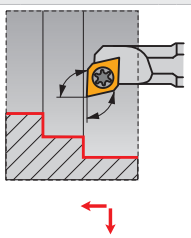
105

SELP(RL)-E INT 95°
EP..



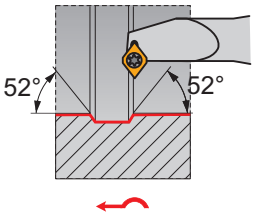
106

SEUP(RL) INT 93°
EP..



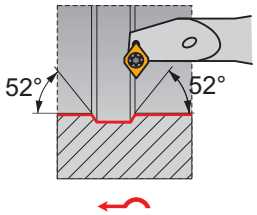
107

SEXP(RL) INT 52°30´
EP..



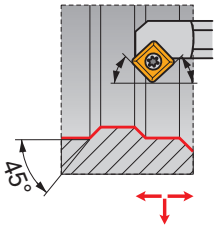
108

SEXP(RL)-E INT 52°30´
EP..



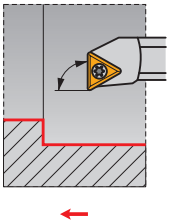
109

SSSC(RL) INT 45°
SC..



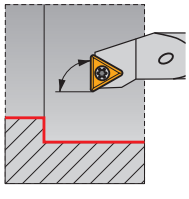
122

STFC(RL) INT 90°
TC..



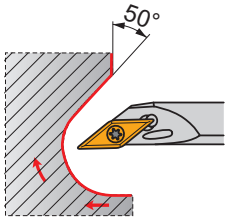
129

STFC(RL)-E INT 90°
TC..



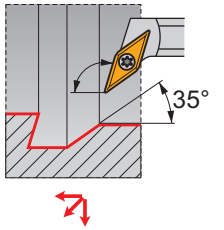
131

SVJB(RL) INT 93°
VB, VC..



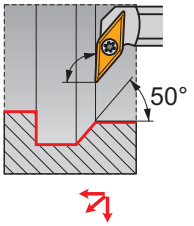
141

SVQB(C)(RL) INT 107°30´
VB, VC..



142

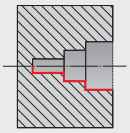
SVUB(C)(RL) INT 93°
VB, VC..



143

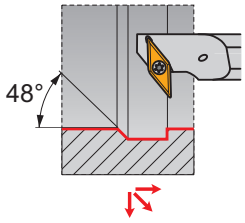
ISO TURNING – INTERNAL

LONG AND UNSTABLE COMPONENTS (positive inserts)



SVLC(RL) INT 95°

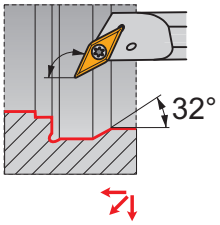
VC..



147

SVXC(RL) INT 113°

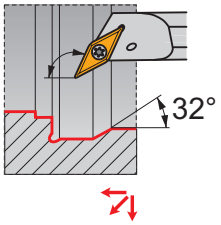
VC..



148

SVXC(RL)-E INT 113°

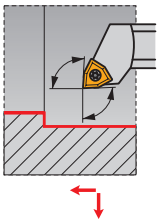
VC..



149

SWLC(RL) INT 95°

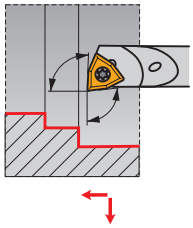
WC..



151

SWUC(RL) INT 93°

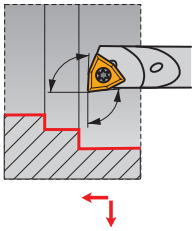
WC..



152

SWUC(RL)-E INT 93°

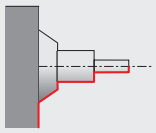
WC..



153

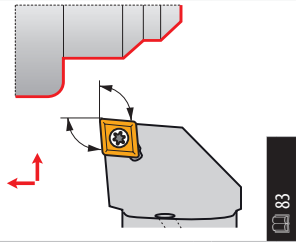
ISO TURNING – EXTERNAL PSC

LONG AND UNSTABLE COMPONENTS (positive inserts)



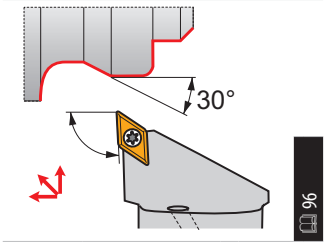
C.-SCLC(RL) EXT 95°

CC..



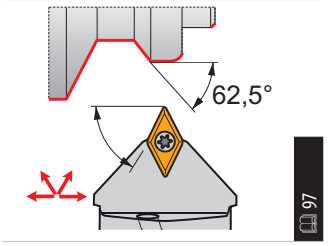
C.-SDJC(RL) EXT 93°

DC..



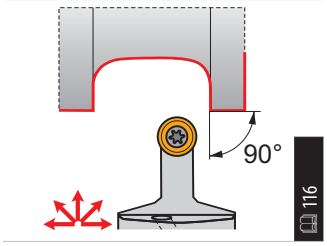
C.-SDNCN EXT 62°30´

DC..



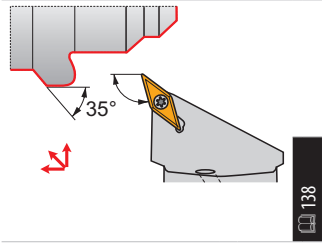
C.-SRDCN EXT

RC..



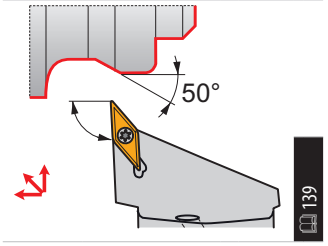
C.-SVHB(RL) EXT 107°30´

VB, VC..



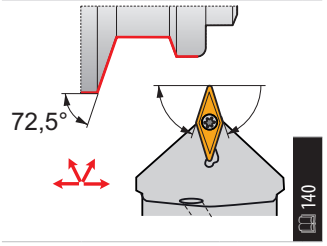
C.-SVJB(RL) EXT 93°

VB, VC..



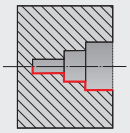
C.-SVVBN EXT 72°30´

VB, VC..



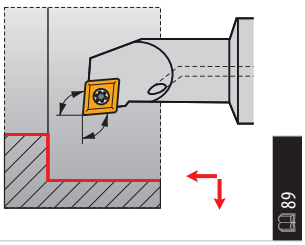
ISO TURNING – INTERNAL PSC

LONG AND UNSTABLE COMPONENTS (positive inserts)



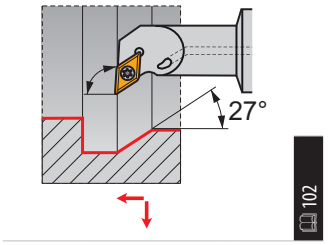
C.-SCLC(RL) INT 95°

CC..



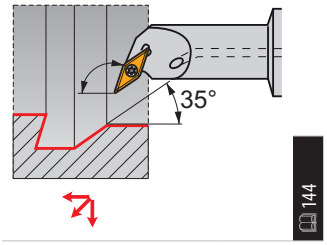
C.-SDUC(RL) INT 93°

DC..



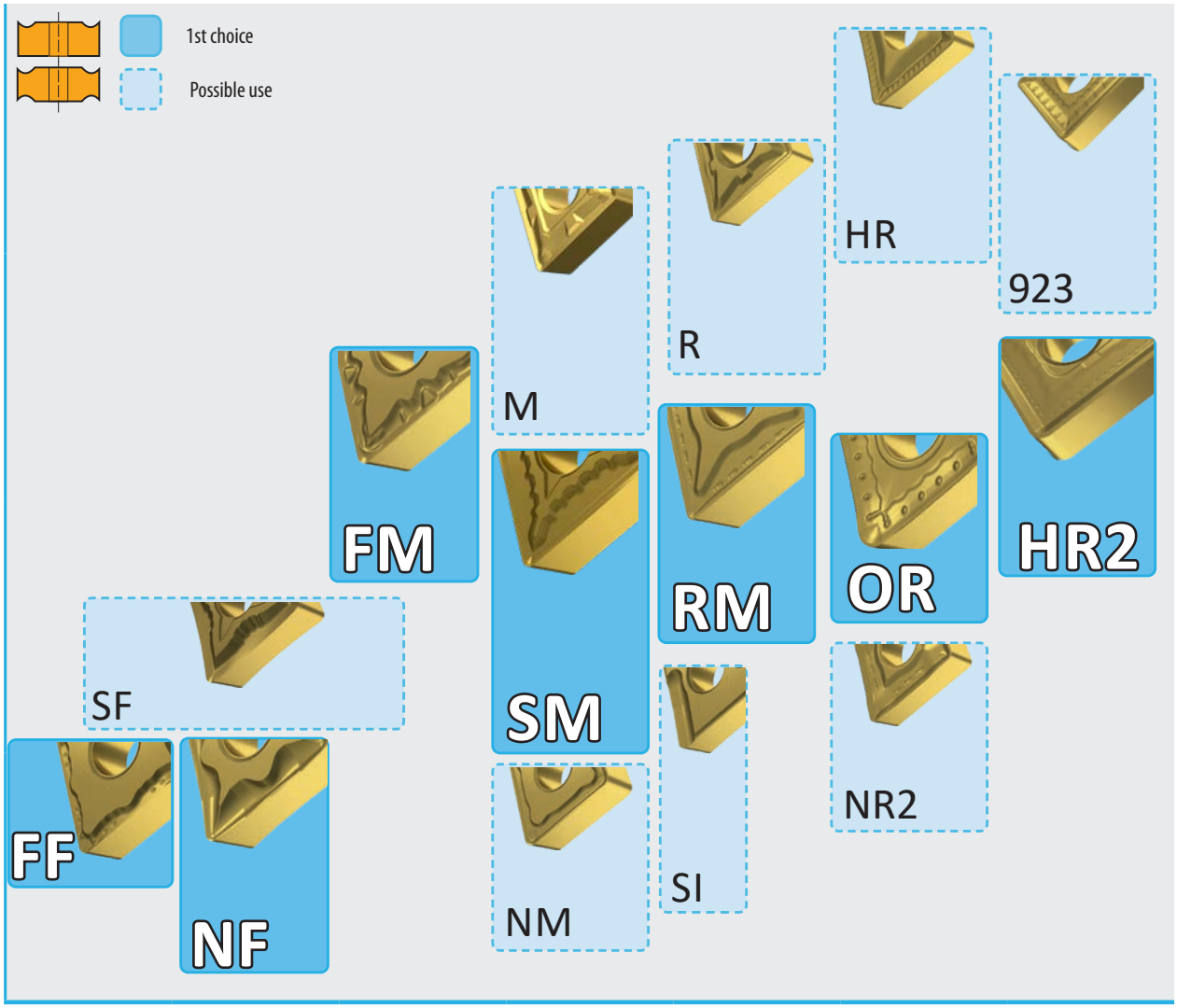
C.-SVQB(C)(RL) INT 108°

VB, VC..

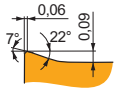
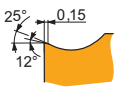
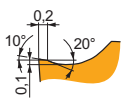
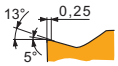
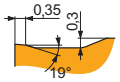
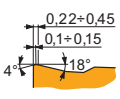


NEGATIVE INSERTS

P



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

FF		Highly positive geometry designed for fine finish machining, stainless steel and steel, potentially cast irons, continuous cuts
NF		Highly positive design for fine finish and medium machining, stainless steels. steel, potentially cast irons, non ferrous materials and super alloys, continuous cuts
FM		Positive geometry designed for finish to semi-rough machining, steel and cast irons, potentially and super alloys, continuous and moderately interrupted cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts
RM		Designed for semi-rough and rough machining, steels, stainless steels and cast irons, potentaillly super alloys, continuous and interrupted cuts
OR		Designed for finish to heavy rough machining, steels and cast irons, potentially stainless steel and super alloys, continuous and interrupted cuts

M

1st choice

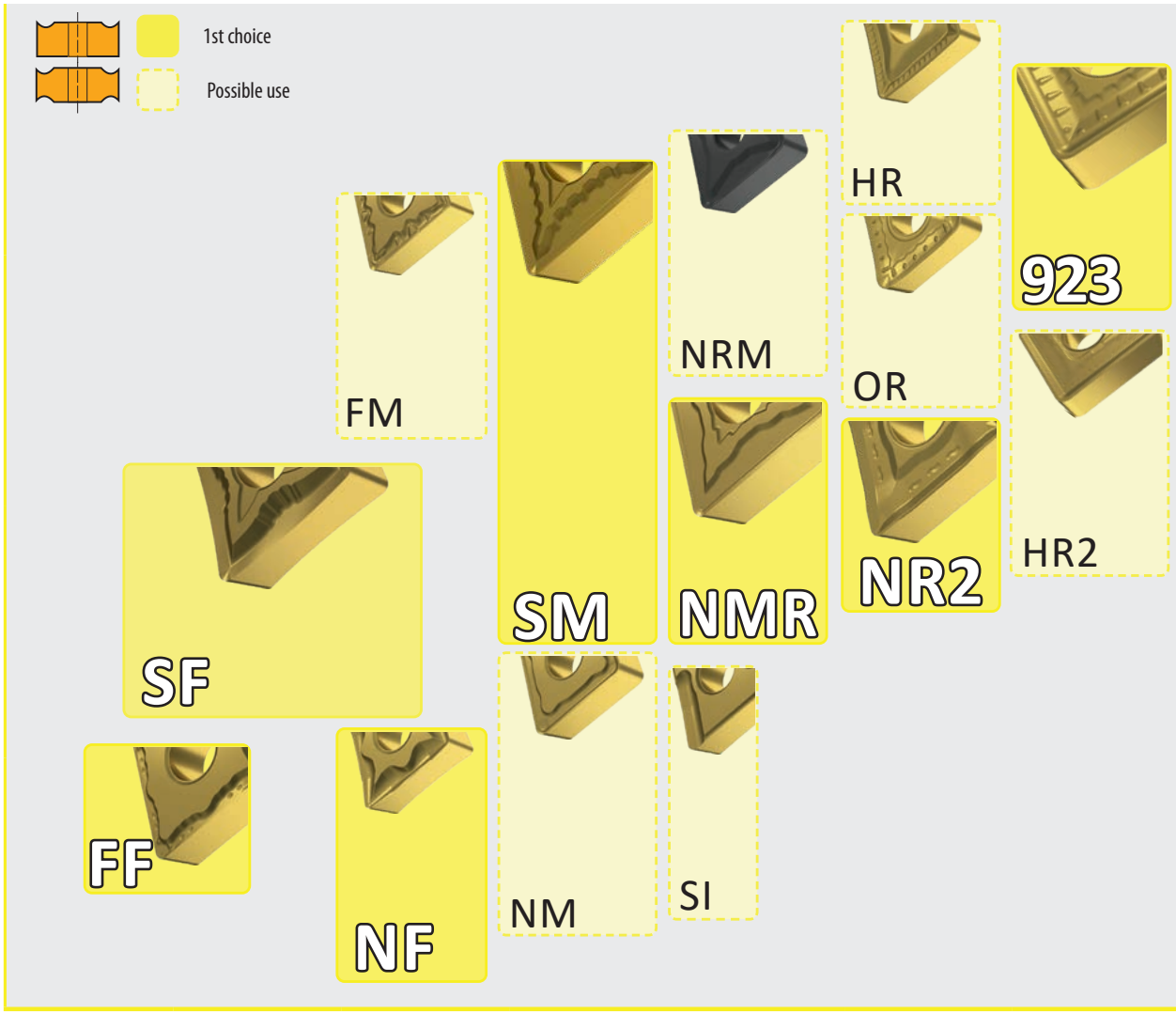
Possible use

Very unstable working conditions

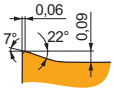
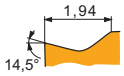
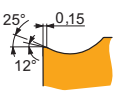
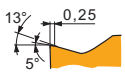
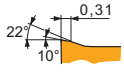
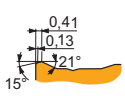
Unstable working conditions

Stable working conditions

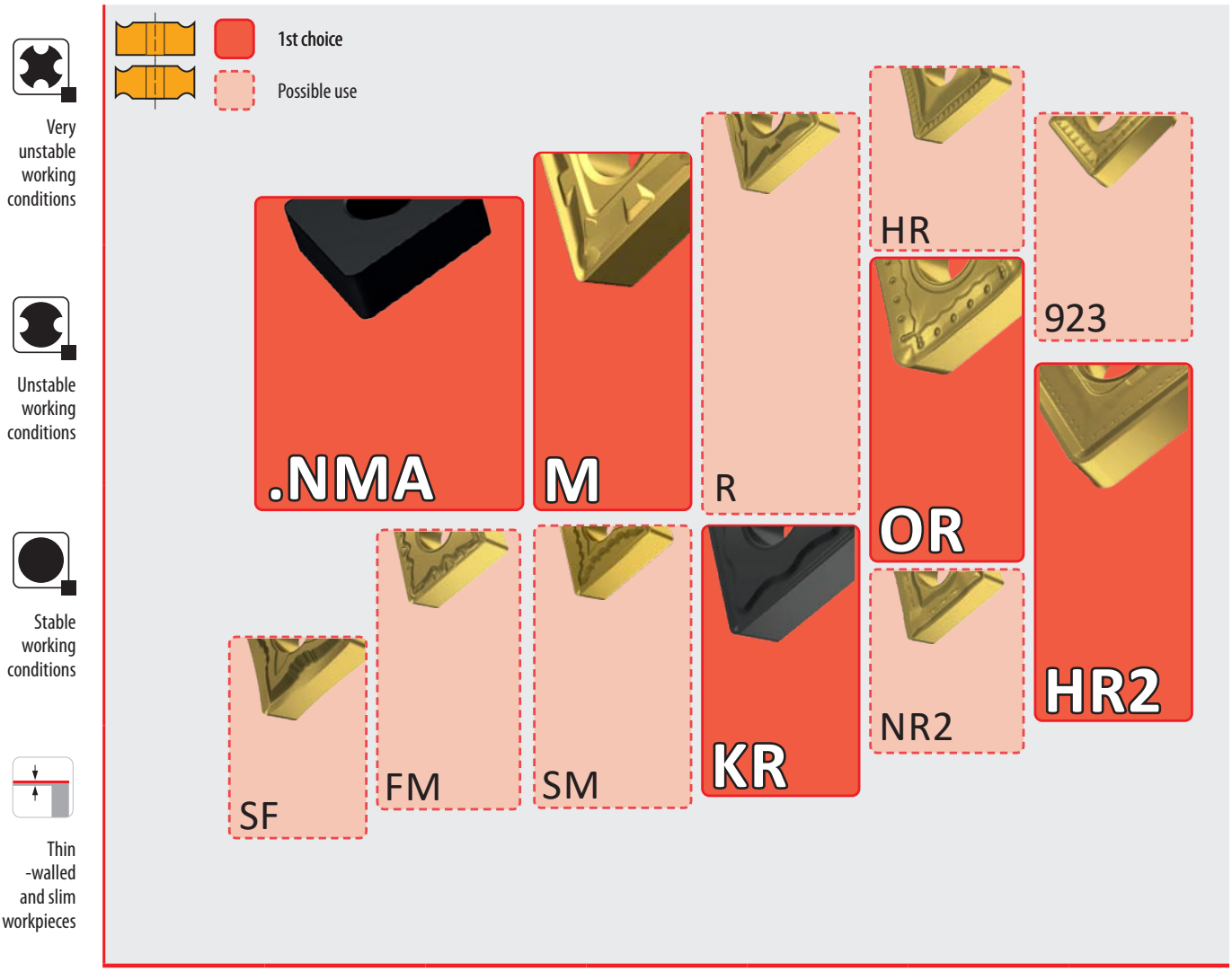
Thin -walled and slim workpieces



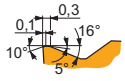
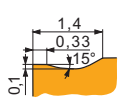
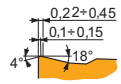
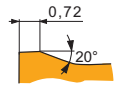
	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

FF		Highly positive geometry designed for fine finish machining, stainless steel and steel, potentially cast irons, continuous cuts
SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts
NF		Highly positive design for fine finish and medium machining, stainless steels. steel, potentially cast irons, non ferrous materials and super alloys, continuous cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts
NMR		Positive design for medium to rough machining, stainless steels as well as soft steels and super alloys, continuous cuts
NR2		Designed for finish to rough machining, stainless steels and steels, potentially cast irons and super alloys, continuous and interrupted cuts

K



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

.NMA		Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts
M		Designed for finish and semi-rough machining, cast irons, potentially steels and hard materials, continuous and interrupted cuts
KR		Designed for semi-rough and rough machining, cast irons, potentially steel and hard materials, continuous and interrupted cuts
OR		Designed for finish to heavy rough machining, steels and cast irons, potentially stainless steel and super alloys, continuous and interrupted cuts
HR2		Designed for rough to heavy rough machining with high feeds, steels and cast irons, potentially stainless steels, continuous and interrupted cuts

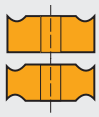
N

Very unstable working conditions

Unstable working conditions

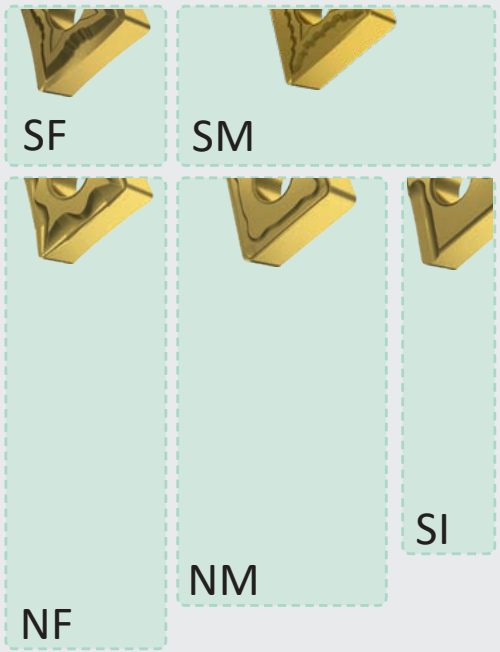
Stable working conditions

Thin -walled and slim workpieces

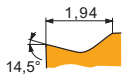
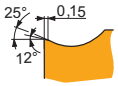
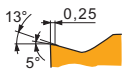


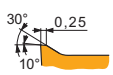
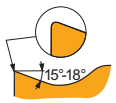
1st choice

Possible use



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts
NF		Highly positive design for fine finish and medium machining, stainless steels. steel, potentially cast irons, non ferrous materials and super alloys, continuous cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts

NM		Highly positive design for fine finish, medium and rough machining, stainless steels, steels, potentially non ferrrous materials and super alloys, continuous cuts
SI		Positive geometry for fine finish to semi-rough machining, steels, stainless steels and cast irons and potentially non ferrous materials, continuous cuts

S

Very unstable working conditions

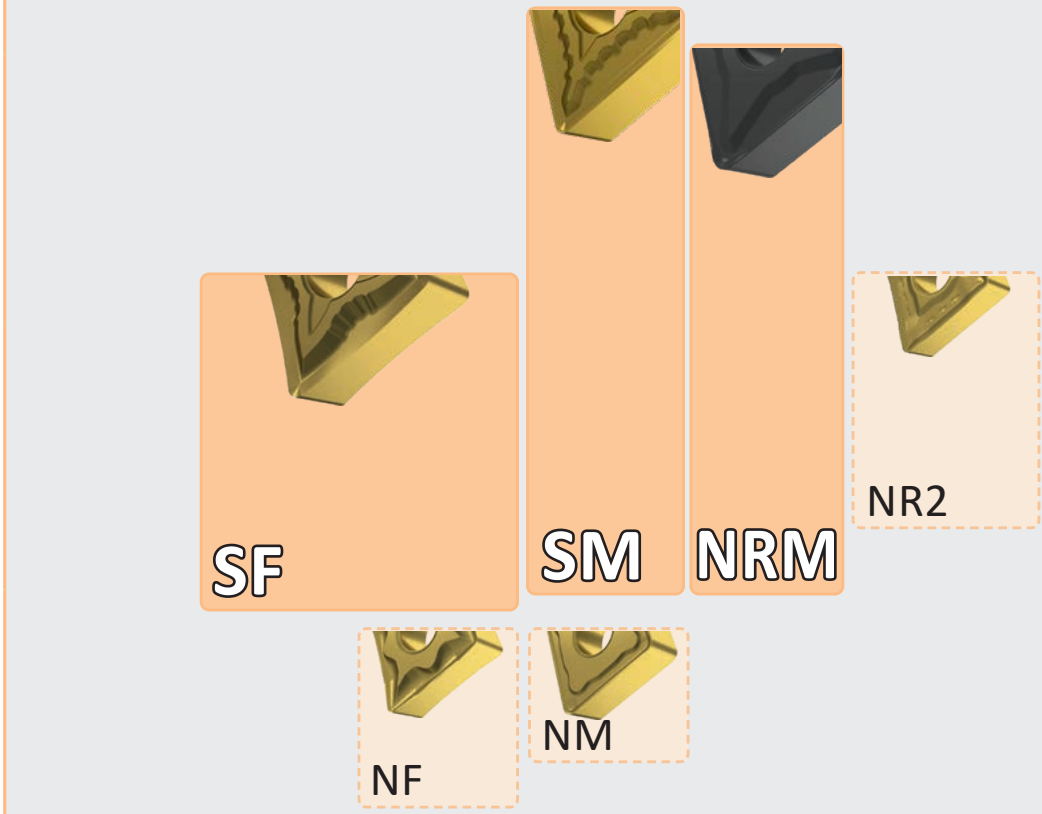
Unstable working conditions

Stable working conditions

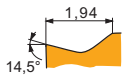
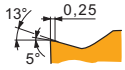
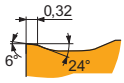
Thin -walled and slim workpieces

1st choice

Possible use



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts
NRM		Positive design for semi-rough and rough machining, stainless steel, soft steels and super alloys, continuous cuts

H

1st choice

Possible use

Very unstable working conditions

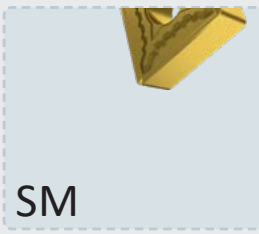
Unstable working conditions

Stable working conditions

Thin -walled and slim workpieces

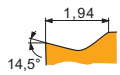
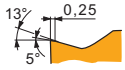

.NMA

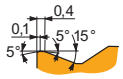

R


SM

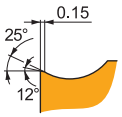
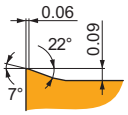

SF

	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

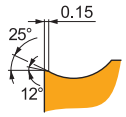
SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts
.NMA		Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts

R		Designed for semi-rough and rough machining, cast irons, potentially steel and hard materials, continuous and interrupted cuts

FINE-FINISHING – NAVIGATOR

NF			**NF** chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy
FF			**FF** chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.

NF

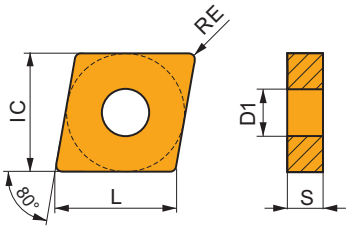


NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy

PRAMET

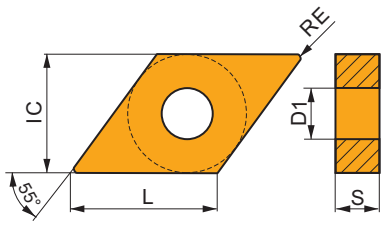
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76



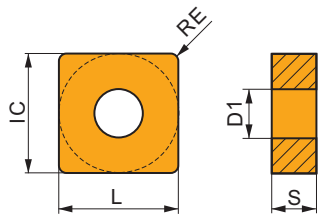
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



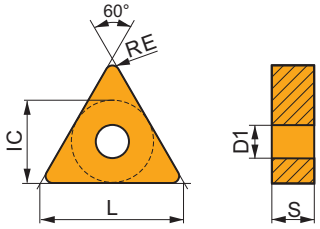
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



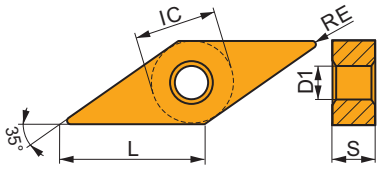
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



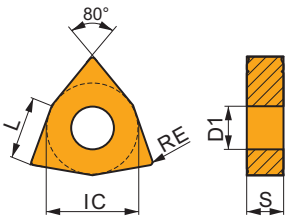
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

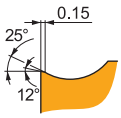
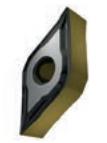
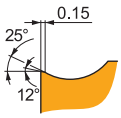


WNMG

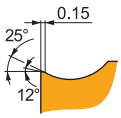
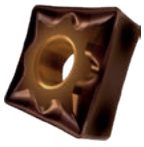
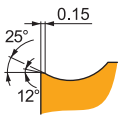
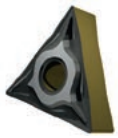
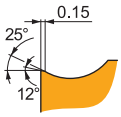
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



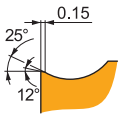
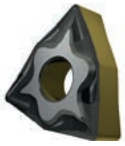
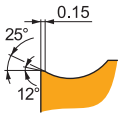
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
		**NF** chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy																	
CNMG 090304E-NF:T6310	0.4	190	0.17	0.8	135	0.15	0.8	150	0.17	0.8	570	0.20	0.8	55	0.12	0.6	–	–	–
CNMG 090304E-NF:T7335	0.4	210	0.18	0.8	160	0.16	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
CNMG 090304E-NF:T8430	0.4	225	0.17	0.8	120	0.15	0.8	185	0.17	0.8	615	0.20	0.8	45	0.12	0.6	–	–	–
CNMG 090304E-NF:T9325	0.4	265	0.18	0.8	155	0.16	0.8	250	0.18	0.8	–	–	–	55	0.16	0.6	–	–	–
CNMG 090308E-NF:T8430	0.8	245	0.19	1.0	135	0.17	1.0	200	0.19	1.0	675	0.23	1.0	50	0.15	0.8	–	–	–
CNMG 090308E-NF:T9325	0.8	300	0.19	1.0	180	0.17	1.0	285	0.19	1.0	–	–	–	65	0.15	0.8	–	–	–
CNMG 120404E-NF:HF7	0.4	–	–	–	95	0.15	1.7	155	0.17	1.7	495	0.20	1.7	–	–	–	–	–	–
CNMG 120404E-NF:T6310	0.4	180	0.17	1.7	125	0.15	1.7	145	0.17	1.7	540	0.20	1.7	50	0.14	1.4	–	–	–
CNMG 120404E-NF:T7325	0.4	200	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
CNMG 120404E-NF:T7335	0.4	195	0.18	1.7	150	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
CNMG 120404E-NF:T8315	0.4	185	0.17	1.7	110	0.15	1.7	175	0.17	1.7	555	0.20	1.7	45	0.14	1.4	–	–	–
CNMG 120404E-NF:T8430	0.4	200	0.17	1.7	110	0.15	1.7	165	0.17	1.7	555	0.20	1.7	40	0.14	1.4	–	–	–
CNMG 120404E-NF:T9325	0.4	250	0.18	1.7	150	0.16	1.7	235	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–
CNMG 120404E-NF:T9415	0.4	315	0.17	1.7	–	–	–	295	0.17	1.7	–	–	–	–	–	–	–	–	–
CNMG 120408E-NF:HF7	0.8	–	–	–	110	0.17	1.7	180	0.19	1.7	570	0.23	1.7	–	–	–	–	–	–
CNMG 120408E-NF:T6310	0.8	200	0.19	1.7	140	0.17	1.7	160	0.19	1.7	600	0.23	1.7	60	0.15	1.4	–	–	–
CNMG 120408E-NF:T7325	0.8	235	0.19	1.7	180	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
CNMG 120408E-NF:T7335	0.8	225	0.19	1.7	175	0.17	1.7	–	–	–	–	–	–	70	0.15	1.4	–	–	–
CNMG 120408E-NF:T8315	0.8	215	0.19	1.7	125	0.17	1.7	200	0.19	1.7	645	0.23	1.7	50	0.15	1.4	–	–	–
CNMG 120408E-NF:T8430	0.8	235	0.19	1.7	125	0.17	1.7	190	0.19	1.7	645	0.23	1.7	50	0.15	1.4	–	–	–
CNMG 120408E-NF:T9325	0.8	285	0.19	1.7	170	0.17	1.7	270	0.19	1.7	–	–	–	60	0.15	1.4	–	–	–
CNMG 120408E-NF:T9415	0.8	360	0.19	1.7	–	–	–	340	0.19	1.7	–	–	–	–	–	–	–	–	–
CNMG 120412E-NF:T6310	1.2	185	0.30	2.1	130	0.27	2.1	145	0.30	2.1	555	0.36	2.1	55	0.21	1.7	–	–	–
CNMG 120412E-NF:T7325	1.2	205	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
CNMG 120412E-NF:T7335	1.2	200	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
CNMG 120412E-NF:T8430	1.2	200	0.30	2.1	110	0.27	2.1	165	0.30	2.1	555	0.36	2.1	40	0.21	1.7	–	–	–
CNMG 120412E-NF:T9415	1.2	315	0.30	2.1	–	–	–	295	0.30	2.1	–	–	–	–	–	–	–	–	–
		**NF** chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy																	
DNMG 110404E-NF:T6310	0.4	155	0.15	0.8	110	0.14	0.8	125	0.15	0.8	465	0.18	0.8	45	0.12	0.6	–	–	–
DNMG 110404E-NF:T7325	0.4	170	0.18	0.8	130	0.16	0.8	–	–	–	–	–	–	55	0.16	0.6	–	–	–
DNMG 110404E-NF:T7335	0.4	165	0.18	0.8	125	0.16	0.8	–	–	–	–	–	–	50	0.16	0.6	–	–	–
DNMG 110404E-NF:T8430	0.4	190	0.15	0.8	105	0.14	0.8	155	0.15	0.8	525	0.18	0.8	40	0.12	0.6	–	–	–
DNMG 110404E-NF:T9325	0.4	210	0.18	0.8	125	0.16	0.8	195	0.18	0.8	–	–	–	45	0.16	0.6	–	–	–
DNMG 110408E-NF:T6310	0.8	175	0.17	1.0	125	0.15	1.0	140	0.17	1.0	525	0.20	1.0	50	0.14	0.8	–	–	–
DNMG 110408E-NF:T7325	0.8	200	0.18	1.0	155	0.16	1.0	–	–	–	–	–	–	65	0.16	0.8	–	–	–
DNMG 110408E-NF:T7335	0.8	195	0.18	1.0	150	0.16	1.0	–	–	–	–	–	–	60	0.16	0.8	–	–	–
DNMG 110408E-NF:T8430	0.8	205	0.17	1.0	110	0.15	1.0	170	0.17	1.0	570	0.20	1.0	45	0.14	0.8	–	–	–
DNMG 110408E-NF:T9325	0.8	250	0.18	1.0	150	0.16	1.0	235	0.18	1.0	–	–	–	55	0.16	0.8	–	–	–
DNMG 110408E-NF:T9415	0.8	315	0.17	1.0	–	–	–	295	0.17	1.0	–	–	–	–	–	–	–	–	–
DNMG 150404E-NF:T6310	0.4	140	0.17	1.7	100	0.15	1.7	110	0.17	1.7	420	0.20	1.7	40	0.15	1.4	–	–	–
DNMG 150404E-NF:T7325	0.4	160	0.18	1.7	120	0.16	1.7	–	–	–	–	–	–	50	0.16	1.4	–	–	–
DNMG 150404E-NF:T7335	0.4	155	0.18	1.7	120	0.16	1.7	–	–	–	–	–	–	50	0.16	1.4	–	–	–
DNMG 150404E-NF:T8430	0.4	165	0.17	1.7	90	0.15	1.7	135	0.17	1.7	450	0.20	1.7	35	0.15	1.4	–	–	–
DNMG 150404E-NF:T9325	0.4	200	0.18	1.7	120	0.16	1.7	190	0.18	1.7	–	–	–	45	0.16	1.4	–	–	–
DNMG 150404E-NF:T9415	0.4	260	0.15	1.7	–	–	–	245	0.15	1.7	–	–	–	–	–	–	–	–	–
DNMG 150408E-NF:T6310	0.8	165	0.18	1.7	115	0.16	1.7	130	0.18	1.7	495	0.22	1.7	45	0.16	1.4	–	–	–
DNMG 150408E-NF:T7325	0.8	190	0.18	1.7	145	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
DNMG 150408E-NF:T7335	0.8	185	0.18	1.7	140	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
DNMG 150408E-NF:T8430	0.8	190	0.18	1.7	105	0.16	1.7	155	0.18	1.7	525	0.22	1.7	40	0.16	1.4	–	–	–
DNMG 150408E-NF:T9325	0.8	235	0.18	1.7	140	0.16	1.7	220	0.18	1.7	–	–	–	50	0.16	1.4	–	–	–
DNMG 150408E-NF:T9415	0.8	300	0.17	1.7	–	–	–	285	0.17	1.7	–	–	–	–	–	–	–	–	–

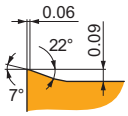
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
																			
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy																			
DNMG 150604E-NF:HF7	0.4	–	–	–	80	0.14	1.9	130	0.15	1.9	420	0.18	1.9	–	–	–	–	–	–
DNMG 150604E-NF:T6310	0.4	140	0.17	1.9	100	0.15	1.9	110	0.17	1.9	420	0.20	1.9	40	0.15	1.5	–	–	–
DNMG 150604E-NF:T7325	0.4	155	0.18	1.9	120	0.16	1.9	–	–	–	–	–	–	50	0.16	1.5	–	–	–
DNMG 150604E-NF:T7335	0.4	150	0.18	1.9	115	0.16	1.9	–	–	–	–	–	–	45	0.16	1.5	–	–	–
DNMG 150604E-NF:T8315	0.4	145	0.17	1.9	85	0.15	1.9	135	0.17	1.9	435	0.20	1.9	35	0.15	1.5	–	–	–
DNMG 150604E-NF:T8430	0.4	165	0.17	1.9	90	0.15	1.9	135	0.17	1.9	450	0.20	1.9	35	0.15	1.5	–	–	–
DNMG 150604E-NF:T9325	0.4	195	0.18	1.9	115	0.16	1.9	185	0.18	1.9	–	–	–	40	0.16	1.5	–	–	–
DNMG 150604E-NF:T9415	0.4	260	0.15	1.9	–	–	–	245	0.15	1.9	–	–	–	–	–	–	–	–	–
DNMG 150608E-NF:HF7	0.8	–	–	–	90	0.15	1.9	145	0.17	1.9	465	0.20	1.9	–	–	–	–	–	–
DNMG 150608E-NF:T6310	0.8	165	0.18	1.9	115	0.16	1.9	130	0.18	1.9	495	0.22	1.9	45	0.16	1.5	–	–	–
DNMG 150608E-NF:T7325	0.8	185	0.18	1.9	140	0.16	1.9	–	–	–	–	–	–	60	0.16	1.5	–	–	–
DNMG 150608E-NF:T7335	0.8	180	0.18	1.9	140	0.16	1.9	–	–	–	–	–	–	55	0.16	1.5	–	–	–
DNMG 150608E-NF:T8315	0.8	175	0.18	1.9	105	0.16	1.9	165	0.18	1.9	525	0.22	1.9	40	0.16	1.5	–	–	–
DNMG 150608E-NF:T8430	0.8	190	0.18	1.9	105	0.16	1.9	155	0.18	1.9	525	0.22	1.9	40	0.16	1.5	–	–	–
DNMG 150608E-NF:T9325	0.8	230	0.18	1.9	135	0.16	1.9	215	0.18	1.9	–	–	–	50	0.16	1.5	–	–	–
DNMG 150608E-NF:T9415	0.8	295	0.17	1.9	–	–	–	280	0.17	1.9	–	–	–	–	–	–	–	–	–
DNMG 150612E-NF:T6310	1.2	150	0.30	1.5	105	0.27	1.5	120	0.30	1.5	450	0.36	1.5	45	0.21	1.2	–	–	–
DNMG 150612E-NF:T8430	1.2	165	0.30	1.5	90	0.27	1.5	135	0.30	1.5	450	0.36	1.5	35	0.21	1.2	–	–	–
																			
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy																			
SNMG 120404E-NF:T6310	0.4	185	0.17	1.7	130	0.15	1.7	145	0.17	1.7	555	0.20	1.7	55	0.14	1.4	–	–	–
SNMG 120404E-NF:T7335	0.4	205	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
SNMG 120404E-NF:T8430	0.4	210	0.17	1.7	115	0.15	1.7	175	0.17	1.7	585	0.20	1.7	45	0.14	1.4	–	–	–
SNMG 120404E-NF:T9325	0.4	260	0.18	1.7	155	0.16	1.7	245	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–
SNMG 120408E-NF:HF7	0.8	–	–	–	120	0.17	1.7	190	0.19	1.7	600	0.23	1.7	–	–	–	–	–	–
SNMG 120408E-NF:T6310	0.8	210	0.19	1.7	150	0.17	1.7	165	0.19	1.7	630	0.23	1.7	60	0.15	1.4	–	–	–
SNMG 120408E-NF:T7325	0.8	245	0.19	1.7	190	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
SNMG 120408E-NF:T7335	0.8	240	0.19	1.7	185	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
SNMG 120408E-NF:T8315	0.8	230	0.19	1.7	135	0.17	1.7	215	0.19	1.7	690	0.23	1.7	55	0.15	1.4	–	–	–
SNMG 120408E-NF:T8430	0.8	250	0.19	1.7	135	0.17	1.7	205	0.19	1.7	690	0.23	1.7	50	0.15	1.4	–	–	–
SNMG 120408E-NF:T9325	0.8	300	0.19	1.7	180	0.17	1.7	285	0.19	1.7	–	–	–	65	0.15	1.4	–	–	–
																			
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy																			
TNMG 160404E-NF:HF7	0.4	–	–	–	90	0.14	1.4	140	0.15	1.4	450	0.18	1.4	–	–	–	–	–	–
TNMG 160404E-NF:T6310	0.4	150	0.17	1.4	105	0.15	1.4	120	0.17	1.4	450	0.20	1.4	45	0.15	1.1	–	–	–
TNMG 160404E-NF:T7325	0.4	170	0.18	1.4	130	0.16	1.4	–	–	–	–	–	–	55	0.16	1.1	–	–	–
TNMG 160404E-NF:T7335	0.4	165	0.18	1.4	125	0.16	1.4	–	–	–	–	–	–	50	0.16	1.1	–	–	–
TNMG 160404E-NF:T8315	0.4	160	0.17	1.4	95	0.15	1.4	150	0.17	1.4	480	0.20	1.4	40	0.15	1.1	–	–	–
TNMG 160404E-NF:T8430	0.4	175	0.17	1.4	95	0.15	1.4	140	0.17	1.4	480	0.20	1.4	35	0.15	1.1	–	–	–
TNMG 160404E-NF:T9325	0.4	215	0.18	1.4	125	0.16	1.4	200	0.18	1.4	–	–	–	45	0.16	1.1	–	–	–
TNMG 160404E-NF:T9415	0.4	285	0.15	1.4	–	–	–	270	0.15	1.4	–	–	–	–	–	–	–	–	–
TNMG 160408E-NF:HF7	0.8	–	–	–	100	0.15	1.4	160	0.17	1.4	510	0.20	1.4	–	–	–	–	–	–
TNMG 160408E-NF:T6310	0.8	180	0.18	1.4	125	0.16	1.4	145	0.18	1.4	540	0.22	1.4	50	0.16	1.1	–	–	–
TNMG 160408E-NF:T7325	0.8	200	0.18	1.4	155	0.16	1.4	–	–	–	–	–	–	65	0.16	1.1	–	–	–
TNMG 160408E-NF:T7335	0.8	195	0.18	1.4	150	0.16	1.4	–	–	–	–	–	–	60	0.16	1.1	–	–	–
TNMG 160408E-NF:T8315	0.8	190	0.18	1.4	110	0.16	1.4	180	0.18	1.4	570	0.22	1.4	45	0.16	1.1	–	–	–
TNMG 160408E-NF:T8430	0.8	205	0.18	1.4	110	0.16	1.4	170	0.18	1.4	570	0.22	1.4	45	0.16	1.1	–	–	–
TNMG 160408E-NF:T9325	0.8	255	0.18	1.4	150	0.16	1.4	240	0.18	1.4	–	–	–	55	0.16	1.1	–	–	–

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	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
 		**NF** chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy																	
VNMG 160404E-NF:T6310	0.4	140	0.12	1.2	100	0.11	1.2	110	0.12	1.2	420	0.14	1.2	40	0.11	1.0	–	–	–
VNMG 160404E-NF:T7325	0.4	140	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	45	0.16	1.0	–	–	–
VNMG 160404E-NF:T7335	0.4	140	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	45	0.16	1.0	–	–	–
VNMG 160404E-NF:T8315	0.4	150	0.12	1.2	90	0.11	1.2	140	0.12	1.2	450	0.14	1.2	35	0.11	1.0	–	–	–
VNMG 160404E-NF:T8430	0.4	175	0.12	1.2	95	0.11	1.2	140	0.12	1.2	480	0.14	1.2	35	0.11	1.0	–	–	–
VNMG 160404E-NF:T9325	0.4	180	0.18	1.2	105	0.16	1.2	170	0.18	1.2	–	–	–	40	0.16	1.0	–	–	–
VNMG 160404E-NF:T9415	0.4	255	0.12	1.2	–	–	–	240	0.12	1.2	–	–	–	–	–	–	–	–	–
VNMG 160408E-NF:T6310	0.8	145	0.17	1.4	100	0.15	1.4	115	0.17	1.4	435	0.20	1.4	40	0.14	1.1	–	–	–
VNMG 160408E-NF:T7325	0.8	165	0.18	1.4	125	0.16	1.4	–	–	–	–	–	–	50	0.16	1.1	–	–	–
VNMG 160408E-NF:T7335	0.8	160	0.18	1.4	120	0.16	1.4	–	–	–	–	–	–	50	0.16	1.1	–	–	–
VNMG 160408E-NF:T8315	0.8	160	0.17	1.4	95	0.15	1.4	150	0.17	1.4	480	0.20	1.4	40	0.14	1.1	–	–	–
VNMG 160408E-NF:T8430	0.8	175	0.17	1.4	95	0.15	1.4	140	0.17	1.4	480	0.20	1.4	35	0.14	1.1	–	–	–
VNMG 160408E-NF:T9325	0.8	210	0.18	1.4	125	0.16	1.4	195	0.18	1.4	–	–	–	45	0.16	1.1	–	–	–
VNMG 160408E-NF:T9415	0.8	270	0.17	1.4	–	–	–	255	0.17	1.4	–	–	–	–	–	–	–	–	–
 		**NF** chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy																	
WNMG 060404E-NF:T6310	0.4	190	0.17	0.8	135	0.15	0.8	150	0.17	0.8	570	0.20	0.8	55	0.12	0.6	–	–	–
WNMG 060404E-NF:T7325	0.4	215	0.18	0.8	165	0.16	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
WNMG 060404E-NF:T7335	0.4	210	0.18	0.8	160	0.16	0.8	–	–	–	–	–	–	65	0.16	0.6	–	–	–
WNMG 060404E-NF:T8315	0.4	200	0.17	0.8	120	0.15	0.8	190	0.17	0.8	600	0.20	0.8	50	0.12	0.6	–	–	–
WNMG 060404E-NF:T8430	0.4	225	0.17	0.8	120	0.15	0.8	185	0.17	0.8	615	0.20	0.8	45	0.12	0.6	–	–	–
WNMG 060404E-NF:T9325	0.4	265	0.18	0.8	155	0.16	0.8	250	0.18	0.8	–	–	–	55	0.16	0.6	–	–	–
WNMG 060404E-NF:T9415	0.4	340	0.17	0.8	–	–	–	320	0.17	0.8	–	–	–	–	–	–	–	–	–
WNMG 060408E-NF:T6310	0.8	215	0.19	1.0	150	0.17	1.0	170	0.19	1.0	645	0.23	1.0	60	0.15	0.8	–	–	–
WNMG 060408E-NF:T7325	0.8	245	0.19	1.0	190	0.17	1.0	–	–	–	–	–	–	75	0.15	0.8	–	–	–
WNMG 060408E-NF:T8430	0.8	245	0.19	1.0	135	0.17	1.0	200	0.19	1.0	675	0.23	1.0	50	0.15	0.8	–	–	–
WNMG 060408E-NF:T9325	0.8	300	0.19	1.0	180	0.17	1.0	285	0.19	1.0	–	–	–	65	0.15	0.8	–	–	–
WNMG 060408E-NF:T9415	0.8	380	0.19	1.0	–	–	–	360	0.19	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404E-NF:HF7	0.4	–	–	–	95	0.15	1.7	155	0.17	1.7	495	0.20	1.7	–	–	–	–	–	–
WNMG 080404E-NF:T6310	0.4	180	0.17	1.7	125	0.15	1.7	145	0.17	1.7	540	0.20	1.7	50	0.14	1.4	–	–	–
WNMG 080404E-NF:T7325	0.4	200	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–
WNMG 080404E-NF:T7335	0.4	195	0.18	1.7	150	0.16	1.7	–	–	–	–	–	–	60	0.16	1.4	–	–	–
WNMG 080404E-NF:T8315	0.4	185	0.17	1.7	110	0.15	1.7	175	0.17	1.7	555	0.20	1.7	45	0.14	1.4	–	–	–
WNMG 080404E-NF:T8430	0.4	200	0.17	1.7	110	0.15	1.7	165	0.17	1.7	555	0.20	1.7	40	0.14	1.4	–	–	–
WNMG 080404E-NF:T9325	0.4	250	0.18	1.7	150	0.16	1.7	235	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–
WNMG 080408E-NF:HF7	0.8	–	–	–	110	0.17	1.7	180	0.19	1.7	570	0.23	1.7	–	–	–	–	–	–
WNMG 080408E-NF:T6310	0.8	200	0.19	1.7	140	0.17	1.7	160	0.19	1.7	600	0.23	1.7	60	0.15	1.4	–	–	–
WNMG 080408E-NF:T7325	0.8	235	0.19	1.7	180	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–
WNMG 080408E-NF:T7335	0.8	225	0.19	1.7	175	0.17	1.7	–	–	–	–	–	–	70	0.15	1.4	–	–	–
WNMG 080408E-NF:T8315	0.8	215	0.19	1.7	125	0.17	1.7	200	0.19	1.7	645	0.23	1.7	50	0.15	1.4	–	–	–
WNMG 080408E-NF:T8430	0.8	235	0.19	1.7	125	0.17	1.7	190	0.19	1.7	645	0.23	1.7	50	0.15	1.4	–	–	–
WNMG 080408E-NF:T9325	0.8	285	0.19	1.7	170	0.17	1.7	270	0.19	1.7	–	–	–	60	0.15	1.4	–	–	–
WNMG 080408E-NF:T9415	0.8	360	0.19	1.7	–	–	–	340	0.19	1.7	–	–	–	–	–	–	–	–	–
WNMG 080412E-NF:T6310	1.2	185	0.30	2.1	130	0.27	2.1	145	0.30	2.1	555	0.36	2.1	55	0.21	1.7	–	–	–
WNMG 080412E-NF:T7325	1.2	205	0.30	2.1	155	0.27	2.1	–	–	–	–	–	–	65	0.21	1.7	–	–	–
WNMG 080412E-NF:T8430	1.2	200	0.30	2.1	110	0.27	2.1	165	0.30	2.1	555	0.36	2.1	40	0.21	1.7	–	–	–
WNMG 080412E-NF:T9415	1.2	315	0.30	2.1	–	–	–	295	0.30	2.1	–	–	–	–	–	–	–	–	–

FF

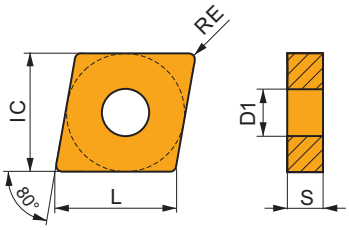


FF chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.

PRAMET

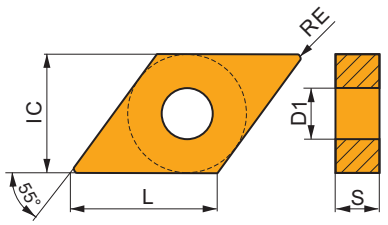
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



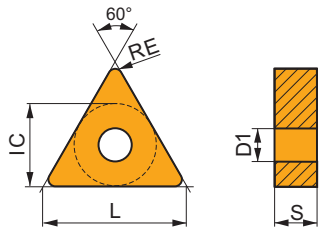
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



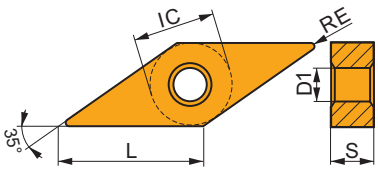
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



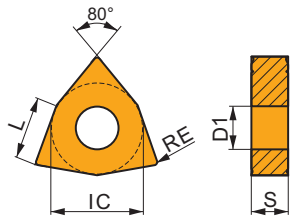
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

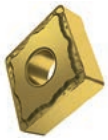
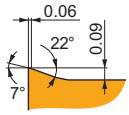


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



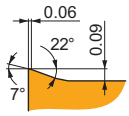
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
CNMG 120404E-FF:T7325	●	0.4	235	0.12	1.0	180	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120404E-FF:T8315	●	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
CNMG 120404E-FF:T8415	●	0.4	260	0.12	1.0	135	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T7325	●	0.8	265	0.15	1.0	205	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T8315	●	0.8	245	0.15	1.0	145	0.14	1.0	230	0.15	1.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-FF:T8415	●	0.8	300	0.15	1.0	155	0.14	1.0	270	0.15	1.0	–	–	–	–	–	–	–	–	–

FF chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.

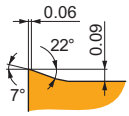
DNMG 110402E-FF:T8315	●	0.2	175	0.10	0.8	105	0.09	0.8	165	0.10	0.8	–	–	–	–	–	–	–	–	–
DNMG 110402E-FF:T8415	●	0.4	215	0.10	0.8	110	0.09	0.8	195	0.10	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8315	●	0.4	175	0.12	0.8	105	0.11	0.8	165	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8415	●	0.4	215	0.12	0.8	110	0.11	0.8	195	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110404E-FF:T8430	●	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	–	–	–	–	–	–	–	–	–
DNMG 110408E-FF:T8315	●	0.8	200	0.15	0.8	120	0.14	0.8	190	0.15	0.8	–	–	–	–	–	–	–	–	–
DNMG 110408E-FF:T8415	●	0.4	240	0.15	0.8	125	0.14	0.8	215	0.15	0.8	–	–	–	–	–	–	–	–	–
DNMG 150404E-FF:T8315	●	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150604E-FF:T8315	●	0.4	175	0.12	1.0	105	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150604E-FF:T8415	●	0.8	210	0.12	1.0	110	0.11	1.0	190	0.12	1.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T7325	●	0.8	210	0.15	1.0	160	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T8315	●	0.8	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-FF:T8415	●	0.8	240	0.15	1.0	125	0.14	1.0	215	0.15	1.0	–	–	–	–	–	–	–	–	–

FF chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.



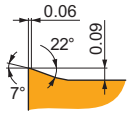
TNMG 160404E-FF:T7325	●	0.4	200	0.12	1.0	155	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8315	●	0.4	185	0.12	1.0	110	0.11	1.0	175	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8415	●	0.4	225	0.12	1.0	115	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160404E-FF:T8430	●	0.4	210	0.12	1.0	115	0.11	1.0	175	0.12	1.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-FF:T8315	●	0.8	205	0.15	1.0	120	0.14	1.0	190	0.15	1.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-FF:T8415	●	0.8	250	0.15	1.0	130	0.14	1.0	225	0.15	1.0	–	–	–	–	–	–	–	–	–

FF chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.



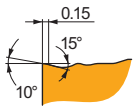
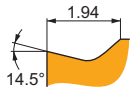
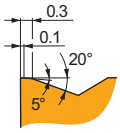
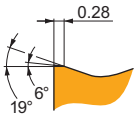
VNMG 160404E-FF:T7325	●	0.4	165	0.12	1.0	125	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8315	●	0.4	150	0.12	1.0	90	0.11	1.0	140	0.12	1.0	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8415	●	0.4	185	0.12	1.0	95	0.11	1.0	165	0.12	1.0	–	–	–	–	–	–	–	–	–
VNMG 160404E-FF:T8430	●	0.4	175	0.12	1.0	95	0.11	1.0	140	0.12	1.0	–	–	–	–	–	–	–	–	–

FF chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.

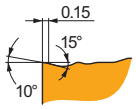


WNMG 060402E-FF:T8315	●	0.2	215	0.10	1.0	125	0.09	1.0	200	0.10	1.0	–	–	–	–	–	–	–	–	–
WNMG 060402E-FF:T8415	●	0.2	260	0.10	1.0	135	0.09	1.0	240	0.10	1.0	–	–	–	–	–	–	–	–	–
WNMG 060404E-FF:T8315	●	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 060404E-FF:T8415	●	0.4	260	0.12	1.0	135	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T7325	●	0.4	235	0.12	1.0	180	0.11	1.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T8315	●	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080404E-FF:T8415	●	0.4	260	0.12	1.0	135	0.11	1.0	240	0.12	1.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T7325	●	0.8	265	0.15	1.0	205	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T8315	●	0.8	245	0.15	1.0	145	0.14	1.0	230	0.15	1.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-FF:T8415	●	0.8	300	0.15	1.0	155	0.14	1.0	270	0.15	1.0	–	–	–	–	–	–	–	–	–

FINISHING – NAVIGATOR

FM			**FM** chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.
SF			**SF** chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.
W-M			**W-M** chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.
W-MR			**W-MR** chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.

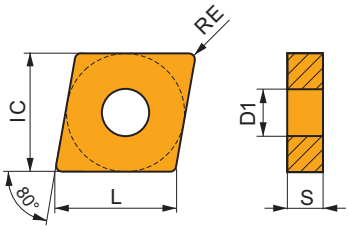
FM



FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

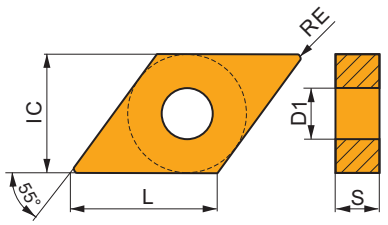
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76



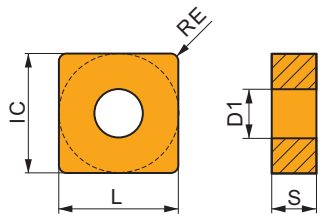
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



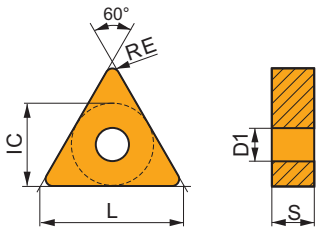
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



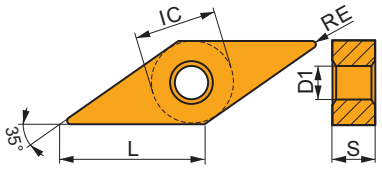
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



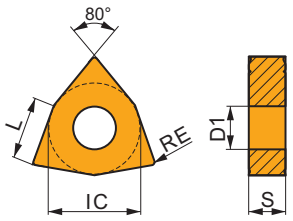
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

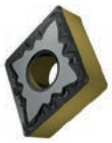
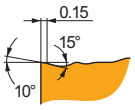
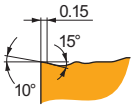


WNMG

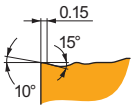
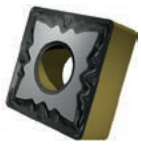
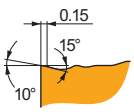
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
06T3	9.525	3.81	6.50	3.97
0804	12.700	5.16	8.70	4.76



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	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)	
	(mm)																								
 		**FM** chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																							
CNMG 090304E-FM:T8430	0.4	195	0.20	1.4		105	0.18	1.4		160	0.20	1.4		–	–	–		40	0.14	1.1		–	–	–	
CNMG 090304E-FM:T9325	0.4	240	0.20	1.4		140	0.18	1.4		225	0.20	1.4		–	–	–		50	0.16	1.1		–	–	–	
CNMG 090304E-FM:T9415	0.4	305	0.20	1.4		–	–	–		285	0.20	1.4		–	–	–		–	–	–		–	–	–	
CNMG 090308E-FM:T8430	0.8	235	0.20	1.4		125	0.18	1.4		190	0.20	1.4		–	–	–		50	0.14	1.1		–	–	–	
CNMG 090308E-FM:T9325	0.8	285	0.20	1.4		170	0.18	1.4		270	0.20	1.4		–	–	–		60	0.16	1.1		–	–	–	
CNMG 090308E-FM:T9415	0.8	365	0.20	1.4		–	–	–		345	0.20	1.4		–	–	–		–	–	–		–	–	–	
CNMG 120404E-FM:T7325	0.4	185	0.20	2.1		140	0.18	2.1		–	–	–		–	–	–		60	0.16	1.7		–	–	–	
CNMG 120404E-FM:T7335	0.4	180	0.20	2.1		140	0.18	2.1		–	–	–		–	–	–		55	0.16	1.7		–	–	–	
CNMG 120404E-FM:T8315	0.4	175	0.20	2.1		105	0.18	2.1		165	0.20	2.1		–	–	–		40	0.14	1.7		–	–	–	
CNMG 120404E-FM:T8415	0.4	215	0.20	2.1		110	0.18	2.1		195	0.20	2.1		–	–	–		45	0.14	1.7		–	–	–	
CNMG 120404E-FM:T8430	0.4	190	0.20	2.1		105	0.18	2.1		155	0.20	2.1		–	–	–		40	0.14	1.7		–	–	–	
CNMG 120404E-FM:T9325	0.4	230	0.20	2.1		135	0.18	2.1		215	0.20	2.1		–	–	–		50	0.16	1.7		–	–	–	
CNMG 120404E-FM:T9415	0.4	290	0.20	2.1		–	–	–		275	0.20	2.1		–	–	–		–	–	–		–	–	–	
CNMG 120404E-FM:TT310	0.4	260	0.20	2.1		155	0.18	2.1		–	–	–		–	–	–		–	–	–		–	–	–	
CNMG 120408E-FM:T7325	0.8	220	0.20	2.1		170	0.18	2.1		–	–	–		–	–	–		70	0.16	1.7		–	–	–	
CNMG 120408E-FM:T7335	0.8	215	0.20	2.1		165	0.18	2.1		–	–	–		–	–	–		65	0.16	1.7		–	–	–	
CNMG 120408E-FM:T8315	0.8	205	0.20	2.1		120	0.18	2.1		190	0.20	2.1		–	–	–		50	0.16	1.7		–	–	–	
CNMG 120408E-FM:T8415	0.8	250	0.20	2.1		130	0.18	2.1		225	0.20	2.1		–	–	–		55	0.16	1.7		–	–	–	
CNMG 120408E-FM:T8430	0.8	225	0.20	2.1		120	0.18	2.1		185	0.20	2.1		–	–	–		45	0.16	1.7		–	–	–	
CNMG 120408E-FM:T9310	0.8	335	0.20	2.1		–	–	–		315	0.20	2.1		–	–	–		–	–	–		–	–	–	
CNMG 120408E-FM:T9315	0.8	305	0.20	2.1		–	–	–		285	0.20	2.1		–	–	–		–	–	–		–	–	–	
CNMG 120408E-FM:T9325	0.8	275	0.20	2.1		165	0.18	2.1		260	0.20	2.1		–	–	–		60	0.16	1.7		–	–	–	
CNMG 120408E-FM:T9415	0.8	350	0.20	2.1		–	–	–		330	0.20	2.1		–	–	–		–	–	–		–	–	–	
CNMG 120408E-FM:TT310	0.8	310	0.20	2.1		185	0.18	2.1		–	–	–		–	–	–		–	–	–		–	–	–	
CNMG 120412E-FM:T7325	1.2	210	0.27	2.1		160	0.24	2.1		–	–	–		–	–	–		65	0.19	1.7		–	–	–	
CNMG 120412E-FM:T9325	1.2	255	0.27	2.1		150	0.24	2.1		240	0.27	2.1		–	–	–		55	0.19	1.7		–	–	–	
CNMG 120412E-FM:T9415	1.2	330	0.27	2.1		–	–	–		310	0.27	2.1		–	–	–		–	–	–		–	–	–	
 		**FM** chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																							
DNMG 110404E-FM:T8315	0.4	150	0.20	0.8		90	0.18	0.8		140	0.20	0.8		–	–	–		35	0.14	0.6		–	–	–	
DNMG 110404E-FM:T8415	0.4	185	0.20	0.8		95	0.18	0.8		165	0.20	0.8		–	–	–		40	0.14	0.6		–	–	–	
DNMG 110404E-FM:T8430	0.4	165	0.20	0.8		90	0.18	0.8		135	0.20	0.8		–	–	–		35	0.14	0.6		–	–	–	
DNMG 110404E-FM:T9325	0.4	200	0.20	0.8		120	0.18	0.8		190	0.20	0.8		–	–	–		45	0.20	0.6		–	–	–	
DNMG 110404E-FM:T9415	0.4	260	0.20	0.8		–	–	–		245	0.20	0.8		–	–	–		–	–	–		–	–	–	
DNMG 110408E-FM:T7325	0.8	200	0.20	0.8		155	0.18	0.8		–	–	–		–	–	–		65	0.16	0.6		–	–	–	
DNMG 110408E-FM:T8315	0.8	180	0.20	0.8		105	0.18	0.8		170	0.20	0.8		–	–	–		45	0.14	0.6		–	–	–	
DNMG 110408E-FM:T8415	0.8	220	0.20	0.8		115	0.18	0.8		200	0.20	0.8		–	–	–		50	0.14	0.6		–	–	–	
DNMG 110408E-FM:T8430	0.8	195	0.20	0.8		105	0.18	0.8		160	0.20	0.8		–	–	–		40	0.14	0.6		–	–	–	
DNMG 110408E-FM:T9310	0.8	295	0.20	0.8		–	–	–		280	0.20	0.8		–	–	–		–	–	–		–	–	–	
DNMG 110408E-FM:T9325	0.8	240	0.20	0.8		140	0.18	0.8		225	0.20	0.8		–	–	–		50	0.16	0.6		–	–	–	
DNMG 110408E-FM:T9415	0.8	305	0.20	0.8		–	–	–		285	0.20	0.8		–	–	–		–	–	–		–	–	–	
DNMG 150404E-FM:T7325	0.4	150	0.20	1.7		115	0.18	1.7		–	–	–		–	–	–		45	0.20	1.4		–	–	–	
DNMG 150404E-FM:T8430	0.4	150	0.20	1.7		80	0.18	1.7		125	0.20	1.7		–	–	–		30	0.14	1.4		–	–	–	
DNMG 150404E-FM:T9325	0.4	190	0.20	1.7		110	0.18	1.7		180	0.20	1.7		–	–	–		40	0.20	1.4		–	–	–	
DNMG 150404E-FM:T9415	0.4	235	0.20	1.7		–	–	–		220	0.20	1.7		–	–	–		–	–	–		–	–	–	
DNMG 150408E-FM:T7325	0.8	180	0.20	1.7		140	0.18	1.7		–	–	–		–	–	–		55	0.16	1.4		–	–	–	
DNMG 150408E-FM:T8430	0.8	185	0.20	1.7		100	0.18	1.7		150	0.20	1.7		–	–	–		40	0.16	1.4		–	–	–	
DNMG 150408E-FM:T9325	0.8	225	0.20	1.7		135	0.18	1.7		210	0.20	1.7		–	–	–		50	0.16	1.4		–	–	–	
DNMG 150408E-FM:T9415	0.8	280	0.20	1.7		–	–	–		265	0.20	1.7		–	–	–		–	–	–		–	–	–	

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																			
DNMG 150604E-FM:T7325	● 0.4	◪ 150	0.20	1.7	◪ 115	0.18	1.7	–	–	–	–	–	–	◪ 45	0.20	1.4	–	–	–
DNMG 150604E-FM:T7335	● 0.4	◪ 150	0.20	1.7	◪ 115	0.18	1.7	–	–	–	–	–	–	◪ 45	0.20	1.4	–	–	–
DNMG 150604E-FM:T8315	● 0.4	◪ 140	0.20	1.7	◪ 80	0.18	1.7	■ 130	0.20	1.7	–	–	–	◪ 35	0.14	1.4	–	–	–
DNMG 150604E-FM:T8415	● 0.4	■ 170	0.20	1.7	◪ 90	0.18	1.7	■ 155	0.20	1.7	–	–	–	◪ 35	0.14	1.4	–	–	–
DNMG 150604E-FM:T8430	● 0.4	■ 150	0.20	1.7	◪ 80	0.18	1.7	◪ 125	0.20	1.7	–	–	–	◪ 30	0.14	1.4	–	–	–
DNMG 150604E-FM:T9310	● 0.4	■ 230	0.20	1.7	–	–	–	◪ 215	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150604E-FM:T9315	● 0.4	■ 210	0.20	1.7	–	–	–	◪ 195	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150604E-FM:T9325	● 0.4	■ 190	0.20	1.7	◪ 110	0.18	1.7	◪ 180	0.20	1.7	–	–	–	◪ 40	0.20	1.4	–	–	–
DNMG 150604E-FM:T9415	● 0.4	■ 235	0.20	1.7	–	–	–	◪ 220	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T7325	● 0.8	◪ 180	0.20	1.7	◪ 140	0.18	1.7	–	–	–	–	–	–	◪ 55	0.16	1.4	–	–	–
DNMG 150608E-FM:T7335	● 0.8	◪ 175	0.20	1.7	◪ 135	0.18	1.7	–	–	–	–	–	–	◪ 55	0.16	1.4	–	–	–
DNMG 150608E-FM:T8315	● 0.8	◪ 170	0.20	1.7	◪ 100	0.18	1.7	■ 160	0.20	1.7	–	–	–	◪ 40	0.16	1.4	–	–	–
DNMG 150608E-FM:T8415	● 0.8	■ 210	0.20	1.7	◪ 110	0.18	1.7	■ 190	0.20	1.7	–	–	–	◪ 45	0.16	1.4	–	–	–
DNMG 150608E-FM:T8430	● 0.8	■ 185	0.20	1.7	◪ 100	0.18	1.7	◪ 150	0.20	1.7	–	–	–	◪ 40	0.16	1.4	–	–	–
DNMG 150608E-FM:T9310	● 0.8	■ 275	0.20	1.7	–	–	–	◪ 260	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T9315	● 0.8	■ 250	0.20	1.7	–	–	–	◪ 235	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150608E-FM:T9325	● 0.8	■ 225	0.20	1.7	◪ 135	0.18	1.7	◪ 210	0.20	1.7	–	–	–	◪ 50	0.16	1.4	–	–	–
DNMG 150608E-FM:T9415	● 0.8	■ 280	0.20	1.7	–	–	–	◪ 265	0.20	1.7	–	–	–	–	–	–	–	–	–
DNMG 150612E-FM:T7325	● 1.2	◪ 180	0.25	1.7	◪ 140	0.23	1.7	–	–	–	–	–	–	◪ 55	0.18	1.4	–	–	–
DNMG 150612E-FM:T8430	⬢ 1.2	■ 175	0.25	1.7	◪ 95	0.23	1.7	◪ 140	0.25	1.7	–	–	–	◪ 35	0.18	1.4	–	–	–
DNMG 150612E-FM:T9315	● 1.2	■ 240	0.25	1.7	–	–	–	◪ 225	0.25	1.7	–	–	–	–	–	–	–	–	–
DNMG 150612E-FM:T9325	● 1.2	■ 215	0.25	1.7	◪ 125	0.23	1.7	◪ 200	0.25	1.7	–	–	–	◪ 45	0.18	1.4	–	–	–
DNMG 150612E-FM:T9415	● 1.2	■ 275	0.25	1.7	–	–	–	◪ 260	0.25	1.7	–	–	–	–	–	–	–	–	–
DNMG 150616E-FM:T9315	● 1.6	■ 235	0.30	1.7	–	–	–	◪ 220	0.30	1.7	–	–	–	–	–	–	–	–	–
DNMG 150616E-FM:T9325	● 1.6	■ 210	0.30	1.7	◪ 125	0.27	1.7	◪ 195	0.30	1.7	–	–	–	◪ 45	0.21	1.4	–	–	–
DNMG 150616E-FM:T9415	● 1.6	■ 270	0.30	1.7	–	–	–	◪ 255	0.30	1.7	–	–	–	–	–	–	–	–	–
 																			
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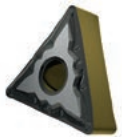
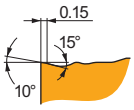
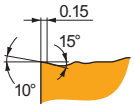
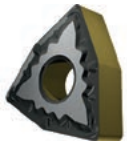
SNMG 120404E-FM:T6310	● 0.4	■ 175	0.20	2.1	◪ 125	0.18	2.1	■ 140	0.20	2.1	–	–	–	◪ 50	0.14	1.7	–	–	–
SNMG 120404E-FM:T7325	● 0.4	◪ 195	0.20	2.1	◪ 150	0.18	2.1	–	–	–	–	–	–	◪ 60	0.16	1.7	–	–	–
SNMG 120404E-FM:T8315	● 0.4	◪ 180	0.20	2.1	◪ 105	0.18	2.1	■ 170	0.20	2.1	–	–	–	◪ 45	0.14	1.7	–	–	–
SNMG 120404E-FM:T8415	● 0.4	■ 220	0.20	2.1	◪ 115	0.18	2.1	■ 200	0.20	2.1	–	–	–	◪ 50	0.14	1.7	–	–	–
SNMG 120404E-FM:T8430	● 0.4	■ 195	0.20	2.1	◪ 105	0.18	2.1	◪ 160	0.20	2.1	–	–	–	◪ 40	0.14	1.7	–	–	–
SNMG 120404E-FM:T9325	● 0.4	■ 240	0.20	2.1	◪ 140	0.18	2.1	◪ 225	0.20	2.1	–	–	–	◪ 50	0.16	1.7	–	–	–
SNMG 120404E-FM:T9415	● 0.4	■ 305	0.20	2.1	–	–	–	◪ 285	0.20	2.1	–	–	–	–	–	–	–	–	–
SNMG 120408E-FM:T7325	⬢ 0.8	◪ 235	0.20	2.1	◪ 180	0.18	2.1	–	–	–	–	–	–	◪ 75	0.16	1.7	–	–	–
SNMG 120408E-FM:T8315	⬢ 0.8	◪ 215	0.20	2.1	◪ 125	0.18	2.1	■ 200	0.20	2.1	–	–	–	◪ 50	0.16	1.7	–	–	–
SNMG 120408E-FM:T8415	⬢ 0.8	■ 260	0.20	2.1	◪ 135	0.18	2.1	■ 240	0.20	2.1	–	–	–	◪ 60	0.16	1.7	–	–	–
SNMG 120408E-FM:T8430	⬢ 0.8	■ 235	0.20	2.1	◪ 125	0.18	2.1	◪ 190	0.20	2.1	–	–	–	◪ 50	0.16	1.7	–	–	–
SNMG 120408E-FM:T9325	⬢ 0.8	■ 290	0.20	2.1	◪ 170	0.18	2.1	◪ 275	0.20	2.1	–	–	–	◪ 65	0.16	1.7	–	–	–
SNMG 120408E-FM:T9415	● 0.8	■ 365	0.20	2.1	–	–	–	◪ 345	0.20	2.1	–	–	–	–	–	–	–	–	–
SNMG 120412E-FM:T8430	⬢ 1.2	■ 220	0.27	2.1	◪ 120	0.24	2.1	◪ 180	0.27	2.1	–	–	–	◪ 45	0.19	1.7	–	–	–
SNMG 120412E-FM:T9325	⬢ 1.2	■ 270	0.27	2.1	◪ 160	0.24	2.1	◪ 255	0.27	2.1	–	–	–	◪ 60	0.19	1.7	–	–	–
SNMG 120412E-FM:T9415	⬢ 1.2	■ 345	0.27	2.1	–	–	–	◪ 325	0.27	2.1	–	–	–	–	–	–	–	–	–
SNMG 120416E-FM:T8430	⬢ 1.6	■ 220	0.32	2.1	◪ 120	0.29	2.1	◪ 180	0.32	2.1	–	–	–	◪ 45	0.22	1.7	–	–	–

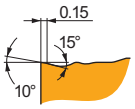
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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 chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																				
TNMG 160404E-FM:T7325	●	0.4	◪	160	0.20	1.7	◪	120	0.18	1.7		–	–	–	–	–	–	◪	50	0.20	1.4	–	–	–
TNMG 160404E-FM:T7335	●	0.4	◪	160	0.20	1.7	◪	120	0.18	1.7		–	–	–	–	–	–	◪	50	0.20	1.4	–	–	–
TNMG 160404E-FM:T8315	●	0.4	◪	150	0.20	1.7	◪	90	0.18	1.7	■	140	0.20	1.7	–	–	–	◪	35	0.14	1.4	–	–	–
TNMG 160404E-FM:T8415	●	0.4	■	185	0.20	1.7	◪	95	0.18	1.7	■	165	0.20	1.7	–	–	–	◪	40	0.14	1.4	–	–	–
TNMG 160404E-FM:T8430	●	0.4	■	165	0.20	1.7	◪	90	0.18	1.7	◪	135	0.20	1.7	–	–	–	◪	35	0.14	1.4	–	–	–
TNMG 160404E-FM:T9325	●	0.4	■	200	0.20	1.7	◪	120	0.18	1.7	◪	190	0.20	1.7	–	–	–	◪	45	0.20	1.4	–	–	–
TNMG 160404E-FM:T9415	●	0.4	■	250	0.20	1.7		–	–	–	◪	235	0.20	1.7	–	–	–		–	–	–	–	–	–
TNMG 160404E-FM:TT310	●	0.4	■	225	0.20	1.7	◪	135	0.18	1.7		–	–	–	–	–	–		–	–	–	–	–	–
TNMG 160408E-FM:T7325	●	0.8	◪	195	0.20	1.7	◪	150	0.18	1.7		–	–	–	–	–	–	◪	60	0.16	1.4	–	–	–
TNMG 160408E-FM:T7335	●	0.8	◪	190	0.20	1.7	◪	145	0.18	1.7		–	–	–	–	–	–	◪	60	0.16	1.4	–	–	–
TNMG 160408E-FM:T8315	●	0.8	◪	180	0.20	1.7	◪	105	0.18	1.7	■	170	0.20	1.7	–	–	–	◪	45	0.16	1.4	–	–	–
TNMG 160408E-FM:T8415	●	0.8	■	220	0.20	1.7	◪	115	0.18	1.7	■	200	0.20	1.7	–	–	–	◪	50	0.16	1.4	–	–	–
TNMG 160408E-FM:T8430	●	0.8	■	195	0.20	1.7	◪	105	0.18	1.7	◪	160	0.20	1.7	–	–	–	◪	40	0.16	1.4	–	–	–
TNMG 160408E-FM:T9310	●	0.8	■	290	0.20	1.7		–	–	–	◪	275	0.20	1.7	–	–	–		–	–	–	–	–	–
TNMG 160408E-FM:T9325	●	0.8	■	235	0.20	1.7	◪	140	0.18	1.7	◪	220	0.20	1.7	–	–	–	◪	50	0.16	1.4	–	–	–
TNMG 160408E-FM:T9415	●	0.8	■	300	0.20	1.7		–	–	–	◪	285	0.20	1.7	–	–	–		–	–	–	–	–	–
TNMG 160408E-FM:TT310	●	0.8	■	270	0.20	1.7	◪	160	0.18	1.7		–	–	–	–	–	–		–	–	–	–	–	–
TNMG 160412E-FM:T8430	●	1.2	■	185	0.25	1.7	◪	100	0.23	1.7	◪	150	0.25	1.7	–	–	–	◪	40	0.18	1.4	–	–	–
TNMG 160412E-FM:T9325	●	1.2	■	225	0.25	1.7	◪	135	0.23	1.7	◪	210	0.25	1.7	–	–	–	◪	50	0.18	1.4	–	–	–
TNMG 160412E-FM:T9415	●	1.2	■	290	0.25	1.7		–	–	–	◪	275	0.25	1.7	–	–	–		–	–	–	–	–	–
TNMG 220404E-FM:T8430	●	0.4	■	165	0.20	1.7	◪	90	0.18	1.7	◪	135	0.20	1.7	–	–	–	◪	35	0.18	1.4	–	–	–
TNMG 220404E-FM:T9325	●	0.4	■	200	0.20	1.7	◪	120	0.18	1.7	◪	190	0.20	1.7	–	–	–	◪	45	0.18	1.4	–	–	–
TNMG 220404E-FM:T9415	●	0.4	■	250	0.20	1.7		–	–	–	◪	235	0.20	1.7	–	–	–		–	–	–	–	–	–
TNMG 220408E-FM:T8430	●	0.8	■	195	0.20	1.7	◪	105	0.18	1.7	◪	160	0.20	1.7	–	–	–	◪	40	0.16	1.4	–	–	–
TNMG 220408E-FM:T9325	●	0.8	■	235	0.20	1.7	◪	140	0.18	1.7	◪	220	0.20	1.7	–	–	–	◪	50	0.16	1.4	–	–	–
TNMG 220408E-FM:T9415	●	0.8	■	300	0.20	1.7		–	–	–	◪	285	0.20	1.7	–	–	–		–	–	–	–	–	–
																				
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																				
VNMG 160404E-FM:T7325	●	0.4	◪	140	0.20	1.2	◪	105	0.18	1.2		–	–	–	–	–	–	◪	45	0.20	1.0	–	–	–
VNMG 160404E-FM:T8430	●	0.4	■	135	0.20	1.2	◪	75	0.18	1.2	◪	110	0.20	1.2	–	–	–	◪	25	0.14	1.0	–	–	–
VNMG 160404E-FM:T9315	●	0.4	■	190	0.20	1.2		–	–	–	◪	180	0.20	1.2	–	–	–		–	–	–	–	–	–
VNMG 160404E-FM:T9325	●	0.4	■	170	0.20	1.2	◪	100	0.18	1.2	◪	160	0.20	1.2	–	–	–	◪	35	0.20	1.0	–	–	–
VNMG 160404E-FM:T9415	●	0.4	■	215	0.20	1.2		–	–	–	◪	200	0.20	1.2	–	–	–		–	–	–	–	–	–
VNMG 160408E-FM:T7325	●	0.8	◪	160	0.20	1.4	◪	120	0.18	1.4		–	–	–	–	–	–	◪	50	0.16	1.1	–	–	–
VNMG 160408E-FM:T8430	●	0.8	■	165	0.20	1.4	◪	90	0.18	1.4	◪	135	0.20	1.4	–	–	–	◪	35	0.16	1.1	–	–	–
VNMG 160408E-FM:T9315	●	0.8	■	220	0.20	1.4		–	–	–	◪	205	0.20	1.4	–	–	–		–	–	–	–	–	–
VNMG 160408E-FM:T9325	●	0.8	■	200	0.20	1.4	◪	120	0.18	1.4	◪	190	0.20	1.4	–	–	–	◪	45	0.16	1.1	–	–	–
VNMG 160408E-FM:T9415	●	0.8	■	255	0.20	1.4		–	–	–	◪	240	0.20	1.4	–	–	–		–	–	–	–	–	–
VNMG 160412E-FM:T8430	●	1.2	■	165	0.22	1.4	◪	90	0.20	1.4	◪	135	0.22	1.4	–	–	–	◪	35	0.18	1.1	–	–	–
VNMG 160412E-FM:T9315	●	1.2	■	225	0.22	1.4		–	–	–	◪	210	0.22	1.4	–	–	–		–	–	–	–	–	–
VNMG 160412E-FM:T9325	●	1.2	■	200	0.22	1.4	◪	120	0.20	1.4	◪	190	0.22	1.4	–	–	–	◪	45	0.18	1.1	–	–	–
VNMG 160412E-FM:T9415	●	1.2	■	255	0.22	1.4		–	–	–	◪	240	0.22	1.4	–	–	–		–	–	–	–	–	–

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	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)
	(mm)																		

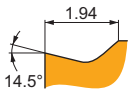




FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

WNMG 060404E-FM:T7325	●	0.4	◪	195	0.20	1.4	◪	150	0.18	1.4		–	–	–	–	–	–	◪	60	0.16	1.1	–	–	–
WNMG 060404E-FM:T8315	●	0.4	◪	180	0.20	1.4	◪	105	0.18	1.4	■	170	0.20	1.4	–	–	–	◪	45	0.14	1.1	–	–	–
WNMG 060404E-FM:T8415	●	0.4	■	220	0.20	1.4	◪	115	0.18	1.4	■	200	0.20	1.4	–	–	–	◪	50	0.14	1.1	–	–	–
WNMG 060404E-FM:T8430	●	0.4	■	195	0.20	1.4	◪	105	0.18	1.4	◪	160	0.20	1.4	–	–	–	◪	40	0.14	1.1	–	–	–
WNMG 060404E-FM:T9325	●	0.4	■	240	0.20	1.4	◪	140	0.18	1.4	◪	225	0.20	1.4	–	–	–	◪	50	0.16	1.1	–	–	–
WNMG 060404E-FM:T9415	●	0.4	■	305	0.20	1.4		–	–	–	◪	285	0.20	1.4	–	–	–		–	–	–	–	–	–
WNMG 060404E-FM:TT310	●	0.4	■	275	0.20	1.4	◪	165	0.18	1.4		–	–	–	–	–	–		–	–	–	–	–	–
WNMG 060408E-FM:T7325	●●	0.8	◪	235	0.20	1.4	◪	180	0.18	1.4		–	–	–	–	–	–	◪	75	0.16	1.1	–	–	–
WNMG 060408E-FM:T8430	●●	0.8	■	235	0.20	1.4	◪	125	0.18	1.4	◪	190	0.20	1.4	–	–	–	◪	50	0.14	1.1	–	–	–
WNMG 060408E-FM:T9315	●	0.8	■	315	0.20	1.4		–	–	–	◪	295	0.20	1.4	–	–	–		–	–	–	–	–	–
WNMG 060408E-FM:T9325	●	0.8	■	285	0.20	1.4	◪	170	0.18	1.4	◪	270	0.20	1.4	–	–	–	◪	60	0.16	1.1	–	–	–
WNMG 060408E-FM:T9415	●	0.8	■	365	0.20	1.4		–	–	–	◪	345	0.20	1.4	–	–	–		–	–	–	–	–	–
WNMG 060412E-FM:T9415	●●	1.2	■	350	0.27	1.2		–	–	–	◪	330	0.27	1.2	–	–	–		–	–	–	–	–	–
WNMG 06T304E-FM:T8430	●	0.4	■	195	0.20	1.4	◪	105	0.18	1.4	◪	160	0.20	1.4	–	–	–	◪	40	0.14	1.1	–	–	–
WNMG 06T304E-FM:T9325	●	0.4	■	240	0.20	1.4	◪	140	0.18	1.4	◪	225	0.20	1.4	–	–	–	◪	50	0.16	1.1	–	–	–
WNMG 06T308E-FM:T8430	●●	0.8	■	235	0.20	1.4	◪	125	0.18	1.4	◪	190	0.20	1.4	–	–	–	◪	50	0.14	1.1	–	–	–
WNMG 06T308E-FM:T9325	●	0.8	■	285	0.20	1.4	◪	170	0.18	1.4	◪	270	0.20	1.4	–	–	–	◪	60	0.16	1.1	–	–	–
WNMG 080404E-FM:T7325	●	0.4	◪	190	0.20	1.9	◪	145	0.18	1.9		–	–	–	–	–	–	◪	60	0.16	1.5	–	–	–
WNMG 080404E-FM:T7335	●	0.4	◪	180	0.20	1.9	◪	140	0.18	1.9		–	–	–	–	–	–	◪	55	0.16	1.5	–	–	–
WNMG 080404E-FM:T8315	●	0.4	◪	180	0.20	1.9	◪	105	0.18	1.9	■	170	0.20	1.9	–	–	–	◪	45	0.14	1.5	–	–	–
WNMG 080404E-FM:T8415	●	0.4	■	215	0.20	1.9	◪	110	0.18	1.9	■	195	0.20	1.9	–	–	–	◪	45	0.14	1.5	–	–	–
WNMG 080404E-FM:T8430	●	0.4	■	190	0.20	1.9	◪	105	0.18	1.9	◪	155	0.20	1.9	–	–	–	◪	40	0.14	1.5	–	–	–
WNMG 080404E-FM:T9325	●	0.4	■	245	0.20	1.2	◪	145	0.18	1.2	◪	230	0.20	1.2	–	–	–	◪	55	0.16	1.0	–	–	–
WNMG 080404E-FM:T9415	●	0.4	■	310	0.20	1.2		–	–	–	◪	290	0.20	1.2	–	–	–		–	–	–	–	–	–
WNMG 080408E-FM:T7325	●●	0.8	◪	225	0.20	1.9	◪	175	0.18	1.9		–	–	–	–	–	–	◪	70	0.16	1.5	–	–	–
WNMG 080408E-FM:T7335	●●	0.8	◪	215	0.20	1.9	◪	165	0.18	1.9		–	–	–	–	–	–	◪	65	0.16	1.5	–	–	–
WNMG 080408E-FM:T8315	●●	0.8	◪	210	0.20	1.9	◪	125	0.18	1.9	■	195	0.20	1.9	–	–	–	◪	50	0.16	1.5	–	–	–
WNMG 080408E-FM:T8415	●●	0.8	■	250	0.20	1.9	◪	130	0.18	1.9	■	225	0.20	1.9	–	–	–	◪	55	0.16	1.5	–	–	–
WNMG 080408E-FM:T8430	●●	0.8	■	225	0.20	1.9	◪	120	0.18	1.9	◪	185	0.20	1.9	–	–	–	◪	45	0.16	1.5	–	–	–
WNMG 080408E-FM:T9325	●	0.8	■	280	0.20	1.9	◪	165	0.18	1.9	◪	265	0.20	1.9	–	–	–	◪	60	0.16	1.5	–	–	–
WNMG 080408E-FM:T9415	●	0.8	■	350	0.20	1.9		–	–	–	◪	330	0.20	1.9	–	–	–		–	–	–	–	–	–
WNMG 080412E-FM:T7325	●●	1.2	◪	220	0.27	1.9	◪	170	0.24	1.9		–	–	–	–	–	–	◪	70	0.19	1.5	–	–	–
WNMG 080412E-FM:T7335	●●	1.2	◪	205	0.27	1.9	◪	155	0.24	1.9		–	–	–	–	–	–	◪	65	0.19	1.5	–	–	–
WNMG 080412E-FM:T8430	●●	1.2	■	210	0.27	1.9	◪	115	0.24	1.9	◪	175	0.27	1.9	–	–	–	◪	45	0.19	1.5	–	–	–
WNMG 080412E-FM:T9310	●●	1.2	■	310	0.27	1.9		–	–	–	◪	290	0.27	1.9	–	–	–		–	–	–	–	–	–
WNMG 080412E-FM:T9325	●●	1.2	■	255	0.27	1.9	◪	150	0.24	1.9	◪	240	0.27	1.9	–	–	–	◪	55	0.19	1.5	–	–	–
WNMG 080412E-FM:T9415	●●	1.2	■	335	0.27	1.9		–	–	–	◪	315	0.27	1.9	–	–	–		–	–	–	–	–	–

SF

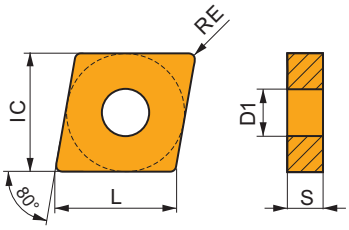


SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.

PRAMET

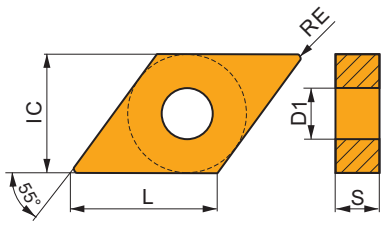
CNGG / CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



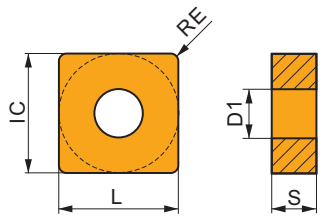
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



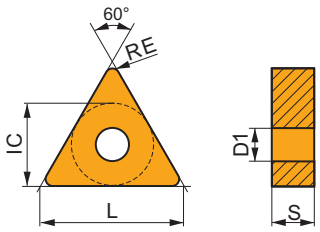
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



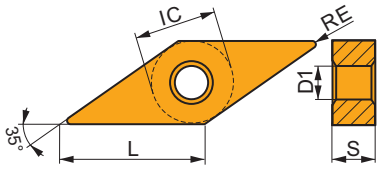
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



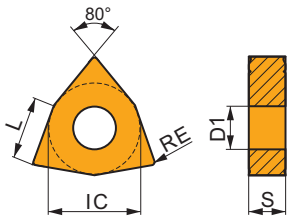
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

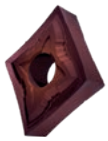
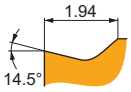
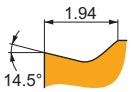


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.																			
CNGG 120402E-SF:H07	0.2	–	–	–	105	0.09	1.0	165	0.10	1.0	525	0.12	1.0	50	0.08	0.8	–	–	–
CNGG 120402E-SF:T6310	0.2	195	0.10	1.0	140	0.09	1.0	155	0.10	1.0	585	0.12	1.0	55	0.08	0.8	35	0.10	0.2
CNGG 120402E-SF:T8315	0.2	205	0.10	1.0	120	0.09	1.0	190	0.10	1.0	615	0.12	1.0	50	0.08	0.8	40	0.10	0.2
CNGG 120402E-SF:T8415	0.2	250	0.10	1.0	130	0.09	1.0	225	0.10	1.0	630	0.12	1.0	55	0.08	0.8	40	0.10	0.2
CNGG 120402E-SF:T8430	0.2	240	0.10	1.0	130	0.09	1.0	195	0.10	1.0	660	0.12	1.0	50	0.08	0.8	40	0.10	0.2
  																			
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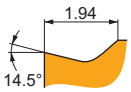
CNMG 120404E-SF:H07	0.4	–	–	–	90	0.14	1.0	145	0.15	1.0	470	0.18	1.0	45	0.12	0.8	–	–	–
CNMG 120404E-SF:T6310	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.11	0.3
CNMG 120404E-SF:T7325	0.4	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
CNMG 120404E-SF:T8315	0.4	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	585	0.18	1.0	45	0.12	0.8	35	0.11	0.3
CNMG 120404E-SF:T8415	0.4	240	0.15	1.0	125	0.14	1.0	215	0.15	1.0	600	0.18	1.0	55	0.12	0.8	40	0.10	0.3
CNMG 120404E-SF:T8430	0.4	220	0.15	1.0	120	0.14	1.0	180	0.15	1.0	600	0.18	1.0	45	0.12	0.8	35	0.11	0.3
CNMG 120404E-SF:T9325	0.4	255	0.17	1.0	150	0.15	1.0	240	0.17	1.0	–	–	–	55	0.15	0.8	–	–	–
CNMG 120404E-SF:T9415	0.4	315	0.17	1.0	–	–	–	295	0.17	1.0	–	–	–	–	–	–	60	0.13	0.3
CNMG 120408E-SF:H07	0.8	–	–	–	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.15	0.8	–	–	–
CNMG 120408E-SF:T6310	0.8	200	0.20	1.0	140	0.18	1.0	160	0.20	1.0	600	0.24	1.0	60	0.14	0.8	40	0.10	0.7
CNMG 120408E-SF:T7325	0.8	230	0.20	1.0	175	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
CNMG 120408E-SF:T7335	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
CNMG 120408E-SF:T8315	0.8	210	0.20	1.0	125	0.18	1.0	195	0.20	1.0	630	0.24	1.0	50	0.14	0.8	40	0.10	0.7
CNMG 120408E-SF:T8415	0.8	255	0.20	1.0	135	0.18	1.0	230	0.20	1.0	645	0.24	1.0	55	0.14	0.8	45	0.10	0.7
CNMG 120408E-SF:T8430	0.8	230	0.20	1.0	125	0.18	1.0	185	0.20	1.0	630	0.24	1.0	45	0.14	0.8	35	0.10	0.7
CNMG 120408E-SF:T9325	0.8	280	0.20	1.0	165	0.18	1.0	265	0.20	1.0	–	–	–	60	0.16	0.8	–	–	–
CNMG 120412E-SF:T6310	1.2	190	0.25	1.5	135	0.23	1.5	150	0.25	1.5	570	0.30	1.5	55	0.18	1.2	35	0.13	1.0
CNMG 120412E-SF:T8315	1.2	200	0.25	1.5	120	0.23	1.5	190	0.25	1.5	600	0.30	1.5	50	0.18	1.2	40	0.13	1.0
CNMG 120412E-SF:T8415	1.2	250	0.25	1.5	130	0.23	1.5	225	0.25	1.5	630	0.30	1.5	55	0.17	1.2	40	0.13	1.0
CNMG 120412E-SF:T8430	1.2	210	0.25	1.5	115	0.23	1.5	175	0.25	1.5	585	0.30	1.5	45	0.18	1.2	35	0.13	1.0
  																			
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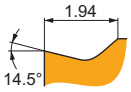
DNMG 110404E-SF:T6310	0.4	150	0.15	0.8	105	0.14	0.8	120	0.15	0.8	450	0.18	0.8	45	0.12	0.6	30	0.11	0.3
DNMG 110404E-SF:T8315	0.4	160	0.15	0.8	95	0.14	0.8	150	0.15	0.8	480	0.18	0.8	40	0.12	0.6	30	0.11	0.3
DNMG 110404E-SF:T8415	0.4	190	0.15	0.8	100	0.14	0.8	170	0.15	0.8	480	0.18	0.8	40	0.12	0.6	30	0.10	0.3
DNMG 110404E-SF:T8430	0.4	180	0.15	0.8	95	0.14	0.8	145	0.15	0.8	495	0.18	0.8	35	0.12	0.6	30	0.11	0.3
DNMG 110408E-SF:T6310	0.8	175	0.17	0.8	125	0.15	0.8	140	0.17	0.8	525	0.20	0.8	50	0.14	0.6	35	0.11	0.7
DNMG 110408E-SF:T8415	0.8	220	0.17	0.8	115	0.15	0.8	200	0.17	0.8	555	0.20	0.8	50	0.14	0.6	35	0.11	0.7
DNMG 110408E-SF:T8430	0.8	200	0.17	0.8	110	0.15	0.8	165	0.17	0.8	555	0.20	0.8	40	0.14	0.6	35	0.11	0.7
DNMG 150404E-SF:T6310	0.4	140	0.15	1.5	100	0.14	1.5	110	0.15	1.5	420	0.18	1.5	40	0.12	1.2	25	0.11	0.3
DNMG 150404E-SF:T8315	0.4	150	0.15	1.5	90	0.14	1.5	140	0.15	1.5	450	0.18	1.5	35	0.12	1.2	30	0.11	0.3
DNMG 150404E-SF:T8415	0.4	180	0.15	1.5	90	0.14	1.5	160	0.15	1.5	450	0.18	1.5	40	0.12	1.2	30	0.10	0.3
DNMG 150404E-SF:T8430	0.4	165	0.15	1.5	90	0.14	1.5	135	0.15	1.5	450	0.18	1.5	35	0.12	1.2	25	0.11	0.3
DNMG 150408E-SF:T6310	0.8	160	0.17	1.5	115	0.15	1.5	125	0.17	1.5	480	0.20	1.5	45	0.14	1.2	30	0.11	0.7
DNMG 150408E-SF:T8315	0.8	170	0.17	1.5	100	0.15	1.5	160	0.17	1.5	510	0.20	1.5	40	0.14	1.2	30	0.11	0.7
DNMG 150408E-SF:T8415	0.8	210	0.17	1.5	110	0.15	1.5	190	0.17	1.5	525	0.20	1.5	45	0.14	1.2	35	0.11	0.7
DNMG 150408E-SF:T8430	0.8	190	0.17	1.5	105	0.15	1.5	155	0.17	1.5	525	0.20	1.5	40	0.14	1.2	30	0.11	0.7
DNMG 150604E-SF:H07	0.4	–	–	–	70	0.14	1.5	115	0.15	1.5	360	0.18	1.5	35	0.12	1.2	–	–	–
DNMG 150604E-SF:T6310	0.4	140	0.15	1.5	100	0.14	1.5	110	0.15	1.5	420	0.18	1.5	40	0.12	1.2	25	0.11	0.3
DNMG 150604E-SF:T7325	0.4	155	0.17	1.5	120	0.15	1.5	–	–	–	–	–	–	50	0.15	1.2	–	–	–
DNMG 150604E-SF:T8315	0.4	150	0.15	1.5	90	0.14	1.5	140	0.15	1.5	450	0.18	1.5	35	0.12	1.2	30	0.11	0.3
DNMG 150604E-SF:T8415	0.4	180	0.15	1.5	90	0.14	1.5	160	0.15	1.5	450	0.18	1.5	40	0.12	1.2	30	0.10	0.3
DNMG 150604E-SF:T8430	0.4	165	0.15	1.5	90	0.14	1.5	135	0.15	1.5	450	0.18	1.5	35	0.12	1.2	25	0.11	0.3

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
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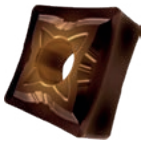
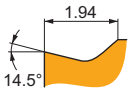
DNMG 150608E-SF:H07	0.8	–	–	–	80	0.15	1.5	130	0.17	1.5	415	0.20	1.5	40	0.14	1.2	–	–	–
DNMG 150608E-SF:T6310	0.8	160	0.17	1.5	115	0.15	1.5	125	0.17	1.5	480	0.20	1.5	45	0.14	1.2	30	0.11	0.7
DNMG 150608E-SF:T7325	0.8	185	0.17	1.5	140	0.15	1.5	–	–	–	–	–	–	60	0.15	1.2	–	–	–
DNMG 150608E-SF:T8315	0.8	170	0.17	1.5	100	0.15	1.5	160	0.17	1.5	510	0.20	1.5	40	0.14	1.2	30	0.11	0.7
DNMG 150608E-SF:T8415	0.8	210	0.17	1.5	110	0.15	1.5	190	0.17	1.5	525	0.20	1.5	45	0.14	1.2	35	0.11	0.7
DNMG 150608E-SF:T8430	0.8	190	0.17	1.5	105	0.15	1.5	155	0.17	1.5	525	0.20	1.5	40	0.14	1.2	30	0.11	0.7
DNMG 150608E-SF:T9325	0.8	235	0.17	1.5	140	0.15	1.5	220	0.17	1.5	–	–	–	50	0.15	1.2	–	–	–
DNMG 150608E-SF:T9415	0.8	290	0.17	1.5	–	–	–	275	0.17	1.5	–	–	–	–	–	–	55	0.12	0.7
DNMG 150612E-SF:T6310	1.2	155	0.25	1.5	110	0.23	1.5	125	0.25	1.5	465	0.30	1.5	45	0.18	1.2	30	0.13	0.9
DNMG 150612E-SF:T8415	1.2	195	0.25	1.5	100	0.23	1.5	180	0.25	1.5	495	0.30	1.5	45	0.17	1.2	30	0.13	0.9
 																			
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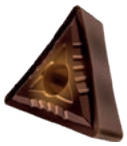
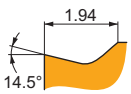
SNMG 120408E-SF:H07	0.8	–	–	–	105	0.18	1.0	165	0.20	1.0	525	0.24	1.0	50	0.14	0.8	–	–	–
SNMG 120408E-SF:T6310	0.8	210	0.20	1.0	150	0.18	1.0	165	0.20	1.0	630	0.24	1.0	60	0.14	0.8	40	0.10	0.7
SNMG 120408E-SF:T8415	0.8	275	0.20	1.0	140	0.18	1.0	250	0.20	1.0	690	0.24	1.0	60	0.14	0.8	45	0.10	0.7
SNMG 120408E-SF:T8430	0.8	245	0.20	1.0	135	0.18	1.0	200	0.20	1.0	675	0.24	1.0	50	0.14	0.8	40	0.10	0.7
SNMG 120408E-SF:T9325	0.8	295	0.20	1.0	175	0.18	1.0	280	0.20	1.0	–	–	–	65	0.16	0.8	–	–	–
SNMG 120412E-SF:T6310	1.2	200	0.25	1.5	140	0.23	1.5	160	0.25	1.5	600	0.30	1.5	60	0.18	1.2	40	0.13	1.0
SNMG 120412E-SF:T8415	1.2	260	0.25	1.5	135	0.23	1.5	240	0.25	1.5	660	0.30	1.5	60	0.17	1.2	45	0.13	1.0
SNMG 120412E-SF:T8430	1.2	225	0.25	1.5	120	0.23	1.5	185	0.25	1.5	615	0.30	1.5	45	0.18	1.2	35	0.13	1.0
 																			
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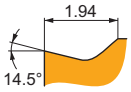
TNMG 160404E-SF:T6310	0.4	150	0.15	1.3	105	0.14	1.3	120	0.15	1.3	450	0.18	1.3	45	0.12	1.0	30	0.11	0.3
TNMG 160404E-SF:T7325	0.4	170	0.17	1.3	130	0.15	1.3	–	–	–	–	–	–	55	0.15	1.0	–	–	–
TNMG 160404E-SF:T8315	0.4	160	0.15	1.3	95	0.14	1.3	150	0.15	1.3	480	0.18	1.3	40	0.12	1.0	30	0.11	0.3
TNMG 160404E-SF:T8415	0.4	195	0.15	1.3	100	0.14	1.3	180	0.15	1.3	495	0.18	1.3	45	0.12	1.0	30	0.10	0.3
TNMG 160404E-SF:T8430	0.4	180	0.15	1.3	95	0.14	1.3	145	0.15	1.3	495	0.18	1.3	35	0.12	1.0	30	0.11	0.3
TNMG 160408E-SF:T6310	0.8	175	0.17	1.3	125	0.15	1.3	140	0.17	1.3	525	0.20	1.3	50	0.14	1.0	35	0.11	0.7
TNMG 160408E-SF:T8315	0.8	185	0.17	1.3	110	0.15	1.3	175	0.17	1.3	555	0.20	1.3	45	0.14	1.0	35	0.11	0.7
TNMG 160408E-SF:T8415	0.8	225	0.17	1.3	115	0.15	1.3	205	0.17	1.3	570	0.20	1.3	50	0.14	1.0	35	0.11	0.7
TNMG 160408E-SF:T8430	0.8	205	0.17	1.3	110	0.15	1.3	170	0.17	1.3	570	0.20	1.3	45	0.14	1.0	35	0.11	0.7
TNMG 160412E-SF:T6310	1.2	165	0.25	1.5	115	0.23	1.5	130	0.25	1.5	495	0.30	1.5	45	0.18	1.2	30	0.13	0.9
TNMG 160412E-SF:T8415	1.2	210	0.25	1.5	110	0.23	1.5	190	0.25	1.5	525	0.30	1.5	45	0.17	1.2	35	0.13	0.9
TNMG 220404E-SF:T6310	0.4	145	0.17	1.7	100	0.15	1.7	115	0.17	1.7	435	0.20	1.7	40	0.15	1.4	25	0.12	0.3
TNMG 220404E-SF:T8415	0.4	185	0.17	1.7	95	0.15	1.7	165	0.17	1.7	465	0.20	1.7	40	0.15	1.4	30	0.12	0.3
TNMG 220408E-SF:T6310	0.8	170	0.17	1.7	120	0.15	1.7	135	0.17	1.7	510	0.20	1.7	50	0.15	1.4	30	0.12	0.7
TNMG 220408E-SF:T8315	0.8	180	0.17	1.7	105	0.15	1.7	170	0.17	1.7	540	0.20	1.7	45	0.15	1.4	35	0.12	0.7
TNMG 220408E-SF:T8415	0.8	220	0.17	1.7	115	0.15	1.7	200	0.17	1.7	555	0.20	1.7	50	0.15	1.4	35	0.12	0.7
TNMG 220408E-SF:T8430	0.8	195	0.17	1.7	105	0.15	1.7	160	0.17	1.7	540	0.20	1.7	40	0.15	1.4	30	0.12	0.7
TNMG 220412E-SF:T6310	1.2	155	0.30	1.7	110	0.27	1.7	125	0.30	1.7	465	0.36	1.7	45	0.21	1.4	30	0.15	0.9
TNMG 220412E-SF:T8415	1.2	195	0.30	1.7	100	0.27	1.7	180	0.30	1.7	495	0.36	1.7	45	0.21	1.4	30	0.15	0.9

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	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
 																			
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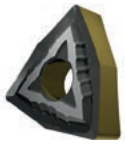
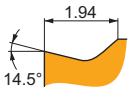
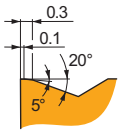
VNMG 160404E-SF:T6310	0.4	125	0.15	1.2	90	0.14	1.2	100	0.15	1.2	375	0.18	1.2	35	0.14	1.0	25	0.15	0.3
VNMG 160404E-SF:T7325	0.4	145	0.15	1.2	110	0.14	1.2	–	–	–	–	–	–	45	0.14	1.0	–	–	–
VNMG 160404E-SF:T8315	0.4	135	0.15	1.2	80	0.14	1.2	125	0.15	1.2	405	0.18	1.2	30	0.14	1.0	25	0.15	0.3
VNMG 160404E-SF:T8415	0.4	160	0.15	1.2	85	0.14	1.2	145	0.15	1.2	405	0.18	1.2	35	0.14	1.0	25	0.15	0.3
VNMG 160404E-SF:T8430	0.4	145	0.15	1.2	80	0.14	1.2	120	0.15	1.2	405	0.18	1.2	30	0.14	1.0	25	0.15	0.3
VNMG 160408E-SF:T6310	0.8	140	0.17	1.4	100	0.15	1.4	110	0.17	1.4	420	0.20	1.4	40	0.14	1.1	25	0.11	0.7
VNMG 160408E-SF:T8315	0.8	150	0.17	1.4	90	0.15	1.4	140	0.17	1.4	450	0.20	1.4	35	0.14	1.1	30	0.11	0.7
VNMG 160408E-SF:T8415	0.8	185	0.17	1.4	95	0.15	1.4	165	0.17	1.4	465	0.20	1.4	40	0.14	1.1	30	0.11	0.7
VNMG 160408E-SF:T8430	0.8	165	0.17	1.4	90	0.15	1.4	135	0.17	1.4	450	0.20	1.4	35	0.14	1.1	25	0.11	0.7
VNMG 160408E-SF:T9325	0.8	205	0.17	1.4	120	0.15	1.4	190	0.17	1.4	–	–	–	45	0.15	1.1	–	–	–
VNMG 160408E-SF:T9415	0.8	255	0.17	1.4	–	–	–	240	0.17	1.4	–	–	–	–	–	–	50	0.12	0.7
 																			
SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.																			
WNMG 060404E-SF:T6310	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.11	0.3
WNMG 060404E-SF:T8315	0.4	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	585	0.18	1.0	45	0.12	0.8	35	0.11	0.3
WNMG 060404E-SF:T8415	0.4	240	0.15	1.0	125	0.14	1.0	215	0.15	1.0	600	0.18	1.0	55	0.12	0.8	40	0.10	0.3
WNMG 060404E-SF:T8430	0.4	220	0.15	1.0	120	0.14	1.0	180	0.15	1.0	600	0.18	1.0	45	0.12	0.8	35	0.11	0.3
WNMG 060408E-SF:T6310	0.8	200	0.20	1.0	140	0.18	1.0	160	0.20	1.0	600	0.24	1.0	60	0.14	0.8	40	0.10	0.7
WNMG 060408E-SF:T8315	0.8	210	0.20	1.0	125	0.18	1.0	195	0.20	1.0	630	0.24	1.0	50	0.14	0.8	40	0.10	0.7
WNMG 060408E-SF:T8415	0.8	255	0.20	1.0	135	0.18	1.0	230	0.20	1.0	645	0.24	1.0	55	0.14	0.8	45	0.10	0.7
WNMG 060408E-SF:T8430	0.8	230	0.20	1.0	125	0.18	1.0	185	0.20	1.0	630	0.24	1.0	45	0.14	0.8	35	0.10	0.7
WNMG 080404E-SF:H07	0.4	–	–	–	90	0.14	1.0	145	0.15	1.0	470	0.18	1.0	45	0.12	0.8	–	–	–
WNMG 080404E-SF:T6310	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.11	0.3
WNMG 080404E-SF:T7325	0.4	205	0.17	1.0	155	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
WNMG 080404E-SF:T8315	0.4	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	585	0.18	1.0	45	0.12	0.8	35	0.11	0.3
WNMG 080404E-SF:T8415	0.4	240	0.15	1.0	125	0.14	1.0	215	0.15	1.0	600	0.18	1.0	55	0.12	0.8	40	0.10	0.3
WNMG 080404E-SF:T8430	0.4	220	0.15	1.0	120	0.14	1.0	180	0.15	1.0	600	0.18	1.0	45	0.12	0.8	35	0.11	0.3
WNMG 080408E-SF:H07	0.8	–	–	–	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.14	0.8	–	–	–
WNMG 080408E-SF:T6310	0.8	200	0.20	1.0	140	0.18	1.0	160	0.20	1.0	600	0.24	1.0	60	0.14	0.8	40	0.10	0.7
WNMG 080408E-SF:T7325	0.8	230	0.20	1.0	175	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
WNMG 080408E-SF:T7335	0.8	220	0.20	1.0	170	0.18	1.0	–	–	–	–	–	–	70	0.16	0.8	–	–	–
WNMG 080408E-SF:T8315	0.8	210	0.20	1.0	125	0.18	1.0	195	0.20	1.0	630	0.24	1.0	50	0.14	0.8	40	0.10	0.7
WNMG 080408E-SF:T8415	0.8	255	0.20	1.0	135	0.18	1.0	230	0.20	1.0	645	0.24	1.0	55	0.14	0.8	45	0.10	0.7
WNMG 080408E-SF:T8430	0.8	230	0.20	1.0	125	0.18	1.0	185	0.20	1.0	630	0.24	1.0	45	0.14	0.8	35	0.10	0.7
WNMG 080408E-SF:T9325	0.8	280	0.20	1.0	165	0.18	1.0	265	0.20	1.0	–	–	–	60	0.16	0.8	–	–	–
WNMG 080408E-SF:T9415	0.8	355	0.20	1.0	–	–	–	335	0.20	1.0	–	–	–	–	–	–	70	0.13	0.7

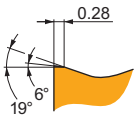
W-M



W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.

PRAMET

W-MR

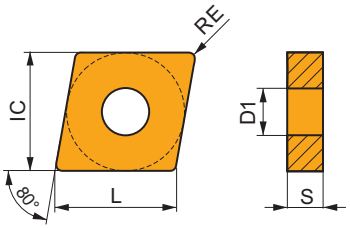


W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.

PRAMET

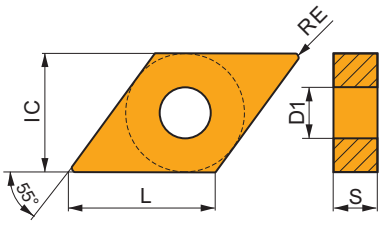
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



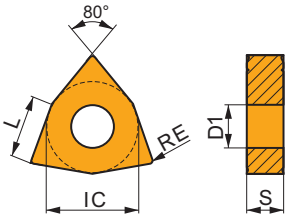
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35

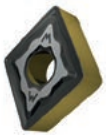
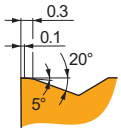
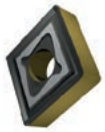
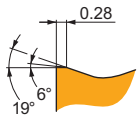
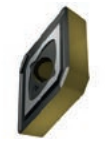
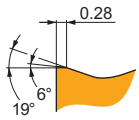
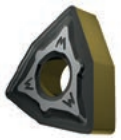
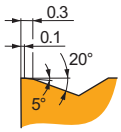
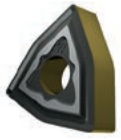
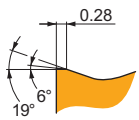


WNMG

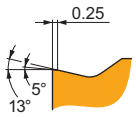
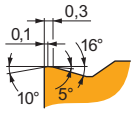
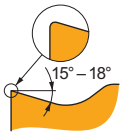
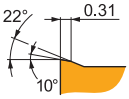
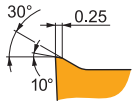
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



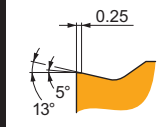
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.																			
CNMG 120408W-M:T5315	0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9315	0.8	200	0.45	1.5	–	–	–	190	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9325	0.8	185	0.45	1.5	–	–	–	175	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-M:T9415	0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
 																			
W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.																			
CNMG 120404W-MR:T9415	0.4	240	0.30	1.5	–	–	–	225	0.30	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T5315	0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T9325	0.8	185	0.45	1.5	110	0.41	1.5	175	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120408W-MR:T9415	0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T5315	1.2	230	0.55	1.5	–	–	–	215	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9315	1.2	200	0.55	1.5	–	–	–	190	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9325	1.2	180	0.55	1.5	105	0.50	1.5	170	0.55	1.5	–	–	–	–	–	–	–	–	–
CNMG 120412W-MR:T9415	1.2	245	0.55	1.5	–	–	–	230	0.55	1.5	–	–	–	–	–	–	–	–	–
 																			
W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.																			
DNMG 150608W-MR:T9325	0.8	155	0.40	1.5	90	0.36	1.5	145	0.40	1.5	–	–	–	–	–	–	–	–	–
DNMG 150608W-MR:T9415	0.8	205	0.40	1.5	–	–	–	190	0.40	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9315	1.2	160	0.50	1.5	–	–	–	150	0.50	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9325	1.2	145	0.50	1.5	85	0.45	1.5	135	0.50	1.5	–	–	–	–	–	–	–	–	–
DNMG 150612W-MR:T9415	1.2	200	0.50	1.5	–	–	–	190	0.50	1.5	–	–	–	–	–	–	–	–	–
 																			
W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.																			
WNMG 060408W-M:T9325	0.8	190	0.45	1.2	–	–	–	180	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 060408W-M:T9415	0.8	255	0.45	1.2	–	–	–	240	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 060412W-M:T5315	1.2	235	0.55	1.2	–	–	–	220	0.55	1.2	–	–	–	–	–	–	–	–	–
WNMG 060412W-M:T9415	1.2	250	0.55	1.2	–	–	–	235	0.55	1.2	–	–	–	–	–	–	–	–	–
WNMG 080408W-M:T9325	0.8	185	0.45	1.5	–	–	–	175	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-M:T9415	0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-M:T9325	1.2	180	0.55	1.5	–	–	–	170	0.55	1.5	–	–	–	–	–	–	–	–	–
 																			
W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.																			
WNMG 060408W-MR:T9415	0.8	255	0.45	1.2	–	–	–	240	0.45	1.2	–	–	–	–	–	–	–	–	–
WNMG 080404W-MR:T9415	0.4	240	0.30	1.5	–	–	–	225	0.30	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T5315	0.8	230	0.45	1.5	–	–	–	215	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9310	0.8	215	0.45	1.5	–	–	–	200	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9325	0.8	185	0.45	1.5	110	0.41	1.5	175	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080408W-MR:T9415	0.8	245	0.45	1.5	–	–	–	230	0.45	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-MR:T5315	1.2	230	0.55	1.5	–	–	–	215	0.55	1.5	–	–	–	–	–	–	–	–	–
WNMG 080412W-MR:T9415	1.2	245	0.55	1.5	–	–	–	230	0.55	1.5	–	–	–	–	–	–	–	–	–

MEDIUM – NAVIGATOR

SM			**SM** chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.
M			**M** chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.
SI			**SI** chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.
NMR			**NMR** chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.
NM			**NM** chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.
.NMA			**.NMA** flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.
.NMA ..S			**.NMA..S** flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.

SM

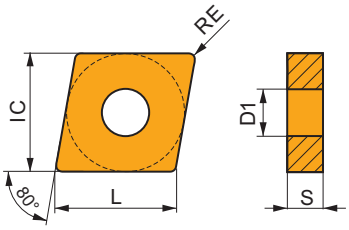


SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

PRAMET

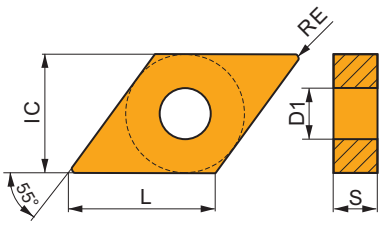
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



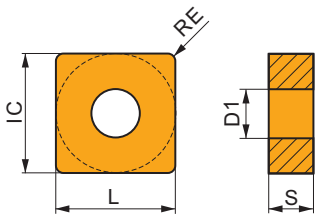
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



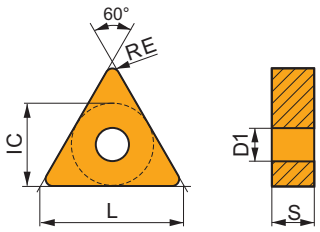
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1906	19.050	7.94	19.05	6.35



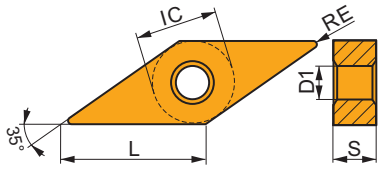
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



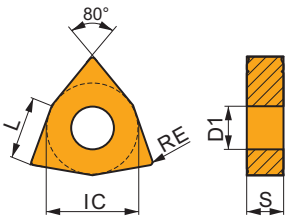
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



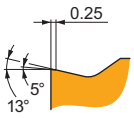
WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



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

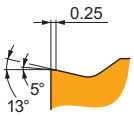
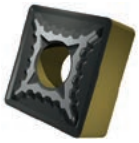
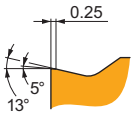
Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
		(mm)																		



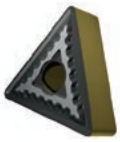
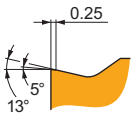
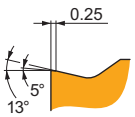
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

CNMG 120404E-SM:T6310	●	0.4	■	155	0.20	2.0	■	110	0.18	2.0	■	125	0.20	2.0	◪	465	0.24	2.0	■	45	0.18	1.6	◪	30	0.13	0.3
CNMG 120404E-SM:T7325	●	0.4	◪	180	0.20	2.0	■	140	0.18	2.0		–	–	–		–	–	–	■	55	0.18	1.6		–	–	–
CNMG 120404E-SM:T7335	●	0.4	◪	175	0.20	2.0	■	135	0.18	2.0		–	–	–		–	–	–	■	55	0.18	1.6		–	–	–
CNMG 120404E-SM:T8415	●	0.4	■	200	0.20	2.0	■	105	0.18	2.0	■	185	0.20	2.0	◪	510	0.24	2.0	■	45	0.18	1.6	◪	35	0.13	0.3
CNMG 120404E-SM:T8430	●	0.4	■	180	0.20	2.0	■	95	0.18	2.0	◪	145	0.20	2.0	◪	495	0.24	2.0	◪	35	0.18	1.6	◪	30	0.13	0.3
CNMG 120404E-SM:T9325	●	0.4	■	220	0.20	2.0	■	130	0.18	2.0	◪	205	0.20	2.0		–	–	–	◪	45	0.18	1.6		–	–	–
CNMG 120404E-SM:T9415	●	0.4	■	280	0.20	2.0		–	–	–	◪	265	0.20	2.0		–	–	–		–	–	–	◪	55	0.13	0.3
CNMG 120408E-SM:T6310	⧓	0.8	■	175	0.25	2.0	■	125	0.23	2.0	■	140	0.25	2.0	◪	525	0.30	2.0	■	50	0.20	1.6	◪	35	0.13	0.7
CNMG 120408E-SM:T7325	⧓	0.8	◪	200	0.25	2.0	■	155	0.23	2.0		–	–	–		–	–	–	■	65	0.20	1.6		–	–	–
CNMG 120408E-SM:T7335	⧓	0.8	◪	190	0.25	2.0	■	145	0.23	2.0		–	–	–		–	–	–	■	60	0.20	1.6		–	–	–
CNMG 120408E-SM:T8415	⧓	0.8	■	225	0.25	2.0	■	115	0.23	2.0	■	205	0.25	2.0	◪	570	0.30	2.0	■	50	0.20	1.6	◪	35	0.13	0.7
CNMG 120408E-SM:T8430	⧓	0.8	■	195	0.25	2.0	■	105	0.23	2.0	◪	160	0.25	2.0	◪	540	0.30	2.0	◪	40	0.20	1.6	◪	30	0.13	0.7
CNMG 120408E-SM:T9325	⧓	0.8	■	235	0.25	2.0	■	140	0.23	2.0	◪	220	0.25	2.0		–	–	–	◪	50	0.20	1.6		–	–	–
CNMG 120408E-SM:T9415	⧓	0.8	■	305	0.25	2.0		–	–	–	◪	285	0.25	2.0		–	–	–		–	–	–	◪	60	0.13	0.7
CNMG 120412E-SM:T6310	⧓	1.2	■	175	0.30	2.0	■	125	0.27	2.0	■	140	0.30	2.0	◪	525	0.36	2.0	■	50	0.24	1.6	◪	35	0.15	1.0
CNMG 120412E-SM:T7325	⧓	1.2	◪	195	0.30	2.0	■	150	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
CNMG 120412E-SM:T7335	⧓	1.2	◪	190	0.30	2.0	■	145	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
CNMG 120412E-SM:T8415	⧓	1.2	■	225	0.30	2.0	■	115	0.27	2.0	■	205	0.30	2.0	◪	570	0.36	2.0	■	50	0.24	1.6	◪	35	0.15	1.0
CNMG 120412E-SM:T8430	⧓	1.2	■	190	0.30	2.0	■	105	0.27	2.0	◪	155	0.30	2.0	◪	525	0.36	2.0	◪	40	0.24	1.6	◪	30	0.15	1.0
CNMG 120412E-SM:T9325	⧓	1.2	■	235	0.30	2.0	■	140	0.27	2.0	◪	220	0.30	2.0		–	–	–	◪	50	0.24	1.6		–	–	–
CNMG 120412E-SM:T9415	⧓	1.2	■	300	0.30	2.0		–	–	–	◪	285	0.30	2.0		–	–	–		–	–	–	◪	60	0.15	1.0
CNMG 160608E-SM:T7325	⧓	0.8	◪	185	0.26	3.0	■	140	0.23	3.0		–	–	–		–	–	–	■	60	0.23	2.4		–	–	–
CNMG 160608E-SM:T8430	⧓	0.8	■	180	0.26	3.0	■	95	0.23	3.0	◪	145	0.26	3.0	◪	495	0.31	3.0	◪	35	0.23	2.4	◪	30	0.13	0.7
CNMG 160608E-SM:T9325	⧓	0.8	■	225	0.26	3.0	■	135	0.23	3.0	◪	210	0.26	3.0		–	–	–	◪	50	0.23	2.4		–	–	–
CNMG 160612E-SM:T6310	⧓	1.2	■	170	0.30	3.0	■	120	0.27	3.0	■	135	0.30	3.0	◪	510	0.36	3.0	■	50	0.27	2.4	◪	30	0.15	1.0
CNMG 160612E-SM:T7325	⧓	1.2	◪	190	0.30	3.0	■	145	0.27	3.0		–	–	–		–	–	–	■	60	0.27	2.4		–	–	–
CNMG 160612E-SM:T7335	⧓	1.2	◪	180	0.30	3.0	■	140	0.27	3.0		–	–	–		–	–	–	■	55	0.27	2.4		–	–	–
CNMG 160612E-SM:T8415	⧓	1.2	■	215	0.30	3.0	■	110	0.27	3.0	■	195	0.30	3.0	◪	540	0.36	3.0	■	45	0.27	2.4	◪	35	0.15	1.0
CNMG 160612E-SM:T9325	⧓	1.2	■	225	0.30	3.0	■	135	0.27	3.0	◪	210	0.30	3.0		–	–	–	◪	50	0.27	2.4		–	–	–
CNMG 160612E-SM:T9415	⧓	1.2	■	290	0.30	3.0		–	–	–	◪	275	0.30	3.0		–	–	–		–	–	–	◪	55	0.15	1.0
CNMG 190612E-SM:T6310	⧓	1.2	■	165	0.30	4.0	■	115	0.27	4.0	■	130	0.30	4.0	◪	495	0.36	4.0	■	45	0.27	3.2	◪	30	0.15	1.0
CNMG 190612E-SM:T7325	⧓	1.2	◪	185	0.30	4.0	■	140	0.27	4.0		–	–	–		–	–	–	■	60	0.27	3.2		–	–	–
CNMG 190612E-SM:T7335	⧓	1.2	◪	175	0.30	4.0	■	135	0.27	4.0		–	–	–		–	–	–	■	55	0.27	3.2		–	–	–
CNMG 190612E-SM:T8415	⧓	1.2	■	210	0.30	4.0	■	110	0.27	4.0	■	190	0.30	4.0	◪	525	0.36	4.0	■	45	0.27	3.2	◪	35	0.15	1.0
CNMG 190612E-SM:T9415	⧓	1.2	■	280	0.30	4.0		–	–	–	◪	265	0.30	4.0		–	–	–		–	–	–	◪	55	0.15	1.0

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

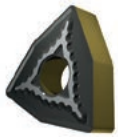
Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
																			
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.																			
DNMG 110404E-SM:T6310	0.4	140	0.20	0.8	100	0.18	0.8	110	0.20	0.8	420	0.24	0.8	40	0.18	0.6	25	0.14	0.3
DNMG 110404E-SM:T7325	0.4	160	0.20	0.8	120	0.18	0.8	–	–	–	–	–	–	50	0.18	0.6	–	–	–
DNMG 110404E-SM:T8415	0.4	180	0.20	0.8	90	0.18	0.8	160	0.20	0.8	450	0.24	0.8	40	0.18	0.6	30	0.14	0.3
DNMG 110404E-SM:T8430	0.4	155	0.20	0.8	85	0.18	0.8	130	0.20	0.8	435	0.24	0.8	30	0.18	0.6	25	0.14	0.3
DNMG 110404E-SM:T9325	0.4	190	0.20	0.8	110	0.18	0.8	180	0.20	0.8	–	–	–	40	0.18	0.6	–	–	–
DNMG 110408E-SM:T6310	0.8	150	0.25	1.2	105	0.23	1.2	120	0.25	1.2	450	0.30	1.2	45	0.20	1.0	30	0.13	0.7
DNMG 110408E-SM:T7325	0.8	170	0.25	1.2	130	0.23	1.2	–	–	–	–	–	–	55	0.20	1.0	–	–	–
DNMG 110408E-SM:T7335	0.8	160	0.25	1.2	120	0.23	1.2	–	–	–	–	–	–	50	0.20	1.0	–	–	–
DNMG 110408E-SM:T8415	0.8	190	0.25	1.2	100	0.23	1.2	170	0.25	1.2	480	0.30	1.2	40	0.20	1.0	30	0.13	0.7
DNMG 110408E-SM:T8430	0.8	170	0.25	1.2	90	0.23	1.2	135	0.25	1.2	465	0.30	1.2	35	0.20	1.0	25	0.13	0.7
DNMG 110408E-SM:T9325	0.8	200	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	45	0.20	1.0	–	–	–
DNMG 150404E-SM:T6310	0.4	130	0.20	1.7	90	0.18	1.7	100	0.20	1.7	390	0.24	1.7	35	0.18	1.4	25	0.14	0.3
DNMG 150404E-SM:T8415	0.4	165	0.20	1.7	85	0.18	1.7	150	0.20	1.7	420	0.24	1.7	35	0.18	1.4	25	0.14	0.3
DNMG 150408E-SM:T6310	0.8	140	0.25	1.7	100	0.23	1.7	110	0.25	1.7	420	0.30	1.7	40	0.20	1.4	25	0.13	0.7
DNMG 150408E-SM:T8415	0.8	185	0.25	1.7	95	0.23	1.7	165	0.25	1.7	465	0.30	1.7	40	0.20	1.4	30	0.13	0.7
DNMG 150604E-SM:T6310	0.4	130	0.20	1.7	90	0.18	1.7	100	0.20	1.7	390	0.24	1.7	35	0.18	1.4	25	0.14	0.3
DNMG 150604E-SM:T7325	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
DNMG 150604E-SM:T7335	0.4	140	0.20	1.7	105	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
DNMG 150604E-SM:T8415	0.4	165	0.20	1.7	85	0.18	1.7	150	0.20	1.7	420	0.24	1.7	35	0.18	1.4	25	0.14	0.3
DNMG 150604E-SM:T8430	0.4	145	0.20	1.7	80	0.18	1.7	120	0.20	1.7	405	0.24	1.7	30	0.18	1.4	25	0.14	0.3
DNMG 150604E-SM:T9325	0.4	180	0.20	1.7	105	0.18	1.7	170	0.20	1.7	–	–	–	40	0.18	1.4	–	–	–
DNMG 150604E-SM:T9415	0.4	225	0.20	1.7	–	–	–	210	0.20	1.7	–	–	–	–	–	–	45	0.14	0.3
DNMG 150608E-SM:T6310	0.8	140	0.25	1.7	100	0.23	1.7	110	0.25	1.7	420	0.30	1.7	40	0.20	1.4	25	0.13	0.7
DNMG 150608E-SM:T7325	0.8	160	0.25	1.7	120	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
DNMG 150608E-SM:T7335	0.8	155	0.25	1.7	120	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
DNMG 150608E-SM:T8415	0.8	185	0.25	1.7	95	0.23	1.7	165	0.25	1.7	465	0.30	1.7	40	0.20	1.4	30	0.13	0.7
DNMG 150608E-SM:T8430	0.8	155	0.25	1.7	85	0.23	1.7	130	0.25	1.7	435	0.30	1.7	30	0.20	1.4	25	0.13	0.7
DNMG 150608E-SM:T9325	0.8	195	0.25	1.7	115	0.23	1.7	185	0.25	1.7	–	–	–	40	0.20	1.4	–	–	–
DNMG 150608E-SM:T9415	0.8	250	0.25	1.7	–	–	–	235	0.25	1.7	–	–	–	–	–	–	50	0.13	0.7
DNMG 150612E-SM:T6310	1.2	145	0.30	1.7	100	0.27	1.7	115	0.30	1.7	435	0.36	1.7	40	0.24	1.4	25	0.15	0.9
DNMG 150612E-SM:T7325	1.2	160	0.30	1.7	120	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
DNMG 150612E-SM:T8415	1.2	185	0.30	1.7	95	0.27	1.7	165	0.30	1.7	465	0.36	1.7	40	0.24	1.4	30	0.15	0.9
DNMG 150612E-SM:T8430	1.2	155	0.30	1.7	85	0.27	1.7	130	0.30	1.7	435	0.36	1.7	30	0.24	1.4	25	0.15	0.9
DNMG 150612E-SM:T9415	1.2	245	0.30	1.7	–	–	–	230	0.30	1.7	–	–	–	–	–	–	45	0.15	0.9
																			
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.																			
SNMG 120408E-SM:T6310	0.8	185	0.25	1.8	130	0.23	1.8	145	0.25	1.8	555	0.30	1.8	55	0.20	1.4	35	0.13	0.7
SNMG 120408E-SM:T7325	0.8	210	0.25	1.8	160	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
SNMG 120408E-SM:T7335	0.8	205	0.25	1.8	155	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
SNMG 120408E-SM:T8415	0.8	240	0.25	1.8	125	0.23	1.8	215	0.25	1.8	600	0.30	1.8	55	0.20	1.4	40	0.13	0.7
SNMG 120408E-SM:T8430	0.8	205	0.25	1.8	110	0.23	1.8	170	0.25	1.8	570	0.30	1.8	45	0.20	1.4	35	0.13	0.7
SNMG 120408E-SM:T9325	0.8	255	0.25	1.8	150	0.23	1.8	240	0.25	1.8	–	–	–	55	0.20	1.4	–	–	–
SNMG 120408E-SM:T9415	0.8	325	0.25	1.8	–	–	–	305	0.25	1.8	–	–	–	–	–	–	65	0.13	0.7
SNMG 120412E-SM:T7325	1.2	210	0.30	1.8	160	0.27	1.8	–	–	–	–	–	–	65	0.24	1.4	–	–	–
SNMG 120412E-SM:T9415	1.2	325	0.30	1.8	–	–	–	305	0.30	1.8	–	–	–	–	–	–	65	0.15	1.0
SNMG 190612E-SM:T6310	1.2	175	0.30	4.0	125	0.27	4.0	140	0.30	4.0	525	0.36	4.0	50	0.27	3.2	35	0.15	1.0
SNMG 190612E-SM:T7325	1.2	195	0.30	4.0	150	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
SNMG 190612E-SM:T7335	1.2	185	0.30	4.0	140	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
SNMG 190612E-SM:T8415	1.2	220	0.30	4.0	115	0.27	4.0	200	0.30	4.0	555	0.36	4.0	50	0.27	3.2	35	0.15	1.0
SNMG 190612E-SM:T9325	1.2	230	0.30	4.0	135	0.27	4.0	215	0.30	4.0	–	–	–	50	0.27	3.2	–	–	–
SNMG 190616E-SM:T7335	1.6	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
SNMG 190616E-SM:T9325	1.6	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	45	0.32	3.2	–	–	–

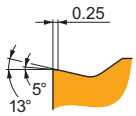
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.																			
TNMG 160404E-SM:T6310	0.4	135	0.20	1.7	95	0.18	1.7	105	0.20	1.7	405	0.24	1.7	40	0.18	1.4	25	0.14	0.3
TNMG 160404E-SM:T7325	0.4	155	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.18	1.4	–	–	–
TNMG 160404E-SM:T7335	0.4	150	0.20	1.7	115	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-SM:T8415	0.4	170	0.20	1.7	90	0.18	1.7	155	0.20	1.7	435	0.24	1.7	35	0.18	1.4	30	0.14	0.3
TNMG 160404E-SM:T8430	0.4	155	0.20	1.7	85	0.18	1.7	130	0.20	1.7	435	0.24	1.7	30	0.18	1.4	25	0.14	0.3
TNMG 160404E-SM:T9325	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.18	1.4	–	–	–
TNMG 160404E-SM:T9415	0.4	240	0.20	1.7	–	–	–	225	0.20	1.7	–	–	–	–	–	–	45	0.14	0.3
TNMG 160408E-SM:T6310	0.8	150	0.25	1.7	105	0.23	1.7	120	0.25	1.7	450	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 160408E-SM:T7325	0.8	170	0.25	1.7	130	0.23	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
TNMG 160408E-SM:T7335	0.8	165	0.25	1.7	125	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 160408E-SM:T8415	0.8	195	0.25	1.7	100	0.23	1.7	180	0.25	1.7	495	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 160408E-SM:T8430	0.8	170	0.25	1.7	90	0.23	1.7	135	0.25	1.7	465	0.30	1.7	35	0.20	1.4	25	0.13	0.7
TNMG 160408E-SM:T9325	0.8	205	0.25	1.7	120	0.23	1.7	190	0.25	1.7	–	–	–	45	0.20	1.4	–	–	–
TNMG 160408E-SM:T9415	0.8	265	0.25	1.7	–	–	–	250	0.25	1.7	–	–	–	–	–	–	50	0.13	0.7
TNMG 160412E-SM:T6310	1.2	155	0.30	1.7	110	0.27	1.7	125	0.30	1.7	465	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 160412E-SM:T7325	1.2	170	0.30	1.7	130	0.27	1.7	–	–	–	–	–	–	55	0.24	1.4	–	–	–
TNMG 160412E-SM:T7335	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160412E-SM:T8415	1.2	195	0.30	1.7	100	0.27	1.7	180	0.30	1.7	495	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 160412E-SM:T9325	1.2	205	0.30	1.7	120	0.27	1.7	190	0.30	1.7	–	–	–	45	0.24	1.4	–	–	–
TNMG 220404E-SM:T6310	0.4	135	0.20	1.7	95	0.18	1.7	105	0.20	1.7	405	0.24	1.7	40	0.18	1.4	25	0.14	0.3
TNMG 220404E-SM:T7325	0.4	155	0.20	1.7	120	0.18	1.7	–	–	–	–	–	–	50	0.18	1.4	–	–	–
TNMG 220404E-SM:T8415	0.4	170	0.20	1.7	90	0.18	1.7	155	0.20	1.7	435	0.24	1.7	35	0.18	1.4	30	0.14	0.3
TNMG 220404E-SM:T8430	0.4	155	0.20	1.7	85	0.18	1.7	130	0.20	1.7	435	0.24	1.7	30	0.18	1.4	25	0.14	0.3
TNMG 220404E-SM:T9325	0.4	190	0.20	1.7	110	0.18	1.7	180	0.20	1.7	–	–	–	40	0.18	1.4	–	–	–
TNMG 220408E-SM:T6310	0.8	150	0.25	1.7	105	0.23	1.7	120	0.25	1.7	450	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 220408E-SM:T7325	0.8	170	0.25	1.7	130	0.23	1.7	–	–	–	–	–	–	55	0.20	1.4	–	–	–
TNMG 220408E-SM:T7335	0.8	165	0.25	1.7	125	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 220408E-SM:T8415	0.8	195	0.25	1.7	100	0.23	1.7	180	0.25	1.7	495	0.30	1.7	45	0.20	1.4	30	0.13	0.7
TNMG 220408E-SM:T8430	0.8	170	0.25	1.7	90	0.23	1.7	135	0.25	1.7	465	0.30	1.7	35	0.20	1.4	25	0.13	0.7
TNMG 220408E-SM:T9325	0.8	205	0.25	1.7	120	0.23	1.7	190	0.25	1.7	–	–	–	45	0.20	1.4	–	–	–
TNMG 220408E-SM:T9415	0.8	265	0.25	1.7	–	–	–	250	0.25	1.7	–	–	–	–	–	–	50	0.13	0.7
TNMG 220412E-SM:T6310	1.2	155	0.30	1.7	110	0.27	1.7	125	0.30	1.7	465	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 220412E-SM:T7325	1.2	170	0.30	1.7	130	0.27	1.7	–	–	–	–	–	–	55	0.24	1.4	–	–	–
TNMG 220412E-SM:T7335	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 220412E-SM:T8415	1.2	195	0.30	1.7	100	0.27	1.7	180	0.30	1.7	495	0.36	1.7	45	0.24	1.4	30	0.15	0.9
TNMG 220412E-SM:T9325	1.2	205	0.30	1.7	120	0.27	1.7	190	0.30	1.7	–	–	–	45	0.24	1.4	–	–	–
TNMG 220412E-SM:T9415	1.2	260	0.30	1.7	–	–	–	245	0.30	1.7	–	–	–	–	–	–	50	0.15	0.9
 																			
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.																			
VNMG 160404E-SM:T6310	0.4	120	0.18	1.2	85	0.16	1.2	95	0.18	1.2	360	0.22	1.2	35	0.16	1.0	20	0.13	0.3
VNMG 160404E-SM:T7325	0.4	135	0.18	1.2	105	0.16	1.2	–	–	–	–	–	–	40	0.16	1.0	–	–	–
VNMG 160404E-SM:T8415	0.4	155	0.18	1.2	80	0.16	1.2	140	0.18	1.2	390	0.22	1.2	35	0.16	1.0	25	0.13	0.3
VNMG 160404E-SM:T8430	0.4	135	0.18	1.2	75	0.16	1.2	110	0.18	1.2	375	0.22	1.2	25	0.16	1.0	20	0.13	0.3
VNMG 160404E-SM:T9325	0.4	170	0.18	1.2	100	0.16	1.2	160	0.18	1.2	–	–	–	35	0.16	1.0	–	–	–
VNMG 160404E-SM:T9415	0.4	210	0.18	1.2	–	–	–	195	0.18	1.2	–	–	–	–	–	–	40	0.13	0.3
VNMG 160408E-SM:T6310	0.8	125	0.25	1.4	90	0.23	1.4	100	0.25	1.4	375	0.30	1.4	35	0.20	1.1	25	0.13	0.7
VNMG 160408E-SM:T7325	0.8	145	0.25	1.4	110	0.23	1.4	–	–	–	–	–	–	45	0.20	1.1	–	–	–
VNMG 160408E-SM:T8415	0.8	160	0.25	1.4	85	0.23	1.4	145	0.25	1.4	405	0.30	1.4	35	0.20	1.1	25	0.13	0.7
VNMG 160408E-SM:T8430	0.8	140	0.25	1.4	75	0.23	1.4	115	0.25	1.4	390	0.30	1.4	30	0.20	1.1	20	0.13	0.7
VNMG 160408E-SM:T9325	0.8	170	0.25	1.4	100	0.23	1.4	160	0.25	1.4	–	–	–	35	0.20	1.1	–	–	–

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	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)	
	(mm)																								

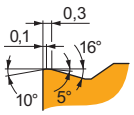




SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

WNMG 060404E-SM:T7335	●	0.4	◪	180	0.20	1.7	■	140	0.18	1.7		–	–	–		–	–	–	■	55	0.18	1.4		–	–	–
WNMG 060404E-SM:T8430	●	0.4	■	185	0.20	1.7	■	100	0.18	1.7	◪	150	0.20	1.7	◪	510	0.24	1.7	◪	40	0.18	1.4	◪	30	0.13	0.3
WNMG 060404E-SM:T9325	●	0.4	■	225	0.20	1.7	■	135	0.18	1.7	◪	210	0.20	1.7		–	–	–	◪	50	0.18	1.4		–	–	–
WNMG 060408E-SM:T6310	❖	0.8	■	175	0.25	1.7	■	125	0.23	1.7	■	140	0.25	1.7	◪	525	0.30	1.7	■	50	0.20	1.4	◪	35	0.13	0.7
WNMG 060408E-SM:T7325	❖	0.8	◪	200	0.25	1.7	■	155	0.23	1.7		–	–	–		–	–	–	■	65	0.20	1.4		–	–	–
WNMG 060408E-SM:T7335	❖	0.8	◪	195	0.25	1.7	■	150	0.23	1.7		–	–	–		–	–	–	■	60	0.20	1.4		–	–	–
WNMG 060408E-SM:T8415	❖	0.8	■	225	0.25	1.7	■	115	0.23	1.7	■	205	0.25	1.7	◪	570	0.30	1.7	■	50	0.20	1.4	◪	35	0.13	0.7
WNMG 060408E-SM:T8430	❖	0.8	■	195	0.25	1.7	■	105	0.23	1.7	◪	160	0.25	1.7	◪	540	0.30	1.7	◪	40	0.20	1.4	◪	30	0.13	0.7
WNMG 060408E-SM:T9325	❖	0.8	■	240	0.25	1.7	■	140	0.23	1.7	◪	225	0.25	1.7		–	–	–	◪	50	0.20	1.4		–	–	–
WNMG 060412E-SM:T7325	❖	1.2	◪	200	0.30	1.7	■	155	0.27	1.7		–	–	–		–	–	–	■	65	0.24	1.4		–	–	–
WNMG 060412E-SM:T8430	❖	1.2	■	195	0.30	1.7	■	105	0.27	1.7	◪	160	0.30	1.7	◪	540	0.36	1.7	◪	40	0.24	1.4	◪	30	0.15	1.0
WNMG 060412E-SM:T9325	❖	1.2	■	240	0.30	1.7	■	140	0.27	1.7	◪	225	0.30	1.7		–	–	–	◪	50	0.24	1.4		–	–	–
WNMG 080404E-SM:T6310	●	0.4	■	155	0.20	2.0	■	110	0.18	2.0	■	125	0.20	2.0	◪	465	0.24	2.0	■	45	0.18	1.6	◪	30	0.13	0.3
WNMG 080404E-SM:T7325	●	0.4	◪	180	0.20	2.0	■	140	0.18	2.0		–	–	–		–	–	–	■	55	0.18	1.6		–	–	–
WNMG 080404E-SM:T7335	●	0.4	◪	175	0.20	2.0	■	135	0.18	2.0		–	–	–		–	–	–	■	55	0.18	1.6		–	–	–
WNMG 080404E-SM:T8415	●	0.4	■	200	0.20	2.0	■	105	0.18	2.0	■	185	0.20	2.0	◪	510	0.24	2.0	■	45	0.18	1.6	◪	35	0.13	0.3
WNMG 080404E-SM:T8430	●	0.4	■	180	0.20	2.0	■	95	0.18	2.0	◪	145	0.20	2.0	◪	495	0.24	2.0	◪	35	0.18	1.6	◪	30	0.13	0.3
WNMG 080404E-SM:T9325	●	0.4	■	220	0.20	2.0	■	130	0.18	2.0	◪	205	0.20	2.0		–	–	–	◪	45	0.18	1.6		–	–	–
WNMG 080404E-SM:T9415	●	0.4	■	280	0.20	2.0		–	–	–	◪	265	0.20	2.0		–	–	–		–	–	–	◪	55	0.13	0.3
WNMG 080408E-SM:T6310	❖	0.8	■	175	0.25	2.0	■	125	0.23	2.0	■	140	0.25	2.0	◪	525	0.30	2.0	■	50	0.20	1.6	◪	35	0.13	0.7
WNMG 080408E-SM:T7325	❖	0.8	◪	200	0.25	2.0	■	155	0.23	2.0		–	–	–		–	–	–	■	65	0.20	1.6		–	–	–
WNMG 080408E-SM:T7335	❖	0.8	◪	190	0.25	2.0	■	145	0.23	2.0		–	–	–		–	–	–	■	60	0.20	1.6		–	–	–
WNMG 080408E-SM:T8415	❖	0.8	■	225	0.25	2.0	■	115	0.23	2.0	■	205	0.25	2.0	◪	570	0.30	2.0	■	50	0.20	1.6	◪	35	0.13	0.7
WNMG 080408E-SM:T8430	❖	0.8	■	195	0.25	2.0	■	105	0.23	2.0	◪	160	0.25	2.0	◪	540	0.30	2.0	◪	40	0.20	1.6	◪	30	0.13	0.7
WNMG 080408E-SM:T9325	❖	0.8	■	235	0.25	2.0	■	140	0.23	2.0	◪	220	0.25	2.0		–	–	–	◪	50	0.20	1.6		–	–	–
WNMG 080408E-SM:T9415	❖	0.8	■	305	0.25	2.0		–	–	–	◪	285	0.25	2.0		–	–	–		–	–	–	◪	60	0.13	0.7
WNMG 080412E-SM:T6310	❖	1.2	■	175	0.30	2.0	■	125	0.27	2.0	■	140	0.30	2.0	◪	525	0.36	2.0	■	50	0.24	1.6	◪	35	0.15	1.0
WNMG 080412E-SM:T7325	❖	1.2	◪	195	0.30	2.0	■	150	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
WNMG 080412E-SM:T7335	❖	1.2	◪	190	0.30	2.0	■	145	0.27	2.0		–	–	–		–	–	–	■	60	0.24	1.6		–	–	–
WNMG 080412E-SM:T8415	❖	1.2	■	225	0.30	2.0	■	115	0.27	2.0	■	205	0.30	2.0	◪	570	0.36	2.0	■	50	0.24	1.6	◪	35	0.15	1.0
WNMG 080412E-SM:T8430	❖	1.2	■	190	0.30	2.0	■	105	0.27	2.0	◪	155	0.30	2.0	◪	525	0.36	2.0	◪	40	0.24	1.6	◪	30	0.15	1.0
WNMG 080412E-SM:T9325	❖	1.2	■	235	0.30	2.0	■	140	0.27	2.0	◪	220	0.30	2.0		–	–	–	◪	50	0.24	1.6		–	–	–
WNMG 080412E-SM:T9415	❖	1.2	■	300	0.30	2.0		–	–	–	◪	285	0.30	2.0		–	–	–		–	–	–	◪	60	0.15	1.0

M

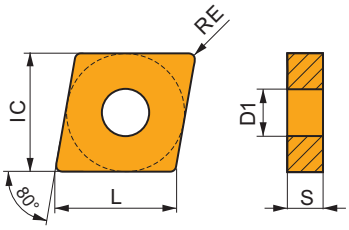


M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

PRAMET

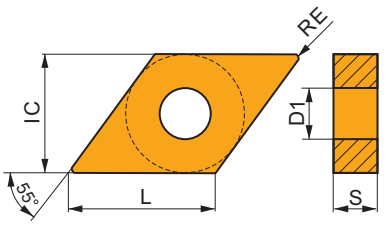
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



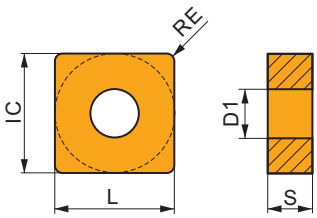
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



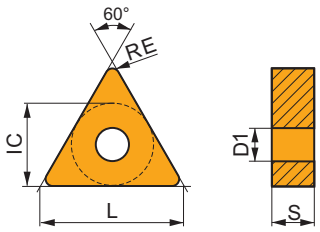
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



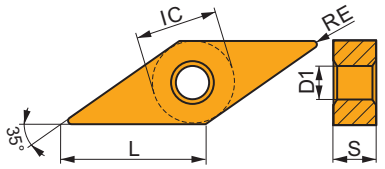
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



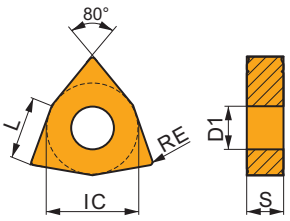
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



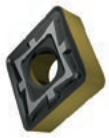
WNMG

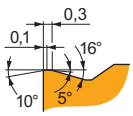
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



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	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)

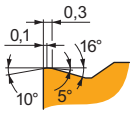




M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

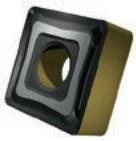
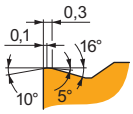
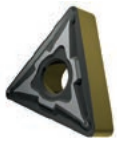
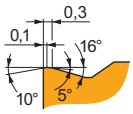
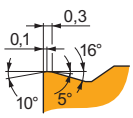
CNMG 090308E-M:T9325	⬌	0.8	■	205	0.32	1.8	–	–	–	◪	190	0.32	1.8	–	–	–	–	–	–	–	–	–
CNMG 090308E-M:T9335	⬌	0.8	■	180	0.32	1.8	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–
CNMG 090308E-M:T9415	●	0.8	■	275	0.32	1.8	–	–	–	◪	260	0.32	1.8	–	–	–	–	–	–	◪	55	0.16	0.5
CNMG 120404E-M:T5315	●	0.4	◪	245	0.20	2.1	–	–	–	■	230	0.20	2.1	–	–	–	–	–	–	◪	45	0.13	0.3
CNMG 120404E-M:T9325	●	0.4	■	210	0.20	2.1	–	–	–	◪	195	0.20	2.1	–	–	–	–	–	–		–	–	–
CNMG 120404E-M:T9335	⬌	0.4	■	180	0.20	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120404E-M:T9415	⬌	0.4	■	265	0.20	2.1	–	–	–	◪	250	0.20	2.1	–	–	–	–	–	–	◪	50	0.13	0.3
CNMG 120408E-M:6640	⬌	0.8	■	165	0.32	2.1	–	–	–	■	155	0.32	2.1	–	–	–	–	–	–		–	–	–
CNMG 120408E-M:T5305	⬌	0.8	◪	280	0.32	2.1	–	–	–	■	265	0.32	2.1	–	–	–	–	–	–	◪	55	0.16	0.7
CNMG 120408E-M:T5315	⬌	0.8	◪	250	0.32	2.1	–	–	–	■	235	0.32	2.1	–	–	–	–	–	–	◪	50	0.16	0.7
CNMG 120408E-M:T8430	⬌	0.8	■	170	0.32	2.1	–	–	–	◪	135	0.32	2.1	–	–	–	–	–	–	◪	25	0.16	0.7
CNMG 120408E-M:T9310	⬌	0.8	■	245	0.32	2.1	–	–	–	◪	230	0.32	2.1	–	–	–	–	–	–	◪	45	0.16	0.7
CNMG 120408E-M:T9315	⬌	0.8	■	225	0.32	2.1	–	–	–	◪	210	0.32	2.1	–	–	–	–	–	–	◪	45	0.16	0.7
CNMG 120408E-M:T9325	⬌	0.8	■	200	0.32	2.1	–	–	–	◪	190	0.32	2.1	–	–	–	–	–	–		–	–	–
CNMG 120408E-M:T9335	⬌	0.8	■	180	0.32	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120408E-M:T9415	⬌	0.8	■	270	0.32	2.1	–	–	–	◪	255	0.32	2.1	–	–	–	–	–	–	◪	50	0.16	0.7
CNMG 120412E-M:T5305	⬌	1.2	◪	275	0.40	2.1	–	–	–	■	260	0.40	2.1	–	–	–	–	–	–	◪	55	0.20	1.0
CNMG 120412E-M:T5315	⬌	1.2	◪	245	0.40	2.1	–	–	–	■	230	0.40	2.1	–	–	–	–	–	–	◪	45	0.20	1.0
CNMG 120412E-M:T9315	⬌	1.2	■	220	0.40	2.1	–	–	–	◪	205	0.40	2.1	–	–	–	–	–	–	◪	40	0.20	1.0
CNMG 120412E-M:T9325	⬌	1.2	■	195	0.40	2.1	–	–	–	◪	185	0.40	2.1	–	–	–	–	–	–		–	–	–
CNMG 120412E-M:T9335	⬌	1.2	■	170	0.40	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 120412E-M:T9415	⬌	1.2	■	265	0.40	2.1	–	–	–	◪	250	0.40	2.1	–	–	–	–	–	–	◪	50	0.20	1.0
CNMG 120416E-M:T9325	⬌	1.6	■	200	0.40	2.1	–	–	–	◪	190	0.40	2.1	–	–	–	–	–	–		–	–	–
CNMG 120416E-M:T9335	⬌	1.6	■	175	0.40	2.1	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 160608E-M:T9310	⬌	0.8	■	235	0.32	3.6	–	–	–	◪	220	0.32	3.6	–	–	–	–	–	–	◪	45	0.16	0.7
CNMG 160608E-M:T9325	⬌	0.8	■	190	0.32	3.6	–	–	–	◪	180	0.32	3.6	–	–	–	–	–	–		–	–	–
CNMG 160608E-M:T9335	⬌	0.8	■	170	0.32	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 160608E-M:T9415	⬌	0.8	■	255	0.32	3.6	–	–	–	◪	240	0.32	3.6	–	–	–	–	–	–	◪	50	0.16	0.7
CNMG 160612E-M:T9325	⬌	1.2	■	185	0.40	3.6	–	–	–	◪	175	0.40	3.6	–	–	–	–	–	–		–	–	–
CNMG 160612E-M:T9335	⬌	1.2	■	160	0.40	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 160612E-M:T9415	⬌	1.2	■	250	0.40	3.6	–	–	–	◪	235	0.40	3.6	–	–	–	–	–	–	◪	50	0.20	1.0
CNMG 160616E-M:T9325	⬌	1.6	■	190	0.40	3.6	–	–	–	◪	180	0.40	3.6	–	–	–	–	–	–		–	–	–
CNMG 160616E-M:T9335	⬌	1.6	■	165	0.40	3.6	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190608E-M:6630	⬌	0.8	■	175	0.32	4.2	–	–	–	◪	165	0.32	4.2	–	–	–	–	–	–		–	–	–
CNMG 190608E-M:T9325	⬌	0.8	■	190	0.32	4.2	–	–	–	◪	180	0.32	4.2	–	–	–	–	–	–		–	–	–
CNMG 190608E-M:T9335	⬌	0.8	■	165	0.32	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190608E-M:T9415	⬌	0.8	■	250	0.32	4.2	–	–	–	◪	235	0.32	4.2	–	–	–	–	–	–	◪	50	0.16	0.7
CNMG 190612E-M:6630	⬌	1.2	■	170	0.40	4.2	–	–	–	◪	160	0.40	4.2	–	–	–	–	–	–		–	–	–
CNMG 190612E-M:6640	⬌	1.2	■	145	0.40	4.2	–	–	–	■	135	0.40	4.2	–	–	–	–	–	–		–	–	–
CNMG 190612E-M:T9325	●	1.2	■	185	0.40	4.2	–	–	–	◪	175	0.40	4.2	–	–	–	–	–	–		–	–	–
CNMG 190612E-M:T9335	●	1.2	■	160	0.40	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190612E-M:T9415	●	1.2	■	245	0.40	4.2	–	–	–	◪	230	0.40	4.2	–	–	–	–	–	–	◪	45	0.20	1.0
CNMG 190616E-M:T9325	●	1.6	■	190	0.40	4.2	–	–	–	◪	180	0.40	4.2	–	–	–	–	–	–		–	–	–
CNMG 190616E-M:T9335	●	1.6	■	165	0.40	4.2	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
CNMG 190616E-M:T9415	●	1.6	■	255	0.40	4.2	–	–	–	◪	240	0.40	4.2	–	–	–	–	–	–	◪	50	0.20	1.3

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

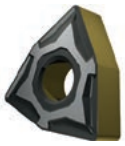
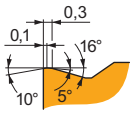
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																			
DNMG 110404E-M:T5315	0.4	210	0.20	1.2	–	–	–	195	0.20	1.2	–	–	–	–	–	–	40	0.14	0.3
DNMG 110404E-M:T9325	0.4	175	0.20	1.2	–	–	–	165	0.20	1.2	–	–	–	–	–	–	–	–	–
DNMG 110404E-M:T9335	0.4	150	0.20	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110404E-M:T9415	0.4	225	0.20	1.2	–	–	–	210	0.20	1.2	–	–	–	–	–	–	45	0.14	0.3
DNMG 110408E-M:T5315	0.8	215	0.30	1.2	–	–	–	200	0.30	1.2	–	–	–	–	–	–	40	0.15	0.7
DNMG 110408E-M:T9325	0.8	175	0.30	1.2	–	–	–	165	0.30	1.2	–	–	–	–	–	–	–	–	–
DNMG 110408E-M:T9335	0.8	155	0.30	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110408E-M:T9415	0.8	235	0.30	1.2	–	–	–	220	0.30	1.2	–	–	–	–	–	–	45	0.15	0.7
DNMG 110412E-M:T9325	1.2	165	0.40	1.2	–	–	–	155	0.40	1.2	–	–	–	–	–	–	–	–	–
DNMG 110412E-M:T9415	1.2	220	0.40	1.2	–	–	–	205	0.40	1.2	–	–	–	–	–	–	40	0.20	0.9
DNMG 150404E-M:T5315	0.4	200	0.20	1.9	–	–	–	190	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150404E-M:T9325	0.4	170	0.20	1.9	–	–	–	160	0.20	1.9	–	–	–	–	–	–	–	–	–
DNMG 150404E-M:T9415	0.4	210	0.20	1.9	–	–	–	195	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150408E-M:T5315	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150408E-M:T9315	0.8	190	0.30	1.9	–	–	–	180	0.30	1.9	–	–	–	–	–	–	35	0.15	0.7
DNMG 150408E-M:T9325	0.8	170	0.30	1.9	–	–	–	160	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150408E-M:T9335	0.8	145	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150408E-M:T9415	0.8	220	0.30	1.9	–	–	–	205	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150412E-M:T5315	1.2	200	0.40	1.9	–	–	–	190	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150412E-M:T9315	1.2	175	0.40	1.9	–	–	–	165	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150412E-M:T9325	1.2	160	0.40	1.9	–	–	–	150	0.40	1.9	–	–	–	–	–	–	–	–	–
DNMG 150412E-M:T9415	1.2	210	0.40	1.9	–	–	–	195	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150604E-M:T5315	0.4	200	0.20	1.9	–	–	–	190	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150604E-M:T9325	0.4	170	0.20	1.9	–	–	–	160	0.20	1.9	–	–	–	–	–	–	–	–	–
DNMG 150604E-M:T9335	0.4	145	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150604E-M:T9415	0.4	210	0.20	1.9	–	–	–	195	0.20	1.9	–	–	–	–	–	–	40	0.14	0.3
DNMG 150608E-M:T5315	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150608E-M:T9310	0.8	205	0.30	1.9	–	–	–	190	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150608E-M:T9315	0.8	190	0.30	1.9	–	–	–	180	0.30	1.9	–	–	–	–	–	–	35	0.15	0.7
DNMG 150608E-M:T9325	0.8	170	0.30	1.9	–	–	–	160	0.30	1.9	–	–	–	–	–	–	–	–	–
DNMG 150608E-M:T9335	0.8	145	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-M:T9415	0.8	220	0.30	1.9	–	–	–	205	0.30	1.9	–	–	–	–	–	–	40	0.15	0.7
DNMG 150612E-M:T5315	1.2	200	0.40	1.9	–	–	–	190	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9
DNMG 150612E-M:T9310	1.2	190	0.40	1.9	–	–	–	180	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-M:T9315	1.2	175	0.40	1.9	–	–	–	165	0.40	1.9	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-M:T9325	1.2	160	0.40	1.9	–	–	–	150	0.40	1.9	–	–	–	–	–	–	–	–	–
DNMG 150612E-M:T9335	1.2	140	0.40	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-M:T9415	1.2	210	0.40	1.9	–	–	–	195	0.40	1.9	–	–	–	–	–	–	40	0.20	0.9

M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.																			
SNMG 120408E-M:T5305	0.8	290	0.32	2.1	–	–	–	275	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
SNMG 120408E-M:T5315	0.8	260	0.32	2.1	–	–	–	245	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
SNMG 120408E-M:T9325	0.8	210	0.32	2.1	–	–	–	195	0.32	2.1	–	–	–	–	–	–	–	–	–
SNMG 120408E-M:T9335	0.8	185	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120408E-M:T9415	0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
SNMG 120412E-M:T9325	1.2	200	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 120412E-M:T9335	1.2	175	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120412E-M:T9415	1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.20	1.0
SNMG 120416E-M:T9325	1.6	210	0.40	2.1	–	–	–	195	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9325	1.2	195	0.40	3.4	–	–	–	185	0.40	3.4	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9335	1.2	170	0.40	3.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150612E-M:T9415	1.2	260	0.40	3.4	–	–	–	245	0.40	3.4	–	–	–	–	–	–	50	0.20	1.0
SNMG 190612E-M:6630	1.2	175	0.40	4.0	–	–	–	165	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9325	1.2	190	0.40	4.0	–	–	–	180	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9335	1.2	165	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190612E-M:T9415	1.2	255	0.40	4.0	–	–	–	240	0.40	4.0	–	–	–	–	–	–	50	0.20	1.0
SNMG 190616E-M:T9325	1.6	200	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-M:T9335	1.6	175	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-M:T9415	1.6	270	0.40	4.0	–	–	–	255	0.40	4.0	–	–	–	–	–	–	50	0.20	1.3
 																			
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.																			
TNMG 160404E-M:T5315	0.4	215	0.20	1.6	–	–	–	200	0.20	1.6	–	–	–	–	–	–	40	0.14	0.3
TNMG 160404E-M:T9325	0.4	180	0.20	1.6	–	–	–	170	0.20	1.6	–	–	–	–	–	–	–	–	–
TNMG 160404E-M:T9335	0.4	155	0.20	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160404E-M:T9415	0.4	230	0.20	1.6	–	–	–	215	0.20	1.6	–	–	–	–	–	–	45	0.14	0.3
TNMG 160408E-M:T5305	0.8	250	0.30	1.6	–	–	–	235	0.30	1.6	–	–	–	–	–	–	50	0.15	0.7
TNMG 160408E-M:T5315	0.8	225	0.30	1.6	–	–	–	210	0.30	1.6	–	–	–	–	–	–	45	0.15	0.7
TNMG 160408E-M:T9310	0.8	220	0.30	1.6	–	–	–	205	0.30	1.6	–	–	–	–	–	–	40	0.15	0.7
TNMG 160408E-M:T9325	0.8	185	0.30	1.6	–	–	–	175	0.30	1.6	–	–	–	–	–	–	–	–	–
TNMG 160408E-M:T9335	0.8	160	0.30	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160408E-M:T9415	0.8	240	0.30	1.6	–	–	–	225	0.30	1.6	–	–	–	–	–	–	45	0.15	0.7
TNMG 160412E-M:T5315	1.2	215	0.40	1.6	–	–	–	200	0.40	1.6	–	–	–	–	–	–	40	0.20	0.9
TNMG 160412E-M:T9325	1.2	170	0.40	1.6	–	–	–	160	0.40	1.6	–	–	–	–	–	–	–	–	–
TNMG 160412E-M:T9335	1.2	145	0.40	1.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-M:T9415	1.2	225	0.40	1.6	–	–	–	210	0.40	1.6	–	–	–	–	–	–	45	0.20	0.9
TNMG 220408E-M:T5315	0.8	215	0.30	2.1	–	–	–	200	0.30	2.1	–	–	–	–	–	–	40	0.15	0.7
TNMG 220408E-M:T9325	0.8	180	0.30	2.1	–	–	–	170	0.30	2.1	–	–	–	–	–	–	–	–	–
TNMG 220408E-M:T9335	0.8	155	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-M:T9415	0.8	230	0.30	2.1	–	–	–	215	0.30	2.1	–	–	–	–	–	–	45	0.15	0.7
TNMG 220412E-M:T5315	1.2	205	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	40	0.20	0.9
TNMG 220412E-M:T9325	1.2	165	0.40	2.1	–	–	–	155	0.40	2.1	–	–	–	–	–	–	–	–	–
TNMG 220412E-M:T9335	1.2	140	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220412E-M:T9415	1.2	225	0.40	2.1	–	–	–	210	0.40	2.1	–	–	–	–	–	–	45	0.20	0.9
 																			
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.																			
VNMG 160404E-M:T5315	0.4	180	0.20	1.2	–	–	–	170	0.20	1.2	–	–	–	–	–	–	35	0.14	0.3
VNMG 160404E-M:T9325	0.4	155	0.20	1.2	–	–	–	145	0.20	1.2	–	–	–	–	–	–	–	–	–
VNMG 160404E-M:T9415	0.4	195	0.20	1.2	–	–	–	185	0.20	1.2	–	–	–	–	–	–	35	0.14	0.3
VNMG 160408E-M:T5305	0.8	205	0.30	1.4	–	–	–	190	0.30	1.4	–	–	–	–	–	–	40	0.15	0.7
VNMG 160408E-M:T5315	0.8	185	0.30	1.4	–	–	–	175	0.30	1.4	–	–	–	–	–	–	35	0.15	0.7
VNMG 160408E-M:T9325	0.8	150	0.30	1.4	–	–	–	140	0.30	1.4	–	–	–	–	–	–	–	–	–
VNMG 160408E-M:T9335	0.8	130	0.30	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160408E-M:T9415	0.8	200	0.30	1.4	–	–	–	190	0.30	1.4	–	–	–	–	–	–	40	0.15	0.7
VNMG 160412E-M:T9325	1.2	140	0.40	1.4	–	–	–	130	0.40	1.4	–	–	–	–	–	–	–	–	–

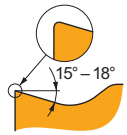
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				

M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

WNMG 060404E-M:T5315		0.4	250	0.20	1.8	–	–	–	235	0.20	1.8	–	–	–	–	–	–	50	0.13	0.3
WNMG 060404E-M:T9325		0.4	215	0.20	1.8	–	–	–	200	0.20	1.8	–	–	–	–	–	–	–	–	–
WNMG 060404E-M:T9415		0.4	270	0.20	1.8	–	–	–	255	0.20	1.8	–	–	–	–	–	–	50	0.13	0.3
WNMG 060408E-M:T5315		0.8	255	0.32	1.8	–	–	–	240	0.32	1.8	–	–	–	–	–	–	50	0.16	0.7
WNMG 060408E-M:T9325		0.8	205	0.32	1.8	–	–	–	190	0.32	1.8	–	–	–	–	–	–	–	–	–
WNMG 060408E-M:T9335		0.8	180	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 060408E-M:T9415		0.8	275	0.32	1.8	–	–	–	260	0.32	1.8	–	–	–	–	–	–	55	0.16	0.7
WNMG 080404E-M:T5315		0.4	260	0.20	1.2	–	–	–	245	0.20	1.2	–	–	–	–	–	–	50	0.13	0.3
WNMG 080404E-M:T9325		0.4	210	0.20	2.1	–	–	–	195	0.20	2.1	–	–	–	–	–	–	–	–	–
WNMG 080404E-M:T9335		0.4	180	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-M:T9415		0.4	265	0.20	2.1	–	–	–	250	0.20	2.1	–	–	–	–	–	–	50	0.13	0.3
WNMG 080408E-M:T5305		0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
WNMG 080408E-M:T5315		0.8	250	0.32	2.1	–	–	–	235	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
WNMG 080408E-M:T8430		0.8	170	0.32	2.1	–	–	–	135	0.32	2.1	–	–	–	–	–	–	25	0.16	0.7
WNMG 080408E-M:T9310		0.8	245	0.32	2.1	–	–	–	230	0.32	2.1	–	–	–	–	–	–	45	0.16	0.7
WNMG 080408E-M:T9315		0.8	225	0.32	2.1	–	–	–	210	0.32	2.1	–	–	–	–	–	–	45	0.16	0.7
WNMG 080408E-M:T9325		0.8	200	0.32	2.1	–	–	–	190	0.32	2.1	–	–	–	–	–	–	–	–	–
WNMG 080408E-M:T9335		0.8	180	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-M:T9415		0.8	270	0.32	2.1	–	–	–	255	0.32	2.1	–	–	–	–	–	–	50	0.16	0.7
WNMG 080412E-M:T5305		1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.20	1.0
WNMG 080412E-M:T5315		1.2	245	0.40	2.1	–	–	–	230	0.40	2.1	–	–	–	–	–	–	45	0.20	1.0
WNMG 080412E-M:T9310		1.2	235	0.40	2.1	–	–	–	220	0.40	2.1	–	–	–	–	–	–	45	0.20	1.0
WNMG 080412E-M:T9315		1.2	220	0.40	2.1	–	–	–	205	0.40	2.1	–	–	–	–	–	–	40	0.20	1.0
WNMG 080412E-M:T9325		1.2	195	0.40	2.1	–	–	–	185	0.40	2.1	–	–	–	–	–	–	–	–	–
WNMG 080412E-M:T9335		1.2	170	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-M:T9415		1.2	265	0.40	2.1	–	–	–	250	0.40	2.1	–	–	–	–	–	–	50	0.20	1.0

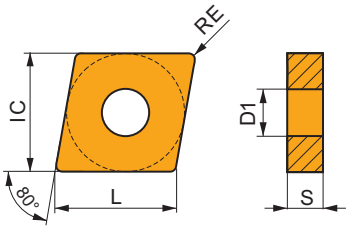
SI



SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

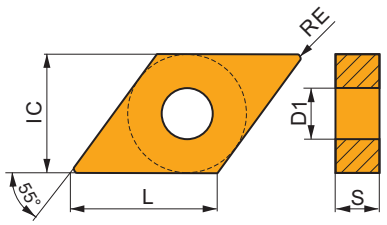
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



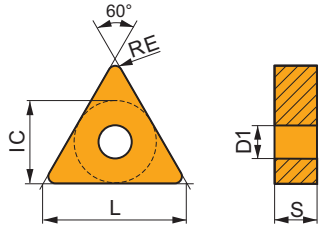
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



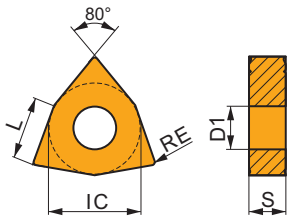
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

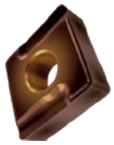
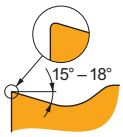
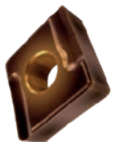
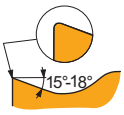


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																			
CNMG 120404ER-SI:T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
CNMG 120404ER-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
CNMG 120404ER-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
CNMG 120408ER-SI:T7325	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408ER-SI:T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408ER-SI:T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
CNMG 120408ER-SI:T9325	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
CNMG 120412ER-SI:T8430	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–
  																			
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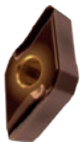
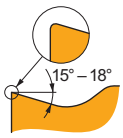
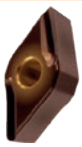
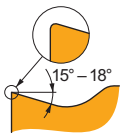
CNMG 120404EL-SI:T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
CNMG 120404EL-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
CNMG 120404EL-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
CNMG 120408EL-SI:T7325	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408EL-SI:T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
CNMG 120408EL-SI:T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
CNMG 120408EL-SI:T9325	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
CNMG 120412EL-SI:T8430	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–
  																			
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																			
DNMG 110404ER-SI:T7325	0.4	185	0.20	1.0	140	0.18	1.0	–	–	–	–	–	–	60	0.18	0.8	–	–	–
DNMG 110404ER-SI:T7335	0.4	180	0.20	1.0	140	0.18	1.0	–	–	–	–	–	–	55	0.18	0.8	–	–	–
DNMG 110404ER-SI:T8430	0.4	185	0.20	1.0	100	0.18	1.0	–	–	–	510	0.24	1.0	40	0.18	0.8	–	–	–
DNMG 110404ER-SI:T9325	0.4	225	0.20	1.0	135	0.18	1.0	–	–	–	–	–	–	50	0.18	0.8	–	–	–
DNMG 110408ER-SI:T7335	0.8	175	0.35	1.0	135	0.32	1.0	–	–	–	–	–	–	55	0.25	0.8	–	–	–
DNMG 110408ER-SI:T8430	0.8	180	0.35	1.0	95	0.32	1.0	–	–	–	495	0.42	1.0	35	0.25	0.8	–	–	–
DNMG 110408ER-SI:T9325	0.8	210	0.35	1.0	125	0.32	1.0	–	–	–	–	–	–	45	0.25	0.8	–	–	–
DNMG 150404ER-SI:T8430	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150404ER-SI:T9325	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150408ER-SI:T8430	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150408ER-SI:T9325	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150604ER-SI:T7325	0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604ER-SI:T7335	0.4	170	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8315	0.4	165	0.20	1.5	95	0.18	1.5	–	–	–	495	0.24	1.5	40	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8415	0.4	195	0.20	1.5	100	0.18	1.5	–	–	–	495	0.24	1.5	45	0.18	1.2	–	–	–
DNMG 150604ER-SI:T8430	0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150604ER-SI:T9325	0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150604ER-SI:T9335	0.4	185	0.20	1.5	110	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
DNMG 150608ER-SI:T7325	0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608ER-SI:T7335	0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608ER-SI:T8315	0.8	165	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	40	0.25	1.2	–	–	–
DNMG 150608ER-SI:T8415	0.8	200	0.35	1.5	105	0.32	1.5	–	–	–	510	0.42	1.5	45	0.24	1.2	–	–	–
DNMG 150608ER-SI:T8430	0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150608ER-SI:T9325	0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150608ER-SI:T9335	0.8	180	0.35	1.5	105	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–

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	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
  																			
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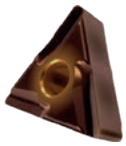
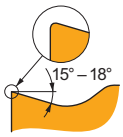
DNMG 110404EL-SI:T8430	● 0.4	185	0.20	1.0	100	0.18	1.0	–	–	–	510	0.24	1.0	40	0.18	0.8	–	–	–
DNMG 110404EL-SI:T9325	● 0.4	225	0.20	1.0	135	0.18	1.0	–	–	–	–	–	–	50	0.18	0.8	–	–	–
DNMG 110408EL-SI:T8430	● 0.8	180	0.35	1.0	95	0.32	1.0	–	–	–	495	0.42	1.0	35	0.25	0.8	–	–	–
DNMG 110408EL-SI:T9325	● 0.8	210	0.35	1.0	125	0.32	1.0	–	–	–	–	–	–	45	0.25	0.8	–	–	–
DNMG 150404EL-SI:T8430	● 0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150404EL-SI:T9325	● 0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150408EL-SI:T7335	● 0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150408EL-SI:T8430	● 0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150408EL-SI:T9325	● 0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150604EL-SI:T7325	● 0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604EL-SI:T7335	● 0.4	170	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
DNMG 150604EL-SI:T8315	● 0.4	165	0.20	1.5	95	0.18	1.5	–	–	–	495	0.24	1.5	40	0.18	1.2	–	–	–
DNMG 150604EL-SI:T8430	● 0.4	175	0.20	1.5	95	0.18	1.5	–	–	–	480	0.24	1.5	35	0.18	1.2	–	–	–
DNMG 150604EL-SI:T9325	● 0.4	220	0.20	1.5	130	0.18	1.5	–	–	–	–	–	–	45	0.18	1.2	–	–	–
DNMG 150604EL-SI:T9335	● 0.4	185	0.20	1.5	110	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
DNMG 150608EL-SI:T7325	● 0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608EL-SI:T7335	● 0.8	170	0.35	1.5	130	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
DNMG 150608EL-SI:T8315	● 0.8	165	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	40	0.25	1.2	–	–	–
DNMG 150608EL-SI:T8415	● 0.8	200	0.35	1.5	105	0.32	1.5	–	–	–	510	0.42	1.5	45	0.24	1.2	–	–	–
DNMG 150608EL-SI:T8430	● 0.8	170	0.35	1.5	90	0.32	1.5	–	–	–	465	0.42	1.5	35	0.25	1.2	–	–	–
DNMG 150608EL-SI:T9325	● 0.8	200	0.35	1.5	120	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
DNMG 150608EL-SI:T9335	● 0.8	180	0.35	1.5	105	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–
  																			
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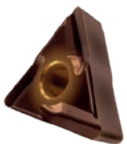
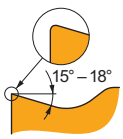
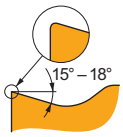
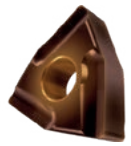
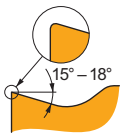
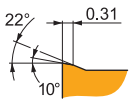
TNMG 160404ER-SI:T7325	● 0.4	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	60	0.18	1.2	–	–	–
TNMG 160404ER-SI:T7335	● 0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8315	● 0.4	175	0.20	1.5	105	0.18	1.5	–	–	–	525	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8415	● 0.4	210	0.20	1.5	110	0.18	1.5	–	–	–	525	0.24	1.5	45	0.18	1.2	–	–	–
TNMG 160404ER-SI:T8430	● 0.4	185	0.20	1.5	100	0.18	1.5	–	–	–	510	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404ER-SI:T9325	● 0.4	230	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	50	0.18	1.2	–	–	–
TNMG 160404ER-SI:T9335	● 0.4	195	0.20	1.5	115	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
TNMG 160408ER-SI:T7325	● 0.8	190	0.35	1.5	145	0.32	1.5	–	–	–	–	–	–	60	0.25	1.2	–	–	–
TNMG 160408ER-SI:T7335	● 0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
TNMG 160408ER-SI:T8315	● 0.8	175	0.35	1.5	105	0.32	1.5	–	–	–	525	0.42	1.5	40	0.25	1.2	–	–	–
TNMG 160408ER-SI:T8415	● 0.8	215	0.35	1.5	110	0.32	1.5	–	–	–	540	0.42	1.5	45	0.24	1.2	–	–	–
TNMG 160408ER-SI:T8430	● 0.8	180	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	35	0.25	1.2	–	–	–
TNMG 160408ER-SI:T9325	● 0.8	215	0.35	1.5	125	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
TNMG 160408ER-SI:T9335	● 0.8	190	0.35	1.5	110	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–
  																			
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																			
TNMG 160404EL-SI:T7325	● 0.4	190	0.20	1.5	145	0.18	1.5	–	–	–	–	–	–	60	0.18	1.2	–	–	–
TNMG 160404EL-SI:T7335	● 0.4	180	0.20	1.5	140	0.18	1.5	–	–	–	–	–	–	55	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8315	● 0.4	175	0.20	1.5	105	0.18	1.5	–	–	–	525	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8415	● 0.4	210	0.20	1.5	110	0.18	1.5	–	–	–	525	0.24	1.5	45	0.18	1.2	–	–	–
TNMG 160404EL-SI:T8430	● 0.4	185	0.20	1.5	100	0.18	1.5	–	–	–	510	0.24	1.5	40	0.18	1.2	–	–	–
TNMG 160404EL-SI:T9325	● 0.4	230	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	50	0.18	1.2	–	–	–
TNMG 160404EL-SI:T9335	● 0.4	195	0.20	1.5	115	0.18	1.5	–	–	–	–	–	–	40	0.18	1.2	–	–	–
TNMG 160408EL-SI:T7325	● 0.8	190	0.35	1.5	145	0.32	1.5	–	–	–	–	–	–	60	0.25	1.2	–	–	–
TNMG 160408EL-SI:T7335	● 0.8	180	0.35	1.5	140	0.32	1.5	–	–	–	–	–	–	55	0.25	1.2	–	–	–
TNMG 160408EL-SI:T8315	● 0.8	175	0.35	1.5	105	0.32	1.5	–	–	–	525	0.42	1.5	40	0.25	1.2	–	–	–
TNMG 160408EL-SI:T8415	● 0.8	215	0.35	1.5	110	0.32	1.5	–	–	–	540	0.42	1.5	45	0.24	1.2	–	–	–
TNMG 160408EL-SI:T8430	● 0.8	180	0.35	1.5	95	0.32	1.5	–	–	–	495	0.42	1.5	35	0.25	1.2	–	–	–
TNMG 160408EL-SI:T9325	● 0.8	215	0.35	1.5	125	0.32	1.5	–	–	–	–	–	–	45	0.25	1.2	–	–	–
TNMG 160408EL-SI:T9335	● 0.8	190	0.35	1.5	110	0.32	1.5	–	–	–	–	–	–	40	0.25	1.2	–	–	–

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	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
																			
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																			
WNMG 060404ER-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 060404ER-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080404ER-SI:T7325	0.4	220	0.20	1.7	170	0.18	1.7	–	–	–	–	–	–	70	0.18	1.4	–	–	–
WNMG 080404ER-SI:T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8315	0.4	205	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	50	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8415	0.4	250	0.20	1.7	130	0.18	1.7	–	–	–	630	0.24	1.7	55	0.18	1.4	–	–	–
WNMG 080404ER-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 080404ER-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080408ER-SI:T7325	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408ER-SI:T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408ER-SI:T8315	0.8	205	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	50	0.25	1.4	–	–	–
WNMG 080408ER-SI:T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
WNMG 080408ER-SI:T9325	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
WNMG 080412ER-SI:T8430	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–
																			
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																			
WNMG 060404EL-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 060404EL-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080404EL-SI:T7325	0.4	220	0.20	1.7	170	0.18	1.7	–	–	–	–	–	–	70	0.18	1.4	–	–	–
WNMG 080404EL-SI:T7335	0.4	215	0.20	1.7	165	0.18	1.7	–	–	–	–	–	–	65	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8315	0.4	205	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	50	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8415	0.4	250	0.20	1.7	130	0.18	1.7	–	–	–	630	0.24	1.7	55	0.18	1.4	–	–	–
WNMG 080404EL-SI:T8430	0.4	225	0.20	1.7	120	0.18	1.7	–	–	–	615	0.24	1.7	45	0.18	1.4	–	–	–
WNMG 080404EL-SI:T9325	0.4	270	0.20	1.7	160	0.18	1.7	–	–	–	–	–	–	60	0.18	1.4	–	–	–
WNMG 080408EL-SI:T7325	0.8	215	0.35	1.7	165	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408EL-SI:T7335	0.8	205	0.35	1.7	155	0.32	1.7	–	–	–	–	–	–	65	0.25	1.4	–	–	–
WNMG 080408EL-SI:T8315	0.8	205	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	50	0.25	1.4	–	–	–
WNMG 080408EL-SI:T8430	0.8	210	0.35	1.7	115	0.32	1.7	–	–	–	585	0.42	1.7	45	0.25	1.4	–	–	–
WNMG 080408EL-SI:T9325	0.8	255	0.35	1.7	150	0.32	1.7	–	–	–	–	–	–	55	0.25	1.4	–	–	–
WNMG 080412EL-SI:T8430	1.2	225	0.35	1.7	120	0.32	1.7	–	–	–	615	0.42	1.7	45	0.25	1.4	–	–	–

NMR

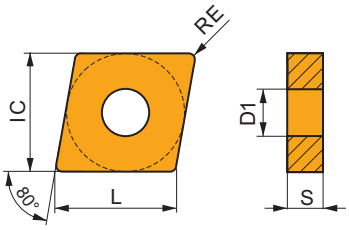


NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

PRAMET

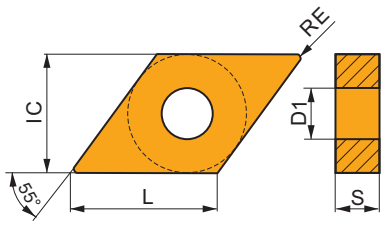
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



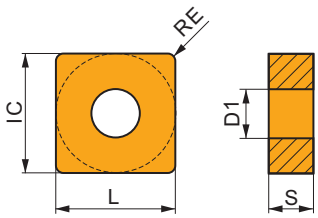
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



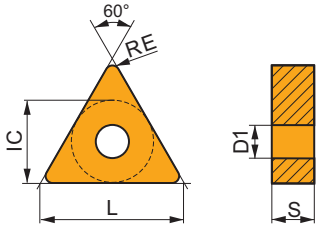
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



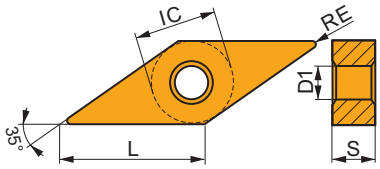
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



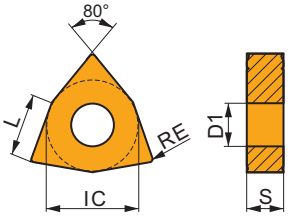
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



WNMG

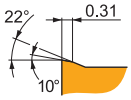
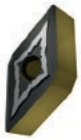
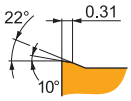
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



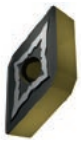
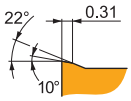
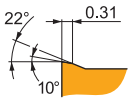
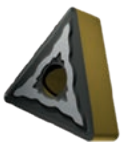
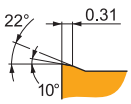
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
CNMG 090308E-NMR:T7325	⇕	0.8	175	0.35	1.6	135	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
CNMG 090308E-NMR:T7335	⇕	0.8	170	0.35	1.6	130	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
CNMG 120404E-NMR:T7325	●	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.20	2.2	–	–	–
CNMG 120404E-NMR:T7335	●	0.4	155	0.25	2.0	120	0.23	2.0	–	–	–	–	–	–	50	0.20	1.6	–	–	–
CNMG 120404E-NMR:T8430	⇕	0.4	150	0.25	2.7	80	0.23	2.7	–	–	–	–	–	–	30	0.20	2.2	–	–	–
CNMG 120404E-NMR:T9325	●	0.4	190	0.25	2.0	110	0.23	2.0	–	–	–	–	–	–	40	0.20	1.6	–	–	–
CNMG 120404E-NMR:T9415	●	0.4	245	0.25	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

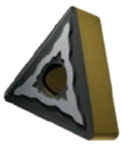
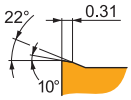
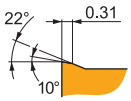
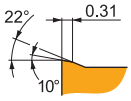
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
 		**NMR** chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.																	
CNMG 120408E-NMR:T6310	0.8	150	0.35	2.7	105	0.32	2.7	–	–	–	–	–	–	45	0.25	2.2	–	–	–
CNMG 120408E-NMR:T7325	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.25	2.2	–	–	–
CNMG 120408E-NMR:T7335	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.25	2.2	–	–	–
CNMG 120408E-NMR:T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
CNMG 120408E-NMR:T9325	0.8	190	0.35	2.7	110	0.32	2.7	–	–	–	–	–	–	40	0.25	2.2	–	–	–
CNMG 120408E-NMR:T9415	0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-NMR:T6310	1.2	150	0.40	2.7	105	0.36	2.7	–	–	–	–	–	–	45	0.28	2.2	–	–	–
CNMG 120412E-NMR:T7325	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
CNMG 120412E-NMR:T7335	1.2	160	0.40	2.7	120	0.36	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
CNMG 120412E-NMR:T8430	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
CNMG 120412E-NMR:T9325	1.2	190	0.40	2.7	110	0.36	2.7	–	–	–	–	–	–	40	0.28	2.2	–	–	–
CNMG 120412E-NMR:T9415	1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120416E-NMR:T7325	1.6	170	0.45	2.7	130	0.41	2.7	–	–	–	–	–	–	55	0.32	2.2	–	–	–
CNMG 120416E-NMR:T7335	1.6	160	0.45	2.7	120	0.41	2.7	–	–	–	–	–	–	50	0.32	2.2	–	–	–
CNMG 120416E-NMR:T8430	1.6	155	0.45	2.7	85	0.41	2.7	–	–	–	–	–	–	30	0.32	2.2	–	–	–
CNMG 160608E-NMR:T7325	0.8	160	0.35	4.0	120	0.32	4.0	–	–	–	–	–	–	50	0.25	3.2	–	–	–
CNMG 160608E-NMR:T7335	0.8	150	0.35	4.0	115	0.32	4.0	–	–	–	–	–	–	45	0.25	3.2	–	–	–
CNMG 160608E-NMR:T9325	0.8	185	0.35	4.0	110	0.32	4.0	–	–	–	–	–	–	40	0.25	3.2	–	–	–
CNMG 160608E-NMR:T9415	0.8	245	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-NMR:T7325	1.2	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 160612E-NMR:T7335	1.2	155	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 160612E-NMR:T8430	1.2	150	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
CNMG 160612E-NMR:T9325	1.2	185	0.40	4.0	110	0.36	4.0	–	–	–	–	–	–	40	0.28	3.2	–	–	–
CNMG 160612E-NMR:T9415	1.2	245	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160616E-NMR:T7325	1.6	165	0.45	4.0	125	0.41	4.0	–	–	–	–	–	–	50	0.32	3.2	–	–	–
CNMG 160616E-NMR:T7335	1.6	155	0.45	4.0	120	0.41	4.0	–	–	–	–	–	–	50	0.32	3.2	–	–	–
CNMG 160616E-NMR:T8430	1.6	150	0.45	4.0	80	0.41	4.0	–	–	–	–	–	–	30	0.32	3.2	–	–	–
CNMG 160616E-NMR:T9325	1.6	180	0.45	4.0	105	0.41	4.0	–	–	–	–	–	–	40	0.32	3.2	–	–	–
CNMG 160616E-NMR:T9415	1.6	240	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190608E-NMR:T6310	0.8	140	0.35	5.2	100	0.32	5.2	–	–	–	–	–	–	40	0.25	4.2	–	–	–
CNMG 190608E-NMR:T7325	0.8	155	0.35	5.2	120	0.32	5.2	–	–	–	–	–	–	50	0.25	4.2	–	–	–
CNMG 190608E-NMR:T7335	0.8	150	0.35	5.2	115	0.32	5.2	–	–	–	–	–	–	45	0.25	4.2	–	–	–
CNMG 190608E-NMR:T9325	0.8	180	0.35	5.2	105	0.32	5.2	–	–	–	–	–	–	40	0.25	4.2	–	–	–
CNMG 190608E-NMR:T9415	0.8	225	0.35	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-NMR:T6310	1.2	140	0.40	5.2	100	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
CNMG 190612E-NMR:T7325	1.2	160	0.40	5.2	120	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
CNMG 190612E-NMR:T7335	1.2	150	0.40	5.2	115	0.36	5.2	–	–	–	–	–	–	45	0.28	4.2	–	–	–
CNMG 190612E-NMR:T8430	1.2	145	0.40	5.2	80	0.36	5.2	–	–	–	–	–	–	30	0.28	4.2	–	–	–
CNMG 190612E-NMR:T9325	1.2	180	0.40	5.2	105	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
CNMG 190616E-NMR:T7325	1.6	160	0.45	5.2	120	0.41	5.2	–	–	–	–	–	–	50	0.32	4.2	–	–	–
CNMG 190616E-NMR:T7335	1.6	150	0.45	5.2	115	0.41	5.2	–	–	–	–	–	–	45	0.32	4.2	–	–	–
CNMG 190616E-NMR:T8430	1.6	145	0.45	5.2	80	0.41	5.2	–	–	–	–	–	–	30	0.32	4.2	–	–	–
CNMG 190616E-NMR:T9325	1.6	175	0.45	5.2	105	0.41	5.2	–	–	–	–	–	–	35	0.32	4.2	–	–	–
CNMG 190616E-NMR:T9415	1.6	240	0.45	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 		**NMR** chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.																	
DNMG 110404E-NMR:T7325	0.4	150	0.20	0.8	115	0.18	0.8	–	–	–	–	–	–	45	0.18	0.6	–	–	–
DNMG 110404E-NMR:T9325	0.4	185	0.20	0.8	110	0.18	0.8	–	–	–	–	–	–	40	0.18	0.6	–	–	–
DNMG 110408E-NMR:T7325	0.8	155	0.30	0.8	120	0.27	0.8	–	–	–	–	–	–	50	0.24	0.6	–	–	–
DNMG 110408E-NMR:T9415	0.8	240	0.30	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 110412E-NMR:T7325	1.2	155	0.30	1.6	120	0.27	1.6	–	–	–	–	–	–	50	0.24	1.3	–	–	–
DNMG 110412E-NMR:T9325	1.2	180	0.30	1.6	105	0.27	1.6	–	–	–	–	–	–	40	0.24	1.3	–	–	–

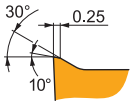
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.																			
DNMG 150404E-NMR:T7325	0.4	140	0.20	1.9	105	0.18	1.9	–	–	–	–	–	–	45	0.18	1.5	–	–	–
DNMG 150404E-NMR:T9325	0.4	170	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	35	0.18	1.5	–	–	–
DNMG 150408E-NMR:T7325	0.8	145	0.30	1.9	110	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150408E-NMR:T8430	0.8	135	0.30	1.9	75	0.27	1.9	–	–	–	–	–	–	25	0.24	1.5	–	–	–
DNMG 150408E-NMR:T9325	0.8	170	0.30	1.9	100	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150408E-NMR:T9415	0.8	220	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150604E-NMR:T7325	0.4	140	0.20	1.9	105	0.18	1.9	–	–	–	–	–	–	45	0.18	1.5	–	–	–
DNMG 150604E-NMR:T7335	0.4	130	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	40	0.18	1.5	–	–	–
DNMG 150604E-NMR:T8430	0.4	135	0.20	1.9	75	0.18	1.9	–	–	–	–	–	–	25	0.18	1.5	–	–	–
DNMG 150604E-NMR:T9325	0.4	170	0.20	1.9	100	0.18	1.9	–	–	–	–	–	–	35	0.18	1.5	–	–	–
DNMG 150604E-NMR:T9415	0.4	210	0.20	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150608E-NMR:T6310	0.8	125	0.30	1.9	90	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150608E-NMR:T7325	0.8	145	0.30	1.9	110	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150608E-NMR:T7335	0.8	140	0.30	1.9	105	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–
DNMG 150608E-NMR:T8430	0.8	135	0.30	1.9	75	0.27	1.9	–	–	–	–	–	–	25	0.24	1.5	–	–	–
DNMG 150608E-NMR:T9325	0.8	170	0.30	1.9	100	0.27	1.9	–	–	–	–	–	–	35	0.24	1.5	–	–	–
DNMG 150608E-NMR:T9415	0.8	220	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-NMR:T7325	1.2	155	0.30	1.9	120	0.27	1.9	–	–	–	–	–	–	50	0.24	1.5	–	–	–
DNMG 150612E-NMR:T8430	1.2	145	0.30	1.9	80	0.27	1.9	–	–	–	–	–	–	30	0.24	1.5	–	–	–
DNMG 150612E-NMR:T9325	1.2	180	0.30	1.9	105	0.27	1.9	–	–	–	–	–	–	40	0.24	1.5	–	–	–
DNMG 150612E-NMR:T9415	1.2	235	0.30	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																			
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.																			
SNMG 120408E-NMR:T7325	0.8	175	0.35	2.6	135	0.32	2.6	–	–	–	–	–	–	55	0.25	2.1	–	–	–
SNMG 120408E-NMR:T7335	0.8	165	0.35	2.6	125	0.32	2.6	–	–	–	–	–	–	50	0.25	2.1	–	–	–
SNMG 120408E-NMR:T8430	0.8	165	0.35	2.6	90	0.32	2.6	–	–	–	–	–	–	35	0.25	2.1	–	–	–
SNMG 120408E-NMR:T9325	0.8	200	0.35	2.6	120	0.32	2.6	–	–	–	–	–	–	45	0.25	2.1	–	–	–
SNMG 120412E-NMR:T6310	1.2	160	0.40	2.6	115	0.36	2.6	–	–	–	–	–	–	45	0.28	2.1	–	–	–
SNMG 120412E-NMR:T7335	1.2	165	0.40	2.6	125	0.36	2.6	–	–	–	–	–	–	50	0.28	2.1	–	–	–
SNMG 120412E-NMR:T9325	1.2	200	0.40	2.6	120	0.36	2.6	–	–	–	–	–	–	45	0.28	2.1	–	–	–
SNMG 120416E-NMR:T7325	1.6	180	0.45	2.6	140	0.41	2.6	–	–	–	–	–	–	55	0.32	2.1	–	–	–
SNMG 150612E-NMR:T6310	1.2	150	0.40	3.8	105	0.36	3.8	–	–	–	–	–	–	45	0.28	3.0	–	–	–
SNMG 150612E-NMR:T7325	1.2	170	0.40	3.8	130	0.36	3.8	–	–	–	–	–	–	55	0.28	3.0	–	–	–
SNMG 150612E-NMR:T8430	1.2	155	0.40	3.8	85	0.36	3.8	–	–	–	–	–	–	30	0.28	3.0	–	–	–
SNMG 150612E-NMR:T9325	1.2	190	0.40	3.8	110	0.36	3.8	–	–	–	–	–	–	40	0.28	3.0	–	–	–
SNMG 190612E-NMR:T6310	1.2	145	0.40	5.2	100	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
SNMG 190612E-NMR:T7325	1.2	165	0.40	5.2	125	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
SNMG 190612E-NMR:T7335	1.2	155	0.40	5.2	120	0.36	5.2	–	–	–	–	–	–	50	0.28	4.2	–	–	–
SNMG 190612E-NMR:T9325	1.2	185	0.40	5.2	110	0.36	5.2	–	–	–	–	–	–	40	0.28	4.2	–	–	–
SNMG 190616E-NMR:T6310	1.6	150	0.45	5.2	105	0.41	5.2	–	–	–	–	–	–	45	0.32	4.2	–	–	–
SNMG 190616E-NMR:T7325	1.6	170	0.45	5.2	130	0.41	5.2	–	–	–	–	–	–	55	0.32	4.2	–	–	–
SNMG 190616E-NMR:T7335	1.6	155	0.45	5.2	120	0.41	5.2	–	–	–	–	–	–	50	0.32	4.2	–	–	–
SNMG 190616E-NMR:T8430	1.6	150	0.45	5.2	80	0.41	5.2	–	–	–	–	–	–	30	0.32	4.2	–	–	–
SNMG 190616E-NMR:T9415	1.6	250	0.45	5.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
 																			
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.																			
TNMG 160404E-NMR:T6310	0.4	130	0.20	1.7	90	0.18	1.7	–	–	–	–	–	–	35	0.18	1.4	–	–	–
TNMG 160404E-NMR:T7325	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-NMR:T7335	0.4	145	0.20	1.7	110	0.18	1.7	–	–	–	–	–	–	45	0.18	1.4	–	–	–
TNMG 160404E-NMR:T8430	0.4	145	0.20	1.7	80	0.18	1.7	–	–	–	–	–	–	30	0.18	1.4	–	–	–
TNMG 160404E-NMR:T9325	0.4	180	0.20	1.7	105	0.18	1.7	–	–	–	–	–	–	40	0.18	1.4	–	–	–

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.																			
TNMG 160408E-NMR:T6310	0.8	140	0.30	1.7	100	0.27	1.7	–	–	–	–	–	–	40	0.24	1.4	–	–	–
TNMG 160408E-NMR:T7325	0.8	155	0.30	1.7	120	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160408E-NMR:T7335	0.8	145	0.30	1.7	110	0.27	1.7	–	–	–	–	–	–	45	0.24	1.4	–	–	–
TNMG 160408E-NMR:T8430	0.8	150	0.30	1.7	80	0.27	1.7	–	–	–	–	–	–	30	0.24	1.4	–	–	–
TNMG 160408E-NMR:T9325	0.8	185	0.30	1.7	110	0.27	1.7	–	–	–	–	–	–	40	0.24	1.4	–	–	–
TNMG 160408E-NMR:T9415	0.8	235	0.30	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-NMR:T7325	1.2	165	0.30	1.7	125	0.27	1.7	–	–	–	–	–	–	50	0.24	1.4	–	–	–
TNMG 160412E-NMR:T8430	1.2	155	0.30	1.7	85	0.27	1.7	–	–	–	–	–	–	30	0.24	1.4	–	–	–
TNMG 160412E-NMR:T9415	1.2	250	0.30	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-NMR:T6310	0.8	135	0.30	2.1	95	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220408E-NMR:T7325	0.8	150	0.30	2.1	115	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
TNMG 220408E-NMR:T7335	0.8	145	0.30	2.1	110	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
TNMG 220408E-NMR:T8430	0.8	145	0.30	2.1	80	0.27	2.1	–	–	–	–	–	–	30	0.24	1.7	–	–	–
TNMG 220408E-NMR:T9325	0.8	180	0.30	2.1	105	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T6310	1.2	140	0.30	2.1	100	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T7325	1.2	160	0.30	2.1	120	0.27	2.1	–	–	–	–	–	–	50	0.24	1.7	–	–	–
TNMG 220412E-NMR:T9325	1.2	190	0.30	2.1	110	0.27	2.1	–	–	–	–	–	–	40	0.24	1.7	–	–	–
TNMG 220412E-NMR:T9415	1.2	245	0.30	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
  																			
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.																			
VNMG 160404E-NMR:T7325	0.4	125	0.20	1.2	95	0.18	1.2	–	–	–	–	–	–	40	0.18	1.0	–	–	–
VNMG 160404E-NMR:T9325	0.4	155	0.20	1.2	90	0.18	1.2	–	–	–	–	–	–	30	0.18	1.0	–	–	–
VNMG 160408E-NMR:T7325	0.8	130	0.30	1.4	100	0.27	1.4	–	–	–	–	–	–	40	0.24	1.1	–	–	–
VNMG 160408E-NMR:T8430	0.8	125	0.30	1.4	65	0.27	1.4	–	–	–	–	–	–	25	0.24	1.1	–	–	–
VNMG 160408E-NMR:T9325	0.8	150	0.30	1.4	90	0.27	1.4	–	–	–	–	–	–	30	0.24	1.1	–	–	–
VNMG 160408E-NMR:T9415	0.8	200	0.30	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
VNMG 160412E-NMR:T8430	1.2	130	0.30	1.4	70	0.27	1.4	–	–	–	–	–	–	25	0.24	1.1	–	–	–
  																			
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.																			
WNMG 060404E-NMR:T6310	0.4	145	0.25	1.6	100	0.23	1.6	–	–	–	–	–	–	40	0.20	1.3	–	–	–
WNMG 060404E-NMR:T7325	0.4	160	0.25	1.6	120	0.23	1.6	–	–	–	–	–	–	50	0.20	1.3	–	–	–
WNMG 060404E-NMR:T8430	0.4	165	0.25	1.6	90	0.23	1.6	–	–	–	–	–	–	35	0.20	1.3	–	–	–
WNMG 060404E-NMR:T9325	0.4	200	0.25	1.6	120	0.23	1.6	–	–	–	–	–	–	45	0.20	1.3	–	–	–
WNMG 060408E-NMR:T7325	0.8	175	0.35	1.6	135	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
WNMG 060408E-NMR:T7335	0.8	170	0.35	1.6	130	0.32	1.6	–	–	–	–	–	–	55	0.25	1.3	–	–	–
WNMG 060408E-NMR:T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
WNMG 060408E-NMR:T9325	0.8	200	0.35	1.6	120	0.32	1.6	–	–	–	–	–	–	45	0.25	1.3	–	–	–
WNMG 080404E-NMR:T6310	0.4	140	0.25	2.7	100	0.23	2.7	–	–	–	–	–	–	40	0.20	2.2	–	–	–
WNMG 080404E-NMR:T7325	0.4	155	0.25	2.7	120	0.23	2.7	–	–	–	–	–	–	50	0.20	2.2	–	–	–
WNMG 080404E-NMR:T7335	0.4	150	0.25	2.7	115	0.23	2.7	–	–	–	–	–	–	45	0.20	2.2	–	–	–
WNMG 080404E-NMR:T8430	0.4	150	0.25	2.7	80	0.23	2.7	–	–	–	–	–	–	30	0.20	2.2	–	–	–
WNMG 080404E-NMR:T9415	0.4	240	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NMR:T6310	0.8	150	0.35	2.7	105	0.32	2.7	–	–	–	–	–	–	45	0.25	2.2	–	–	–
WNMG 080408E-NMR:T7325	0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.25	2.2	–	–	–
WNMG 080408E-NMR:T7335	0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.25	2.2	–	–	–
WNMG 080408E-NMR:T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–	–
WNMG 080408E-NMR:T9325	0.8	190	0.35	2.7	110	0.32	2.7	–	–	–	–	–	–	40	0.25	2.2	–	–	–
WNMG 080408E-NMR:T9415	0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-NMR:T6310	1.2	150	0.40	2.7	105	0.36	2.7	–	–	–	–	–	–	45	0.28	2.2	–	–	–
WNMG 080412E-NMR:T7325	1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
WNMG 080412E-NMR:T7335	1.2	160	0.40	2.7	120	0.36	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
WNMG 080412E-NMR:T8430	1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
WNMG 080412E-NMR:T9325	1.2	190	0.40	2.7	110	0.36	2.7	–	–	–	–	–	–	40	0.28	2.2	–	–	–
WNMG 080412E-NMR:T9415	1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

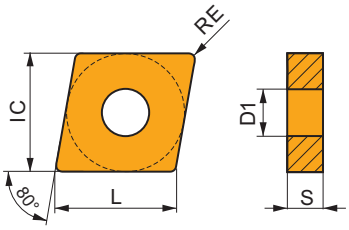
NM



NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

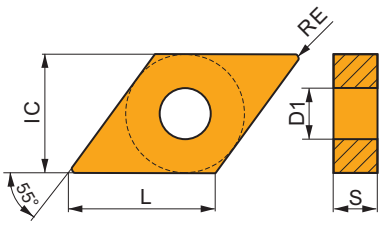
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



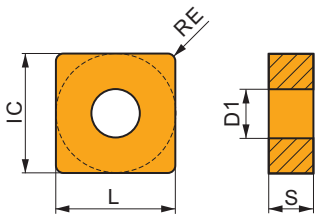
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



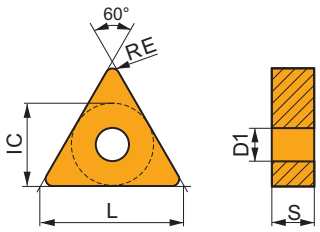
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



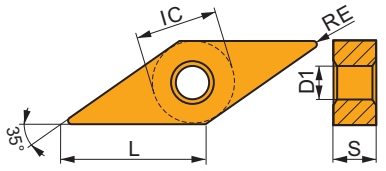
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



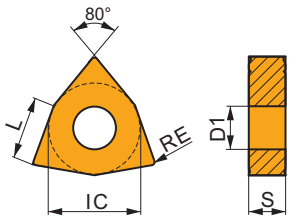
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

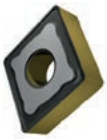
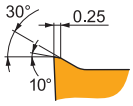


WNMG

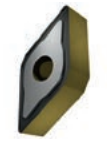
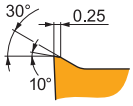
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



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	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)
																				
CNMG 120404E-NM:T7325	●	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
CNMG 120404E-NM:T7335	●	0.4	190	0.20	2.1	145	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
CNMG 120404E-NM:T8430	●	0.4	195	0.20	2.1	105	0.18	2.1	–	–	–	540	0.24	2.1	40	0.16	1.7	–	–	–
CNMG 120404E-NM:T9325	●	0.4	240	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	50	0.16	1.7	–	–	–
CNMG 120404E-NM:T9415	●	0.4	305	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-NM:T7325	⇕	0.8	215	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
CNMG 120408E-NM:T7335	⇕	0.8	210	0.25	2.1	160	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
CNMG 120408E-NM:T8315	⇕	0.8	205	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	50	0.20	1.7	–	–	–
CNMG 120408E-NM:T8415	⇕	0.8	245	0.25	2.1	125	0.23	2.1	–	–	–	615	0.30	2.1	55	0.20	1.7	–	–	–
CNMG 120408E-NM:T8430	⇕	0.8	210	0.25	2.1	115	0.23	2.1	–	–	–	585	0.30	2.1	45	0.20	1.7	–	–	–
CNMG 120408E-NM:T9315	⇕	0.8	290	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-NM:T9325	⇕	0.8	260	0.25	2.1	155	0.23	2.1	–	–	–	–	–	–	55	0.20	1.7	–	–	–
CNMG 120408E-NM:T9415	⇕	0.8	335	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-NM:T7325	⇕	1.2	215	0.30	2.1	165	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
CNMG 120412E-NM:T7335	⇕	1.2	210	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
CNMG 120412E-NM:T8430	⇕	1.2	210	0.30	2.1	115	0.27	2.1	–	–	–	585	0.36	2.1	45	0.24	1.7	–	–	–
CNMG 120412E-NM:T9325	⇕	1.2	255	0.30	2.1	150	0.27	2.1	–	–	–	–	–	–	55	0.24	1.7	–	–	–
CNMG 160608E-NM:T7325	⇕	0.8	195	0.30	3.6	150	0.27	3.6	–	–	–	–	–	–	60	0.27	2.9	–	–	–
CNMG 160608E-NM:T7335	⇕	0.8	190	0.30	3.6	145	0.27	3.6	–	–	–	–	–	–	60	0.27	2.9	–	–	–
CNMG 160608E-NM:T8430	⇕	0.8	185	0.30	3.6	100	0.27	3.6	–	–	–	510	0.36	3.6	40	0.27	2.9	–	–	–
CNMG 160608E-NM:T9325	⇕	0.8	225	0.30	3.6	135	0.27	3.6	–	–	–	–	–	–	50	0.27	2.9	–	–	–
CNMG 160612E-NM:T7325	⇕	1.2	205	0.30	3.6	155	0.27	3.6	–	–	–	–	–	–	65	0.27	2.9	–	–	–
CNMG 160612E-NM:T7335	⇕	1.2	200	0.30	3.6	155	0.27	3.6	–	–	–	–	–	–	65	0.27	2.9	–	–	–
CNMG 160612E-NM:T8315	⇕	1.2	195	0.30	3.6	115	0.27	3.6	–	–	–	585	0.36	3.6	45	0.27	2.9	–	–	–
CNMG 160612E-NM:T9325	⇕	1.2	240	0.30	3.6	140	0.27	3.6	–	–	–	–	–	–	50	0.27	2.9	–	–	–
CNMG 190612E-NM:T7325	⇕	1.2	195	0.35	4.2	150	0.32	4.2	–	–	–	–	–	–	60	0.32	3.4	–	–	–
CNMG 190612E-NM:T7335	⇕	1.2	180	0.35	4.2	140	0.32	4.2	–	–	–	–	–	–	55	0.32	3.4	–	–	–
CNMG 190612E-NM:T8430	⇕	1.2	180	0.35	4.2	95	0.32	4.2	–	–	–	495	0.42	4.2	35	0.32	3.4	–	–	–
CNMG 190612E-NM:T9325	⇕	1.2	220	0.35	4.2	130	0.32	4.2	–	–	–	–	–	–	45	0.32	3.4	–	–	–

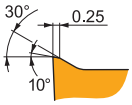
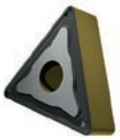
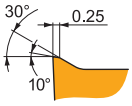
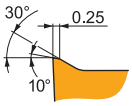
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

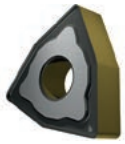
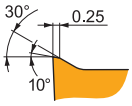
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

DNMG 110404E-NM:T7325	●	0.4	175	0.20	0.8	135	0.18	0.8	–	–	–	–	–	–	55	0.20	0.6	–	–	–
DNMG 110404E-NM:T7335	●	0.4	165	0.20	0.8	125	0.18	0.8	–	–	–	–	–	–	50	0.20	0.6	–	–	–
DNMG 110404E-NM:T8430	●	0.4	175	0.20	0.8	95	0.18	0.8	–	–	–	480	0.24	0.8	35	0.20	0.6	–	–	–
DNMG 110404E-NM:T9325	●	0.4	210	0.20	0.8	125	0.18	0.8	–	–	–	–	–	–	45	0.20	0.6	–	–	–
DNMG 110408E-NM:T7325	⇕	0.8	190	0.25	0.8	145	0.23	0.8	–	–	–	–	–	–	60	0.20	0.6	–	–	–
DNMG 110408E-NM:T7335	⇕	0.8	185	0.25	0.8	140	0.23	0.8	–	–	–	–	–	–	60	0.20	0.6	–	–	–
DNMG 110408E-NM:T8315	⇕	0.8	180	0.25	0.8	105	0.23	0.8	–	–	–	540	0.30	0.8	45	0.20	0.6	–	–	–
DNMG 110408E-NM:T8415	⇕	0.8	215	0.25	0.8	110	0.23	0.8	–	–	–	540	0.30	0.8	45	0.20	0.6	–	–	–
DNMG 110408E-NM:T8430	⇕	0.8	190	0.25	0.8	105	0.23	0.8	–	–	–	525	0.30	0.8	40	0.20	0.6	–	–	–
DNMG 110408E-NM:T9325	⇕	0.8	230	0.25	0.8	135	0.23	0.8	–	–	–	–	–	–	50	0.20	0.6	–	–	–
DNMG 150408E-NM:T8430	⇕	0.8	175	0.25	1.9	95	0.23	1.9	–	–	–	480	0.30	1.9	35	0.20	1.5	–	–	–
DNMG 150408E-NM:T9325	⇕	0.8	210	0.25	1.9	125	0.23	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
DNMG 150604E-NM:T7325	●	0.4	160	0.20	1.9	120	0.18	1.9	–	–	–	–	–	–	50	0.20	1.5	–	–	–
DNMG 150604E-NM:T7335	●	0.4	150	0.20	1.9	115	0.18	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
DNMG 150604E-NM:T8430	●	0.4	155	0.20	1.9	85	0.18	1.9	–	–	–	435	0.24	1.9	30	0.20	1.5	–	–	–
DNMG 150604E-NM:T9325	●	0.4	195	0.20	1.9	115	0.18	1.9	–	–	–	–	–	–	40	0.20	1.5	–	–	–
DNMG 150608E-NM:T7325	●	0.8	175	0.25	1.9	135	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
DNMG 150608E-NM:T7335	●	0.8	170	0.25	1.9	130	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
DNMG 150608E-NM:T8315	●	0.8	165	0.25	1.9	95	0.23	1.9	–	–	–	495	0.30	1.9	40	0.20	1.5	–	–	–
DNMG 150608E-NM:T8430	⇕	0.8	175	0.25	1.9	95	0.23	1.9	–	–	–	480	0.30	1.9	35	0.20	1.5	–	–	–
DNMG 150608E-NM:T9325	●	0.8	210	0.25	1.9	125	0.23	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
DNMG 150608E-NM:T9415	●	0.8	275	0.25	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
DNMG 150612E-NM:T7325	⇕	1.2	175	0.30	1.9	135	0.27	1.9	–	–	–	–	–	–	55	0.24	1.5	–	–	–
DNMG 150612E-NM:T7335	⇕	1.2	170	0.30	1.9	130	0.27	1.9	–	–	–	–	–	–	55	0.24	1.5	–	–	–
DNMG 150612E-NM:T9325	⇕	1.2	205	0.30	1.9	120	0.27	1.9	–	–	–	–	–	–	45	0.24	1.5	–	–	–

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	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)
																				
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.																				
SNMG 120408E-NM:T7325		0.8	225	0.25	2.1	175	0.23	2.1	–	–	–	–	–	–	70	0.20	1.7	–	–	–
SNMG 120408E-NM:T7335		0.8	220	0.25	2.1	170	0.23	2.1	–	–	–	–	–	–	70	0.20	1.7	–	–	–
SNMG 120408E-NM:T8430		0.8	225	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	45	0.20	1.7	–	–	–
SNMG 120408E-NM:T9325		0.8	275	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	60	0.20	1.7	–	–	–
SNMG 120412E-NM:T7325		1.2	225	0.30	2.1	175	0.27	2.1	–	–	–	–	–	–	70	0.24	1.7	–	–	–
SNMG 120412E-NM:T7335		1.2	220	0.30	2.1	170	0.27	2.1	–	–	–	–	–	–	70	0.24	1.7	–	–	–
SNMG 120412E-NM:T9325		1.2	270	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	60	0.24	1.7	–	–	–
																				
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.																				
TNMG 160404E-NM:T7325		0.4	170	0.20	1.9	130	0.18	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
TNMG 160404E-NM:T7335		0.4	160	0.20	1.9	120	0.18	1.9	–	–	–	–	–	–	50	0.20	1.5	–	–	–
TNMG 160404E-NM:T8430		0.4	170	0.20	1.9	90	0.18	1.9	–	–	–	465	0.24	1.9	35	0.20	1.5	–	–	–
TNMG 160404E-NM:T9325		0.4	210	0.20	1.9	125	0.18	1.9	–	–	–	–	–	–	45	0.20	1.5	–	–	–
TNMG 160408E-NM:T7325		0.8	190	0.25	1.9	145	0.23	1.9	–	–	–	–	–	–	60	0.20	1.5	–	–	–
TNMG 160408E-NM:T7335		0.8	180	0.25	1.9	140	0.23	1.9	–	–	–	–	–	–	55	0.20	1.5	–	–	–
TNMG 160408E-NM:T8315		0.8	175	0.25	1.9	105	0.23	1.9	–	–	–	525	0.30	1.9	40	0.20	1.5	–	–	–
TNMG 160408E-NM:T8415		0.8	215	0.25	1.9	110	0.23	1.9	–	–	–	540	0.30	1.9	45	0.20	1.5	–	–	–
TNMG 160408E-NM:T8430		0.8	185	0.25	1.9	100	0.23	1.9	–	–	–	510	0.30	1.9	40	0.20	1.5	–	–	–
TNMG 160408E-NM:T9325		0.8	225	0.25	1.9	135	0.23	1.9	–	–	–	–	–	–	50	0.20	1.5	–	–	–
TNMG 160408E-NM:T9415		0.8	290	0.25	1.9	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-NM:T7325		0.8	190	0.25	1.7	145	0.23	1.7	–	–	–	–	–	–	60	0.20	1.4	–	–	–
TNMG 220408E-NM:T7335		0.8	185	0.25	1.7	140	0.23	1.7	–	–	–	–	–	–	60	0.20	1.4	–	–	–
TNMG 220408E-NM:T8315		0.8	175	0.25	1.7	105	0.23	1.7	–	–	–	525	0.30	1.7	40	0.20	1.4	–	–	–
TNMG 220408E-NM:T8415		0.8	215	0.25	1.7	110	0.23	1.7	–	–	–	540	0.30	1.7	45	0.20	1.4	–	–	–
TNMG 220408E-NM:T8430		0.8	185	0.25	1.7	100	0.23	1.7	–	–	–	510	0.30	1.7	40	0.20	1.4	–	–	–
TNMG 220408E-NM:T9325		0.8	225	0.25	1.7	135	0.23	1.7	–	–	–	–	–	–	50	0.20	1.4	–	–	–
TNMG 220412E-NM:T7325		1.2	190	0.30	1.7	145	0.27	1.7	–	–	–	–	–	–	60	0.24	1.4	–	–	–
TNMG 220412E-NM:T7335		1.2	180	0.30	2.1	140	0.27	2.1	–	–	–	–	–	–	55	0.24	1.7	–	–	–
TNMG 220412E-NM:T9325		1.2	215	0.30	2.1	125	0.27	2.1	–	–	–	–	–	–	45	0.24	1.7	–	–	–
																				
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.																				
VNMG 160404E-NM:T7325		0.4	145	0.20	1.2	110	0.18	1.2	–	–	–	–	–	–	45	0.20	1.0	–	–	–
VNMG 160404E-NM:T7335		0.4	140	0.20	1.2	105	0.18	1.2	–	–	–	–	–	–	45	0.20	1.0	–	–	–
VNMG 160404E-NM:T8315		0.4	135	0.20	1.2	80	0.18	1.2	–	–	–	405	0.24	1.2	30	0.20	1.0	–	–	–
VNMG 160404E-NM:T8415		0.4	160	0.20	1.2	85	0.18	1.2	–	–	–	405	0.24	1.2	35	0.20	1.0	–	–	–
VNMG 160404E-NM:T8430		0.4	145	0.20	1.2	80	0.18	1.2	–	–	–	405	0.24	1.2	30	0.20	1.0	–	–	–
VNMG 160404E-NM:T9325		0.4	180	0.20	1.2	105	0.18	1.2	–	–	–	–	–	–	40	0.20	1.0	–	–	–
VNMG 160408E-NM:T7325		0.8	160	0.25	1.4	120	0.23	1.4	–	–	–	–	–	–	50	0.20	1.1	–	–	–
VNMG 160408E-NM:T7335		0.8	155	0.25	1.4	120	0.23	1.4	–	–	–	–	–	–	50	0.20	1.1	–	–	–
VNMG 160408E-NM:T8315		0.8	145	0.25	1.4	85	0.23	1.4	–	–	–	435	0.30	1.4	35	0.20	1.1	–	–	–
VNMG 160408E-NM:T8415		0.8	180	0.25	1.4	90	0.23	1.4	–	–	–	450	0.30	1.4	40	0.20	1.1	–	–	–
VNMG 160408E-NM:T8430		0.8	155	0.25	1.4	85	0.23	1.4	–	–	–	435	0.30	1.4	30	0.20	1.1	–	–	–
VNMG 160408E-NM:T9325		0.8	190	0.25	1.4	110	0.23	1.4	–	–	–	–	–	–	40	0.20	1.1	–	–	–

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	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)
																				

NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

WNMG 060404E-NM:T7325	●	0.4	200	0.20	1.8	155	0.18	1.8	–	–	–	–	–	–	65	0.16	1.4	–	–	–
WNMG 060404E-NM:T7335	●	0.4	195	0.20	1.8	150	0.18	1.8	–	–	–	–	–	–	60	0.16	1.4	–	–	–
WNMG 060404E-NM:T8430	●	0.4	185	0.25	1.8	100	0.23	1.8	–	–	–	510	0.30	1.8	40	0.20	1.4	–	–	–
WNMG 060404E-NM:T9325	●	0.4	245	0.20	1.8	145	0.18	1.8	–	–	–	–	–	–	55	0.16	1.4	–	–	–
WNMG 060408E-NM:T7325	●	0.8	220	0.25	1.8	170	0.23	1.8	–	–	–	–	–	–	70	0.20	1.4	–	–	–
WNMG 060408E-NM:T7335	●	0.8	215	0.25	1.8	165	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
WNMG 060408E-NM:T8430	●	0.8	220	0.25	1.8	120	0.23	1.8	–	–	–	600	0.30	1.8	45	0.20	1.4	–	–	–
WNMG 060408E-NM:T9325	●	0.8	265	0.25	1.8	155	0.23	1.8	–	–	–	–	–	–	55	0.20	1.4	–	–	–
WNMG 060412E-NM:T7325	●	1.2	220	0.30	1.8	170	0.27	1.8	–	–	–	–	–	–	70	0.24	1.4	–	–	–
WNMG 060412E-NM:T7335	●	1.2	220	0.30	1.2	170	0.27	1.2	–	–	–	–	–	–	70	0.24	1.0	–	–	–
WNMG 060412E-NM:T9325	●	1.2	255	0.30	1.8	150	0.27	1.8	–	–	–	–	–	–	55	0.24	1.4	–	–	–
WNMG 080404E-NM:T7325	●	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
WNMG 080404E-NM:T7335	●	0.4	190	0.20	2.1	145	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
WNMG 080404E-NM:T8430	●	0.4	180	0.25	2.1	95	0.23	2.1	–	–	–	495	0.30	2.1	35	0.20	1.7	–	–	–
WNMG 080404E-NM:T9315	●	0.4	270	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080404E-NM:T9325	●	0.4	240	0.20	2.1	140	0.18	2.1	–	–	–	–	–	–	50	0.16	1.7	–	–	–
WNMG 080404E-NM:T9415	●	0.4	305	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NM:T7325	●	0.8	215	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
WNMG 080408E-NM:T7335	●	0.8	210	0.25	2.1	160	0.23	2.1	–	–	–	–	–	–	65	0.20	1.7	–	–	–
WNMG 080408E-NM:T8315	●	0.8	205	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	50	0.20	1.7	–	–	–
WNMG 080408E-NM:T8430	●	0.8	210	0.25	2.1	115	0.23	2.1	–	–	–	585	0.30	2.1	45	0.20	1.7	–	–	–
WNMG 080408E-NM:T9315	●	0.8	290	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NM:T9325	●	0.8	260	0.25	2.1	155	0.23	2.1	–	–	–	–	–	–	55	0.20	1.7	–	–	–
WNMG 080408E-NM:T9415	●	0.8	335	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-NM:T7325	●	1.2	215	0.30	2.1	165	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
WNMG 080412E-NM:T7335	●	1.2	210	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	65	0.24	1.7	–	–	–
WNMG 080412E-NM:T8315	●	1.2	205	0.30	2.1	120	0.27	2.1	–	–	–	615	0.36	2.1	50	0.24	1.7	–	–	–
WNMG 080412E-NM:T8415	●	1.2	245	0.30	2.1	125	0.27	2.1	–	–	–	615	0.36	2.1	55	0.24	1.7	–	–	–
WNMG 080412E-NM:T9325	●	1.2	255	0.30	2.1	150	0.27	2.1	–	–	–	–	–	–	55	0.24	1.7	–	–	–

.NMA

.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

PRAMET

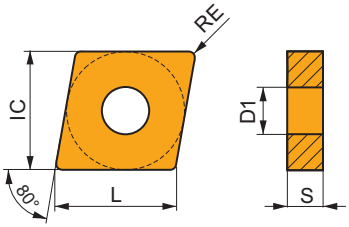
.NMA ..S

.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.

PRAMET

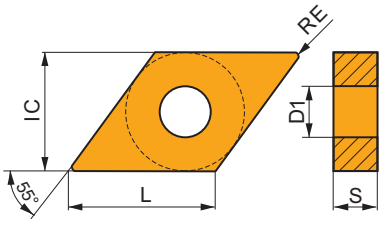
CNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



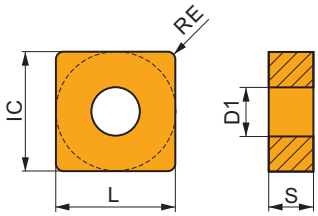
DNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



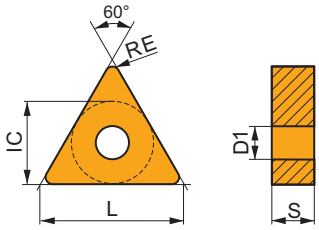
SNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



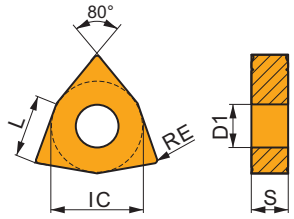
TNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

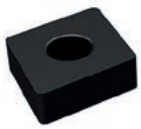
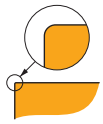
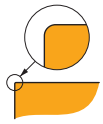
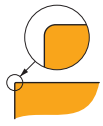


WNMA

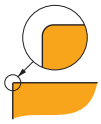
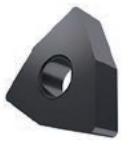
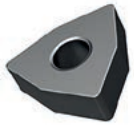
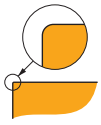
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



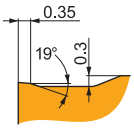
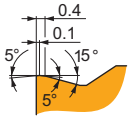
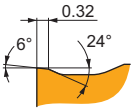
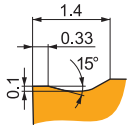
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
CNMA 120404:T5305	●	0.4	–	–	–	–	–	–	235	0.10	4.0	–	–	–	–	–	–	50	0.10	0.3
CNMA 120404:T5315	●	0.4	–	–	–	–	–	–	200	0.10	4.0	–	–	–	–	–	–	40	0.10	0.3
CNMA 120408:T5305	●	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
CNMA 120408:T5315	⇕	0.8	–	–	–	–	–	–	190	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
CNMA 120408:T6310	⇕	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
CNMA 120408:T8415	⇕	0.8	–	–	–	–	–	–	145	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
CNMA 120412:T5305	⇕	1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 120412:T5315	⇕	1.2	–	–	–	–	–	–	180	0.30	4.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 120412:T6310	⇕	1.2	–	–	–	–	–	–	95	0.30	4.0	–	–	–	–	–	–	20	0.15	1.0
CNMA 120412:T8415	⇕	1.2	–	–	–	–	–	–	135	0.30	4.0	–	–	–	–	–	–	25	0.21	0.5
CNMA 120416:T5305	⇕	1.6	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	1.3
CNMA 120416:T5315	⇕	1.6	–	–	–	–	–	–	170	0.40	4.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 160612:T5305	⇕	1.2	–	–	–	–	–	–	190	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 160612:T5315	⇕	1.2	–	–	–	–	–	–	175	0.30	5.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 160616:T5315	⇕	1.6	–	–	–	–	–	–	165	0.40	5.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 190612:T5305	⇕	1.2	–	–	–	–	–	–	190	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 190612:T5315	⇕	1.2	–	–	–	–	–	–	170	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0
CNMA 190616:T5305	⇕	1.6	–	–	–	–	–	–	180	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
CNMA 190616:T5315	⇕	1.6	–	–	–	–	–	–	160	0.40	6.0	–	–	–	–	–	–	30	0.20	1.3
																				
.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.																				
CNMA 120408S:T5305	⇕	0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
CNMA 120412S:T5305	⇕	1.2	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	1.3
CNMA 160612S:T5305	⇕	1.2	–	–	–	–	–	–	190	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
CNMA 190616S:T5305	⇕	1.6	–	–	–	–	–	–	180	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
																				
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
DNMA 150408:T5305	●	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.10	0.7
DNMA 150408:T5315	●	0.8	–	–	–	–	–	–	165	0.20	1.7	–	–	–	–	–	–	35	0.10	0.7
DNMA 150604:T5305	●	0.4	–	–	–	–	–	–	205	0.10	1.7	–	–	–	–	–	–	40	0.10	0.3
DNMA 150604:T5315	●	0.4	–	–	–	–	–	–	180	0.10	1.7	–	–	–	–	–	–	35	0.10	0.3
DNMA 150604:T6310	●	0.4	–	–	–	–	–	–	85	0.10	1.7	–	–	–	–	–	–	20	0.07	0.3
DNMA 150604:T8415	●	0.4	–	–	–	–	–	–	130	0.10	1.7	–	–	–	–	–	–	25	0.07	0.5
DNMA 150608:T5305	●	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.10	0.7
DNMA 150608:T5315	●	0.8	–	–	–	–	–	–	165	0.20	1.7	–	–	–	–	–	–	35	0.10	0.7
DNMA 150608:T6310	⇕	0.8	–	–	–	–	–	–	85	0.20	1.7	–	–	–	–	–	–	20	0.10	0.7
DNMA 150608:T8415	⇕	0.8	–	–	–	–	–	–	125	0.20	1.7	–	–	–	–	–	–	20	0.14	0.5
DNMA 150612:T5305	●	1.2	–	–	–	–	–	–	200	0.20	1.7	–	–	–	–	–	–	40	0.10	0.9
DNMA 150612:T5315	⇕	1.2	–	–	–	–	–	–	175	0.20	1.7	–	–	–	–	–	–	35	0.10	0.9
																				
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
SNMA 120408:T5305	⇕	0.8	–	–	–	–	–	–	230	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
SNMA 120408:T5315	⇕	0.8	–	–	–	–	–	–	200	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
SNMA 120408:T6310	⇕	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
SNMA 120408:T8415	⇕	0.8	–	–	–	–	–	–	150	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
SNMA 120412:T5305	⇕	1.2	–	–	–	–	–	–	205	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 120412:T5315	⇕	1.2	–	–	–	–	–	–	190	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 150612:T5305	⇕	1.2	–	–	–	–	–	–	200	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 150612:T5315	⇕	1.2	–	–	–	–	–	–	185	0.30	5.0	–	–	–	–	–	–	35	0.15	1.0
SNMA 190612:T5305	⇕	1.2	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 190612:T5315	⇕	1.2	–	–	–	–	–	–	180	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0

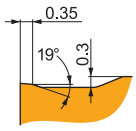
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
SNMA 190616:T5305		1.6	–	–	–	–	–	–	190	0.40	6.0	–	–	–	–	–	–	40	0.20	1.3
SNMA 190616:T5315		1.6	–	–	–	–	–	–	170	0.40	6.0	–	–	–	–	–	–	35	0.20	1.3
SNMA 250724:T5305		2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
SNMA 250724:T5315		2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.30	2.0
SNMA 250924:T5305		2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
SNMA 250924:T5315		2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.30	2.0
																				
.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.																				
SNMA 190616S:T5305		1.6	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 250924S:T5305		2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0
																				
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
TNMA 160404:T5305		0.4	–	–	–	–	–	–	220	0.10	1.5	–	–	–	–	–	–	45	0.10	0.3
TNMA 160404:T5315		0.4	–	–	–	–	–	–	190	0.10	1.5	–	–	–	–	–	–	40	0.10	0.3
TNMA 160408:T5305		0.8	–	–	–	–	–	–	205	0.20	1.5	–	–	–	–	–	–	40	0.10	0.7
TNMA 160408:T5315		0.8	–	–	–	–	–	–	180	0.20	1.5	–	–	–	–	–	–	35	0.10	0.7
TNMA 160408:T6310		0.8	–	–	–	–	–	–	90	0.20	1.5	–	–	–	–	–	–	20	0.10	0.7
TNMA 160408:T8415		0.8	–	–	–	–	–	–	135	0.20	1.5	–	–	–	–	–	–	25	0.14	0.5
TNMA 160412:T5305		1.2	–	–	–	–	–	–	215	0.20	1.5	–	–	–	–	–	–	45	0.10	0.9
TNMA 160412:T5315		1.2	–	–	–	–	–	–	190	0.20	1.5	–	–	–	–	–	–	40	0.10	0.9
TNMA 220408:T5305		0.8	–	–	–	–	–	–	195	0.20	2.0	–	–	–	–	–	–	40	0.10	0.7
TNMA 220408:T5315		0.8	–	–	–	–	–	–	175	0.20	2.0	–	–	–	–	–	–	35	0.10	0.7
TNMA 220408:T6310		0.8	–	–	–	–	–	–	90	0.20	2.0	–	–	–	–	–	–	20	0.10	0.7
TNMA 220408:T8415		0.8	–	–	–	–	–	–	130	0.20	2.0	–	–	–	–	–	–	25	0.14	0.5
TNMA 220412:T5305		1.2	–	–	–	–	–	–	205	0.20	2.0	–	–	–	–	–	–	40	0.10	0.9
TNMA 220412:T5315		1.2	–	–	–	–	–	–	185	0.20	2.0	–	–	–	–	–	–	35	0.10	0.9
																				
.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.																				
TNMA 160408S:T5305		0.8	–	–	–	–	–	–	205	0.20	1.5	–	–	–	–	–	–	40	0.10	0.7
																				
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
WNMA 080404:T5305		0.4	–	–	–	–	–	–	235	0.10	4.0	–	–	–	–	–	–	50	0.10	0.3
WNMA 080404:T5315		0.4	–	–	–	–	–	–	200	0.10	4.0	–	–	–	–	–	–	40	0.10	0.3
WNMA 080408:T5305		0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
WNMA 080408:T5315		0.8	–	–	–	–	–	–	190	0.20	4.0	–	–	–	–	–	–	40	0.10	0.7
WNMA 080408:T6310		0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.10	0.7
WNMA 080408:T8415		0.8	–	–	–	–	–	–	145	0.20	4.0	–	–	–	–	–	–	25	0.14	0.5
WNMA 080412:T5305		1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
WNMA 080412:T5315		1.2	–	–	–	–	–	–	180	0.30	4.0	–	–	–	–	–	–	35	0.15	1.0
WNMA 080412:T6310		1.2	–	–	–	–	–	–	95	0.30	4.0	–	–	–	–	–	–	20	0.15	1.0
WNMA 080412:T8415		1.2	–	–	–	–	–	–	135	0.30	4.0	–	–	–	–	–	–	25	0.21	0.5
																				
.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.																				
WNMA 080408S:T5305		0.8	–	–	–	–	–	–	220	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7

ROUGHING – NAVIGATOR

RM			**RM** chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.
R			**R** chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.
NRM			**NRM** chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.
KR			**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.

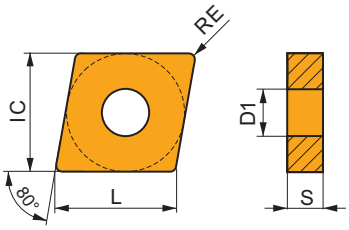
RM



RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

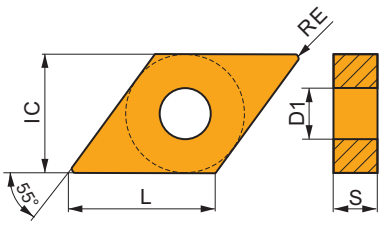
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



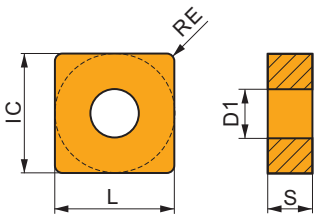
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



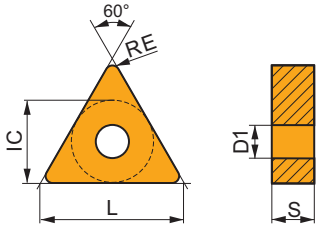
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2509	25.400	9.12	25.40	9.53



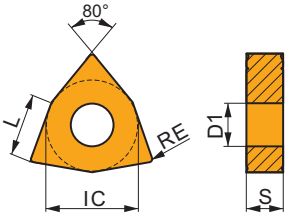
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35
3309	19.050	7.94	33.00	9.53

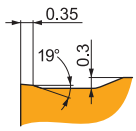


WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76

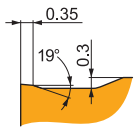


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
																			
		RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.																	
CNMG 120408E-RM:T5305	0.8	275	0.40	4.0	–	–	–	260	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-RM:T5315	0.8	250	0.40	4.0	–	–	–	235	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-RM:T6310	0.8	155	0.40	4.0	110	0.36	4.0	125	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
CNMG 120408E-RM:T7325	0.8	180	0.40	4.0	140	0.36	4.0	–	–	–	–	–	–	55	0.28	3.2	–	–	–
CNMG 120408E-RM:T7335	0.8	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 120408E-RM:T8315	0.8	165	0.40	4.0	95	0.36	4.0	155	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
CNMG 120408E-RM:T8415	0.8	195	0.40	4.0	100	0.36	4.0	180	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
CNMG 120408E-RM:T8430	0.8	165	0.40	4.0	90	0.36	4.0	135	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
CNMG 120408E-RM:T9310	0.8	240	0.40	4.0	–	–	–	225	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-RM:T9315	0.8	220	0.40	4.0	–	–	–	205	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-RM:T9325	0.8	200	0.40	4.0	120	0.36	4.0	190	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
CNMG 120408E-RM:T9335	0.8	170	0.40	4.0	100	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
CNMG 120408E-RM:T9415	0.8	265	0.40	4.0	–	–	–	250	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T5305	1.2	280	0.45	4.0	–	–	–	265	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T5315	1.2	250	0.45	4.0	–	–	–	235	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T6310	1.2	160	0.45	4.0	115	0.41	4.0	125	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
CNMG 120412E-RM:T7325	1.2	180	0.45	4.0	140	0.41	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
CNMG 120412E-RM:T7335	1.2	170	0.45	4.0	130	0.41	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
CNMG 120412E-RM:T8415	1.2	200	0.45	4.0	105	0.41	4.0	185	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
CNMG 120412E-RM:T8430	1.2	170	0.45	4.0	90	0.41	4.0	135	0.45	4.0	–	–	–	35	0.32	3.2	–	–	–
CNMG 120412E-RM:T9310	1.2	240	0.45	4.0	–	–	–	225	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T9315	1.2	220	0.45	4.0	–	–	–	205	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-RM:T9325	1.2	200	0.45	4.0	120	0.41	4.0	190	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
CNMG 120412E-RM:T9335	1.2	175	0.45	4.0	105	0.41	4.0	–	–	–	–	–	–	35	0.32	3.2	–	–	–
CNMG 120412E-RM:T9415	1.2	270	0.45	4.0	–	–	–	255	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120416E-RM:T5315	1.6	255	0.50	4.0	–	–	–	240	0.50	4.0	–	–	–	–	–	–	–	–	–
CNMG 120416E-RM:T7335	1.6	175	0.50	4.0	135	0.45	4.0	–	–	–	–	–	–	55	0.35	3.2	–	–	–
CNMG 120416E-RM:T8430	1.6	170	0.50	4.0	90	0.45	4.0	135	0.50	4.0	–	–	–	35	0.35	3.2	–	–	–
CNMG 120416E-RM:T9325	1.6	205	0.50	4.0	120	0.45	4.0	190	0.50	4.0	–	–	–	45	0.35	3.2	–	–	–
CNMG 120416E-RM:T9335	1.6	175	0.50	4.0	105	0.45	4.0	–	–	–	–	–	–	35	0.35	3.2	–	–	–
CNMG 120416E-RM:T9415	1.6	275	0.50	4.0	–	–	–	260	0.50	4.0	–	–	–	–	–	–	–	–	–
CNMG 160608E-RM:T5305	0.8	265	0.40	6.0	–	–	–	250	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMG 160608E-RM:T5315	0.8	240	0.40	6.0	–	–	–	225	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMG 160608E-RM:T8430	0.8	155	0.40	6.0	85	0.36	6.0	130	0.40	6.0	–	–	–	30	0.28	4.8	–	–	–
CNMG 160608E-RM:T9325	0.8	190	0.40	6.0	110	0.36	6.0	180	0.40	6.0	–	–	–	40	0.28	4.8	–	–	–
CNMG 160608E-RM:T9335	0.8	165	0.40	6.0	95	0.36	6.0	–	–	–	–	–	–	35	0.28	4.8	–	–	–
CNMG 160608E-RM:T9415	0.8	255	0.40	6.0	–	–	–	240	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM:T5305	1.2	270	0.45	6.0	–	–	–	255	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM:T6310	1.2	155	0.45	6.0	110	0.41	6.0	125	0.45	6.0	–	–	–	45	0.32	4.8	–	–	–
CNMG 160612E-RM:T7325	1.2	170	0.45	6.0	130	0.41	6.0	–	–	–	–	–	–	55	0.32	4.8	–	–	–
CNMG 160612E-RM:T7335	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.32	4.8	–	–	–
CNMG 160612E-RM:T8415	1.2	195	0.45	6.0	100	0.41	6.0	180	0.45	6.0	–	–	–	45	0.32	4.8	–	–	–
CNMG 160612E-RM:T8430	1.2	155	0.45	6.0	85	0.41	6.0	130	0.45	6.0	–	–	–	30	0.32	4.8	–	–	–
CNMG 160612E-RM:T9310	1.2	230	0.45	6.0	–	–	–	215	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM:T9315	1.2	215	0.45	6.0	–	–	–	200	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 160612E-RM:T9325	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.32	4.8	–	–	–
CNMG 160612E-RM:T9335	1.2	165	0.45	6.0	95	0.41	6.0	–	–	–	–	–	–	35	0.32	4.8	–	–	–
CNMG 160612E-RM:T9415	1.2	260	0.45	6.0	–	–	–	245	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T5305	1.6	270	0.50	6.0	–	–	–	255	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T5315	1.6	245	0.50	6.0	–	–	–	230	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T7325	1.6	175	0.50	6.0	135	0.45	6.0	–	–	–	–	–	–	55	0.35	4.8	–	–	–
CNMG 160616E-RM:T7335	1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.35	4.8	–	–	–
CNMG 160616E-RM:T9310	1.6	225	0.50	6.0	–	–	–	210	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T9315	1.6	215	0.50	6.0	–	–	–	200	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMG 160616E-RM:T9325	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.35	4.8	–	–	–
CNMG 160616E-RM:T9335	1.6	165	0.50	6.0	95	0.45	6.0	–	–	–	–	–	–	35	0.35	4.8	–	–	–
CNMG 160616E-RM:T9415	1.6	265	0.50	6.0	–	–	–	250	0.50	6.0	–	–	–	–	–	–	–	–	–

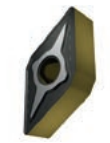
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

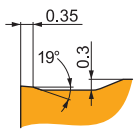
Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
CNMG 190608E-RM:T5305	0.8	260	0.40	7.5	–	–	–	245	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190608E-RM:T5315	0.8	230	0.40	7.5	–	–	–	215	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190608E-RM:T7335	0.8	155	0.40	7.5	120	0.36	7.5	–	–	–	–	–	–	50	0.28	6.0	–	–	–
CNMG 190608E-RM:T9325	0.8	190	0.40	7.5	110	0.36	7.5	180	0.40	7.5	–	–	–	40	0.28	6.0	–	–	–
CNMG 190608E-RM:T9335	0.8	160	0.40	7.5	95	0.36	7.5	–	–	–	–	–	–	35	0.28	6.0	–	–	–
CNMG 190608E-RM:T9415	0.8	250	0.40	7.5	–	–	–	235	0.40	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T5305	1.2	260	0.45	7.5	–	–	–	245	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T5315	1.2	240	0.45	7.5	–	–	–	225	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190612E-RM:T6310	1.2	155	0.45	7.5	110	0.41	7.5	125	0.45	7.5	–	–	–	45	0.32	6.0	–	–	–
CNMG 190612E-RM:T7325	1.2	170	0.45	7.5	130	0.41	7.5	–	–	–	–	–	–	55	0.32	6.0	–	–	–
CNMG 190612E-RM:T7335	1.2	160	0.45	7.5	120	0.41	7.5	–	–	–	–	–	–	50	0.32	6.0	–	–	–
CNMG 190612E-RM:T8415	1.2	195	0.45	7.5	100	0.41	7.5	180	0.45	7.5	–	–	–	45	0.32	6.0	–	–	–
CNMG 190612E-RM:T8430	1.2	150	0.45	7.5	80	0.41	7.5	125	0.45	7.5	–	–	–	30	0.32	6.0	–	–	–
CNMG 190612E-RM:T9325	1.2	185	0.45	7.5	110	0.41	7.5	175	0.45	7.5	–	–	–	40	0.32	6.0	–	–	–
CNMG 190612E-RM:T9335	1.2	165	0.45	7.5	95	0.41	7.5	–	–	–	–	–	–	35	0.32	6.0	–	–	–
CNMG 190612E-RM:T9415	1.2	250	0.45	7.5	–	–	–	235	0.45	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T5305	1.6	265	0.50	7.5	–	–	–	250	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T6310	1.6	155	0.50	7.5	110	0.45	7.5	125	0.50	7.5	–	–	–	45	0.35	6.0	–	–	–
CNMG 190616E-RM:T7325	1.6	175	0.50	7.5	135	0.45	7.5	–	–	–	–	–	–	55	0.35	6.0	–	–	–
CNMG 190616E-RM:T7335	1.6	160	0.50	7.5	120	0.45	7.5	–	–	–	–	–	–	50	0.35	6.0	–	–	–
CNMG 190616E-RM:T8415	1.6	195	0.50	7.5	100	0.45	7.5	180	0.50	7.5	–	–	–	45	0.35	6.0	–	–	–
CNMG 190616E-RM:T8430	1.6	150	0.50	7.5	80	0.45	7.5	125	0.50	7.5	–	–	–	30	0.35	6.0	–	–	–
CNMG 190616E-RM:T9315	1.6	210	0.50	7.5	–	–	–	195	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 190616E-RM:T9325	1.6	190	0.50	7.5	110	0.45	7.5	180	0.50	7.5	–	–	–	40	0.35	6.0	–	–	–
CNMG 190616E-RM:T9335	1.6	160	0.50	7.5	95	0.45	7.5	–	–	–	–	–	–	35	0.35	6.0	–	–	–
CNMG 190616E-RM:T9415	1.6	255	0.50	7.5	–	–	–	240	0.50	7.5	–	–	–	–	–	–	–	–	–
CNMG 250924E-RM:T7325	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMG 250924E-RM:T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMG 250924E-RM:T9226	2.4	90	0.80	12.0	50	0.72	12.0	85	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
CNMG 250924E-RM:T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
CNMG 250924E-RM:T9335	2.4	85	0.80	12.0	50	0.72	12.0	–	–	–	–	–	–	15	0.56	9.6	–	–	–
CNMG 250924E-RM:T9415	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–



RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

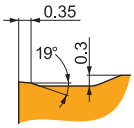
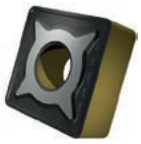
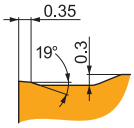
Product	RE	P			M			K			N			S			H		
	(mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
DNMG 110408E-RM:T9325	0.8	170	0.40	2.0	100	0.36	2.0	160	0.40	2.0	–	–	–	35	0.28	1.6	–	–	–
DNMG 110408E-RM:T9415	0.8	230	0.40	2.0	–	–	–	215	0.40	2.0	–	–	–	–	–	–	–	–	–
DNMG 110412E-RM:T9325	1.2	205	0.30	2.0	120	0.27	2.0	190	0.30	2.0	–	–	–	45	0.21	1.6	–	–	–
DNMG 110412E-RM:T9415	1.2	265	0.30	2.0	–	–	–	250	0.30	2.0	–	–	–	–	–	–	–	–	–
DNMG 150408E-RM:T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150408E-RM:T9335	0.8	140	0.40	3.0	80	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150408E-RM:T9415	0.8	220	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150412E-RM:T7325	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
DNMG 150412E-RM:T9325	1.2	170	0.40	3.0	100	0.36	3.0	160	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150412E-RM:T9335	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150412E-RM:T9415	1.2	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T5305	0.8	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T5315	0.8	205	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-RM:T7325	0.8	145	0.40	3.0	110	0.36	3.0	–	–	–	–	–	–	45	0.28	2.4	–	–	–
DNMG 150608E-RM:T7335	0.8	135	0.40	3.0	105	0.36	3.0	–	–	–	–	–	–	40	0.28	2.4	–	–	–
DNMG 150608E-RM:T8315	0.8	135	0.40	3.0	80	0.36	3.0	125	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMG 150608E-RM:T8415	0.8	160	0.40	3.0	85	0.36	3.0	145	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150608E-RM:T8430	0.8	135	0.40	3.0	75	0.36	3.0	110	0.40	3.0	–	–	–	25	0.28	2.4	–	–	–
DNMG 150608E-RM:T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150608E-RM:T9335	0.8	140	0.40	3.0	80	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150608E-RM:T9415	0.8	220	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	–	–	–





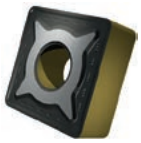
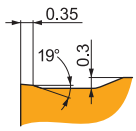
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.																			
DNMG 150612E-RM:T5305	1.2	240	0.40	3.0	–	–	–	225	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-RM:T5315	1.2	215	0.40	3.0	–	–	–	200	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-RM:T7325	1.2	155	0.40	3.0	120	0.36	3.0	–	–	–	–	–	–	50	0.28	2.4	–	–	–
DNMG 150612E-RM:T8430	1.2	140	0.40	3.0	75	0.36	3.0	115	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMG 150612E-RM:T9325	1.2	170	0.40	3.0	100	0.36	3.0	160	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
DNMG 150612E-RM:T9335	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150612E-RM:T9415	1.2	230	0.40	3.0	–	–	–	215	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150616E-RM:T5315	1.6	225	0.40	3.0	–	–	–	210	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150616E-RM:T9325	1.6	180	0.40	3.0	105	0.36	3.0	170	0.40	3.0	–	–	–	40	0.28	2.4	–	–	–
DNMG 150616E-RM:T9335	1.6	155	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.28	2.4	–	–	–
DNMG 150616E-RM:T9415	1.6	245	0.40	3.0	–	–	–	230	0.40	3.0	–	–	–	–	–	–	–	–	–
 																			
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.																			
SNMG 120408E-RM:T5305	0.8	290	0.40	4.0	–	–	–	275	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 120408E-RM:T6310	0.8	165	0.40	4.0	115	0.36	4.0	130	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T7325	0.8	185	0.40	4.0	140	0.36	4.0	–	–	–	–	–	–	60	0.28	3.2	–	–	–
SNMG 120408E-RM:T7335	0.8	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	55	0.28	3.2	–	–	–
SNMG 120408E-RM:T8315	0.8	175	0.40	4.0	105	0.36	4.0	165	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
SNMG 120408E-RM:T8415	0.8	210	0.40	4.0	110	0.36	4.0	190	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T8430	0.8	175	0.40	4.0	95	0.36	4.0	140	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
SNMG 120408E-RM:T9325	0.8	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
SNMG 120408E-RM:T9335	0.8	180	0.40	4.0	105	0.36	4.0	–	–	–	–	–	–	40	0.28	3.2	–	–	–
SNMG 120408E-RM:T9415	0.8	280	0.40	4.0	–	–	–	265	0.40	4.0	–	–	–	–	–	–	–	–	–
SNMG 120412E-RM:T6310	1.2	165	0.45	4.0	115	0.41	4.0	130	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T7325	1.2	190	0.45	4.0	145	0.41	4.0	–	–	–	–	–	–	60	0.32	3.2	–	–	–
SNMG 120412E-RM:T7335	1.2	180	0.45	4.0	140	0.41	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
SNMG 120412E-RM:T8415	1.2	215	0.45	4.0	110	0.41	4.0	195	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T9325	1.2	210	0.45	4.0	125	0.41	4.0	195	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
SNMG 120412E-RM:T9335	1.2	185	0.45	4.0	110	0.41	4.0	–	–	–	–	–	–	40	0.32	3.2	–	–	–
SNMG 120412E-RM:T9415	1.2	280	0.45	4.0	–	–	–	265	0.45	4.0	–	–	–	–	–	–	–	–	–
SNMG 120416E-RM:T8430	1.6	175	0.50	4.0	95	0.45	4.0	140	0.50	4.0	–	–	–	35	0.35	3.2	–	–	–
SNMG 120416E-RM:T9325	1.6	215	0.50	4.0	125	0.45	4.0	200	0.50	4.0	–	–	–	45	0.35	3.2	–	–	–
SNMG 120416E-RM:T9335	1.6	180	0.50	4.0	105	0.45	4.0	–	–	–	–	–	–	40	0.35	3.2	–	–	–
SNMG 120416E-RM:T9415	1.6	290	0.50	4.0	–	–	–	275	0.50	4.0	–	–	–	–	–	–	–	–	–
SNMG 150612E-RM:T6310	1.2	165	0.45	5.0	115	0.41	5.0	130	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T7325	1.2	185	0.45	5.0	140	0.41	5.0	–	–	–	–	–	–	60	0.32	4.0	–	–	–
SNMG 150612E-RM:T8415	1.2	215	0.45	5.0	110	0.41	5.0	195	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T9325	1.2	205	0.45	5.0	120	0.41	5.0	190	0.45	5.0	–	–	–	45	0.32	4.0	–	–	–
SNMG 150612E-RM:T9335	1.2	180	0.45	5.0	105	0.41	5.0	–	–	–	–	–	–	40	0.32	4.0	–	–	–
SNMG 150612E-RM:T9415	1.2	275	0.45	5.0	–	–	–	260	0.45	5.0	–	–	–	–	–	–	–	–	–
SNMG 150616E-RM:T7335	1.6	175	0.50	5.0	135	0.45	5.0	–	–	–	–	–	–	55	0.35	4.0	–	–	–
SNMG 150616E-RM:T9325	1.6	205	0.50	5.0	120	0.45	5.0	190	0.50	5.0	–	–	–	45	0.35	4.0	–	–	–
SNMG 150616E-RM:T9335	1.6	180	0.50	5.0	105	0.45	5.0	–	–	–	–	–	–	40	0.35	4.0	–	–	–
SNMG 150616E-RM:T9415	1.6	285	0.50	5.0	–	–	–	270	0.50	5.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T5305	1.2	275	0.45	7.0	–	–	–	260	0.45	7.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T5315	1.2	250	0.45	7.0	–	–	–	235	0.45	7.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM:T7325	1.2	180	0.45	7.0	140	0.41	7.0	–	–	–	–	–	–	55	0.32	5.6	–	–	–
SNMG 190612E-RM:T7335	1.2	165	0.45	7.0	125	0.41	7.0	–	–	–	–	–	–	50	0.32	5.6	–	–	–
SNMG 190612E-RM:T9325	1.2	195	0.45	7.0	115	0.41	7.0	185	0.45	7.0	–	–	–	40	0.32	5.6	–	–	–
SNMG 190612E-RM:T9335	1.2	175	0.45	7.0	105	0.41	7.0	–	–	–	–	–	–	35	0.32	5.6	–	–	–
SNMG 190612E-RM:T9415	1.2	270	0.45	7.0	–	–	–	255	0.45	7.0	–	–	–	–	–	–	–	–	–

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	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)	
	(mm)																								

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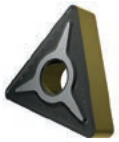
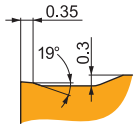
SNMG 190616E-RM:T5305	●	1.6	◪	285	0.50	7.0		–	–	–	■	270	0.50	7.0		–	–	–		–	–	–		–	–	–
SNMG 190616E-RM:T6310	●	1.6	■	160	0.50	7.0	■	115	0.45	7.0	■	125	0.50	7.0		–	–	–	◪	45	0.35	5.6		–	–	–
SNMG 190616E-RM:T7335	●	1.6	◪	170	0.50	7.0	■	130	0.45	7.0		–	–	–		–	–	–	◪	55	0.35	5.6		–	–	–
SNMG 190616E-RM:T8415	✱	1.6	■	210	0.50	7.0	■	110	0.45	7.0	■	190	0.50	7.0		–	–	–	◪	45	0.35	5.6		–	–	–
SNMG 190616E-RM:T8430	✱	1.6	■	165	0.50	7.0	■	90	0.45	7.0	◪	135	0.50	7.0		–	–	–	◪	35	0.35	5.6		–	–	–
SNMG 190616E-RM:T9325	●	1.6	■	200	0.50	7.0	■	120	0.45	7.0	◪	190	0.50	7.0		–	–	–	◪	45	0.35	5.6		–	–	–
SNMG 190616E-RM:T9335	●	1.6	■	175	0.50	7.0	■	105	0.45	7.0		–	–	–		–	–	–	◪	35	0.35	5.6		–	–	–
SNMG 190616E-RM:T9415	●	1.6	■	270	0.50	7.0		–	–	–	◪	255	0.50	7.0		–	–	–		–	–	–		–	–	–
SNMG 250924E-RM:T7325	✱	2.4	◪	110	0.80	12.0	■	85	0.72	12.0		–	–	–		–	–	–	◪	35	0.56	9.6		–	–	–
SNMG 250924E-RM:T7335	✱	2.4	◪	105	0.80	12.0	■	80	0.72	12.0		–	–	–		–	–	–	◪	30	0.56	9.6		–	–	–
SNMG 250924E-RM:T9226	●	2.4	■	95	0.80	12.0	■	55	0.72	12.0	◪	90	0.80	12.0		–	–	–	◪	20	0.56	9.6		–	–	–
SNMG 250924E-RM:T9315	●	2.4	■	125	0.80	12.0		–	–	–	◪	115	0.80	12.0		–	–	–		–	–	–		–	–	–
SNMG 250924E-RM:T9325	●	2.4	■	110	0.80	12.0	■	65	0.72	12.0	◪	100	0.80	12.0		–	–	–	◪	20	0.56	9.6		–	–	–
SNMG 250924E-RM:T9335	✱	2.4	■	90	0.80	12.0	■	50	0.72	12.0		–	–	–		–	–	–	◪	20	0.56	9.6		–	–	–
SNMG 250924E-RM:T9415	●	2.4	■	130	0.80	12.0		–	–	–	◪	120	0.80	12.0		–	–	–		–	–	–		–	–	–

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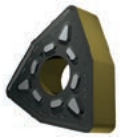
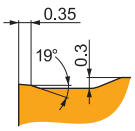
TNMG 160408E-RM:T5305	●	0.8	◪	245	0.40	3.0		–	–	–	■	230	0.40	3.0		–	–	–		–	–	–		–	–	–
TNMG 160408E-RM:T5315	●	0.8	◪	215	0.40	3.0		–	–	–	■	200	0.40	3.0		–	–	–		–	–	–		–	–	–
TNMG 160408E-RM:T7325	●	0.8	◪	155	0.40	3.0	■	120	0.36	3.0		–	–	–		–	–	–	◪	50	0.28	2.4		–	–	–
TNMG 160408E-RM:T7335	●	0.8	◪	145	0.40	3.0	■	110	0.36	3.0		–	–	–		–	–	–	◪	45	0.28	2.4		–	–	–
TNMG 160408E-RM:T9325	●	0.8	■	175	0.40	3.0	■	105	0.36	3.0	◪	165	0.40	3.0		–	–	–	◪	35	0.28	2.4		–	–	–
TNMG 160408E-RM:T9335	●	0.8	■	150	0.40	3.0	■	90	0.36	3.0		–	–	–		–	–	–	◪	30	0.28	2.4		–	–	–
TNMG 160408E-RM:T9415	●	0.8	■	235	0.40	3.0		–	–	–	◪	220	0.40	3.0		–	–	–		–	–	–		–	–	–
TNMG 160412E-RM:T5305	●	1.2	◪	255	0.40	3.0		–	–	–	■	240	0.40	3.0		–	–	–		–	–	–		–	–	–
TNMG 160412E-RM:T7335	●	1.2	◪	155	0.40	3.0	■	120	0.36	3.0		–	–	–		–	–	–	◪	50	0.28	2.4		–	–	–
TNMG 160412E-RM:T8430	●	1.2	■	150	0.40	3.0	■	80	0.36	3.0	◪	125	0.40	3.0		–	–	–	◪	30	0.28	2.4		–	–	–
TNMG 160412E-RM:T9325	●	1.2	■	185	0.40	3.0	■	110	0.36	3.0	◪	175	0.40	3.0		–	–	–	◪	40	0.28	2.4		–	–	–
TNMG 160412E-RM:T9335	●	1.2	■	160	0.40	3.0	■	95	0.36	3.0		–	–	–		–	–	–	◪	35	0.28	2.4		–	–	–
TNMG 160412E-RM:T9415	●	1.2	■	245	0.40	3.0		–	–	–	◪	230	0.40	3.0		–	–	–		–	–	–		–	–	–
TNMG 220408E-RM:T7325	●	0.8	◪	150	0.40	4.0	■	115	0.36	4.0		–	–	–		–	–	–	◪	45	0.28	3.2		–	–	–
TNMG 220408E-RM:T9325	●	0.8	■	170	0.40	4.0	■	100	0.36	4.0	◪	160	0.40	4.0		–	–	–	◪	35	0.28	3.2		–	–	–
TNMG 220408E-RM:T9335	●	0.8	■	145	0.40	4.0	■	85	0.36	4.0		–	–	–		–	–	–	◪	30	0.28	3.2		–	–	–
TNMG 220408E-RM:T9415	●	0.8	■	225	0.40	4.0		–	–	–	◪	210	0.40	4.0		–	–	–		–	–	–		–	–	–
TNMG 220412E-RM:T5305	●	1.2	◪	245	0.40	4.0		–	–	–	■	230	0.40	4.0		–	–	–		–	–	–		–	–	–
TNMG 220412E-RM:T7325	●	1.2	◪	160	0.40	4.0	■	120	0.36	4.0		–	–	–		–	–	–	◪	50	0.28	3.2		–	–	–
TNMG 220412E-RM:T7335	●	1.2	◪	150	0.40	4.0	■	115	0.36	4.0		–	–	–		–	–	–	◪	45	0.28	3.2		–	–	–
TNMG 220412E-RM:T9325	●	1.2	■	180	0.40	4.0	■	105	0.36	4.0	◪	170	0.40	4.0		–	–	–	◪	40	0.28	3.2		–	–	–
TNMG 220412E-RM:T9335	●	1.2	■	155	0.40	4.0	■	90	0.36	4.0		–	–	–		–	–	–	◪	30	0.28	3.2		–	–	–
TNMG 220412E-RM:T9415	●	1.2	■	235	0.40	4.0		–	–	–	◪	220	0.40	4.0		–	–	–		–	–	–		–	–	–
TNMG 220416E-RM:T7325	●	1.6	◪	165	0.40	4.0	■	125	0.36	4.0		–	–	–		–	–	–	◪	50	0.28	3.2		–	–	–
TNMG 220416E-RM:T9325	●	1.6	■	185	0.40	4.0	■	110	0.36	4.0	◪	175	0.40	4.0		–	–	–	◪	40	0.28	3.2		–	–	–
TNMG 220416E-RM:T9335	●	1.6	■	160	0.40	4.0	■	95	0.36	4.0		–	–	–		–	–	–	◪	35	0.28	3.2		–	–	–
TNMG 220416E-RM:T9415	●	1.6	■	250	0.40	4.0		–	–	–	◪	235	0.40	4.0		–	–	–		–	–	–		–	–	–
TNMG 270612E-RM:T7325	●	1.2	◪	110	0.40	6.0	■	85	0.36	6.0		–	–	–		–	–	–	◪	35	0.28	4.8		–	–	–
TNMG 270612E-RM:T9325	●	1.2	■	120	0.40	6.0	■	70	0.36	6.0	◪	110	0.40	6.0		–	–	–	◪	25	0.28	4.8		–	–	–
TNMG 270616E-RM:T7325	●	1.6	◪	115	0.40	6.0	■	85	0.36	6.0		–	–	–		–	–	–	◪	35	0.28	4.8		–	–	–
TNMG 270616E-RM:T9325	●	1.6	■	125	0.40	6.0	■	75	0.36	6.0	◪	115	0.40	6.0		–	–	–	◪	25	0.28	4.8		–	–	–
TNMG 270616E-RM:T9335	●	1.6	■	100	0.40	6.0	■	60	0.36	6.0		–	–	–		–	–	–	◪	20	0.28	4.8		–	–	–
TNMG 270616E-RM:T9415	●	1.6	■	140	0.40	6.0		–	–	–	◪	130	0.40	6.0		–	–	–		–	–	–		–	–	–
TNMG 270624E-RM:T7325	●	2.4	◪	115	0.50	6.0	■	85	0.45	6.0		–	–	–		–	–	–	◪	35	0.35	4.8		–	–	–
TNMG 270624E-RM:T9325	●	2.4	■	120	0.50	6.0	■	70	0.45	6.0	◪	110	0.50	6.0		–	–	–	◪	25	0.35	4.8		–	–	–
TNMG 270624E-RM:T9335	●	2.4	■	95	0.50	6.0	■	55	0.45	6.0		–	–	–		–	–	–	◪	20	0.35	4.8		–	–	–
TNMG 270632E-RM:T9335	●	3.2	■	90	0.60	6.0	■	50	0.54	6.0		–	–	–		–	–	–	◪	20	0.42	4.8		–	–	–
TNMG 330924E-RM:T9226	●	2.4	■	100	0.50	10.0	■	60	0.45	10.0	◪	95	0.50	10.0		–	–	–	◪	20	0.35	8.0		–	–	–
TNMG 330924E-RM:T9335	●	2.4	■	90	0.50	10.0	■	50	0.45	10.0		–	–	–		–	–	–	◪	20	0.35	8.0		–	–	–

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

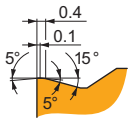




RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
WNMG 060412E-RM:T9315	●	1.2	230	0.45	3.0	–	–	–	215	0.45	3.0	–	–	–	–	–	–	–	–	–
WNMG 060412E-RM:T9325	●	1.2	230	0.45	1.2	135	0.41	1.2	215	0.45	1.2	–	–	–	50	0.32	1.0	–	–	–
WNMG 060412E-RM:T9415	●	1.2	280	0.45	3.0	–	–	–	265	0.45	3.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T5305	●	0.8	275	0.40	4.0	–	–	–	260	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T5315	●	0.8	250	0.40	4.0	–	–	–	235	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T7325	●	0.8	180	0.40	4.0	140	0.36	4.0	–	–	–	–	–	–	55	0.28	3.2	–	–	–
WNMG 080408E-RM:T7335	●	0.8	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
WNMG 080408E-RM:T8315	●	0.8	165	0.40	4.0	95	0.36	4.0	155	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
WNMG 080408E-RM:T8415	●	0.8	195	0.40	4.0	100	0.36	4.0	180	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
WNMG 080408E-RM:T8430	●	0.8	165	0.40	4.0	90	0.36	4.0	135	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
WNMG 080408E-RM:T9310	●	0.8	240	0.40	4.0	–	–	–	225	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T9315	●	0.8	220	0.40	4.0	–	–	–	205	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080408E-RM:T9325	●	0.8	200	0.40	4.0	120	0.36	4.0	190	0.40	4.0	–	–	–	45	0.28	3.2	–	–	–
WNMG 080408E-RM:T9335	●	0.8	170	0.40	4.0	100	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
WNMG 080408E-RM:T9415	●	0.8	265	0.40	4.0	–	–	–	250	0.40	4.0	–	–	–	–	–	–	–	–	–
WNMG 080412E-RM:T5305	●	1.2	280	0.45	4.0	–	–	–	265	0.45	4.0	–	–	–	–	–	–	–	–	–
WNMG 080412E-RM:T5315	●	1.2	250	0.45	4.0	–	–	–	235	0.45	4.0	–	–	–	–	–	–	–	–	–
WNMG 080412E-RM:T9325	●	1.2	200	0.45	4.0	120	0.41	4.0	190	0.45	4.0	–	–	–	45	0.32	3.2	–	–	–
WNMG 080412E-RM:T9335	●	1.2	175	0.45	4.0	105	0.41	4.0	–	–	–	–	–	–	35	0.32	3.2	–	–	–
WNMG 080412E-RM:T9415	●	1.2	270	0.45	4.0	–	–	–	255	0.45	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM:T5305	●	1.6	280	0.50	4.0	–	–	–	265	0.50	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM:T5315	●	1.6	255	0.50	4.0	–	–	–	240	0.50	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM:T8430	✱	1.6	170	0.50	4.0	90	0.45	4.0	135	0.50	4.0	–	–	–	35	0.35	3.2	–	–	–
WNMG 080416E-RM:T9310	●	1.6	240	0.50	4.0	–	–	–	225	0.50	4.0	–	–	–	–	–	–	–	–	–
WNMG 080416E-RM:T9325	●	1.6	205	0.50	4.0	120	0.45	4.0	190	0.50	4.0	–	–	–	45	0.35	3.2	–	–	–
WNMG 080416E-RM:T9335	●	1.6	175	0.50	4.0	105	0.45	4.0	–	–	–	–	–	–	35	0.35	3.2	–	–	–
WNMG 080416E-RM:T9415	●	1.6	275	0.50	4.0	–	–	–	260	0.50	4.0	–	–	–	–	–	–	–	–	–

R

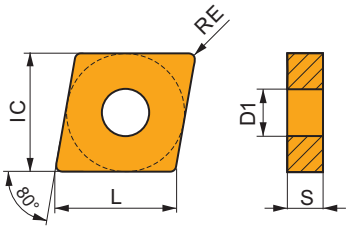


R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.

PRAMET

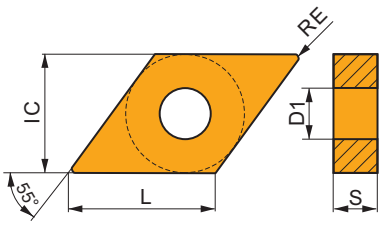
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.880	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



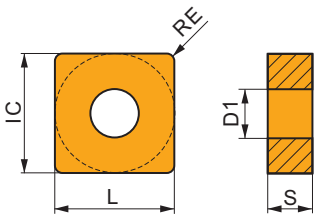
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



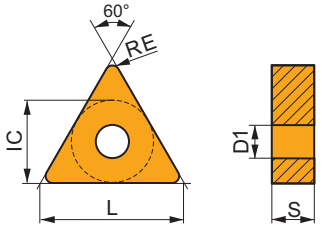
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



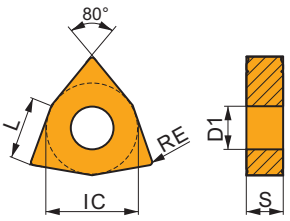
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

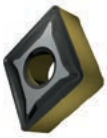
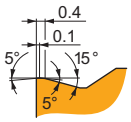
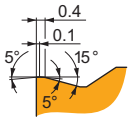
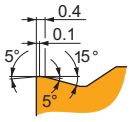


WNMG

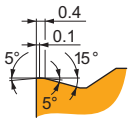
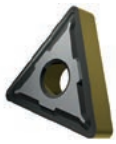
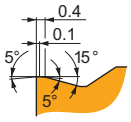
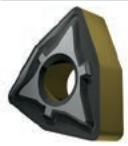
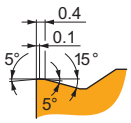
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



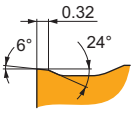
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																			
CNMG 120408E-R:6640	0.8	140	0.40	4.0	–	–	–	130	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T5305	0.8	240	0.40	4.0	–	–	–	225	0.40	4.0	–	–	–	–	–	–	45	0.20	0.7
CNMG 120408E-R:T5315	0.8	215	0.40	4.0	–	–	–	200	0.40	4.0	–	–	–	–	–	–	40	0.20	0.7
CNMG 120408E-R:T9325	0.8	175	0.40	4.0	–	–	–	165	0.40	4.0	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T9335	0.8	150	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120408E-R:T9415	0.8	230	0.40	4.0	–	–	–	215	0.40	4.0	–	–	–	–	–	–	45	0.20	0.7
CNMG 120412E-R:T9325	1.2	175	0.45	4.0	–	–	–	165	0.45	4.0	–	–	–	–	–	–	–	–	–
CNMG 120412E-R:T9335	1.2	155	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-R:T9415	1.2	235	0.45	4.0	–	–	–	220	0.45	4.0	–	–	–	–	–	–	45	0.23	1.0
CNMG 120416E-R:T5315	1.6	225	0.50	4.0	–	–	–	210	0.50	4.0	–	–	–	–	–	–	45	0.25	1.3
CNMG 120416E-R:T9335	1.6	150	0.50	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608E-R:T5315	0.8	210	0.40	5.5	–	–	–	195	0.40	5.5	–	–	–	–	–	–	40	0.20	0.7
CNMG 160612E-R:T5315	1.2	215	0.45	5.5	–	–	–	200	0.45	5.5	–	–	–	–	–	–	40	0.23	1.0
CNMG 160612E-R:T7335	1.2	145	0.45	5.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612E-R:T9315	1.2	190	0.45	5.5	–	–	–	180	0.45	5.5	–	–	–	–	–	–	35	0.23	1.0
CNMG 160612E-R:T9325	1.2	170	0.45	5.5	–	–	–	160	0.45	5.5	–	–	–	–	–	–	–	–	–
CNMG 160612E-R:T9415	1.2	230	0.45	5.5	–	–	–	215	0.45	5.5	–	–	–	–	–	–	45	0.23	1.0
CNMG 190612E-R:6630	1.2	150	0.45	7.0	–	–	–	140	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:6640	1.2	135	0.45	7.0	–	–	–	125	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T5315	1.2	210	0.45	7.0	–	–	–	195	0.45	7.0	–	–	–	–	–	–	40	0.23	1.0
CNMG 190612E-R:T9325	1.2	165	0.45	7.0	–	–	–	155	0.45	7.0	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T9335	1.2	145	0.45	7.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612E-R:T9415	1.2	225	0.45	7.0	–	–	–	210	0.45	7.0	–	–	–	–	–	–	45	0.23	1.0
CNMG 190616E-R:6630	1.6	150	0.50	7.0	–	–	–	140	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:6640	1.6	130	0.50	7.0	–	–	–	120	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T5315	1.6	210	0.50	7.0	–	–	–	195	0.50	7.0	–	–	–	–	–	–	40	0.25	1.3
CNMG 190616E-R:T9315	1.6	180	0.50	7.0	–	–	–	170	0.50	7.0	–	–	–	–	–	–	35	0.25	1.3
CNMG 190616E-R:T9325	1.6	165	0.50	7.0	–	–	–	155	0.50	7.0	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T9335	1.6	145	0.50	7.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616E-R:T9415	1.6	225	0.50	7.0	–	–	–	210	0.50	7.0	–	–	–	–	–	–	45	0.25	1.3
 																			
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																			
DNMG 150408E-R:T5315	0.8	175	0.40	3.0	–	–	–	165	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150608E-R:T5305	0.8	200	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
DNMG 150608E-R:T5315	0.8	175	0.40	3.0	–	–	–	165	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150608E-R:T9325	0.8	140	0.40	3.0	–	–	–	130	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150608E-R:T9415	0.8	190	0.40	3.0	–	–	–	180	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
DNMG 150612E-R:T5315	1.2	185	0.40	3.0	–	–	–	175	0.40	3.0	–	–	–	–	–	–	35	0.20	0.9
DNMG 150612E-R:T9325	1.2	150	0.40	3.0	–	–	–	140	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMG 150612E-R:T9415	1.2	200	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.9
DNMG 150616E-R:T9325	1.6	155	0.40	3.0	–	–	–	145	0.40	3.0	–	–	–	–	–	–	–	–	–
 																			
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																			
SNMG 120408E-R:6640	0.8	145	0.40	3.8	–	–	–	135	0.40	3.8	–	–	–	–	–	–	–	–	–
SNMG 120408E-R:T5305	0.8	250	0.40	3.8	–	–	–	235	0.40	3.8	–	–	–	–	–	–	50	0.20	0.7
SNMG 120408E-R:T9325	0.8	180	0.40	3.8	–	–	–	170	0.40	3.8	–	–	–	–	–	–	–	–	–
SNMG 120408E-R:T9335	0.8	155	0.40	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120412E-R:T9325	1.2	180	0.45	3.8	–	–	–	170	0.45	3.8	–	–	–	–	–	–	–	–	–
SNMG 120412E-R:T9335	1.2	160	0.45	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-R:T9325	1.6	185	0.50	3.8	–	–	–	175	0.50	3.8	–	–	–	–	–	–	–	–	–
SNMG 120416E-R:T9415	1.6	250	0.50	3.8	–	–	–	235	0.50	3.8	–	–	–	–	–	–	50	0.25	1.3

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																			
SNMG 150612E-R:T5315	1.2	230	0.45	4.5	–	–	–	215	0.45	4.5	–	–	–	–	–	–	45	0.23	1.0
SNMG 150612E-R:T9325	1.2	180	0.45	4.5	–	–	–	170	0.45	4.5	–	–	–	–	–	–	–	–	–
SNMG 150612E-R:T9415	1.2	245	0.45	4.5	–	–	–	230	0.45	4.5	–	–	–	–	–	–	45	0.23	1.0
SNMG 150616E-R:T5315	1.6	230	0.50	4.5	–	–	–	215	0.50	4.5	–	–	–	–	–	–	45	0.25	1.3
SNMG 150616E-R:T9325	1.6	180	0.50	4.5	–	–	–	170	0.50	4.5	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:6630	1.2	160	0.45	6.0	–	–	–	150	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:6640	1.2	140	0.45	6.0	–	–	–	130	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190612E-R:T9325	1.2	175	0.45	6.0	–	–	–	165	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:6630	1.6	165	0.50	6.0	–	–	–	155	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9325	1.6	175	0.50	6.0	–	–	–	165	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9335	1.6	150	0.50	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-R:T9415	1.6	240	0.50	6.0	–	–	–	225	0.50	6.0	–	–	–	–	–	–	45	0.25	1.3
 																			
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																			
TNMG 160408E-R:T5305	0.8	210	0.40	3.0	–	–	–	195	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
TNMG 160408E-R:T5315	0.8	185	0.40	3.0	–	–	–	175	0.40	3.0	–	–	–	–	–	–	35	0.20	0.7
TNMG 160408E-R:T9325	0.8	150	0.40	3.0	–	–	–	140	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160408E-R:T9335	0.8	130	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160408E-R:T9415	0.8	205	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
TNMG 160412E-R:T5315	1.2	195	0.40	3.0	–	–	–	185	0.40	3.0	–	–	–	–	–	–	35	0.20	0.9
TNMG 160412E-R:T9325	1.2	160	0.40	3.0	–	–	–	150	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMG 160412E-R:T9335	1.2	140	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 160412E-R:T9415	1.2	215	0.40	3.0	–	–	–	200	0.40	3.0	–	–	–	–	–	–	40	0.20	0.9
TNMG 220408E-R:T9325	0.8	145	0.40	4.0	–	–	–	135	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220408E-R:T9335	0.8	125	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TNMG 220408E-R:T9415	0.8	195	0.40	4.0	–	–	–	185	0.40	4.0	–	–	–	–	–	–	35	0.20	0.7
TNMG 220412E-R:T9325	1.2	155	0.40	4.0	–	–	–	145	0.40	4.0	–	–	–	–	–	–	–	–	–
TNMG 220412E-R:T9415	1.2	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.20	0.9
TNMG 220416E-R:T9325	1.6	165	0.40	4.0	–	–	–	155	0.40	4.0	–	–	–	–	–	–	–	–	–
 																			
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																			
WNMG 080408E-R:T5305	0.8	245	0.40	3.5	–	–	–	230	0.40	3.5	–	–	–	–	–	–	45	0.20	0.7
WNMG 080408E-R:T5315	0.8	220	0.40	3.5	–	–	–	205	0.40	3.5	–	–	–	–	–	–	40	0.20	0.7
WNMG 080408E-R:T9310	0.8	210	0.40	3.5	–	–	–	195	0.40	3.5	–	–	–	–	–	–	40	0.20	0.7
WNMG 080408E-R:T9325	0.8	175	0.40	3.5	–	–	–	165	0.40	3.5	–	–	–	–	–	–	–	–	–
WNMG 080408E-R:T9335	0.8	155	0.40	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-R:T9415	0.8	235	0.40	3.5	–	–	–	220	0.40	3.5	–	–	–	–	–	–	45	0.20	0.7
WNMG 080412E-R:T5305	1.2	250	0.45	3.5	–	–	–	235	0.45	3.5	–	–	–	–	–	–	50	0.23	1.0
WNMG 080412E-R:T5315	1.2	225	0.45	3.5	–	–	–	210	0.45	3.5	–	–	–	–	–	–	45	0.23	1.0
WNMG 080412E-R:T9310	1.2	215	0.45	3.5	–	–	–	200	0.45	3.5	–	–	–	–	–	–	40	0.23	1.0
WNMG 080412E-R:T9325	1.2	180	0.45	3.5	–	–	–	170	0.45	3.5	–	–	–	–	–	–	–	–	–
WNMG 080412E-R:T9335	1.2	155	0.45	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-R:T9415	1.2	240	0.45	3.5	–	–	–	225	0.45	3.5	–	–	–	–	–	–	45	0.23	1.0

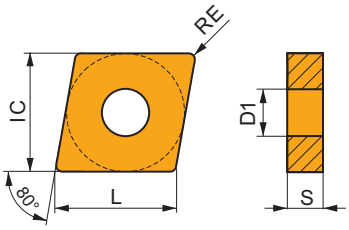
NRM



NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.

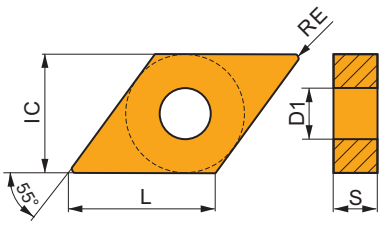
CNMG / CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



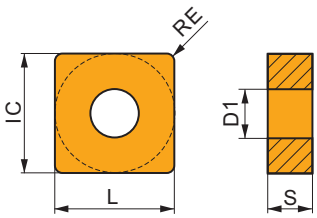
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



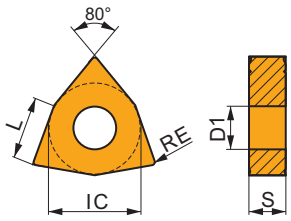
SNMG / SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53

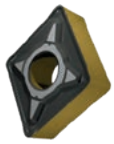
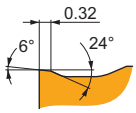
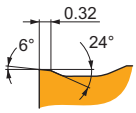
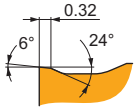


WNMG

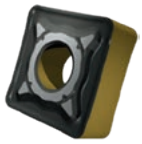
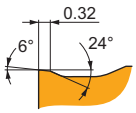
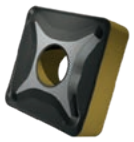
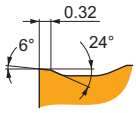
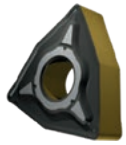
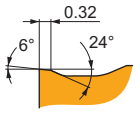
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



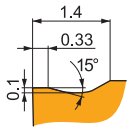
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
			**NRM** chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																	
CNMG 120408-NRM:T7325		0.8	160	0.35	4.0	120	0.32	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 120408-NRM:T8430		0.8	150	0.35	4.0	80	0.32	4.0	–	–	–	–	–	–	30	0.25	3.2	–	–	–
CNMG 120408-NRM:T9415		0.8	245	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412-NRM:T7325		1.2	165	0.40	4.0	125	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
CNMG 120412-NRM:T8430		1.2	150	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.28	3.2	–	–	–
CNMG 120412-NRM:T9415		1.2	245	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160608-NRM:T7325		0.8	155	0.35	6.0	120	0.32	6.0	–	–	–	–	–	–	50	0.28	4.8	–	–	–
CNMG 160608-NRM:T9415		0.8	235	0.35	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160612-NRM:T7325		1.2	155	0.40	6.0	120	0.36	6.0	–	–	–	–	–	–	50	0.32	4.8	–	–	–
CNMG 160612-NRM:T7335		1.2	150	0.40	6.0	115	0.36	6.0	–	–	–	–	–	–	45	0.32	4.8	–	–	–
CNMG 160612-NRM:T9415		1.2	235	0.40	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 160616-NRM:T7325		1.6	155	0.45	6.0	120	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMG 160616-NRM:T7335		1.6	150	0.45	6.0	115	0.41	6.0	–	–	–	–	–	–	45	0.36	4.8	–	–	–
CNMG 160616-NRM:T8430		1.6	145	0.45	6.0	80	0.41	6.0	–	–	–	–	–	–	30	0.32	4.8	–	–	–
CNMG 160616-NRM:T9415		1.6	240	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190612-NRM:T7325		1.2	155	0.40	8.0	120	0.36	8.0	–	–	–	–	–	–	50	0.32	6.4	–	–	–
CNMG 190612-NRM:T8430		1.2	140	0.40	8.0	75	0.36	8.0	–	–	–	–	–	–	30	0.28	6.4	–	–	–
CNMG 190612-NRM:T9415		1.2	230	0.40	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 190616-NRM:T7325		1.6	150	0.45	8.0	115	0.41	8.0	–	–	–	–	–	–	45	0.36	6.4	–	–	–
CNMG 190616-NRM:T7335		1.6	145	0.45	8.0	110	0.41	8.0	–	–	–	–	–	–	45	0.36	6.4	–	–	–
CNMG 190616-NRM:T8430		1.6	140	0.45	8.0	75	0.41	8.0	–	–	–	–	–	–	30	0.32	6.4	–	–	–
CNMG 190616-NRM:T9415		1.6	230	0.45	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 250924-NRM:T7325		2.4	95	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	30	0.49	8.0	–	–	–
CNMG 250924-NRM:T7335		2.4	90	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	25	0.49	8.0	–	–	–
			**NRM** chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																	
CNMM 250924-NRM:T7325		2.4	95	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	30	0.49	8.0	–	–	–
CNMM 250924-NRM:T7335		2.4	90	0.70	10.0	70	0.63	10.0	–	–	–	–	–	–	25	0.49	8.0	–	–	–
			**NRM** chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																	
DNMG 150608-NRM:T7335		0.8	130	0.30	3.0	100	0.27	3.0	–	–	–	–	–	–	40	0.24	2.4	–	–	–
DNMG 150608-NRM:T9415		0.8	210	0.30	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

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	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)
																				
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																				
SNMG 120408-NRM:T7325		0.8	175	0.35	2.6	135	0.32	2.6	–	–	–	–	–	–	55	0.28	2.1	–	–	–
SNMG 120412-NRM:T8430		1.2	165	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	35	0.28	2.4	–	–	–
SNMG 120412-NRM:T9415		1.2	265	0.40	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150612-NRM:T7325		1.2	170	0.40	4.0	130	0.36	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
SNMG 150616-NRM:T7325		1.6	170	0.45	5.0	130	0.41	5.0	–	–	–	–	–	–	55	0.36	4.0	–	–	–
SNMG 150616-NRM:T8430		1.6	150	0.45	5.0	80	0.41	5.0	–	–	–	–	–	–	30	0.32	4.0	–	–	–
SNMG 150616-NRM:T9415		1.6	250	0.45	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 250924-NRM:T7325		2.4	105	0.70	9.0	80	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
SNMG 250924-NRM:T9415		2.4	125	0.70	9.0	–	–	–	115	0.70	9.0	–	–	–	–	–	–	–	–	–
																				
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																				
SNMM 250716-NRM:T9415		1.6	140	0.45	9.0	–	–	–	130	0.45	9.0	–	–	–	–	–	–	–	–	–
SNMM 250724-NRM:T9415		2.4	130	0.65	9.0	–	–	–	120	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 250924-NRM:T7325		2.4	105	0.70	9.0	80	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
SNMM 250924-NRM:T7335		2.4	95	0.70	9.0	70	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
SNMM 250924-NRM:T8430		2.4	130	0.70	9.0	70	0.63	9.0	105	0.70	9.0	–	–	–	25	0.49	7.2	–	–	–
																				
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																				
WNMG 080408-NRM:T7325		0.8	170	0.35	2.7	130	0.32	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
WNMG 080408-NRM:T7335		0.8	160	0.35	2.7	120	0.32	2.7	–	–	–	–	–	–	50	0.28	2.2	–	–	–
WNMG 080408-NRM:T9415		0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412-NRM:T7325		1.2	170	0.40	2.7	130	0.36	2.7	–	–	–	–	–	–	55	0.28	2.2	–	–	–
WNMG 080412-NRM:T8430		1.2	155	0.40	2.7	85	0.36	2.7	–	–	–	–	–	–	30	0.28	2.2	–	–	–
WNMG 080412-NRM:T9315		1.2	215	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412-NRM:T9415		1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

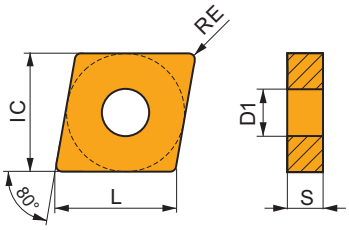
KR



KR chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.

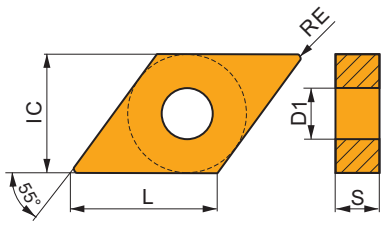
CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



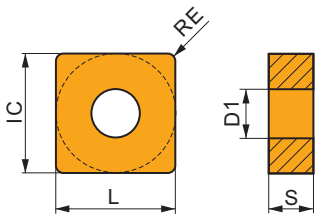
DNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



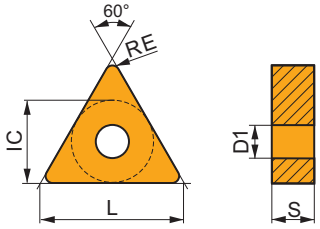
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



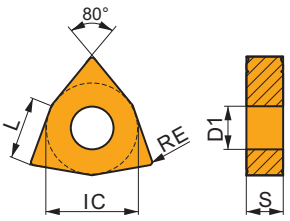
TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

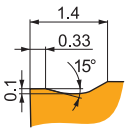
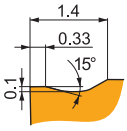
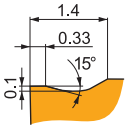
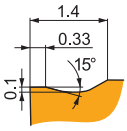
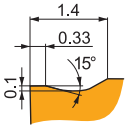


WNMG

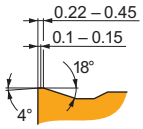
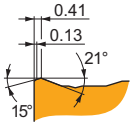
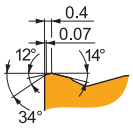
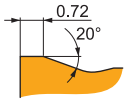
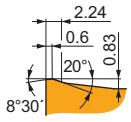
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



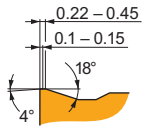
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
			**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.																	
CNMG 120408E-KR:T5305	●	0.8	255	0.35	4.0	–	–	–	240	0.35	4.0	–	–	–	–	–	–	50	0.18	0.7
CNMG 120408E-KR:T5315	⁂	0.8	225	0.35	4.0	–	–	–	210	0.35	4.0	–	–	–	–	–	–	45	0.18	0.7
CNMG 120412E-KR:T5305	⁂	1.2	255	0.40	4.0	–	–	–	240	0.40	4.0	–	–	–	–	–	–	50	0.20	1.0
CNMG 120412E-KR:T5315	⁂	1.2	230	0.40	4.0	–	–	–	215	0.40	4.0	–	–	–	–	–	–	45	0.20	1.0
CNMG 120416E-KR:T5315	⁂	1.6	230	0.45	4.0	–	–	–	215	0.45	4.0	–	–	–	–	–	–	45	0.32	0.8
CNMG 160612E-KR:T5315	⁂	1.2	230	0.45	4.5	–	–	–	215	0.45	4.5	–	–	–	–	–	–	45	0.32	0.8
CNMG 160616E-KR:T5315	⁂	1.6	230	0.50	4.5	–	–	–	215	0.50	4.5	–	–	–	–	–	–	45	0.35	0.8
CNMG 190612E-KR:T5315	⁂	1.2	220	0.45	7.0	–	–	–	205	0.45	7.0	–	–	–	–	–	–	40	0.32	0.8
CNMG 190616E-KR:T5315	⁂	1.6	220	0.50	7.0	–	–	–	205	0.50	7.0	–	–	–	–	–	–	40	0.35	0.8
			**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.																	
DNMG 150608E-KR:T5315	●	0.8	195	0.35	3.0	–	–	–	185	0.35	3.0	–	–	–	–	–	–	35	0.25	0.8
DNMG 150612E-KR:T5315	●	1.2	195	0.40	3.0	–	–	–	185	0.40	3.0	–	–	–	–	–	–	35	0.28	0.8
			**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.																	
SNMG 120408E-KR:T5305	⁂	0.8	265	0.35	3.8	–	–	–	250	0.35	3.8	–	–	–	–	–	–	50	0.18	0.7
SNMG 120408E-KR:T5315	⁂	0.8	235	0.35	3.8	–	–	–	220	0.35	3.8	–	–	–	–	–	–	45	0.18	0.7
SNMG 120412E-KR:T5315	⁂	1.2	240	0.40	3.8	–	–	–	225	0.40	3.8	–	–	–	–	–	–	45	0.20	1.0
SNMG 120416E-KR:T5315	⁂	1.6	260	0.45	3.8	–	–	–	245	0.45	3.8	–	–	–	–	–	–	50	0.32	0.8
SNMG 150612E-KR:T5315	⁂	1.2	240	0.45	4.5	–	–	–	225	0.45	4.5	–	–	–	–	–	–	45	0.32	0.8
SNMG 150616E-KR:T5315	⁂	1.6	240	0.50	4.5	–	–	–	225	0.50	4.5	–	–	–	–	–	–	45	0.35	0.8
SNMG 190616E-KR:T5315	⁂	1.6	230	0.50	7.0	–	–	–	215	0.50	7.0	–	–	–	–	–	–	45	0.35	0.8
			**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.																	
TNMG 160408E-KR:T5305	●	0.8	220	0.35	3.0	–	–	–	205	0.35	3.0	–	–	–	–	–	–	40	0.18	0.7
TNMG 160408E-KR:T5315	●	0.8	200	0.35	3.0	–	–	–	190	0.35	3.0	–	–	–	–	–	–	40	0.18	0.7
TNMG 220408E-KR:T5315	●	0.8	200	0.35	4.0	–	–	–	190	0.35	4.0	–	–	–	–	–	–	40	0.25	0.8
TNMG 220412E-KR:T5315	●	1.2	205	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.28	0.8
			**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.																	
WNMG 080408E-KR:T5305	●	0.8	255	0.35	3.5	–	–	–	240	0.35	3.5	–	–	–	–	–	–	50	0.18	0.7
WNMG 080408E-KR:T5315	⁂	0.8	230	0.35	3.5	–	–	–	215	0.35	3.5	–	–	–	–	–	–	45	0.18	0.7
WNMG 080412E-KR:T5315	⁂	1.2	235	0.40	3.5	–	–	–	220	0.40	3.5	–	–	–	–	–	–	45	0.20	1.0

HEAVY ROUGHING – NAVIGATOR

OR			**OR** chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.
NR2			**NR2** chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.
HR			**HR** chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.
HR2			**HR2** chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features positive rake angle and stable, extra-wide double T-land. It's also conditionally suitable for Stainless steels.
923			**923** chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.

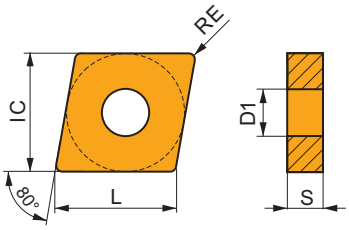
OR



OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

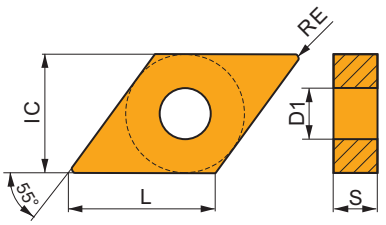
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



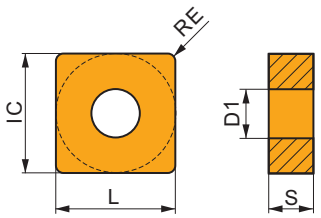
DNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



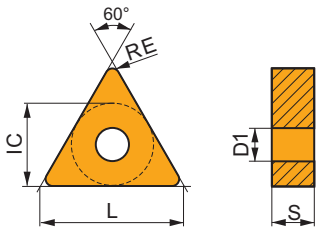
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



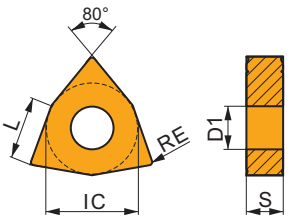
TNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

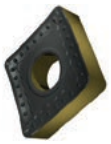
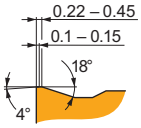
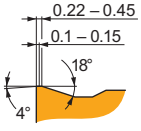


WNMM

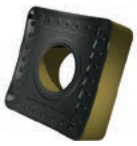
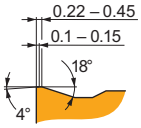
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76
1306	19.050	7.94	13.00	6.35



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	P			M			K			N			S			H		
	(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)	vc (m/min)	f (mm/rev)	ap (mm)
 																			
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.																			
CNMM 120408E-OR:T8430	0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	–	–	–	30	0.28	4.0	–	–	–
CNMM 120408E-OR:T9325	0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	–	–	–	40	0.28	4.0	–	–	–
CNMM 120408E-OR:T9335	0.8	160	0.40	5.0	95	0.36	5.0	–	–	–	–	–	–	35	0.28	4.0	–	–	–
CNMM 120408E-OR:T9415	0.8	250	0.40	5.0	–	–	–	235	0.40	5.0	–	–	–	–	–	–	–	–	–
CNMM 120412E-OR:T9325	1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	–	–	–	40	0.36	4.0	–	–	–
CNMM 120412E-OR:T9335	1.2	165	0.45	5.0	95	0.41	5.0	–	–	–	–	–	–	35	0.36	4.0	–	–	–
CNMM 120412E-OR:T9415	1.2	250	0.45	5.0	–	–	–	235	0.45	5.0	–	–	–	–	–	–	–	–	–
CNMM 120416E-OR:T9325	1.6	190	0.50	5.0	110	0.45	5.0	180	0.50	5.0	–	–	–	40	0.40	4.0	–	–	–
CNMM 160608E-OR:T9325	0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	–	–	–	40	0.32	4.8	–	–	–
CNMM 160608E-OR:T9415	0.8	245	0.40	6.0	–	–	–	230	0.40	6.0	–	–	–	–	–	–	–	–	–
CNMM 160612E-OR:T8430	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	–	–	–	30	0.36	4.8	–	–	–
CNMM 160612E-OR:T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
CNMM 160612E-OR:T9415	1.2	250	0.45	6.0	–	–	–	235	0.45	6.0	–	–	–	–	–	–	–	–	–
CNMM 160616E-OR:T9325	1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
CNMM 160616E-OR:T9415	1.6	250	0.50	6.0	–	–	–	235	0.50	6.0	–	–	–	–	–	–	–	–	–
CNMM 190612E-OR:T8430	1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-OR:T9325	1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	–	–	–	35	0.36	7.2	–	–	–
CNMM 190612E-OR:T9335	1.2	150	0.45	9.0	90	0.41	9.0	–	–	–	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-OR:T9415	1.2	240	0.45	9.0	–	–	–	225	0.45	9.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-OR:6630	1.6	160	0.50	9.0	95	0.45	9.0	150	0.50	9.0	–	–	–	40	0.40	7.2	–	–	–
CNMM 190616E-OR:T8430	1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-OR:T9325	1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	–	–	–	35	0.40	7.2	–	–	–
CNMM 190616E-OR:T9335	1.6	155	0.50	9.0	90	0.45	9.0	–	–	–	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-OR:T9415	1.6	240	0.50	9.0	–	–	–	225	0.50	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-OR:T9315	2.4	165	0.80	9.0	–	–	–	155	0.80	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-OR:T9325	2.4	150	0.80	9.0	90	0.72	9.0	140	0.80	9.0	–	–	–	30	0.56	7.2	–	–	–
CNMM 190624E-OR:T9415	2.4	215	0.80	9.0	–	–	–	200	0.80	9.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-OR:6630	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
CNMM 250924E-OR:T8430	2.4	75	1.00	12.0	40	0.90	12.0	60	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
CNMM 250924E-OR:T9325	2.4	95	1.00	12.0	55	0.90	12.0	90	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
CNMM 250924E-OR:T9335	2.4	75	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
CNMM 250924E-OR:T9415	2.4	110	1.00	12.0	–	–	–	100	1.00	12.0	–	–	–	–	–	–	–	–	–
 																			
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.																			
DNMM 150608E-OR:T9325	0.8	155	0.40	3.0	90	0.36	3.0	145	0.40	3.0	–	–	–	30	0.28	2.4	–	–	–
DNMM 150612E-OR:T9325	1.2	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.32	2.4	–	–	–
DNMM 150612E-OR:T9335	1.2	145	0.40	3.0	85	0.36	3.0	–	–	–	–	–	–	30	0.32	2.4	–	–	–
DNMM 150612E-OR:T9415	1.2	220	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	–	–	–
DNMM 150616E-OR:T9325	1.6	165	0.45	3.0	95	0.41	3.0	155	0.45	3.0	–	–	–	35	0.41	2.4	–	–	–

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
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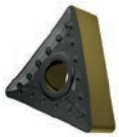
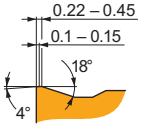
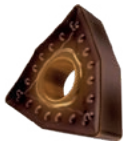
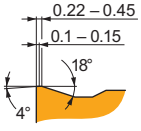
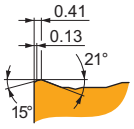
SNMM 120408E-OR:T9325	0.8	195	0.40	4.7	115	0.36	4.7	185	0.40	4.7	–	–	–	40	0.32	3.8	–	–	–
SNMM 120408E-OR:T9335	0.8	175	0.40	4.7	105	0.36	4.7	–	–	–	–	–	–	35	0.32	3.8	–	–	–
SNMM 120408E-OR:T9415	0.8	265	0.40	4.7	–	–	–	250	0.40	4.7	–	–	–	–	–	–	–	–	–
SNMM 120412E-OR:T9325	1.2	200	0.45	4.7	120	0.41	4.7	190	0.45	4.7	–	–	–	45	0.36	3.8	–	–	–
SNMM 120412E-OR:T9415	1.2	270	0.45	4.7	–	–	–	255	0.45	4.7	–	–	–	–	–	–	–	–	–
SNMM 120416E-OR:T9325	1.6	200	0.50	4.7	120	0.45	4.7	190	0.50	4.7	–	–	–	45	0.40	3.8	–	–	–
SNMM 150608E-OR:T9325	0.8	190	0.40	6.0	110	0.36	6.0	180	0.40	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150612E-OR:T9325	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150616E-OR:T9325	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
SNMM 150616E-OR:T9415	1.6	265	0.50	6.0	–	–	–	250	0.50	6.0	–	–	–	–	–	–	–	–	–
SNMM 190612E-OR:T8430	1.2	150	0.45	8.0	80	0.41	8.0	125	0.45	8.0	–	–	–	30	0.36	6.4	–	–	–
SNMM 190612E-OR:T9325	1.2	190	0.45	8.0	110	0.41	8.0	180	0.45	8.0	–	–	–	40	0.36	6.4	–	–	–
SNMM 190612E-OR:T9335	1.2	165	0.45	8.0	95	0.41	8.0	–	–	–	–	–	–	35	0.36	6.4	–	–	–
SNMM 190612E-OR:T9415	1.2	250	0.45	8.0	–	–	–	235	0.45	8.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-OR:6630	1.6	175	0.50	8.0	105	0.45	8.0	165	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-OR:T8345	1.6	125	0.50	8.0	75	0.45	8.0	115	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-OR:T8430	1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-OR:T9325	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-OR:T9335	1.6	160	0.50	8.0	95	0.45	8.0	–	–	–	–	–	–	35	0.40	6.4	–	–	–
SNMM 190616E-OR:T9415	1.6	260	0.50	8.0	–	–	–	245	0.50	8.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-OR:T9325	2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–
SNMM 190624E-OR:T9415	2.4	225	0.80	8.0	–	–	–	210	0.80	8.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-OR:T9226	1.6	115	0.50	12.0	65	0.45	12.0	105	0.50	12.0	–	–	–	20	0.45	9.6	–	–	–
SNMM 250716E-OR:T9325	1.6	120	0.55	12.0	70	0.50	12.0	110	0.55	12.0	–	–	–	25	0.50	9.6	–	–	–
SNMM 250724E-OR:T8345	2.4	55	1.00	12.0	30	0.90	12.0	50	1.00	12.0	–	–	–	10	0.70	9.6	–	–	–
SNMM 250724E-OR:T8430	2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
SNMM 250724E-OR:T9325	2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
SNMM 250724E-OR:T9335	2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
SNMM 250724E-OR:T9415	2.4	120	1.00	12.0	–	–	–	110	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-OR:T8430	2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
SNMM 250924E-OR:T9325	2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
SNMM 250924E-OR:T9335	2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
SNMM 250924E-OR:T9415	2.4	120	1.00	12.0	–	–	–	110	1.00	12.0	–	–	–	–	–	–	–	–	–
 																			
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.																			
TNMM 160408E-OR:T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMM 160408E-OR:T9415	0.8	225	0.40	3.0	–	–	–	210	0.40	3.0	–	–	–	–	–	–	–	–	–
TNMM 220408E-OR:T9325	0.8	160	0.40	4.0	95	0.36	4.0	150	0.40	4.0	–	–	–	35	0.32	3.2	–	–	–
TNMM 220408E-OR:T9335	0.8	140	0.40	4.0	80	0.36	4.0	–	–	–	–	–	–	30	0.32	3.2	–	–	–
TNMM 220412E-OR:T9325	1.2	175	0.40	3.0	105	0.36	3.0	165	0.40	3.0	–	–	–	35	0.32	2.4	–	–	–
TNMM 220412E-OR:T9335	1.2	150	0.40	3.0	90	0.36	3.0	–	–	–	–	–	–	30	0.32	2.4	–	–	–
 																			
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.																			
WNMM 080408E-OR:T8430	0.8	155	0.40	4.0	85	0.36	4.0	130	0.40	4.0	–	–	–	30	0.28	3.2	–	–	–
WNMM 080408E-OR:T9325	0.8	190	0.40	4.0	110	0.36	4.0	180	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
WNMM 080408E-OR:T9335	0.8	165	0.40	4.0	95	0.36	4.0	–	–	–	–	–	–	35	0.28	3.2	–	–	–
WNMM 080412E-OR:T9325	1.2	190	0.45	4.0	110	0.41	4.0	180	0.45	4.0	–	–	–	40	0.36	3.2	–	–	–
WNMM 080416E-OR:T9325	1.6	195	0.50	4.0	115	0.45	4.0	185	0.50	4.0	–	–	–	40	0.40	3.2	–	–	–
WNMM 130612E-OR:T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
WNMM 130616E-OR:T9325	1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–

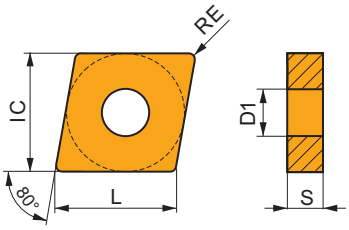
NR2



NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

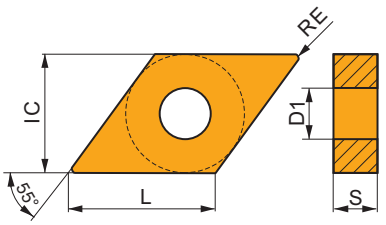
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



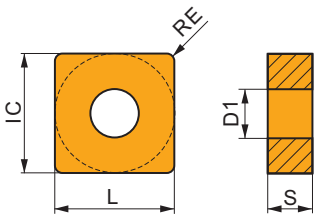
DNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



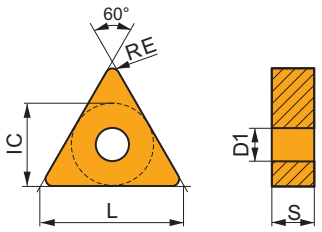
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



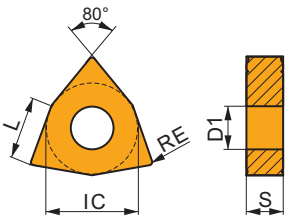
TNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76

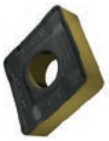
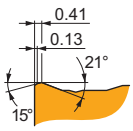
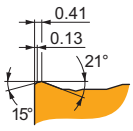


WNMM

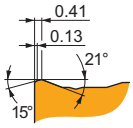
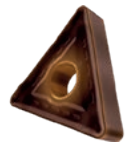
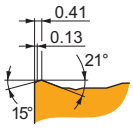
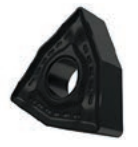
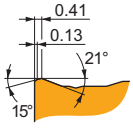
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



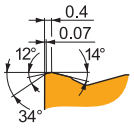
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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)
																				
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																				
CNMM 120408E-NR2:T7325		0.8	165	0.40	5.0	125	0.36	5.0	–	–	–	–	–	–	50	0.28	4.0	–	–	–
CNMM 120408E-NR2:T7335		0.8	155	0.40	5.0	120	0.36	5.0	–	–	–	–	–	–	50	0.28	4.0	–	–	–
CNMM 120408E-NR2:T8430		0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	–	–	–	30	0.28	4.0	–	–	–
CNMM 120408E-NR2:T9325		0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	–	–	–	40	0.28	4.0	–	–	–
CNMM 120408E-NR2:T9415		0.8	250	0.40	5.0	–	–	–	235	0.40	5.0	–	–	–	–	–	–	–	–	–
CNMM 120412E-NR2:T7335		1.2	155	0.45	5.0	120	0.41	5.0	–	–	–	–	–	–	50	0.32	4.0	–	–	–
CNMM 120412E-NR2:T8430		1.2	150	0.45	5.0	80	0.41	5.0	125	0.45	5.0	–	–	–	30	0.32	4.0	–	–	–
CNMM 120412E-NR2:T9325		1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	–	–	–	40	0.32	4.0	–	–	–
CNMM 160608E-NR2:T8430		0.8	150	0.40	6.0	80	0.36	6.0	125	0.40	6.0	–	–	–	30	0.32	4.8	–	–	–
CNMM 160608E-NR2:T9325		0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	–	–	–	40	0.32	4.8	–	–	–
CNMM 160612E-NR2:T7325		1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMM 160612E-NR2:T7335		1.2	155	0.45	6.0	120	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
CNMM 160612E-NR2:T8430		1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	–	–	–	30	0.36	4.8	–	–	–
CNMM 160612E-NR2:T9325		1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
CNMM 160616E-NR2:T7325		1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
CNMM 160616E-NR2:T7335		1.6	160	0.50	6.0	120	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
CNMM 160616E-NR2:T9325		1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
CNMM 190612E-NR2:T7325		1.2	155	0.45	9.0	120	0.41	9.0	–	–	–	–	–	–	50	0.36	7.2	–	–	–
CNMM 190612E-NR2:T7335		1.2	145	0.45	9.0	110	0.41	9.0	–	–	–	–	–	–	45	0.36	7.2	–	–	–
CNMM 190612E-NR2:T8430		1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	–	–	–	30	0.36	7.2	–	–	–
CNMM 190612E-NR2:T9325		1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	–	–	–	35	0.36	7.2	–	–	–
CNMM 190616E-NR2:T7325		1.6	160	0.50	9.0	120	0.45	9.0	–	–	–	–	–	–	50	0.40	7.2	–	–	–
CNMM 190616E-NR2:T7335		1.6	150	0.50	9.0	115	0.45	9.0	–	–	–	–	–	–	45	0.40	7.2	–	–	–
CNMM 190616E-NR2:T8430		1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	–	–	–	30	0.40	7.2	–	–	–
CNMM 190616E-NR2:T9325		1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	–	–	–	35	0.40	7.2	–	–	–
CNMM 190616E-NR2:T9415		1.6	240	0.50	9.0	–	–	–	225	0.50	9.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-NR2:T7335		2.4	130	0.80	9.0	100	0.72	9.0	–	–	–	–	–	–	40	0.56	7.2	–	–	–
CNMM 190624E-NR2:T9325		2.4	150	0.80	9.0	90	0.72	9.0	140	0.80	9.0	–	–	–	30	0.56	7.2	–	–	–
CNMM 250924E-NR2:T7335		2.4	95	0.80	12.0	70	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
CNMM 250924E-NR2:T8430		2.4	80	0.80	12.0	45	0.72	12.0	65	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
CNMM 250924E-NR2:T9325		2.4	100	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
CNMM 250924E-NR2:T9415		2.4	120	0.80	12.0	–	–	–	110	0.80	12.0	–	–	–	–	–	–	–	–	–
																				
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																				
DNMM 150608E-NR2:T9325		0.8	155	0.40	3.0	90	0.36	3.0	145	0.40	3.0	–	–	–	30	0.32	2.4	–	–	–

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																			
SNMM 120408E-NR2:T7325	0.8	175	0.40	4.7	135	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
SNMM 120408E-NR2:T7335	0.8	170	0.40	4.7	130	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
SNMM 120408E-NR2:T8430	0.8	165	0.40	4.7	90	0.36	4.7	135	0.40	4.7	–	–	–	35	0.32	3.8	–	–	–
SNMM 120408E-NR2:T9325	0.8	195	0.40	4.7	115	0.36	4.7	185	0.40	4.7	–	–	–	40	0.32	3.8	–	–	–
SNMM 120412E-NR2:T7335	1.2	165	0.45	4.7	125	0.41	4.7	–	–	–	–	–	–	50	0.36	3.8	–	–	–
SNMM 120412E-NR2:T8430	1.2	165	0.45	4.7	90	0.41	4.7	135	0.45	4.7	–	–	–	35	0.36	3.8	–	–	–
SNMM 120412E-NR2:T9325	1.2	200	0.45	4.7	120	0.41	4.7	190	0.45	4.7	–	–	–	45	0.36	3.8	–	–	–
SNMM 150612E-NR2:T7335	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
SNMM 150612E-NR2:T8430	1.2	165	0.45	6.0	90	0.41	6.0	135	0.45	6.0	–	–	–	35	0.36	4.8	–	–	–
SNMM 150612E-NR2:T9325	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150616E-NR2:T7335	1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
SNMM 150616E-NR2:T9325	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
SNMM 190612E-NR2:T7335	1.2	160	0.45	8.0	120	0.41	8.0	–	–	–	–	–	–	50	0.36	6.4	–	–	–
SNMM 190612E-NR2:T9325	1.2	190	0.45	8.0	110	0.41	8.0	180	0.45	8.0	–	–	–	40	0.36	6.4	–	–	–
SNMM 190616E-NR2:T7325	1.6	175	0.50	8.0	135	0.45	8.0	–	–	–	–	–	–	55	0.40	6.4	–	–	–
SNMM 190616E-NR2:T7335	1.6	160	0.50	8.0	120	0.45	8.0	–	–	–	–	–	–	50	0.40	6.4	–	–	–
SNMM 190616E-NR2:T8430	1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
SNMM 190616E-NR2:T9325	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190616E-NR2:T9415	1.6	260	0.50	8.0	–	–	–	245	0.50	8.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-NR2:T7325	2.4	155	0.80	8.0	120	0.72	8.0	–	–	–	–	–	–	50	0.56	6.4	–	–	–
SNMM 190624E-NR2:T7335	2.4	145	0.80	8.0	110	0.72	8.0	–	–	–	–	–	–	45	0.56	6.4	–	–	–
SNMM 190624E-NR2:T9325	2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–
SNMM 250724E-NR2:T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250724E-NR2:T8430	2.4	85	0.80	12.0	45	0.72	12.0	70	0.80	12.0	–	–	–	15	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9226	2.4	95	0.80	12.0	55	0.72	12.0	90	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250724E-NR2:T9415	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-NR2:T7325	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250924E-NR2:T7335	2.4	100	0.80	12.0	75	0.72	12.0	–	–	–	–	–	–	30	0.56	9.6	–	–	–
SNMM 250924E-NR2:T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	–	–	–	20	0.56	9.6	–	–	–
SNMM 250924E-NR2:T9415	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
 																			
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																			
TNMM 160408E-NR2:T9325	0.8	165	0.40	3.0	95	0.36	3.0	155	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
TNMM 220408E-NR2:T9325	0.8	160	0.40	4.0	95	0.36	4.0	150	0.40	4.0	–	–	–	35	0.28	3.2	–	–	–
TNMM 220412E-NR2:T8430	1.2	140	0.40	4.0	75	0.36	4.0	115	0.40	4.0	–	–	–	30	0.32	3.2	–	–	–
TNMM 220412E-NR2:T9325	1.2	170	0.40	4.0	100	0.36	4.0	160	0.40	4.0	–	–	–	35	0.32	3.2	–	–	–
 																			
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																			
WNMM 080408E-NR2:T7335	0.8	160	0.40	4.0	120	0.36	4.0	–	–	–	–	–	–	50	0.28	3.2	–	–	–
WNMM 080408E-NR2:T9325	0.8	190	0.40	4.0	110	0.36	4.0	180	0.40	4.0	–	–	–	40	0.28	3.2	–	–	–
WNMM 080412E-NR2:T9325	1.2	190	0.45	4.0	110	0.41	4.0	180	0.45	4.0	–	–	–	40	0.32	3.2	–	–	–

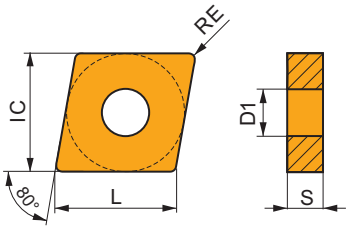
HR



HR chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

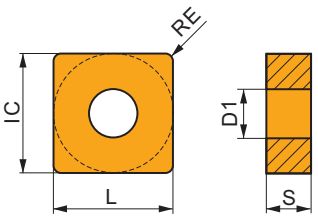
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



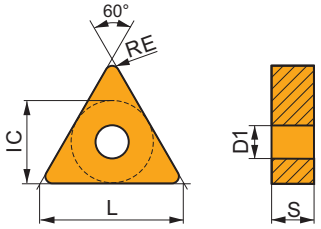
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53

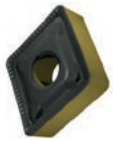
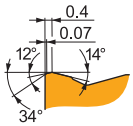
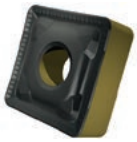
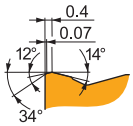
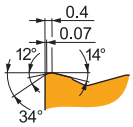


TNMM

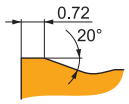
	IC (mm)	D1 (mm)	L (mm)	S (mm)
2706	15.875	6.35	27.50	6.35



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
HR chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.																			
CNMM 190616E-HR:6630	1.6	85	0.60	10.0	50	0.54	10.0	80	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:6640	1.6	75	0.60	10.0	45	0.54	10.0	70	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T8345	1.6	55	0.60	10.0	30	0.54	10.0	50	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T9325	1.6	105	0.60	10.0	60	0.54	10.0	95	0.60	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616E-HR:T9335	1.6	80	0.60	10.0	45	0.54	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:6630	2.4	90	0.65	10.0	50	0.59	10.0	85	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T8345	2.4	60	0.65	10.0	35	0.59	10.0	55	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9325	2.4	100	0.65	10.0	60	0.59	10.0	95	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9335	2.4	85	0.65	10.0	50	0.59	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190624E-HR:T9415	2.4	120	0.65	10.0	–	–	–	110	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:6630	2.4	85	0.65	14.0	50	0.59	14.0	80	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:6640	2.4	75	0.65	14.0	45	0.59	14.0	70	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T8345	2.4	55	0.65	14.0	30	0.59	14.0	50	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9315	2.4	110	0.65	14.0	–	–	–	100	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9325	2.4	100	0.65	14.0	60	0.59	14.0	95	0.65	14.0	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9335	2.4	80	0.65	14.0	45	0.59	14.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 250924E-HR:T9415	2.4	120	0.65	14.0	–	–	–	110	0.65	14.0	–	–	–	–	–	–	–	–	–
 																			
HR chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.																			
SNMM 190616E-HR:6630	1.6	90	0.60	9.0	50	0.54	9.0	85	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T8345	1.6	60	0.60	9.0	35	0.54	9.0	55	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T9325	1.6	110	0.60	9.0	65	0.54	9.0	100	0.60	9.0	–	–	–	–	–	–	–	–	–
SNMM 190616E-HR:T9335	1.6	85	0.60	9.0	50	0.54	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9315	2.4	120	0.65	9.0	–	–	–	110	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9325	2.4	115	0.65	9.0	65	0.59	9.0	105	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9335	2.4	90	0.65	9.0	50	0.59	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR:T9415	2.4	130	0.65	9.0	–	–	–	120	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T8345	1.6	60	0.60	13.0	35	0.54	13.0	55	0.60	13.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T9325	1.6	100	0.60	13.0	60	0.54	13.0	95	0.60	13.0	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR:T9335	1.6	85	0.60	13.0	50	0.54	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:6630	2.4	90	0.65	13.0	50	0.59	13.0	85	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:6640	2.4	80	0.65	13.0	45	0.59	13.0	75	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T8345	2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9325	2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9335	2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR:T9415	2.4	125	0.65	13.0	–	–	–	115	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250732E-HR:T9325	3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:6630	2.4	90	0.65	13.0	50	0.59	13.0	85	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T8345	2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9325	2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9335	2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR:T9415	2.4	125	0.65	13.0	–	–	–	115	0.65	13.0	–	–	–	–	–	–	–	–	–
SNMM 250932E-HR:T9325	3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–
 																			
HR chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.																			
TNMM 270616E-HR:T9325	1.6	90	0.60	7.0	50	0.54	7.0	85	0.60	7.0	–	–	–	–	–	–	–	–	–
TNMM 270616E-HR:T9335	1.6	75	0.60	7.0	45	0.54	7.0	–	–	–	–	–	–	–	–	–	–	–	–
TNMM 270624E-HR:T9226	2.4	80	0.65	7.0	45	0.59	7.0	75	0.65	7.0	–	–	–	–	–	–	–	–	–

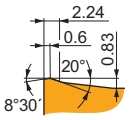
HR2



HR2 chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features positive rake angle and stable, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

PRAMET

923

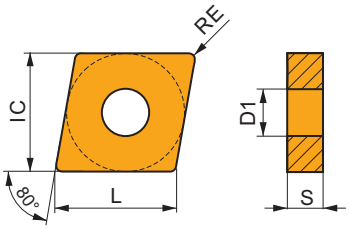


923 chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.

PRAMET

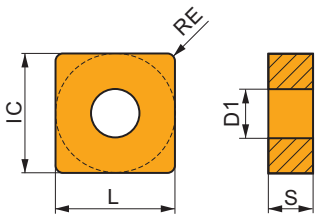
CNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53

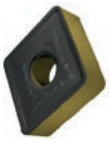
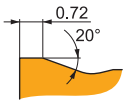


SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
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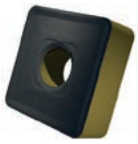
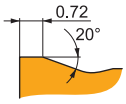
CNMM 190616-HR2:T9226	1.6	85	0.65	10.0	50	0.59	10.0	80	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190616-HR2:T9335	1.6	80	0.65	10.0	45	0.59	10.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 190616-HR2:T9415	1.6	115	0.65	10.0	–	–	–	105	0.65	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624-HR2:T9226	2.4	80	0.85	10.0	45	0.77	10.0	75	0.85	10.0	–	–	–	–	–	–	–	–	–
CNMM 190624-HR2:T9415	2.4	110	0.85	10.0	–	–	–	100	0.85	10.0	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9315	2.4	100	0.85	12.0	–	–	–	95	0.85	12.0	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9335	2.4	75	0.85	12.0	45	0.77	12.0	–	–	–	–	–	–	–	–	–	–	–	–
CNMM 250924-HR2:T9415	2.4	110	0.85	12.0	–	–	–	100	0.85	12.0	–	–	–	–	–	–	–	–	–
 																			
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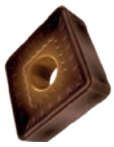
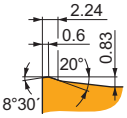
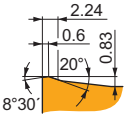
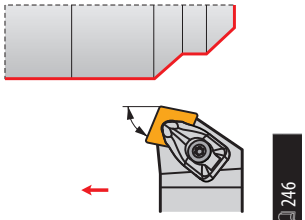
SNMM 190616-HR2:T9335	1.6	85	0.65	8.9	50	0.59	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190616-HR2:T9415	1.6	125	0.65	8.9	–	–	–	115	0.65	8.9	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2:T9335	2.4	80	0.85	8.9	45	0.77	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2:T9415	2.4	120	0.85	8.9	–	–	–	110	0.85	8.9	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2:T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2:T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9315	2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2:T9415	2.4	115	0.85	11.0	–	–	–	105	0.85	11.0	–	–	–	–	–	–	–	–	–
SNMM 250932-HR2:T9335	3.2	75	1.00	11.0	45	0.90	11.0	–	–	–	–	–	–	–	–	–	–	–	–
 																			
923 chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.																			
CNMM 250924S-923:T8430	2.4	75	0.85	12.0	40	0.77	12.0	60	0.85	12.0	–	–	–	15	0.60	9.6	–	–	–
CNMM 250924S-923:T9335	2.4	75	0.85	12.0	45	0.77	12.0	–	–	–	–	–	–	15	0.60	9.6	–	–	–
 																			
923 chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.																			
SNMM 190616S-923:T8345	1.6	100	0.65	8.9	60	0.59	8.9	95	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
SNMM 190616S-923:T8430	1.6	125	0.65	8.9	65	0.59	8.9	100	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
SNMM 190616S-923:T9335	1.6	130	0.65	8.9	75	0.59	8.9	–	–	–	–	–	–	25	0.52	7.1	–	–	–
SNMM 250724S-923:T8430	2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250724S-923:T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T8345	2.4	55	0.85	11.0	30	0.77	11.0	50	0.85	11.0	–	–	–	10	0.60	8.8	–	–	–
SNMM 250924S-923:T8430	2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923:T9415	2.4	115	0.85	11.0	–	–	–	105	0.85	11.0	–	–	–	–	–	–	–	–	–

CN

ISO TURNING – EXTERNAL – NAVIGATOR

DCBN(RL) EXT 75°

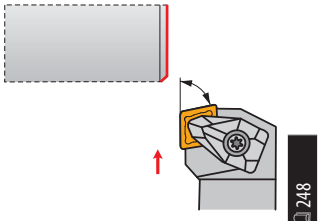
CN..



246

DCKN(RL) EXT 75°

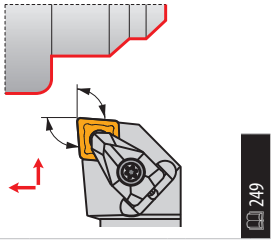
CN..



248

DCLN(RL) EXT 95°

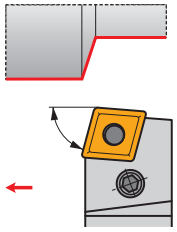
CN..



249

PCBN(RL) EXT 75°

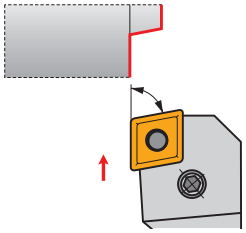
CN..



251

PCKN(RL) EXT 75°

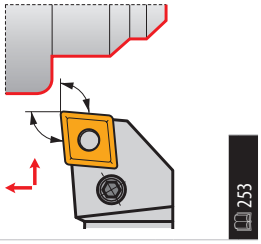
CN..



252

PCLN(RL) EXT 95°

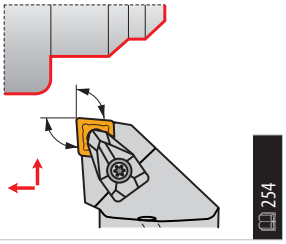
CN..



253

C.-DCLN(RL) EXT 95°

CN..



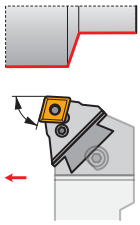
254

CN

ISO TURNING – HEAVY ROUGHING – NAVIGATOR

KHP-CBNR 75°

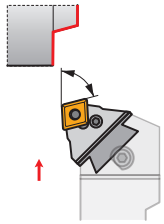
CN..



256

KHP-CBNL 75°

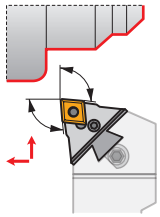
CN..



257

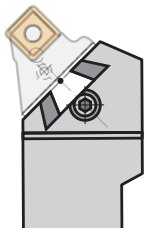
KHP-CLNR 95°

CN..



257

DKH(RL)



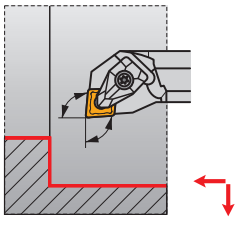
258

CN

ISO TURNING – INTERNAL – NAVIGATOR

DCLN(RL) INT 95°

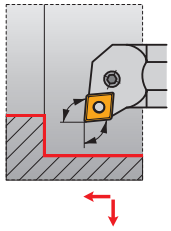
CN..



259

PCLN(RL) INT 95°

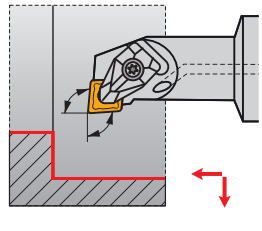
CN..



260

C.-DCLN(RL) INT 95°

CN..



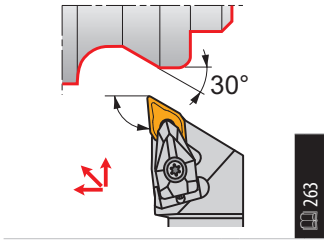
262

DN

ISO TURNING – EXTERNAL – NAVIGATOR

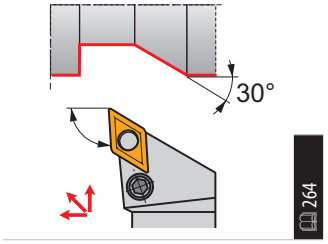
DDJN(RL) EXT 93°

DN..



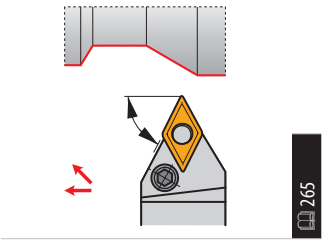
PDJN(RL) EXT 93°

DN..



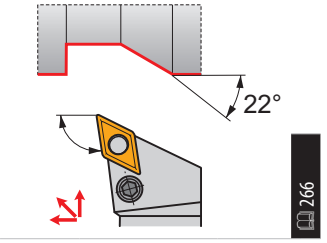
PDNN(RL) EXT 62°30´

DN..



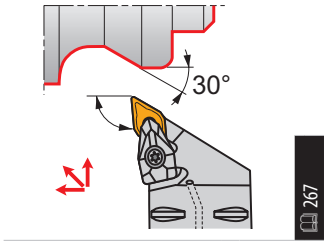
PDXN(RL) EXT 98°

DN..



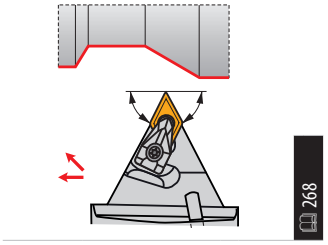
C.-DDJN(RL) EXT 93°

DN..



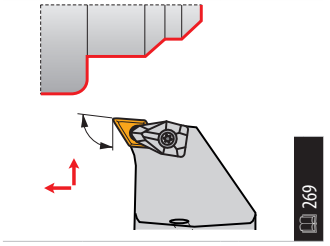
C.-DDNNN EXT 62.5°

DN..



C.-DDUN(RL) EXT 93°

DN..

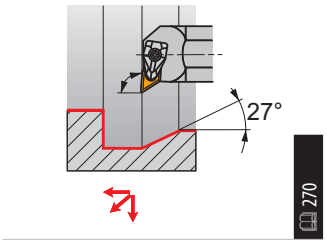


DN

ISO TURNING – INTERNAL – NAVIGATOR

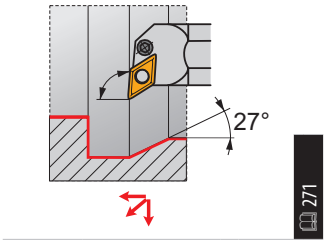
DDUN(RL) INT 93°

DN..



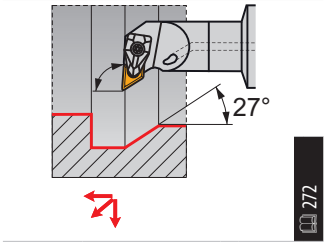
PDUN(RL) INT 93°

DN..



C.-DDUN(RL) INT 93°

DN..

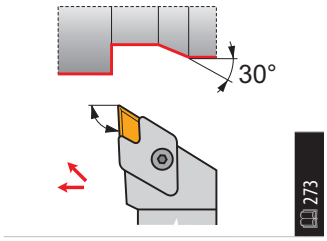


KN

ISO TURNING – EXTERNAL – NAVIGATOR

CKJN(RL) EXT 93°

KN..



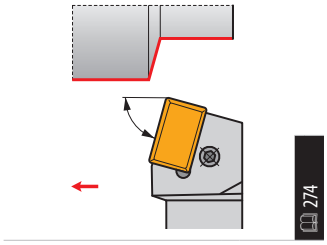
273

LN

ISO TURNING – EXTERNAL – NAVIGATOR

PLBN(RL) EXT 75°

LN..



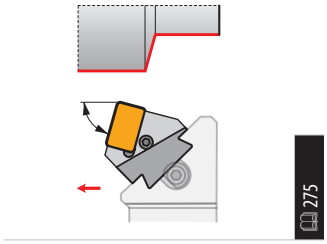
274

LN

ISO TURNING – HEAVY ROUGHING – NAVIGATOR

KHP-LBNR 75°

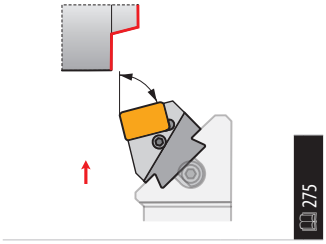
LN..



275

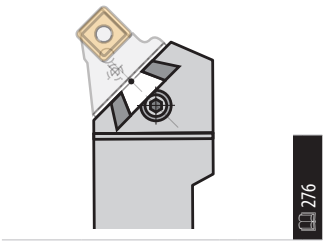
KHP-LBNL 75°

LN..



275

DKH(RL)



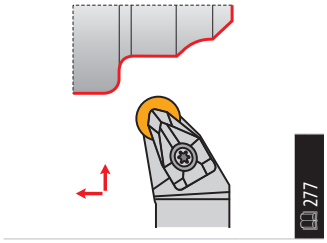
276

RN

ISO TURNING – EXTERNAL – NAVIGATOR

DRSN(RL) EXT

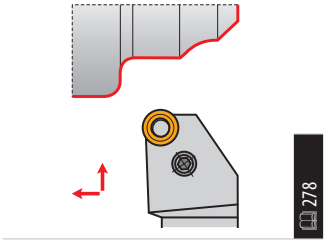
RN..



277

PRSN(RL) EXT

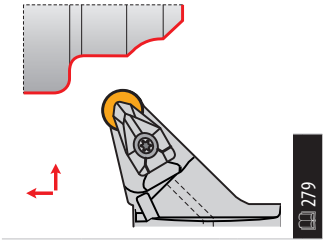
RN..



278

C.-DRSN(RL) EXT

RN..

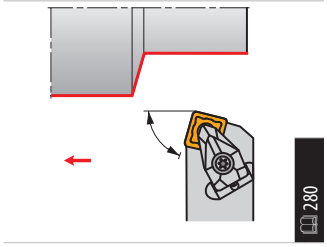


279

SN

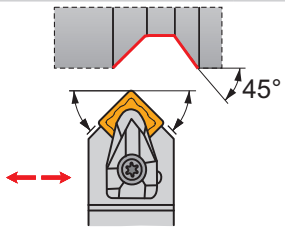
ISO TURNING – EXTERNAL – NAVIGATOR

DSBN(RL) EXT 45°
SN..



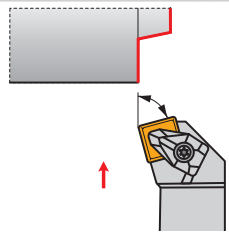
280

DSDNN EXT 45°
SN..



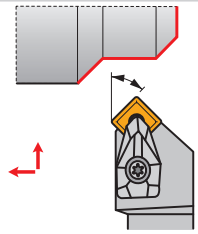
281

DSKN(RL) EXT 75°
SN..



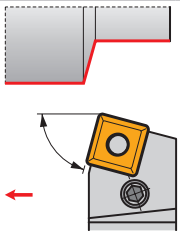
282

DSSN(RL) EXT 45°
SN..



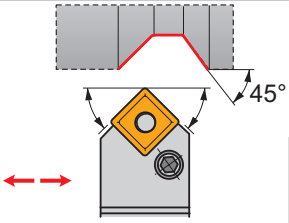
283

PSBN(RL) EXT 75°
SN..



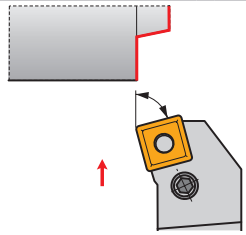
285

PSDNN EXT 45°
SN..



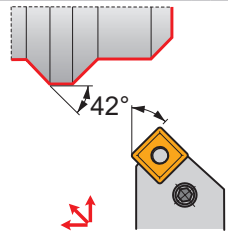
287

PSKN(RL) EXT 75°
SN..



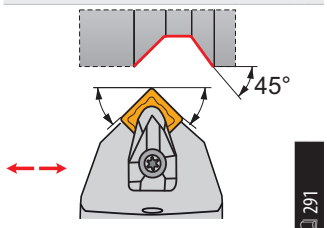
288

PSSN(RL) EXT 45°
SN..



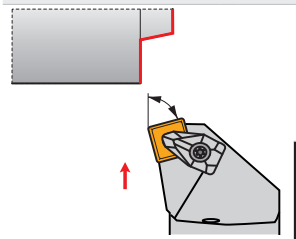
290

C.-DSDNN EXT 45°
SN..



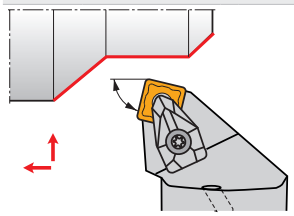
291

C.-DSKN(RL) EXT 75°
SN..



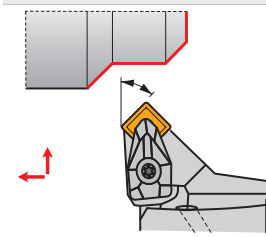
292

C.-DSRN(RL) EXT 75°
SN..



293

C.-DSSN(RL) EXT 45°
SN..

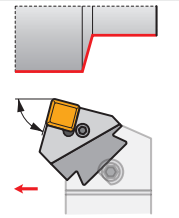


294

SN

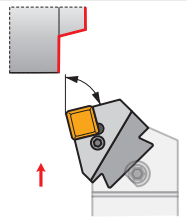
ISO TURNING – HEAVY ROUGHING – NAVIGATOR

KHP-SBNR 75°
SN..



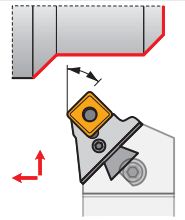
295

KHP-SBNL 75°
SN..



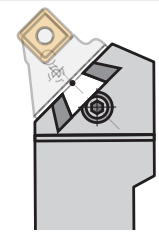
295

KHP-SSNR/L 45°
SN..



296

DKH(RL)

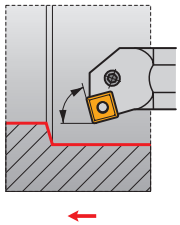


297

SN

ISO TURNING – INTERNAL – NAVIGATOR

PSKN(RL) INT 75°
SN..



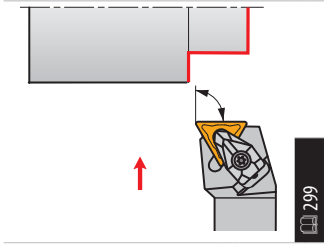
298

TN

ISO TURNING – EXTERNAL – NAVIGATOR

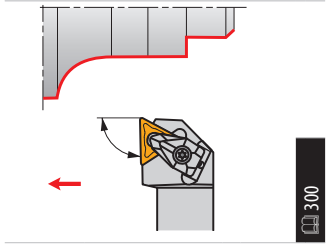
DTFN(RL) EXT 90°

TN..



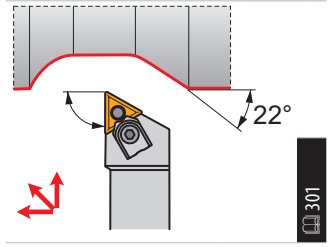
DTGN(RL) EXT 90°

TN..



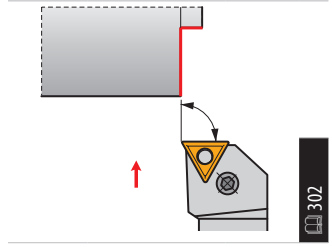
MTJN(RL) EXT 93°

TN..



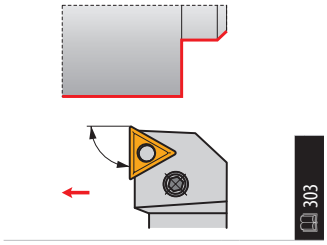
PTFN(RL) EXT 90°

TN..



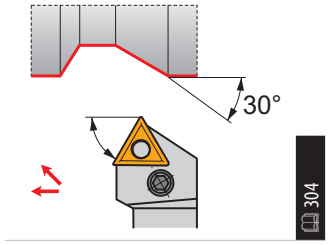
PTGN(RL) EXT 90°

TN..



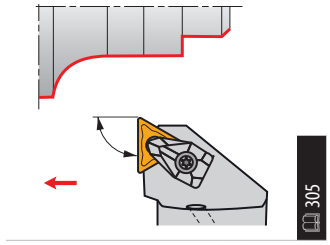
PTTN(RL) EXT 60°

TN..



C.-DTJN(RL) EXT 93°

TN..

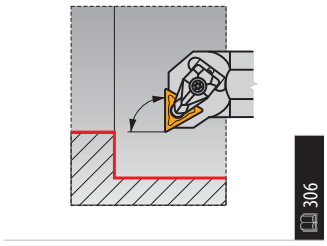


TN

ISO TURNING – INTERNAL – NAVIGATOR

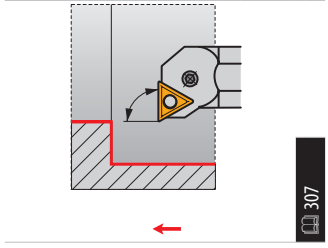
DTFN(RL) INT 90°

TN..



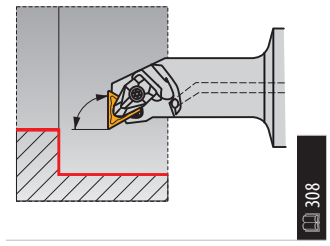
PTFN(RL) INT 90°

TN..



C.-DTFN(RL) INT 91°

TN..

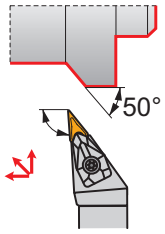


VN

ISO TURNING – EXTERNAL – NAVIGATOR

DVJN(RL) EXT 93°

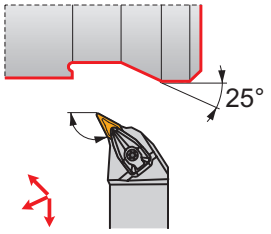
VN..



309

DVPN(RL) EXT 62°30´

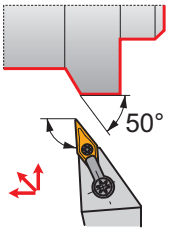
VN..



310

MVJN(RL) EXT 93°

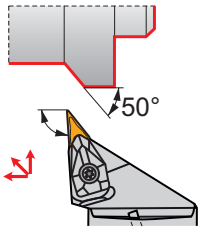
VN..



311

C.-DVJN(RL) EXT 93°

VN..



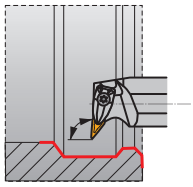
312

VN

ISO TURNING – INTERNAL – NAVIGATOR

DVUN(RL) INT

VN..



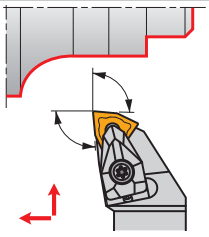
313

WN

ISO TURNING – EXTERNAL – NAVIGATOR

DWLN(RL) EXT 95°

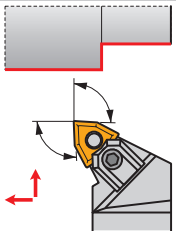
WN..



314

MWLN(RL) EXT 95°

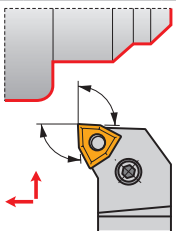
WN..



316

PWLN(RL) EXT 95°

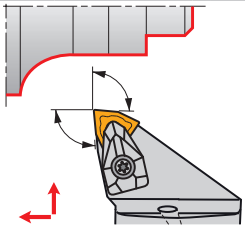
WN..



317

C.-DWLN(RL) EXT 95°

WN..



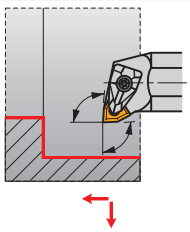
318

WN

ISO TURNING – INTERNAL – NAVIGATOR

DWLN(RL) INT 95°

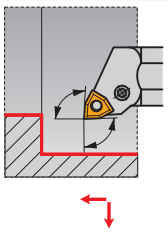
WN..



319

PWLN(RL) INT 95°

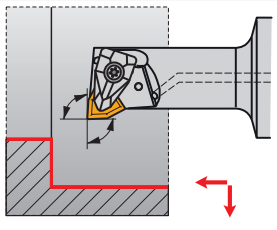
WN..



320

C.-DWLN(RL) INT 95°

WN..



321

DCBN(RL) EXT

P M K N S H

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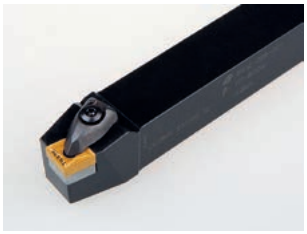
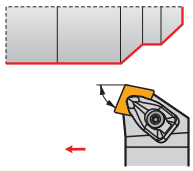
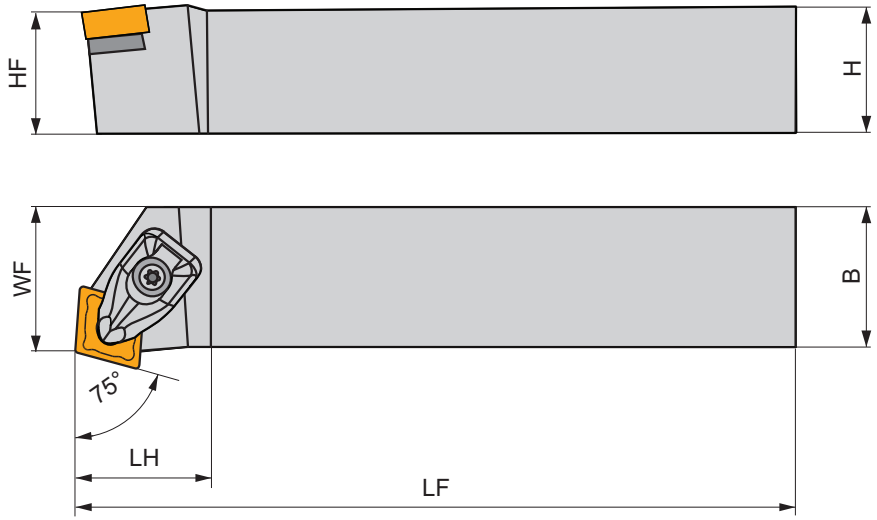
D

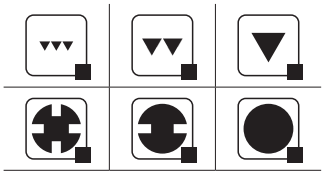


External Double Clamp Turning Holder with 75° Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 75° tool holder. Suited for longitudinal and face turning without shoulder and chamfering with negative CN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCBNR 2020 K 12	20	20	20	17	125	34.2	-6	-6	0.43	GI043	DC12	AT001
	DCBNR 2525 M 12	25	25	25	22	150	34.6	-6	-6	0.76	GI043	DC12	AT001
	DCBNR 3225 P 12	32	25	32	22	170	34.6	-6	-6	1.09	GI043	DC12	AT001
	DCBNR 2525 M 16	25	25	25	22	150	41.5	-6	-6	0.80	GI050	DC16	AT005
	DCBNR 3225 P 16	32	25	32	22	170	32.0	-6	-6	1.11	GI050	DC16	AT005
	DCBNR 3232 P 19	32	32	32	27	170	46.1	-6	-6	1.39	GI042	DC19	–
L	DCBNL 2525 M 12	25	25	25	22	150	34.6	-6	-6	0.76	GI043	DC12	AT001
	DCBNL 3225 P 12	32	25	32	22	170	34.6	-6	-6	1.09	GI043	DC12	AT001
	DCBNL 2525 M 16	25	25	25	22	150	41.5	-6	-6	0.79	GI050	DC16	AT005
	DCBNL 3225 P 16	32	25	32	22	170	32.0	-6	-6	1.11	GI050	DC16	AT005
	DCBNL 3232 P 19	32	32	32	27	170	46.1	-6	-6	1.39	GI042	DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P

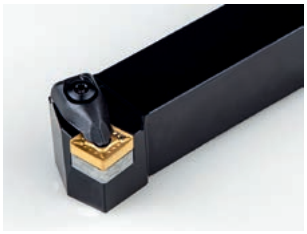
AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

DCKN(RL) EXT

P M K N S H

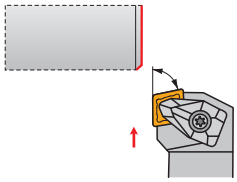
PRAMET

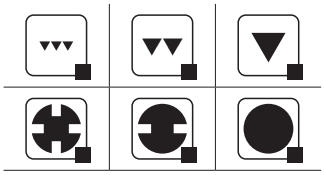
D

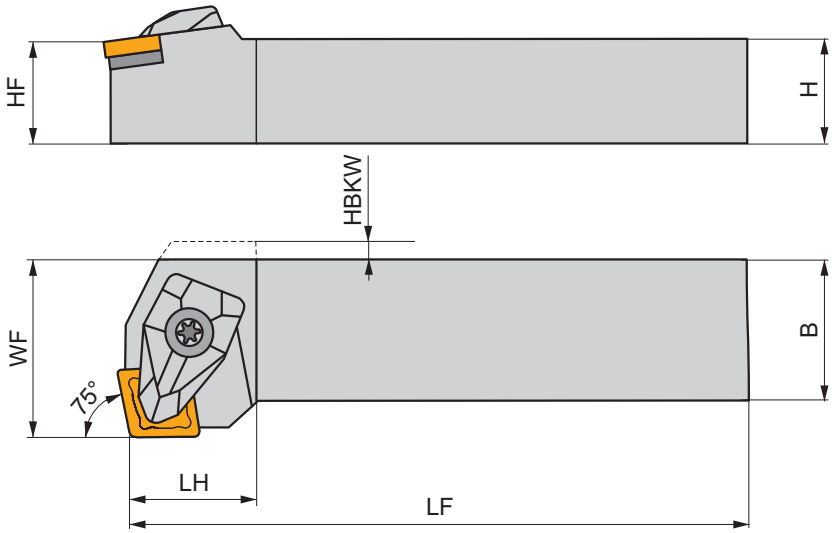


External Double Clamp Holder, 75° (Face) Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 75° tool holder. Suited for face turning and occasionally chamfering with negative CN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	**DCKNR 2020 K 12**	20	20	20	25	125	21.2	4.5	-6	-6	0.46	GI043	DC12	AT001
	DCKNR 2525 M 12	25	25	25	32	150	21.1	–	-6	-6	0.80	GI043	DC12	AT001
	DCKNR 3225 P 12	32	25	32	32	170	21.1	–	-6	-6	1.14	GI043	DC12	AT001
	DCKNR 3232 P 16	32	32	32	40	170	26.0	–	-6	-6	1.46	GI050	DC16	AT005
L	**DCKNL 2525 M 12**	25	25	25	32	150	21.1	–	-6	-6	0.80	GI043	DC12	AT001
	DCKNL 3225 P 12	32	25	32	32	170	21.1	–	-6	-6	1.13	GI043	DC12	AT001
	DCKNL 3232 P 16	32	32	32	40	170	26.0	–	-6	-6	1.45	GI050	DC16	AT005

GI043	CN.. 1204..
GI050	CN.. 1606..

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–

AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

DCLN(RL) EXT

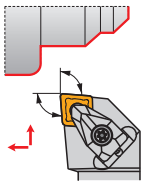
P M K N S H

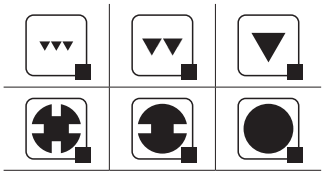
PRAMET

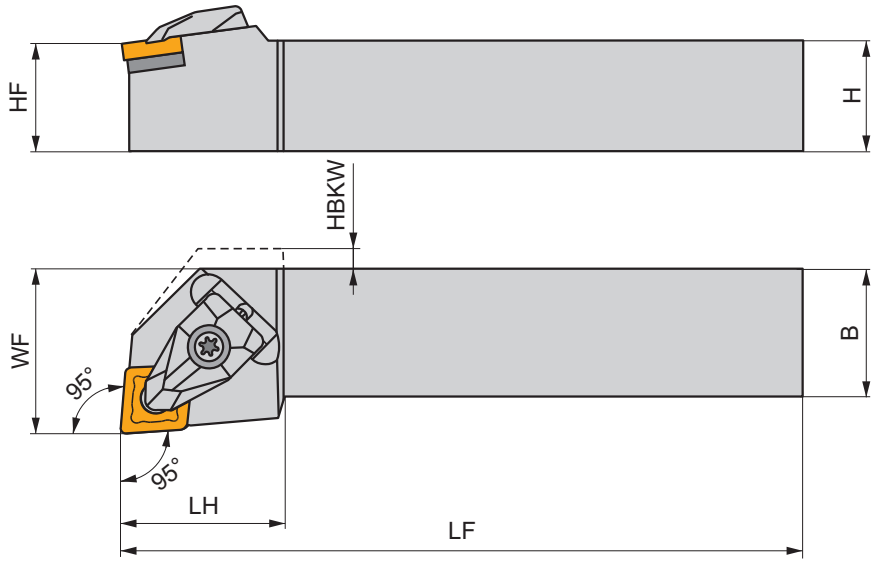
D

External Double Clamp Turning Holder with 95° Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 95° tool holder. Suited for longitudinal turning, chamfering and facing with shoulder, using negative CN.. inserts and. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DCLNR 1616 H 09	16	16	16	20	100	25.0	–	-6	-6	0.24	GI133	DC09	–
	DCLNR 2020 K 09	20	20	20	25	125	25.0	–	-6	-6	0.44	GI133	DC09	–
	DCLNR 2525 M 09	25	25	25	32	150	25.0	–	-6	-6	0.77	GI133	DC09	–
	DCLNR 1616 H 12	16	16	16	20	100	32.3	4.5	-6	-6	0.26	GI043	DCI12	AT001
	DCLNR 2020 K 12	20	20	20	25	125	30.0	–	-6	-6	0.44	GI043	DC12	AT001
	DCLNR 2525 M 12	25	25	25	32	150	30.0	–	-6	-6	0.78	GI043	DC12	AT001
	DCLNR 3225 P 12	32	25	32	32	170	30.0	–	-6	-6	1.07	GI043	DC12	AT001
	DCLNR 2525 M 16	25	25	25	32	150	39.0	–	-6	-6	0.81	GI050	DC16	AT005
	DCLNR 3225 P 16	32	25	32	32	170	35.0	–	-6	-6	1.13	GI050	DC16	AT005
	DCLNR 3232 P 19	32	32	32	40	170	40.0	–	-6	-6	1.40	GI042	DC19	–
	DCLNR 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	3.20	GI042	DC19	–
L	DCLNL 1616 H 09	16	16	16	20	100	24.8	–	-6	-6	0.22	GI133	DC09	–
	DCLNL 2020 K 09	20	20	20	25	125	24.8	–	-6	-6	0.42	GI133	DC09	–
	DCLNL 2525 M 09	25	25	25	32	150	24.8	–	-6	-6	0.76	GI133	DC09	–
	DCLNL 1616 H 12	16	16	16	20	100	32.2	4.5	-6	-6	0.26	GI043	DCI12	AT001
	DCLNL 2020 K 12	20	20	20	25	125	32.0	–	-6	-6	0.44	GI043	DC12	AT001
	DCLNL 2525 M 12	25	25	25	32	150	32.0	–	-6	-6	0.78	GI043	DC12	AT001
	DCLNL 3225 P 12	32	25	32	32	170	32.0	–	-6	-6	1.10	GI043	DC12	AT001
	DCLNL 2525 M 16	25	25	25	32	150	39.0	–	-6	-6	0.81	GI050	DC16	AT005
	DCLNL 3225 P 16	32	25	32	32	170	39.0	–	-6	-6	1.10	GI050	DC16	AT005
	DCLNL 3232 P 19	32	32	32	40	170	43.2	–	-6	-6	1.41	GI042	DC19	–
	DCLNL 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	3.26	GI042	DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..

GI050	CN.. 1606..
GI133	CN.. 0903..

		Nm				
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

PCBN(RL) EXT

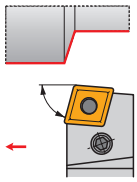
P M K N S H

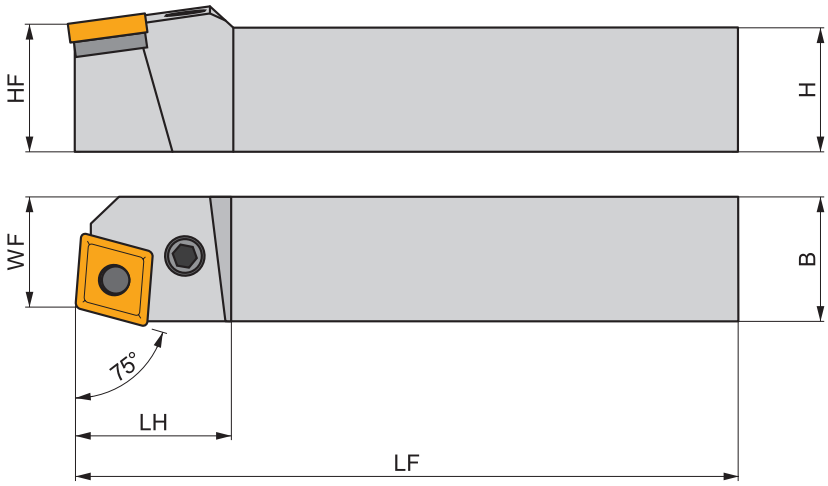
PRAMET

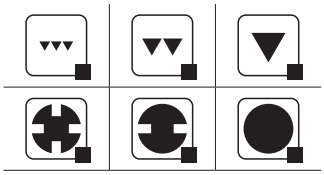
P

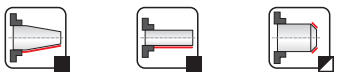
External Lever Lock Turning Holder with 75° Cutting Angle for CN.. Inserts

External Right/Left hand lever lock 75° tool holder. Suited for external chamfering, taper and longitudinal turning without shoulder, using negative CN.. inserts. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PCBNR 2020 K 12	20	20	20	17	125	28.0	-5	-6	0.40	GI043	PC01
	PCBNR 2525 M 12	25	25	25	22	150	36.0	-6	-6	0.74	GI043	PC01
	PCBNR 3232 P 16	32	32	32	27	170	34.0	-5	-6	1.34	GI050	PC02
	PCBNR 3232 P 19	32	32	32	27	170	42.0	-5	-6	1.10	GI042	PC03
	PCBNR 4040 S 19	40	40	40	35	250	45.0	-6	-6	3.05	GI042	PC03
	PCBNR 4040 S 25	40	40	40	41	250	48.0	-5	-6	3.09	GI062	PC04
	PCBNR 5050 T 25	50	50	50	51	300	50.0	-5	-6	5.80	GI062	PC04
L	PCBNL 2020 K 12	20	20	20	17	125	28.0	-5	-6	0.38	GI043	PC01
	PCBNL 2525 M 12	25	25	25	22	150	28.0	-5	-6	0.73	GI043	PC01
	PCBNL 3232 P 16	32	32	32	27	170	34.0	-5	-6	1.25	GI050	PC02
	PCBNL 3232 P 19	32	32	32	27	170	42.0	-5	-6	1.10	GI042	PC03
	PCBNL 4040 S 19	40	40	40	35	250	48.0	-5	-6	3.10	GI042	PC03
	PCBNL 4040 S 25	40	40	40	41	250	48.0	-5	-6	3.12	GI062	PC04
	PCBNL 5050 T 25	50	50	50	51	300	50.0	-5	-6	5.80	GI062	PC04

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI062	CN.. 2509..

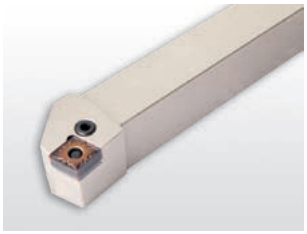
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PC04	PCS 625	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

PCKN(RL) EXT

P M K N S H

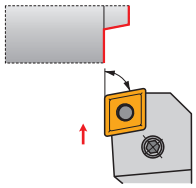
PRAMET

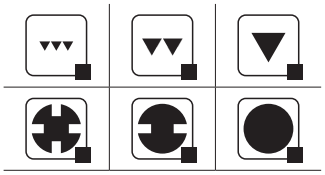
P

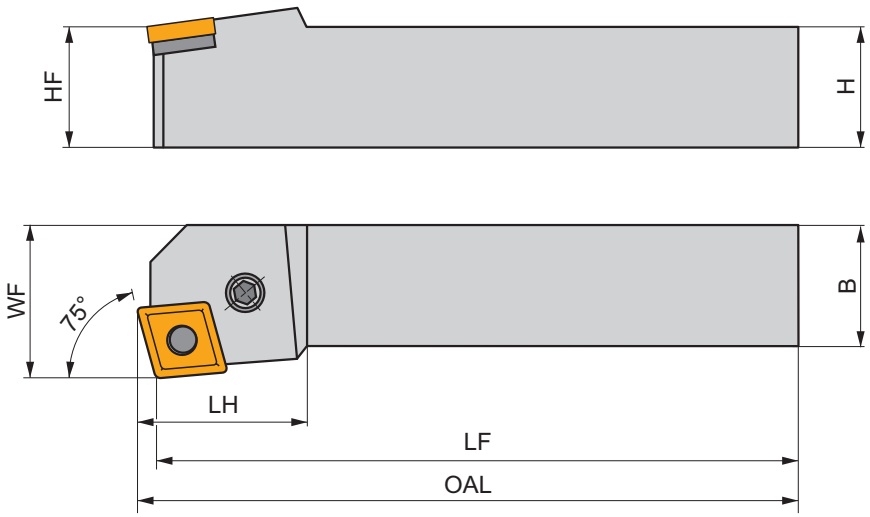


External Lever Lock Holder, 75° (Face Turning) Cutting Angle for CN.. Inserts

External Right/Left hand lever lock 75° tool holder. Suited for external chamfering and face turning with shoulder using negative CN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	**PCKNR 2020 K 12**	20	20	20	25	125	28.0	-6	-5	0.42	GI043	PC01
	PCKNR 2525 M 12	25	25	25	32	150	28.0	-6	-5	0.76	GI043	PC01
	PCKNR 3232 P 16	32	32	32	40	170	34.0	-6	-5	1.42	GI050	PC02
	PCKNR 3232 P 19	32	32	32	40	170	34.0	-6	-5	1.40	GI042	PC03
	PCKNR 4040 S 19	40	40	40	50	250	45.0	-6	-5	3.25	GI042	PC03
L	**PCKNL 2020 K 12**	20	20	20	25	125	28.0	-6	-5	0.42	GI043	PC01
	PCKNL 2525 M 12	25	25	25	32	150	28.0	-6	-5	0.77	GI043	PC01
	PCKNL 3232 P 16	32	32	32	40	170	34.0	-6	-5	1.40	GI050	PC02
	PCKNL 3232 P 19	32	32	32	40	170	45.0	-6	-6	1.40	GI042	PC03
	PCKNL 4040 S 19	40	40	40	50	250	45.0	-6	-5	3.27	GI042	PC03

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4

PCLN(RL) EXT

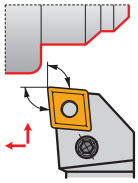
P M K N S H

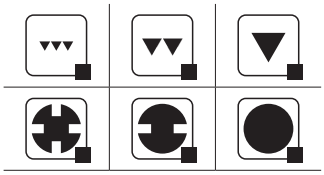
PRAMET

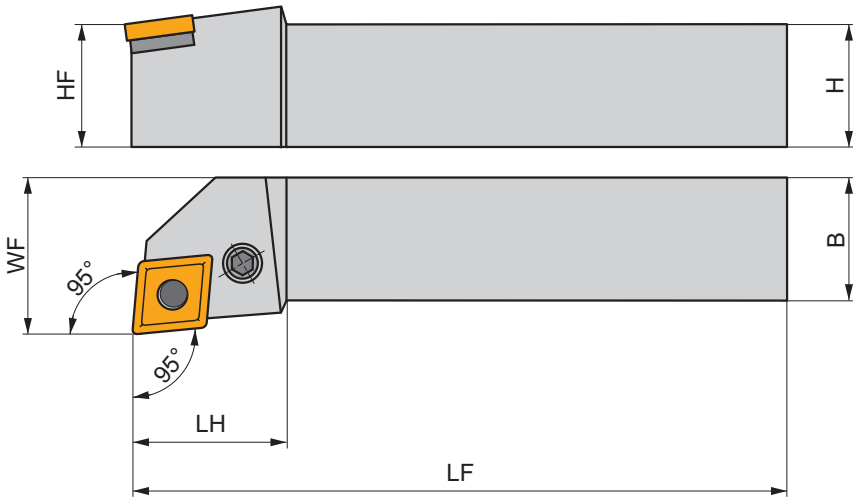
P

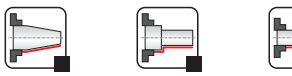
External Lever Lock Turning Holder with 95° Cutting Angle for CN.. Inserts

External Right/Left hand lever lock 95° tool holder. Suited for external taper, face, longitudinal with shoulder turning and chamfering with negative CN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PCLNR 2020 K 12	20	20	20	25	125	28.0	-6	-6	0.42	GI043	PC01
	PCLNR 2525 M 12	25	25	25	32	150	28.0	-6	-6	0.68	GI043	PC01
	PCLNR 3225 P 12	32	25	32	32	170	28.0	-6	-6	0.98	GI043	PC01
	PCLNR 3225 P 16	32	25	32	32	170	34.0	-6	-6	1.09	GI050	PC02
	PCLNR 3232 P 19	32	32	32	40	170	45.0	-6	-6	1.38	GI042	PC03
	PCLNR 4040 S 19	40	40	40	50	250	45.0	-6	-6	3.10	GI042	PC03
	PCLNR 4040 S 25	40	40	40	50	250	45.0	-6	-6	3.15	GI062	PC04
	PCLNR 5050 T 25	50	50	50	60	300	50.0	-6	-6	5.90	GI062	PC04
L	PCLNL 2020 K 12	20	20	20	25	125	28.0	-6	-6	0.42	GI043	PC01
	PCLNL 2525 M 12	25	25	25	32	150	28.0	-6	-6	0.75	GI043	PC01
	PCLNL 3225 P 12	32	25	32	32	170	28.0	-6	-6	1.06	GI043	PC01
	PCLNL 3225 P 16	32	25	32	32	170	34.0	-6	-6	1.08	GI050	PC02
	PCLNL 3232 P 19	32	32	32	40	170	42.0	-6	-6	1.38	GI042	PC03
	PCLNL 4040 S 19	40	40	40	50	250	45.0	-6	-6	3.16	GI042	PC03
	PCLNL 4040 S 25	40	40	40	50	250	45.0	-6	-6	3.17	GI062	PC04
	PCLNL 5050 T 25	50	50	50	60	300	50.0	-6	-6	5.90	GI062	PC04

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI062	CN.. 2509..

				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PC04	PCS 625	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5

C.-DCLN(RL) EXT

P M K N S H

PRAMET

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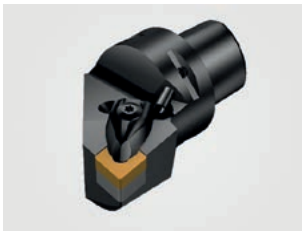
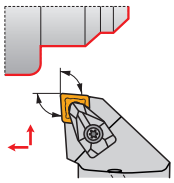
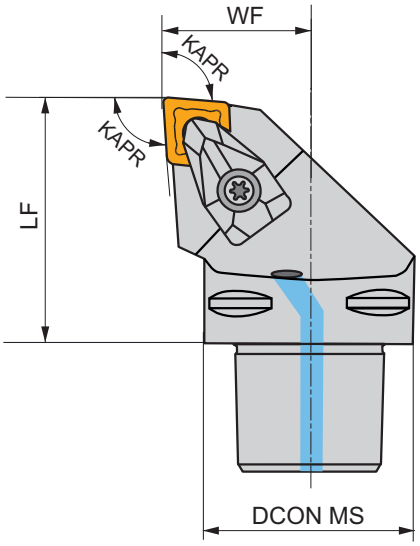
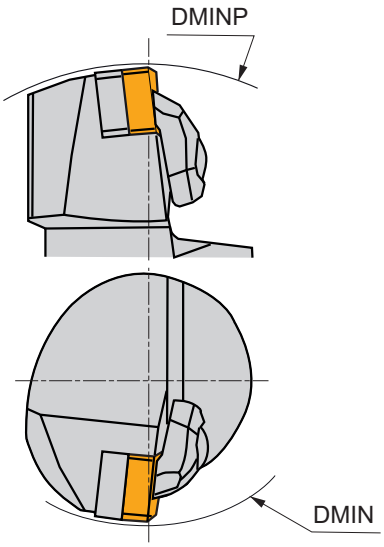


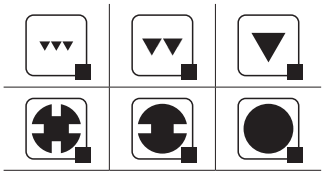
Ext. PSC Quick Change Tool, Double Clamp, 95° Cutting Angle for CN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 95° cutting angle for longitudinal turning, chamfering and face turning with shoulder, using negative CN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C3-DCLNR-22045-12	32	60	121	22	45	95	-6	-6	✓	0.25	GI043	C-DC12	AT001
	C4-DCLNR-27050-12	40	110	140	27	50	95	-6	-6	✓	0.44	GI043	C-DC12	AT001
	C4-DCLNR-27055-16	40	125	145	27	55	95	-6	-6	✓	0.47	GI050	C-DC16	AT005
	C5-DCLNR-35060-12	50	110	165	35	60	95	-6	-6	✓	0.79	GI043	C-DC12	AT001
	C5-DCLNR-35060-16	50	125	165	35	60	95	-6	-6	✓	0.80	GI050	C-DC16	AT005
	C6-DCLNR-45065-12	63	110	190	45	65	95	-6	-6	✓	1.32	GI043	C-DC12	AT001
	C6-DCLNR-45065-16	63	125	190	45	65	95	-6	-6	✓	1.34	GI050	C-DC16	AT005
	C6-DCLNR-45065-19	63	81	190	45	65	95	-6	-6	✓	1.34	GI042	C-DC19	–
	C8-DCLNR-55080-19	80	100	250	55	80	95	-6	-6	✓	2.58	GI042	C-DC19	–
L	C4-DCLNL-27050-12	40	110	140	27	50	95	-6	-6	✓	0.44	GI043	C-DC12	AT001
	C4-DCLNL-27055-16	40	125	145	27	55	95	-6	-6	✓	0.47	GI050	C-DC16	AT005
	C5-DCLNL-35060-12	50	110	165	35	60	95	-6	-6	✓	0.79	GI043	C-DC12	AT001
	C5-DCLNL-35060-16	50	125	165	35	60	95	-6	-6	✓	0.80	GI050	C-DC16	AT005
	C6-DCLNL-45065-12	63	110	190	45	65	95	-6	-6	✓	1.32	GI043	C-DC12	AT001
	C6-DCLNL-45065-16	63	125	190	45	65	95	-6	-6	✓	1.34	GI050	C-DC16	AT005
	C6-DCLNL-45065-19	63	81	190	45	65	95	-6	-6	✓	1.34	GI042	C-DC19	–
	C8-DCLNL-55080-16	80	125	250	55	80	95	-6	-6	✓	2.58	GI050	C-DC16	AT005
	C8-DCLNL-55080-19	80	100	250	55	80	95	-6	-6	✓	2.58	GI042	C-DC19	–

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..

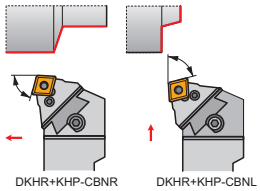
C-DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–	CN 045-01
C-DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P	CN 045-01
C-DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P	CN 045-01

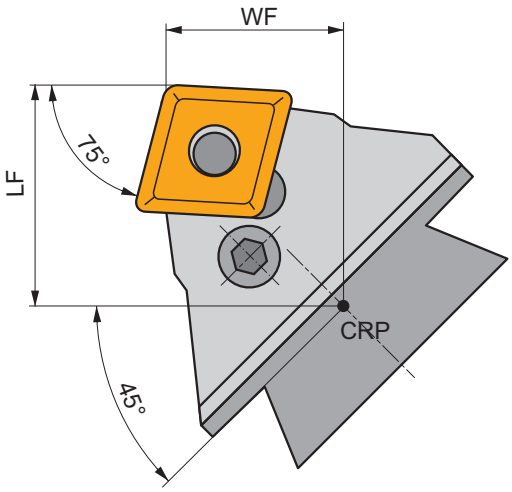
AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

KHP-CBN(RL)

Modular KHP Lever Lock Turning Cartridge, 75° Cutting Angle for CN.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 75° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, taper and chamfer turning with negative CN.. inserts. Tool holder treated for longer tool life.



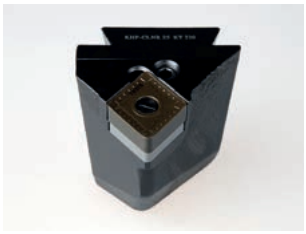


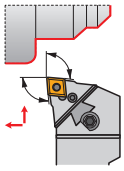
	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	KHP-CBNR 25	32	47	-6	-6	1.54	GI062	PC60
L	KHP-CBNL 25	32	47	-6	-6	1.56	GI062	PC60

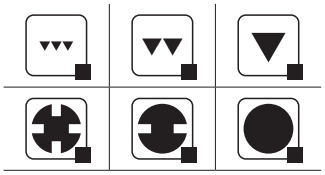
GI062	CN.. 2509..

PC60	CNU 250620	PU 06	US 39	8.0 Nm	M 10x1	33	NT 08	MT 08	HXK 5

KHP-CLN(RL)

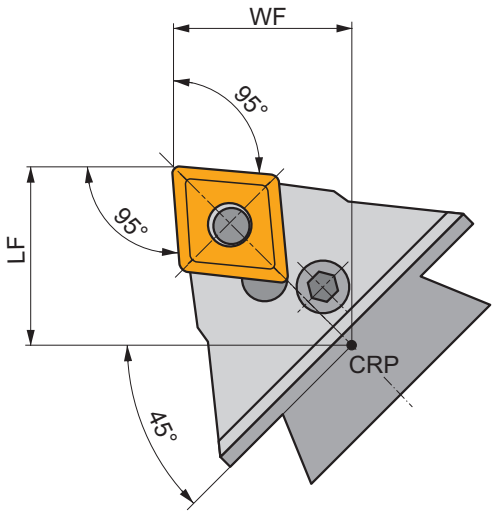


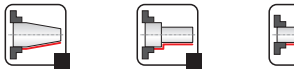




Modular KHP Lever Lock Turning Cartridge, 95° Cutting Angle for CN.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 95° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning with shoulder, face turning with shoulder, taper and chamfer turning with negative CN.. insert. Tool holder treated for longer tool life.





	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	**KHP-CLNR 19**	35	45	-6	-6	1.69	GI042	PC50
	KHP-CLNR 25	35	45	-6	-6	1.25	GI062	PC60
L	**KHP-CLNL 19**	35	45	-6	-6	1.30	GI042	PC50
	KHP-CLNL 25	35	45	-6	-6	1.25	GI062	PC60

GI042	CN.. 1906..
GI062	CN.. 2509..

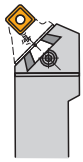
				Nm					
PC50	CNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PC60	CNU 250620	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXK 5

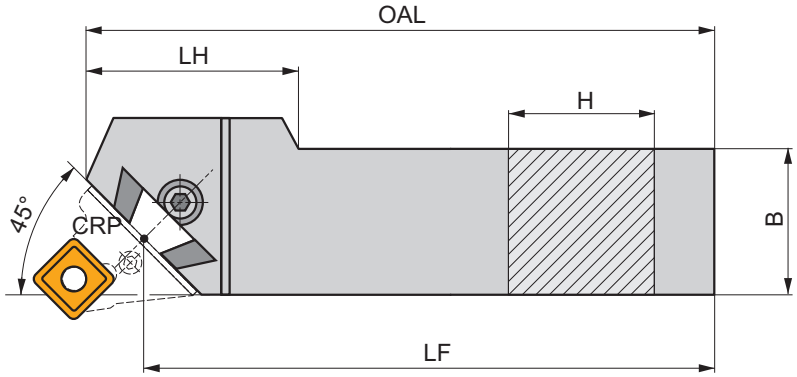
DKH(RL)

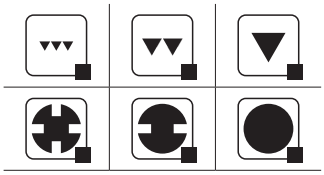
PRAMET

External Tool Holder Shank for KHP/KHS Heavy Turning Cartridges

Dovetailed Right/Left hand modular tool shank for KHP/KHS cartridges. Suited for heavy turning applications. Body treated for longer tool life.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

DCLN(RL) INT

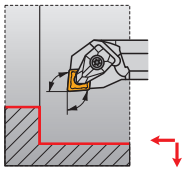
P M K N S H

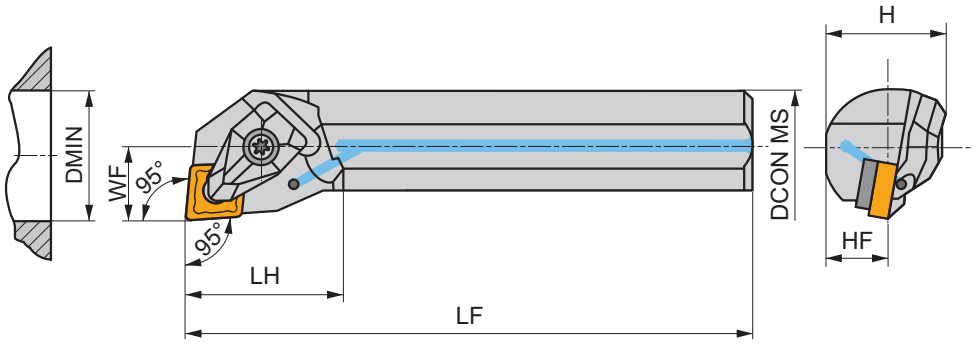
PRAMET

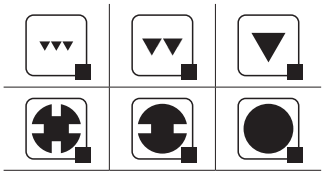
D

Internal Double Clamp Boring Bar with 95° Cutting Angle for CN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 95° cutting angle for CN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A25T-DCLNR 09	25	32	17	23	11.5	300	31.0	-11	-6	✓	0.98	GI133	DC09
	A25T-DCLNR 12	25	32	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI043	DCI12
	A32T-DCLNR 12	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI043	DCI12
	A40T-DCLNR 12	40	50	27	37	18.5	300	32.0	-15	-6	✓	2.56	GI043	DC12
L	A25T-DCLNL 09	25	32	17	23	11.5	300	31.0	-11	-6	✓	0.99	GI133	DC09
	A25T-DCLNL 12	25	32	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI043	DCI12
	A32T-DCLNL 12	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI043	DCI12
	A40T-DCLNL 12	40	50	27	37	18.5	300	32.0	-15	-6	✓	2.55	GI043	DC12

GI043	CN.. 1204..
GI133	CN.. 0903..

		Nm			
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5

PCLN(RL) INT

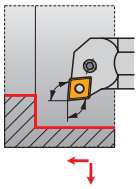
P M K N S H

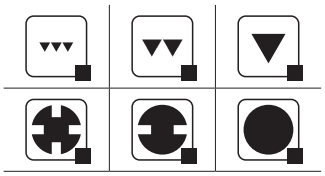
PRAMET

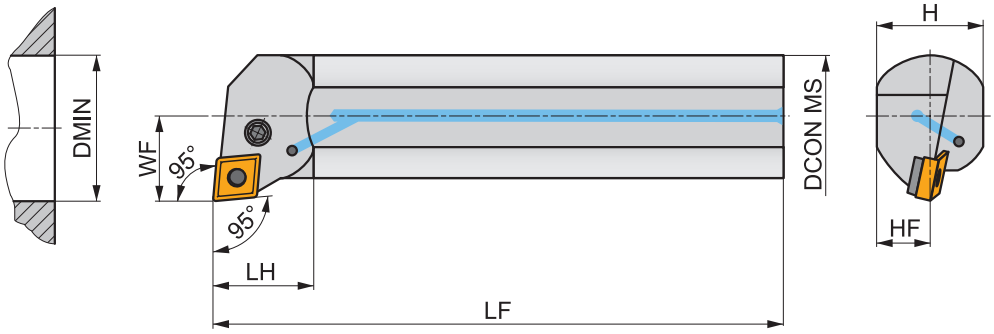
P

Internal Lever Lock Boring Bar with 95° Cutting Angle for CN.. Inserts

Internal Right/Left hand lever lock boring bar, through coolant available, 95° cutting angle for CN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16M-PCLNR 09	16	20	11	15	–	150	-14	-4	✓	0.22	GI133	PC05
	A20Q-PCLNR 09	20	25	13	18	18	180	-13.5	-5	✓	0.33	GI133	PC05
	A25R-PCLNR 12	25	31	17	23	–	200	-14	-4	–	0.70	GI043	PC06
	A32S-PCLNR 12	32	39	22	30	–	250	-12	-4	✓	1.40	GI043	PC07
	A40T-PCLNR 12	40	48	27	37	–	300	-12	-4	✓	2.40	GI043	PC01
	A40T-PCLNR 16	40	48	27	37	–	300	-12	-4	✓	2.65	GI050	PC02
	A50U-PCLNR 16	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI050	PC02
	A60V-PCLNR 16	60	80	43	57	–	400	-12	-4	✓	8.70	GI050	PC02
	A50U-PCLNR 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI042	PC08
	A60V-PCLNR 19	60	80	43	57	–	400	-11	-6	✓	8.22	GI042	PC08
L	A16M-PCLNL 09	16	20	11	15	–	150	-14	-4	✓	0.20	GI133	PC05
	A20Q-PCLNL 09	20	25	13	18	–	180	-13	-4	–	0.34	GI133	PC05
	A25R-PCLNL 12	25	31	17	23	–	200	-14	-4	✓	0.65	GI043	PC06
	A32S-PCLNL 12	32	39	22	30	–	250	-12	-4	✓	1.40	GI043	PC07
	A40T-PCLNL 12	40	50	27	38	38	300	-12	-6	✓	2.58	GI043	PC01
	A40T-PCLNL 16	40	48	27	37	–	300	-12	-4	✓	2.58	GI050	PC02
	A50U-PCLNL 16	50	61	35	47	–	350	-12	-4	✓	4.95	GI050	PC02
	A60V-PCLNL 16	60	80	43	57	–	400	-12	-4	✓	8.70	GI050	PC02

GI042	CN.. 1906..
GI043	CN.. 1204..
GI050	CN.. 1606..
GI133	CN.. 0903..

									
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PC05	–	CL 005	CS 605	1.4	M 5x1	12	–	–	HXK 2
PC07	PCS 612	CL 312	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3
PC06	–	CL 212	CS 626	2.0	M 6x1	13.4	–	–	HXK 2.5
PC08	PCS 619	CL 219	CS 610	3.5	M 10x1	27.2	TR 29	MT 06	HXK 4

C.-DCLN(RL) INT

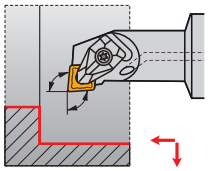
P M K N S H

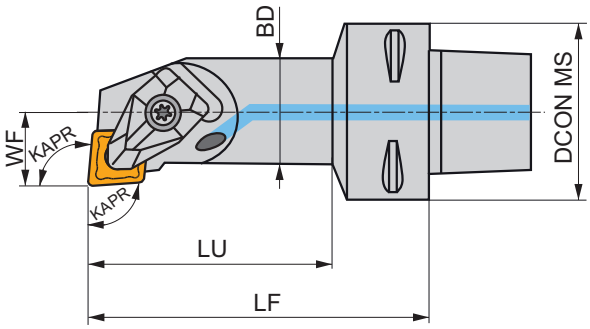
PRAMET

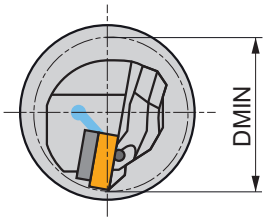
D

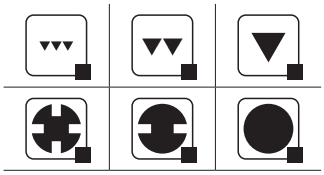
Int. PSC Quick Change Tool, Double Clamp, 95° Cutting Angle for CN.. Inserts

Internal Right/Left hand double clamp tool, through coolant, with 95° cutting angle for negative CN.. inserts. Suited for a wide range of internal turning applications. Polygon Shank Coupling with choice of lengths. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DCLNR-13080-09	40	25	13	80	57	20	95	-14	-6	✓	0.43	GI133	DC09
	C4-DCLNR-17090-12	40	32	17	90	68	25	95	-12	-6	✓	0.53	GI043	DCI12
	C5-DCLNR-17090-12	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DCI12
	C6-DCLNR-17100-12	63	32	17	100	72	25	95	-12	-6	✓	1.15	GI043	DCI12
	C6-DCLNR-27140-16	63	50	27	140	114	40	95	-16	-6	✓	1.81	GI050	DC16
L	C4-DCLNL-17090-12	40	32	17	90	68	25	95	-12	-6	✓	0.53	GI043	DCI12
	C5-DCLNL-17090-12	50	32	17	90	66	25	95	-12	-6	✓	0.72	GI043	DCI12

GI043	CN.. 1204..
GI050	CN.. 1606..
GI133	CN.. 0903..

		Nm				
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

DDJN(RL) EXT

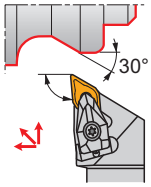
P M K N S H

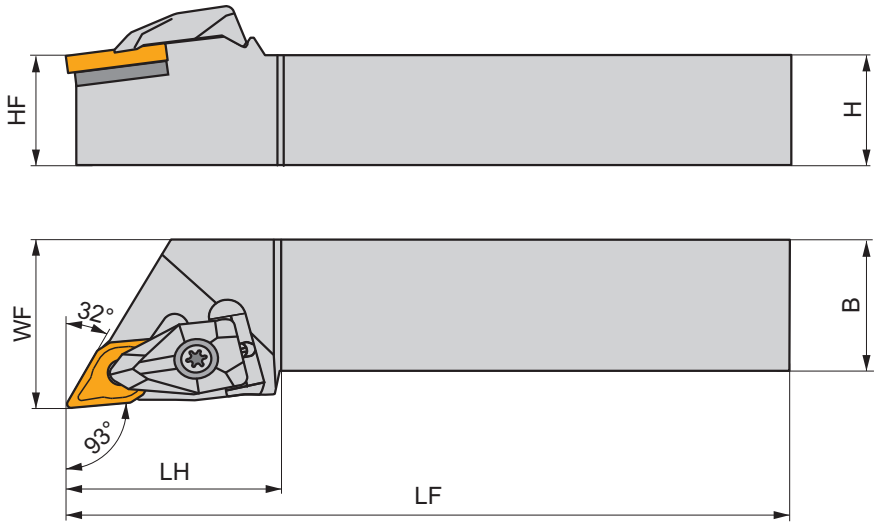
PRAMET

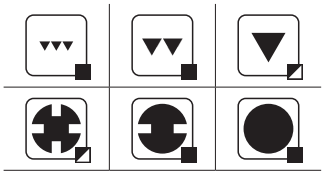
D

External Double Clamp Turning Holder with 93° Cutting Angle for DN.. Inserts

External Right/Left hand double clamp tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copying, chamfering and facing with negative DN.. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	DDJNR 2020 K 11	20	20	20	25	125	30.2	-7	-6	0.41	GI046	DD11	–
	DDJNR 2525 M 11	25	25	25	32	150	30.2	-7	-6	0.74	GI046	DD11	–
	DDJNR 2020 K 15	20	20	20	25	125	39.4	-7	-6	0.42	GI044	DD154	AT002
	DDJNR 2525 M 15	25	25	25	32	150	39.4	-7	-6	0.74	GI044	DD154	AT002
	DDJNR 3225 P 15	32	25	32	32	170	39.4	-7	-6	1.07	GI044	DD154	AT002
	DDJNR 3232 P 15	32	32	32	40	170	39.4	-7	-6	1.33	GI044	DD154	AT002
L	DDJNL 2020 K 11	20	20	20	25	125	30.2	-7	-6	0.42	GI046	DD11	–
	DDJNL 2525 M 11	25	25	25	32	150	30.2	-7	-6	0.74	GI046	DD11	–
	DDJNL 2020 K 15	20	20	20	25	125	39.4	-7	-6	0.42	GI044	DD154	AT002
	DDJNL 2525 M 15	25	25	25	32	150	39.4	-7	-6	0.74	GI044	DD154	AT002
	DDJNL 3225 P 15	32	25	32	32	170	39.4	-7	-6	1.01	GI044	DD154	AT002
	DDJNL 3232 P 15	32	32	32	40	170	39.4	-7	-6	1.34	GI044	DD154	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

PDJN(RL) EXT

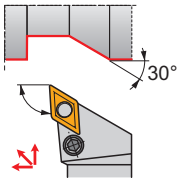
P M K N S H

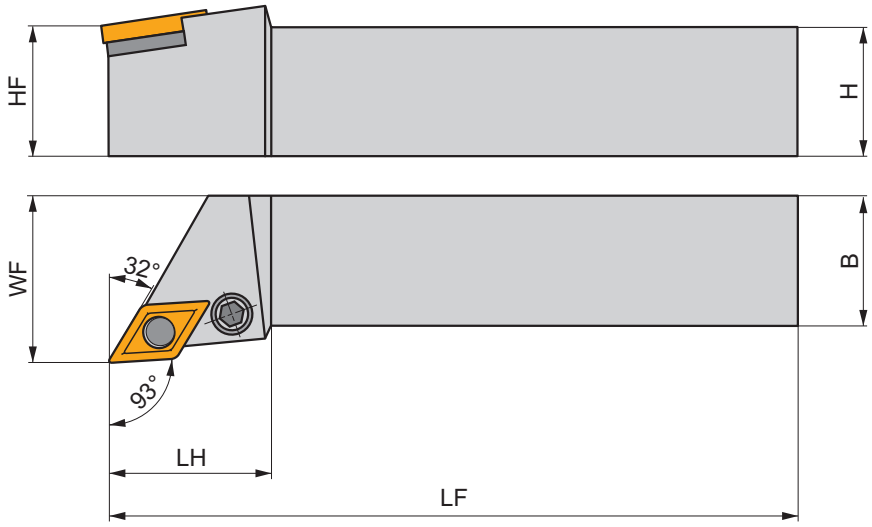
PRAMET

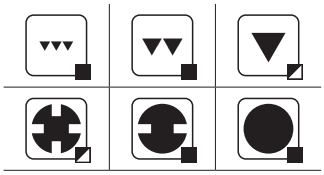
P

External Lever Lock Turning Holder with 93° Cutting Angle for DN.. Inserts

External Right/Left hand lever lock tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copy turning up to 30°, and chamfering with negative DN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PDJNR 2020 K 11	20	20	20	25	125	28.0	-7	-6	0.40	GI046	PD02
	PDJNR 2525 M 11	25	25	25	32	150	28.0	-7	-6	0.73	GI046	PD02
	PDJNR 2020 K 15	20	20	20	25	125	34.0	-7	-6	0.39	GI044	PD01
	PDJNR 2525 M 15	25	25	25	32	150	34.0	-7	-6	0.73	GI044	PD01
	PDJNR 3225 P 15	32	25	32	32	170	34.0	-7	-6	1.04	GI044	PD01
	PDJNR 3232 P 15	32	32	32	40	170	34.0	-7	-6	1.30	GI044	PD01
L	PDJNL 2020 K 11	20	20	20	25	125	28.0	-7	-6	0.40	GI046	PD02
	PDJNL 2525 M 11	25	25	25	32	150	28.0	-7	-6	0.73	GI046	PD02
	PDJNL 2020 K 15	20	20	20	25	125	40.0	-6	-6	0.42	GI044	PD01
	PDJNL 2525 M 15	25	25	25	32	150	34.0	-7	-6	0.73	GI044	PD01
	PDJNL 3225 P 15	32	25	32	32	170	34.0	-7	-6	0.98	GI044	PD01
	PDJNL 3232 P 15	32	32	32	40	170	34.0	-7	-6	1.30	GI044	PD01

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm					
PD01	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5

PDNN(RL) EXT

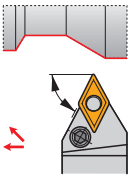
P M K N S H

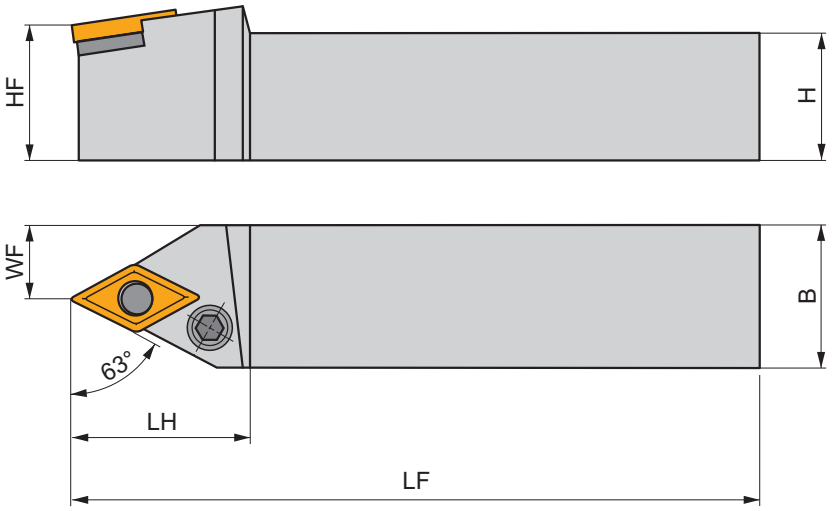
PRAMET

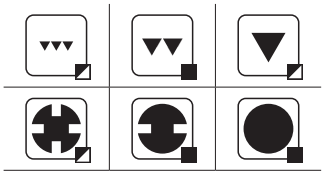
P

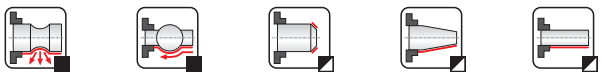
External Lever Lock Turning Holder with 63° Cutting Angle for DN.. Inserts

External Right/Left hand lever lock 63° (neutral) tool holder. Suited for longitudinal turning without shoulder, taper, copy, and chamfer turning with negative DN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PDNNR 2020 K 11**	20	20	20	10	125	28.0	-6	-6	0.37	GI046	PD02
	PDNNR 2525 M 11	25	25	25	12.5	150	25.0	-6	-6	0.60	GI046	PD02
	PDNNR 2525 M 15	25	25	25	12.5	150	34.0	-6	-6	0.69	GI044	PD01
	PDNNR 3225 P 15	32	25	32	12.5	170	34.0	-6	-6	1.00	GI044	PD01
L	**PDNNL 2020 K 11**	20	20	20	10	125	28.0	-6	-6	0.40	GI046	PD02
	PDNNL 2525 M 11	25	25	25	12.5	150	25.0	-6	-6	0.60	GI046	PD02
	PDNNL 2525 M 15	25	25	25	12.5	150	34.0	-6	-6	0.07	GI044	PD01
	PDNNL 3225 P 15	32	25	32	12.5	170	34.0	-6	-6	1.00	GI044	PD01

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm					
PD01	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5

PDXN(RL) EXT

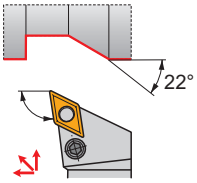
P M K N S H

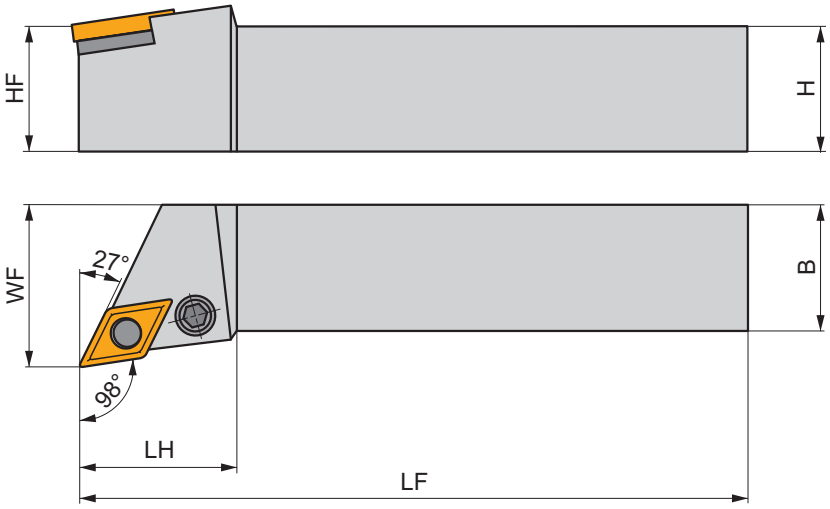
PRAMET

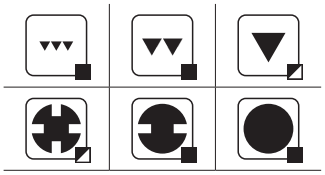
P

External Lever Lock Turning Holder with 98° Cutting Angle for DN.. Inserts

External Right/Left hand lever lock tool holder with 98° cutting angle. Suited for taper, longitudinal turning with shoulder, copy turning up to 22° and chamfering with negative DN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PDXNR 2020 K 15	20	20	20	25	125	40.0	-6	-6	0.38	GI044	PD01
	PDXNR 2525 M 15	25	25	25	32	150	40.0	-6	-6	0.73	GI044	PD01
	PDXNR 3225 P 15	32	25	32	32	170	34.0	-8	-3	0.80	GI044	PD01
L	PDXNL 2020 K 15	20	20	20	25	125	34.0	-8	-3	0.40	GI044	PD01
	PDXNL 2525 M 15	25	25	25	32	150	34.0	-8	-3	0.71	GI044	PD01
	PDXNL 3225 P 15	32	25	32	32	170	34.0	-8	-3	0.95	GI044	PD01

GI044	DN.. 1506..

PD01	PDS 715	CL 415	CS 638	3.0 Nm	M 8x1	21.1	TR 12	MT 05	HXK 3

C.-DDJN(RL) EXT

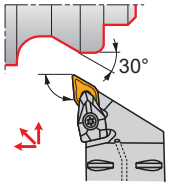
P M K N S H

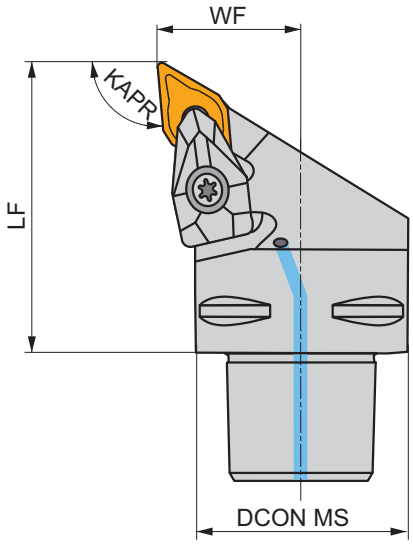
PRAMET

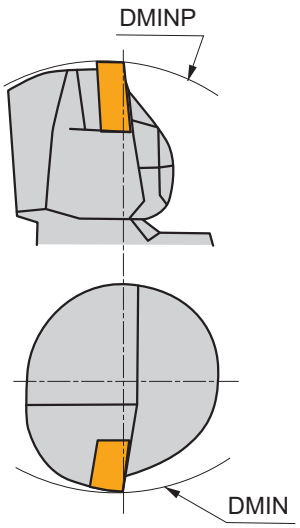
D

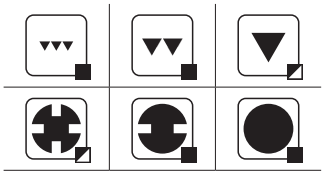
Ext. PSC Quick Change Tool, Double Clamp, 93° Cutting Angle for DN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 93° cutting angle for taper and longitudinal turning with shoulder, copying and chamfering with negative DN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C4-DDJNR-27050-11**	40	60	140	27	50	93	-7	-6	✓	0.38	GI046	C-DD11	–
	C4-DDJNR-27055-15	40	110	145	27	55	93	-7	-6	✓	0.43	GI044	C-DD154-1	AT002
	C5-DDJNR-35060-15	50	110	165	35	60	93	-7	-6	✓	0.72	GI044	C-DD154-2	AT002
	C6-DDJNR-45065-15	63	110	190	45	65	93	-7	-6	✓	1.18	GI044	C-DD154-3	AT002
L	**C4-DDJNL-27050-11**	40	60	140	27	50	93	-7	-6	✓	0.39	GI046	C-DD11	–
	C4-DDJNL-27055-15	40	110	145	27	55	93	-7	-6	✓	0.43	GI044	C-DD154-1	AT002
	C5-DDJNL-35060-15	50	110	165	35	60	93	-7	-6	✓	0.72	GI044	C-DD154-2	AT002
	C6-DDJNL-45065-15	63	110	190	45	65	93	-7	-6	✓	1.18	GI044	C-DD154-3	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm				
C-DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P	CN 034-01
C-DD154-1	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DD154-2	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01
C-DD154-3	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

C.-DDNNN EXT

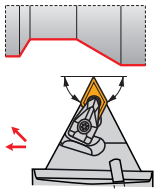
P M K N S H

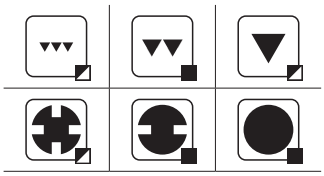
PRAMET

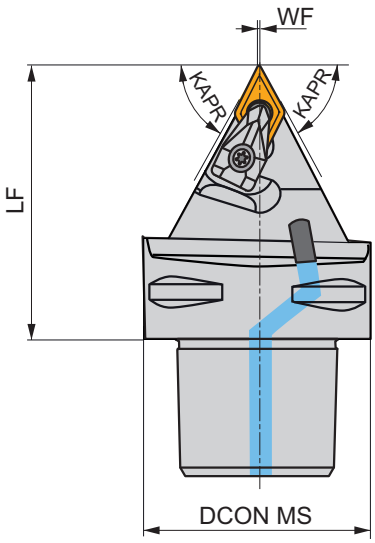
D

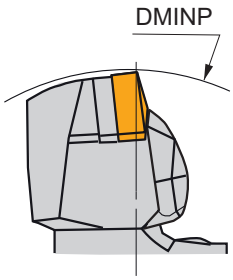
Ext. PSC Quick Change Tool, Double Clamp, 62.5° Cutting Angle for DN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 62.5° cutting angle for taper and longitudinal turning without shoulder, copying and chamfering with negative DN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.













	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
N	**C5-DDNNN-00060-15**	50	165	0.5	60	62.5	-9	-5	✓	0.62	GI044	C-DD154-2	AT002
	C6-DDNNN-00065-15	63	190	0.5	65	62.5	-9	-5	✓	1.06	GI044	C-DD154-2	AT002

GI044	DN.. 1506..

C-DD154-2	DCS 12	3.9 Nm	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

C.-DDUN(RL) EXT

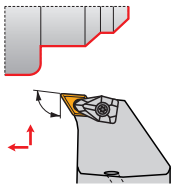
P M K N S H

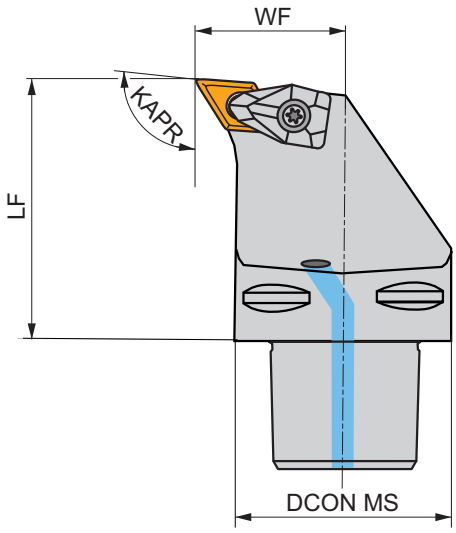
PRAMET

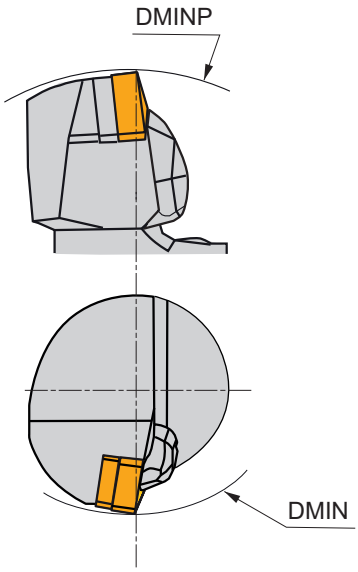
D

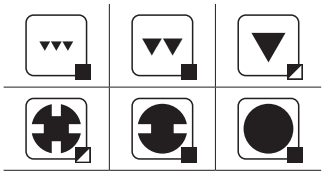
Ext. PSC Quick Change Tool, Double Clamp, 93° (Face) Cutting Angle, DN.. Inserts

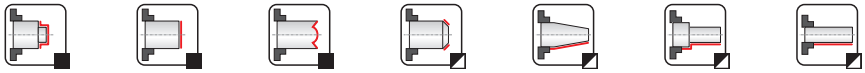
External Right/Left hand double clamp tool, through coolant, with 93° cutting angle for face turning with shoulder, face copy turning, taper turning, longitudinal turning and chamfering with negative DN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C5-DDUNR-35060-15**	50	110	165	35	60	93	-7	-6	✓	0.82	GI044	C-DD154-3	AT002
	C6-DDUNR-45065-15	63	110	190	45	65	93	-7	-6	✓	1.39	GI044	C-DD154-3	AT002
L	**C5-DDUNL-35060-15**	50	110	165	35	60	93	-7	-6	✓	0.82	GI044	C-DD154-3	AT002

GI044	DN.. 1506..

C-DD154-3	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

DDUN(RL) INT

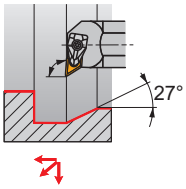
P M K N S H

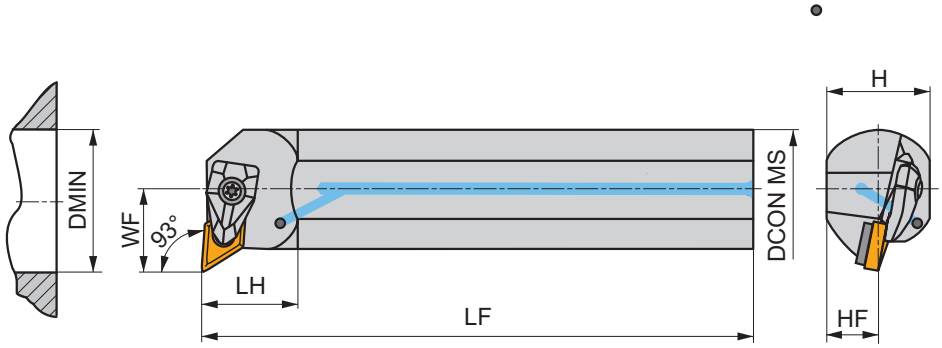
PRAMET

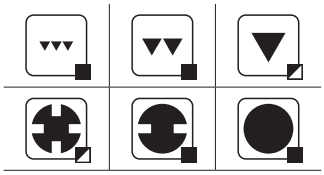
D

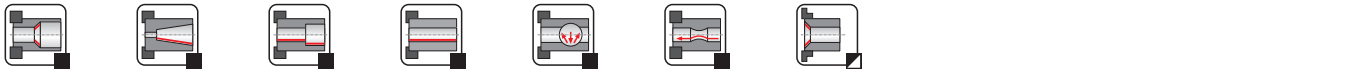
Internal Double Clamp Boring Bar with 93° Cutting Angle for DN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 93° cutting angle for DN.. inserts. Suited for wide range of internal turning applications, copy turning up to 27°.Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg			
R	**A25T-DDUNR 11**	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNR 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI046	DD11	–
	A40T-DDUNR 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.58	GI044	DD154	AT002
	A50U-DDUNR 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.23	GI044	DD154	AT002
L	**A25T-DDUNL 11**	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNL 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.69	GI046	DD11	–
	A40T-DDUNL 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.59	GI044	DD154	AT002
	A50U-DDUNL 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.25	GI044	DD154	AT002

GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

PDUN(RL) INT

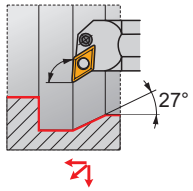
P M K N S H

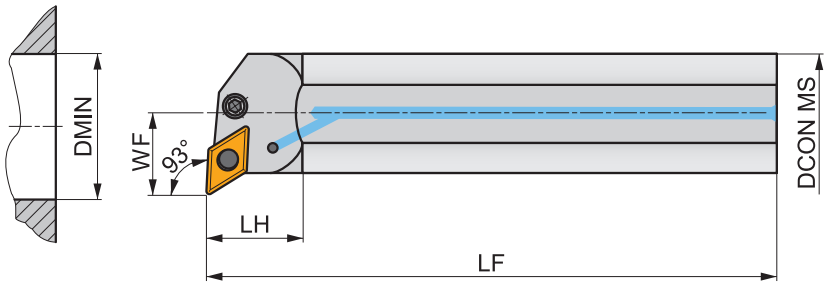
PRAMET

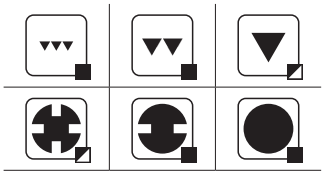
P

Internal Lever Lock Boring Bar with 93° Cutting Angle for DN.. Insert

Internal Right/Left hand lever lock boring bar, through coolant available, 93° cutting angle for DN.. inserts. For a wide range of internal turning applications, copy turning up to 27°. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A25R-PDUNR 11	25	31	17	23	–	200	-14	-5	✓	0.70	GI046	PD02
	A32S-PDUNR 11	32	39	22	30	–	250	-14	-5	✓	1.42	GI046	PD02
	A32S-PDUNR 15	32	39	22	30	–	250	-14	-4	✓	1.44	GI097	PD04
	A40T-PDUNR 15	40	48	27	37	–	300	-11	-6	✓	2.40	GI097	PD03
	A50U-PDUNR 15	50	61	35	47	–	350	-14	-4	✓	4.95	GI097	PD03
	A60V-PDUNR 15	60	80	43	57	–	400	-14	-4	✓	8.22	GI097	PD03
L	A25R-PDUNL 11	25	31	17	23	–	200	-14	-5	✓	0.70	GI046	PD02
	A32S-PDUNL 11	32	39	22	30	–	250	-14	-5	✓	1.42	GI046	PD02
	A32S-PDUNL 15	32	39	22	30	–	250	-14	-4	✓	1.44	GI097	PD04
	A40T-PDUNL 15	40	48	27	37	–	300	-11	-6	✓	2.56	GI097	PD03
	A60V-PDUNL 15	60	80	43	57	–	400	-14	-4	✓	8.16	GI097	PD03

GI044	DN.. 1506..
GI046	DN.. 1104..

				Nm							
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5	–	–
PD03	PDS 715	CL 415	CS 638	3.0	M 8x1	21.1	TR 12	MT 05	HXK 3	PDS 725	TR 35
PD04	PDS 715	CL 415	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3	PDS 725	TR 35

C.-DDUN(RL) INT

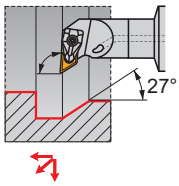
P M K N S H

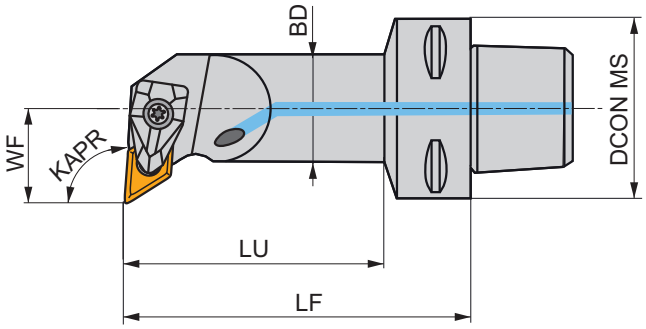
PRAMET

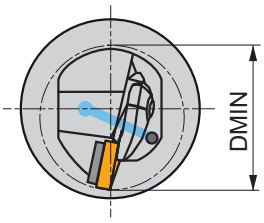
D

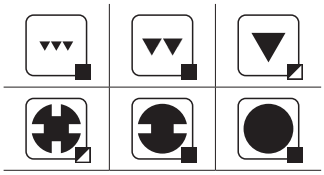
Int. PSC Quick Change Tool, Double Clamp, 93° Cutting Angle for DN.. Insert

Internal Right/Left hand double clamp tool, through coolant, with 93° cutting angle for internal turning applications including copy turning up to 27° with DN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DDUNR-17090-11	40	32	17	90	68	25	93	-12	-6	✓	0.51	GI046	DD11
L	C4-DDUNL-17090-11	40	32	17	90	68	25	93	-12	-6	✓	0.51	GI046	DD11

GI046	DN.. 1104..

DD11	DCS 09	1.7 Nm	DDS 267-01	US 2004-T09P	FLAG T09P

CKJN(RL) EXT

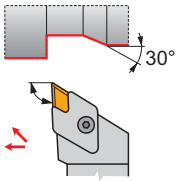
P M K N S H

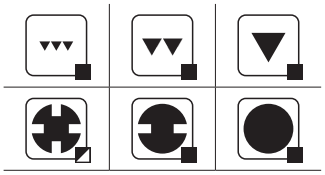
PRAMET

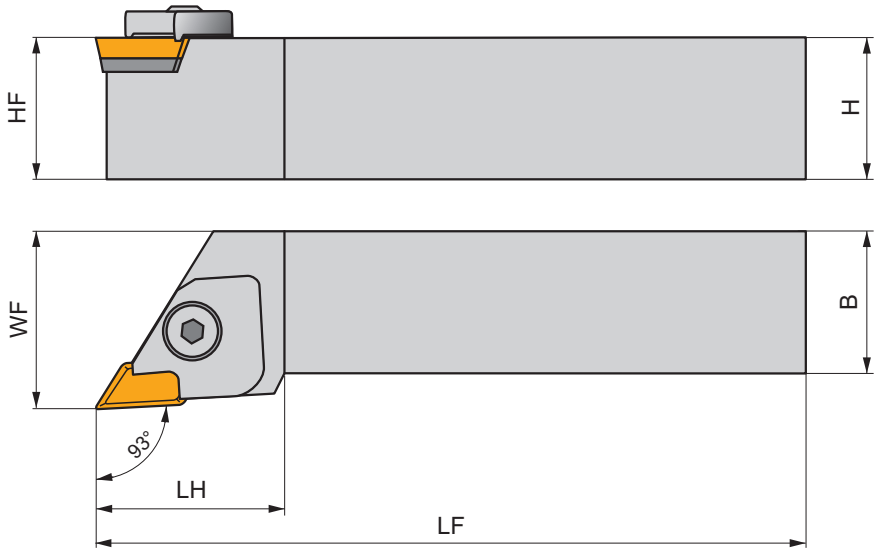
C

External Top Clamp Turning Holder with 93° Cutting Angle for KN.. Inserts

External Right/Left hand top clamp tool holder with 93° cutting angle. Suited for taper, longitudinal turning with shoulder, copy turning up to 30° and chamfering with negative KN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	CKJNR 2020 K 16	20	20	20	30	125	34.0	1	-5	0.40	GI066	R1
	CKJNR 2525 M 16	25	25	25	32	150	34.0	1	-5	0.70	GI066	R
	CKJNR 3225 P 16	32	25	32	32	170	34.0	1	-5	1.06	GI066	R
L	CKJNL 2020 K 16	20	20	20	30	125	34.0	1	-5	0.42	GI067	L1
	CKJNL 2525 M 16	25	25	25	32	150	34.0	1	-5	0.74	GI067	L
	CKJNL 3225 P 16	32	25	32	32	170	34.0	1	-5	1.06	GI067	L

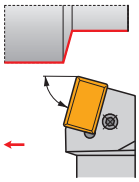
GI066	KN.X 1604…R
GI067	KN.X 1604…L

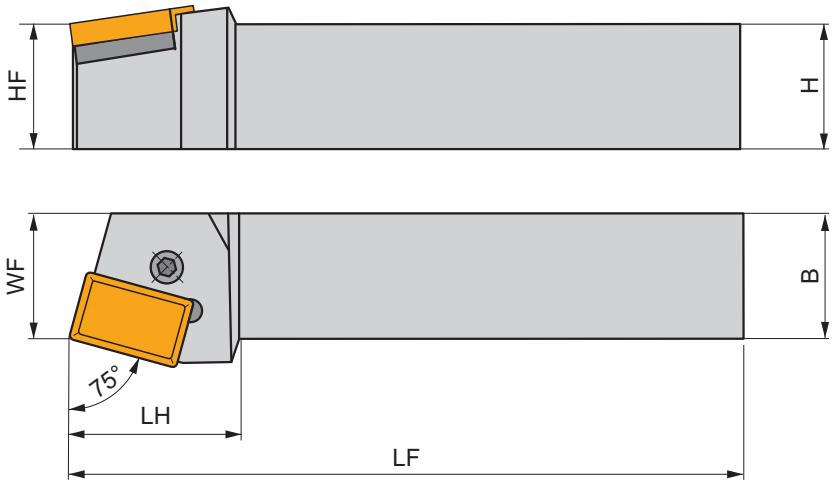
						Nm					
L	KNN 190412L	NT 03	–	UP 26	US 83	6.0	–	–	PR 07	K 23	HXK 4
L1	KNN 190412L	NT 03	–	UP 26	US 83	6.0	–	–	PR 07	K 22	HXK 4
R1	KNN 190412R	NT 03	UP 25	–	US 83	6.0	–	–	PR 07	K 22	HXK 4

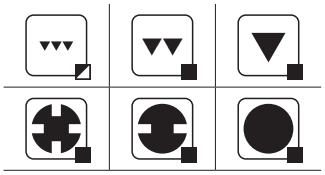
PLBN(RL) EXT

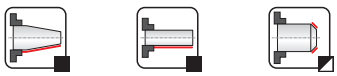
External Lever Lock Heavy Turning Holder, 75° Cutting Angle for LNUX Inserts

External Right/Left hand lever lock tool holder with 75° cutting angle for heavy turning. Suited for longitudinal turning without shoulder, taper and chamfer turning with negative LN.. inserts. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	**PLBNR 6060 V 40-A**	60	60	60	60	400	64.0	-6	-6	13.00	GI102	PL71
	PLBNR 6060 V 50	60	60	60	60	400	70.0	-6	-6	12.75	GI145	PL72
	PLBNR 6060 V 50-2	60	60	60	60	400	70.0	-6	-6	11.60	GI291	PL73
L	**PLBNL 6060 V 40-A**	60	60	60	60	400	64.0	-6	-6	11.14	GI102	PL71
	PLBNL 6060 V 50	60	60	60	60	400	70.0	-6	-6	13.09	GI145	PL72

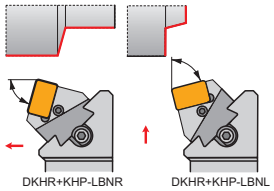
GI102	LNUX 40....
GI145	LNUX 50....
GI291	LNMX 50....

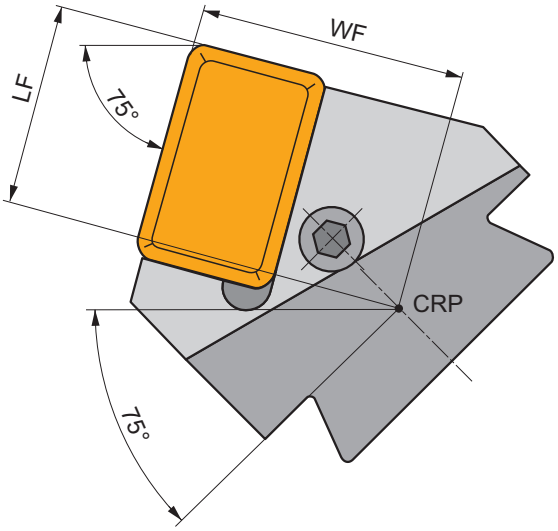
				Nm							
PL71	LNX 400632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5	–	–
PL72	LNX 500632	PU 06	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5	–	–
PL73	LNX 500432P	–	–	–	–	–	–	–	–	UP 1515A-T15P	SDR T15P

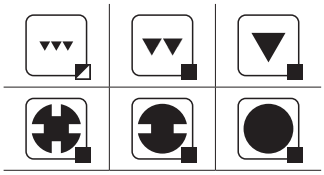
KHP-LBN(RL)

Modular KHP Lever Lock Turning Cartridge, 75° Cutting Angle for LNUX Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 75° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, taper and chamfer turning with negative LNUX inserts. Tool holder treated for longer tool life.







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
L	**KHP-LBNR 40-A**	48	36	-6	-6	1.50	GI102	PL71
	KHP-LBNL 40-A	48	36	-6	-6	1.47	GI102	PL71

GI102	LNUX 40....

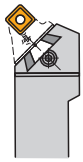
PL71	LNX 400632	PU 06	PS 12040	8.0 Nm	M 12x1	40	NT 08	MT 08	HXK 5

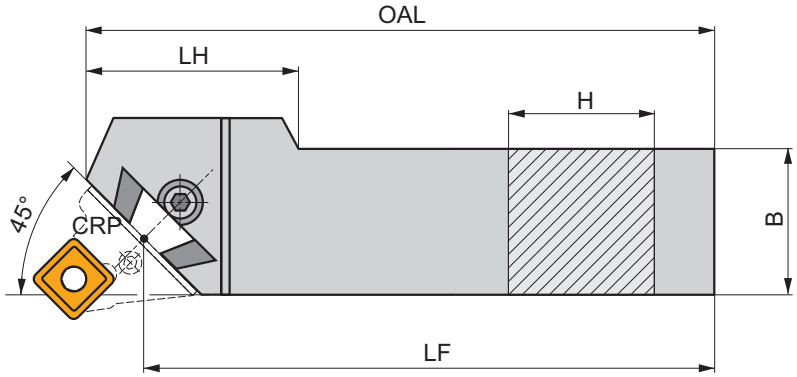
DKH(RL)

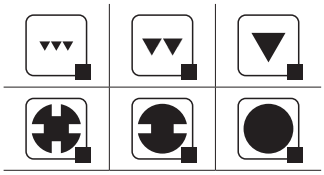
PRAMET

External Tool Holder Shank for KHP/KHS Heavy Turning Cartridges

Dovetailed Right/Left hand modular tool shank for KHP/KHS cartridges. Suited for heavy turning applications. Body treated for longer tool life.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

DRSN(RL) EXT

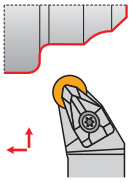
P M K H

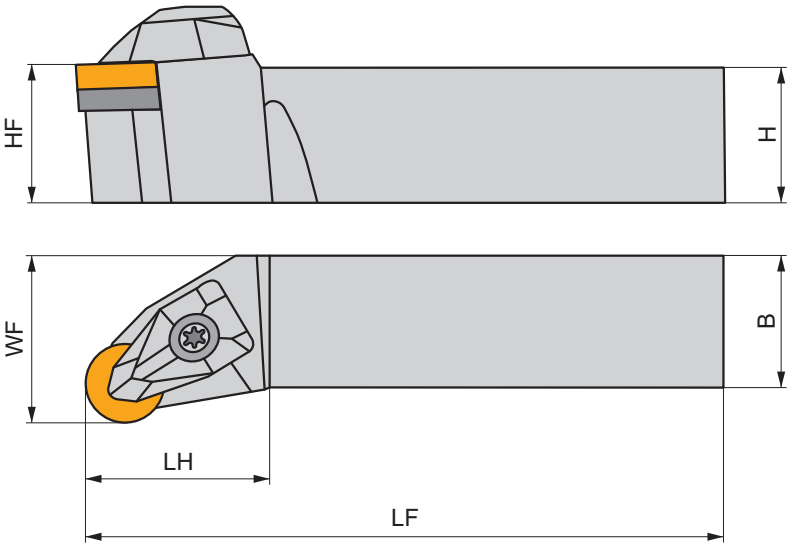
PRAMET

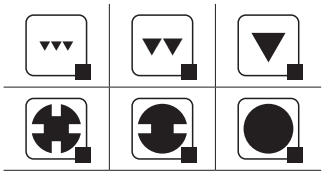
D

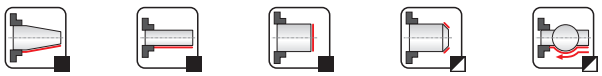
External Double Clamp Holder for RN.. Inserts

External Right/Left hand double clamp tool holder. Suited for longitudinal turning without shoulder, copy turning, taper and chamfer turning with negative round RN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**DRSNR 2525 M 12**	25	25	25	32	150	31.6	-6	-6	0.74	GI083	DR12
L	**DRSNL 2525 M 12**	25	25	25	32	150	31.6	-6	-6	0.75	GI083	DR12

GI083	RN.. 120400

		Nm			
DR12	DCS 12	3.9	DRS 155-02	US 2002-T15P	FLAG T15P/3,5

PRSN(RL) EXT

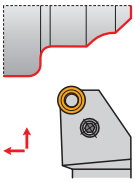
P M K H

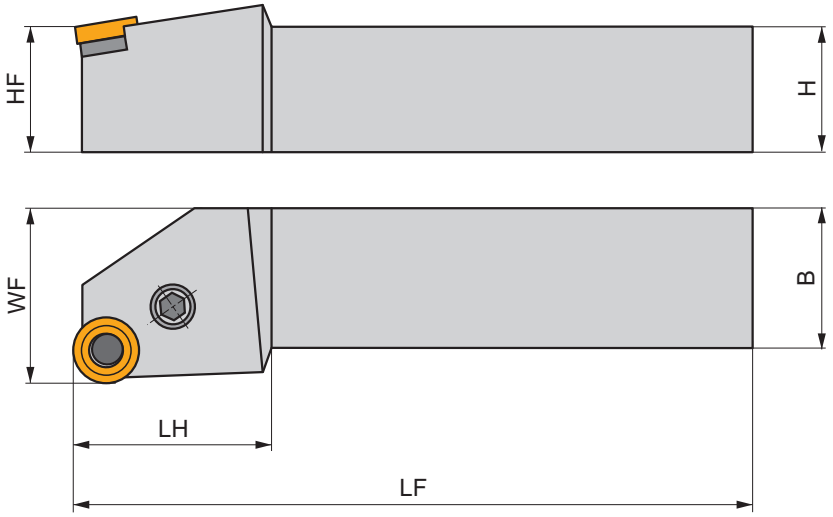
PRAMET

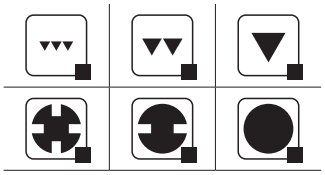
P

External Lever Lock Holder for RN.. Inserts

External Right/Left hand lever lock tool holder. Suited for longitudinal turning, copy turning up to 90°, taper and chamfer turning with negative round RN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PRSNR 2525 M 12**	25	25	25	32	150	28.0	-6	-6	0.68	GI083	PR05
	PRSNR 3225 P 15	32	25	32	32	170	34.0	-6	-6	1.00	GI105	PR06
	PRSNR 4040 S 19	40	40	40	50	250	45.0	-6	-6	2.49	GI106	PR07
L	**PRSNL 2525 M 12**	25	25	25	32	150	28.0	-6	-6	0.74	GI083	PR05
	PRSNL 3225 P 15	32	25	32	32	170	34.0	-6	-6	1.00	GI105	PR06
	PRSNL 4040 S 19	40	40	40	50	250	45.0	-6	-6	2.49	GI106	PR07

GI083	RN.. 120400
GI105	RN.. 150600
GI106	RN.. 190600

				Nm					
PR05	PRS 912	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PR06	PRS 915	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3
PR07	PRS 919	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4

C.-DRSN(RL) EXT

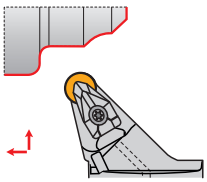
P M K H

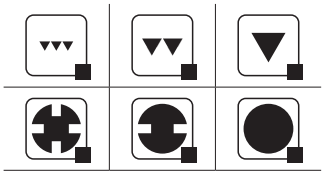
PRAMET

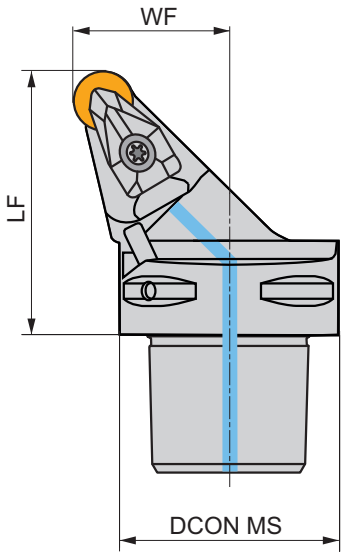
D

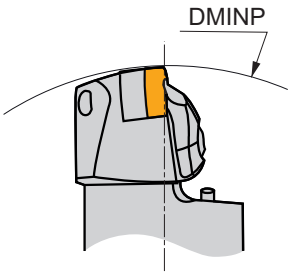
External PSC Quick Change Tool, Double Clamp for RN.. Inserts

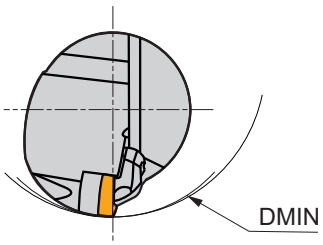
External Right/Left hand double clamp tool, through coolant, for longitudinal turning without shoulder, copy turning, taper and chamfer turning with negative round RN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.

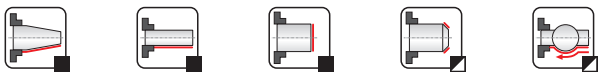












	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg			
R	C6-DRSNR-45065-12	63	110	190	45	65	-6	-6	✓	1.11	GI083	C-DR12	–
L	C6-DRSNL-45065-12	63	110	190	45	65	-6	-6	✓	1.10	GI083	C-DR12	–

GI083	RN.. 120400

C-DR12	DCS 12	3.9 Nm	DRS 155-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

DSBN(RL) EXT

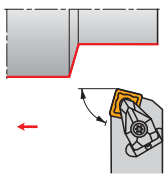
P M K N S H

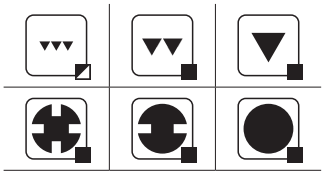
PRAMET

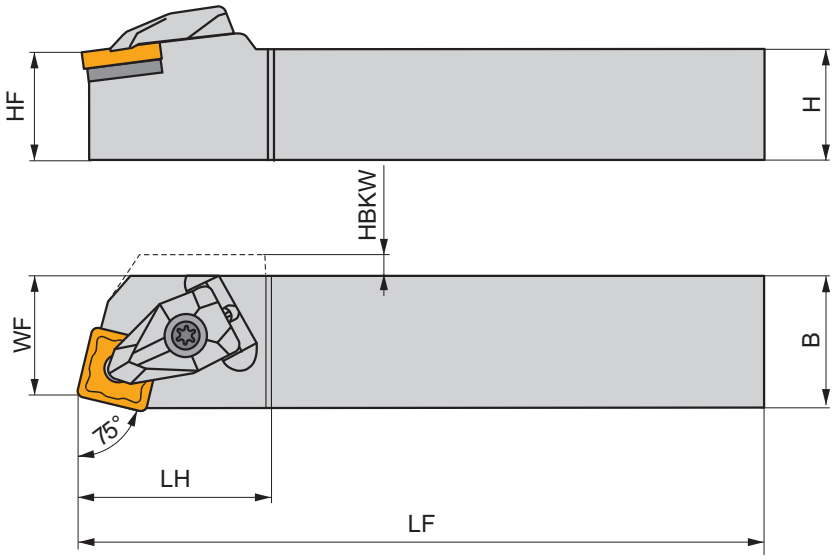
D

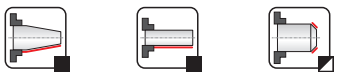
External Double Clamp Holder with 75° Cutting Angle for SN.. Inserts

External Right/Left hand double clamp tool holder with 75° cutting angle. Suited for longitudinal turning without shoulder, taper and chamfer turning with negative SN.. inserts. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LH	HBKW	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	**DSBNR 2525 M 12**	25	25	25	22	150	34.3	–	-6	-6	0.74	GI029	DS12	AT003
	DSBNR 2525 M 15	25	25	25	22	150	41.6	2	-6	-6	0.80	GI082	DS15	AT006
	DSBNR 3225 P 15	32	25	32	22	170	41.7	2	-6	-6	1.07	GI082	DS15	AT006
	DSBNR 3232 P 19	32	32	32	27	170	46.4	–	-6	-6	1.38	GI026	DS19	–
	DSBNR 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	3.14	GI026	DS19	–
L	**DSBNL 2525 M 12**	25	25	25	22	150	34.3	–	-6	-6	0.74	GI029	DS12	AT003
	DSBNL 2525 M 15	25	25	25	22	150	41.6	2	-6	-6	0.80	GI082	DS15	AT006
	DSBNL 3225 P 15	32	25	32	22	170	41.7	2	-6	-6	1.12	GI082	DS15	AT006
	DSBNL 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	3.18	GI026	DS19	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

DSDNN EXT

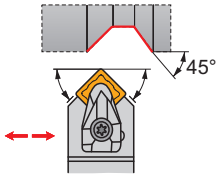
P M K N S H

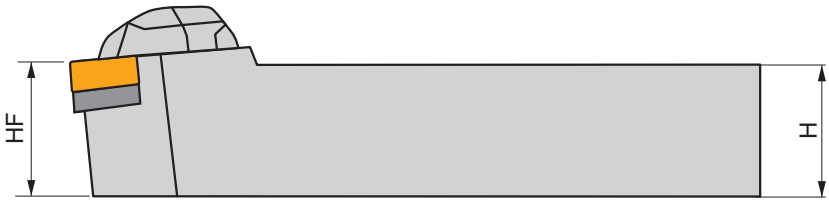
PRAMET

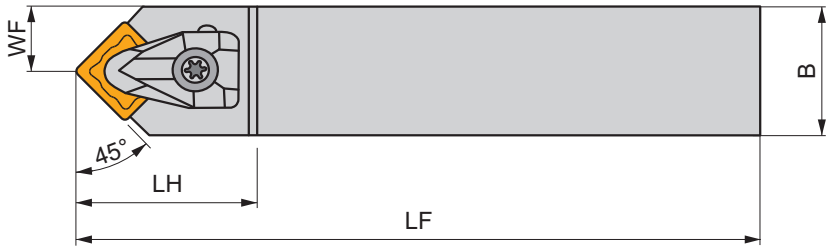
D

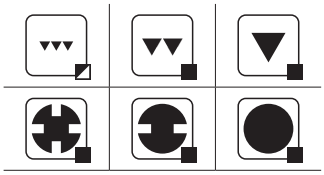
External Double Clamp Holder with 45° Cutting Angle for SN.. Inserts

External neutral double clamp tool holder with 45° cutting angle. Suited for longitudinal turning without shoulder, copy, taper and chamfer turning with negative SN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg			
N	**DSDNN 2525 M 12**	25	25	25	12.8	150	36.5	-6	-6	0.74	GI029	DS12	AT003
	DSDNN 2525 M 15	25	25	25	12.8	150	44.8	-6	-6	0.76	GI082	DS15	AT006
	DSDNN 3232 P 19	32	32	32	16.5	170	49.5	-6	-6	1.35	GI026	DS19	–
	DSDNN 4040 S 25	40	40	40	21	250	57.2	-6	-6	3.13	GI027	DS25	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P
DS25	DCS 25	9.5	DSS 425-07	US 2008-T25P	–	LK T25P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

DSKN(RL) EXT

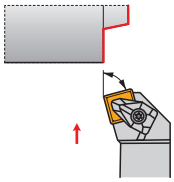
P M K N S H

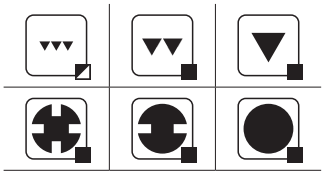
PRAMET

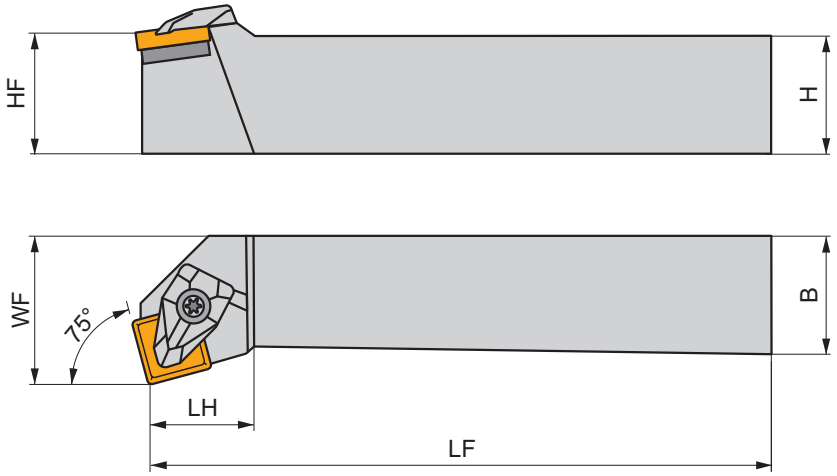
D

External Double Clamp Holder with 75° (Face) Cutting Angle for SN.. Inserts

External Right/Left hand double clamp tool holder with 75° cutting angle. Suited for facing without shoulder and chamfering with SN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	**DSKNR 2525 M 12**	25	25	25	32	150	23.6	-6	-6	0.77	GI029	DS12	AT003
	DSKNR 3232 P 19	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	–
L	**DSKNL 2525 M 12**	25	25	25	32	150	23.6	-6	-6	0.79	GI029	DS12	AT003
	DSKNL 3232 P 19	32	32	32	40	170	32.1	-6	-6	1.46	GI026	DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

DSSN(RL) EXT

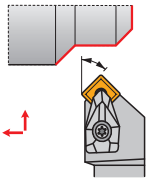
P M K N S H

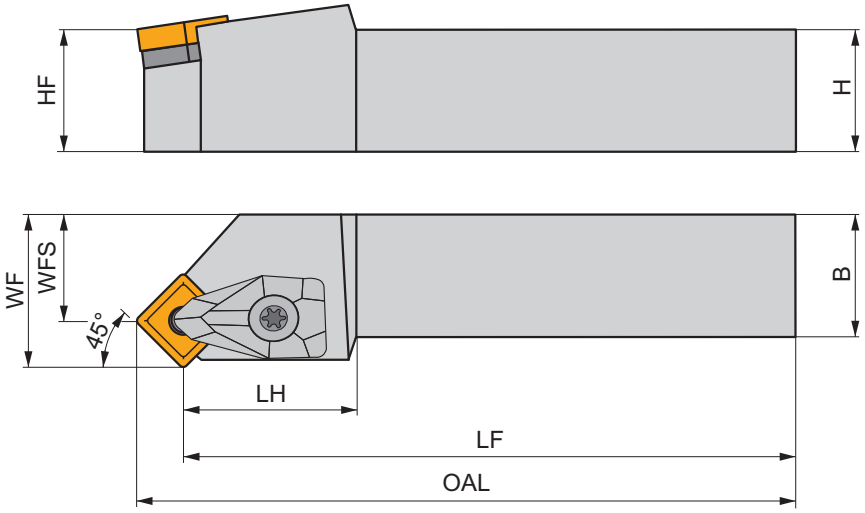
PRAMET

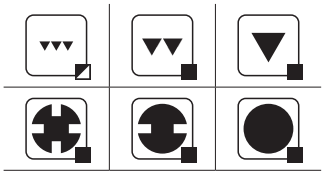
D

External Double Clamp Holder with 45° Cutting Angle for SN.. Inserts

External Right/Left hand double clamp tool holder with 45° cutting angle. Suited for longitudinal and facing without shoulder, taper, copy turning and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	WFS	LF	OAL	LH	LAMS	GAMO	kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
R	**DSSNR 2020 K 12**	20	20	20	25	16.7	125	133.3	27.5	0	-8	0.45	GI029	DS12	AT003
	DSSNR 2525 M 12	25	25	25	32	23.7	150	158.3	27.5	0	-8	0.80	GI029	DS12	AT003
	DSSNR 2525 M 15	25	25	25	32	21.8	150	160.2	32.0	0	-8	0.83	GI082	DS15	AT006
	DSSNR 3225 P 15	32	25	32	32	21.8	170	180.2	34.9	0	-8	1.16	GI082	DS15	AT006
	DSSNR 3232 P 19	32	32	32	40	27.5	170	182.5	37.0	0	-8	1.48	GI026	DS19	–
L	**DSSNL 2525 M 12**	25	25	25	32	23.7	150	158.3	27.5	0	-8	0.19	GI029	DS12	AT003
	DSSNL 2525 M 15	25	25	25	32	21.8	150	160.2	32.0	0	-8	0.83	GI082	DS15	AT006
	DSSNL 3225 P 15	32	25	32	32	21.8	170	180.2	34.9	0	-8	1.16	GI082	DS15	AT006
	DSSNL 3232 P 19	32	32	32	40	27.5	170	182.5	37.0	0	-8	1.48	GI026	DS19	–
	DSSNL 4040 S 19	40	40	40	50	37.5	250	262.5	37.7	0	-8	3.27	GI026	DS19	–

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

PSBN(RL) EXT

P M K N S H

PRAMET

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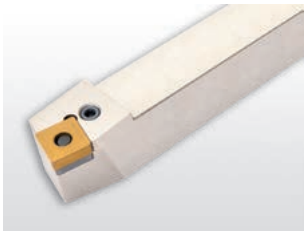
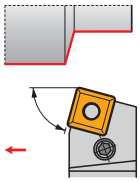
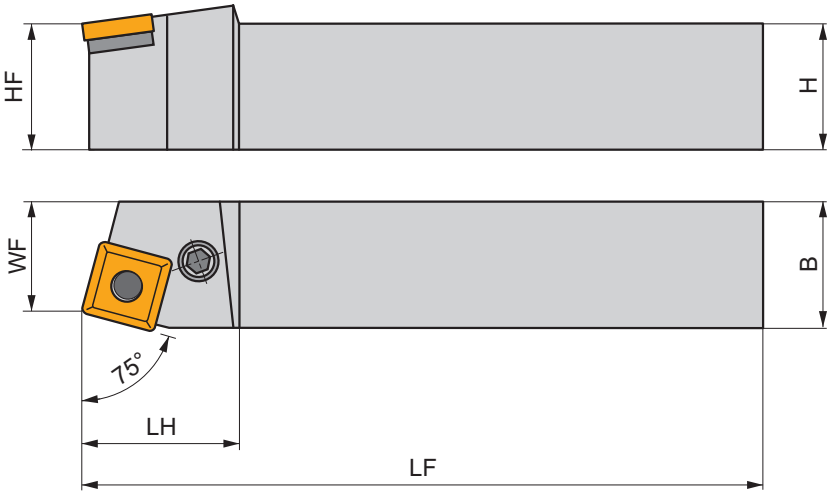
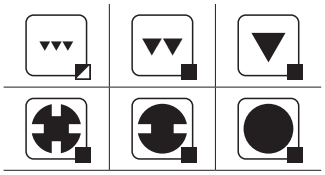


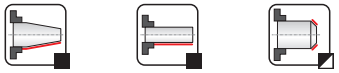
External Lever Lock Holder with 75° Cutting Angle for SN.. Inserts

External Right/Left hand lever lock tool holder with 75° cutting angle. Suited for longitudinal turning without shoulder, taper turning and chamfering with negative SN.. inserts. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	PSBNR 2020 K 12	20	20	20	17	125	36.0	-6	-6	0.42	GI029	PS01
	PSBNR 2525 M 12	25	25	25	22	150	28.0	-6	-6	0.74	GI029	PS01
	PSBNR 3232 P 15	32	32	32	27	170	34.0	-6	-6	1.33	GI082	PS04
	PSBNR 3232 P 19	32	32	32	27	170	42.0	-6	-6	1.30	GI026	PS02
	PSBNR 4040 S 19	40	40	40	35	250	48.0	-6	-6	3.10	GI026	PS02
	PSBNR 4040 S 25	40	40	40	35	250	48.0	-6	-6	2.85	GI027	PS03
	PSBNR 4040 S 2509	40	40	40	35	250	48.0	-6	-6	2.50	GI040	PS03
	PSBNR 4040 S 2512	40	40	40	35	250	48.0	-6	-6	3.00	GI162	PS05
	PSBNR 5050 T 2512	50	50	50	43	300	50.0	-6	-6	5.78	GI162	PS05
	PSBNR 5050 T 25	50	50	50	43	300	50.0	-6	-6	5.76	GI027	PS03
	PSBNR 5050 T 2509	50	50	50	43	300	50.0	-6	-6	5.50	GI040	PS03
L	PSBNL 2020 K 12	20	20	20	17	125	28.0	-6	-6	0.40	GI029	PS01
	PSBNL 2525 M 12	25	25	25	22	150	28.0	-6	-6	0.73	GI029	PS01
	PSBNL 3232 P 15	32	32	32	27	170	34.0	-6	-6	1.33	GI082	PS04
	PSBNL 4040 S 2512	40	40	40	35	250	48.0	-6	-6	3.11	GI162	PS05
	PSBNL 5050 T 2512	50	50	50	43	300	50.0	-6	-6	5.76	GI162	PS05
	PSBNL 3232 P 19	32	32	32	27	170	42.0	-6	-6	1.33	GI026	PS02
	PSBNL 4040 S 19	40	40	40	35	250	48.0	-6	-6	3.09	GI026	PS02
	PSBNL 4040 S 25	40	40	40	35	250	48.0	-6	-6	3.06	GI027	PS03
	PSBNL 4040 S 2509	40	40	40	35	250	50.0	-6	-6	2.50	GI040	PS03
	PSBNL 5050 T 25	50	50	50	43	300	50.0	-6	-6	5.84	GI027	PS03
	PSBNL 5050 T 2509	50	50	50	43	300	50.0	-6	-6	5.80	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..

GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..
GI162	SN.. 2512..

PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PS05	SNU 250624	PU 10-N	PS 12040	8.0	M 12x1	40	NT 08	MT 08	HXK 5

PSDNN EXT

P M K N S H

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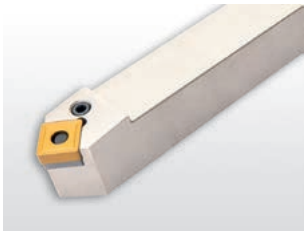
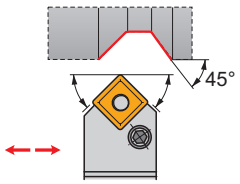
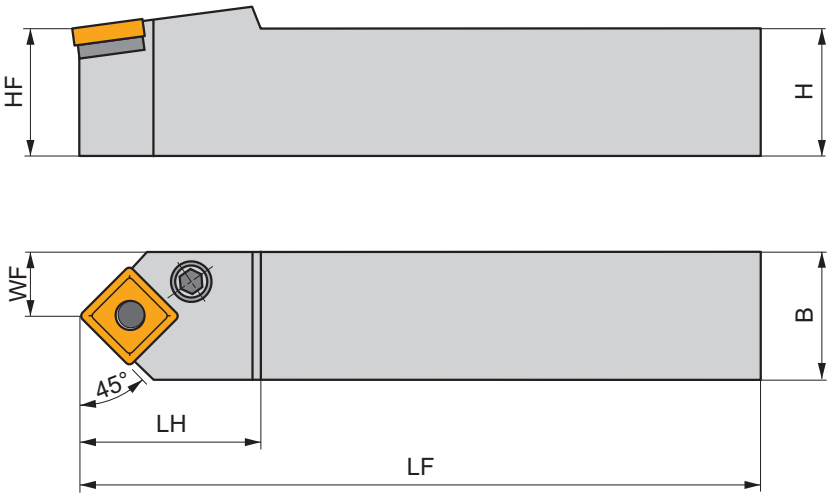
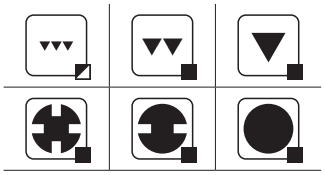


External Lever Lock Holder with 45° Cutting Angle for SN.. Inserts

External neutral lever lock tool holder with 45° cutting angle. Suited for longitudinal turning without shoulder, copy and taper turning and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
N	**PSDNN 2020 K 12**	20	20	20	10	125	28.0	-5	-5	0.39	GI029	PS01
	PSDNN 2525 M 12	25	25	25	12.5	150	28.0	-5	-5	0.68	GI029	PS01
	PSDNN 3232 P 15	32	32	32	16	170	34.0	-5	-5	1.30	GI082	PS04
	PSDNN 3232 P 19	32	32	32	16	170	42.0	-5	-5	1.25	GI026	PS02
	PSDNN 4040 S 19	40	40	40	20	250	42.0	-5	-5	3.03	GI026	PS02
	PSDNN 4040 S 25	40	40	40	20	250	48.0	-5	-5	3.02	GI027	PS03
	PSDNN 5050 T 25	50	50	50	25	300	50.0	-5	-5	5.65	GI027	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

PSKN(RL) EXT

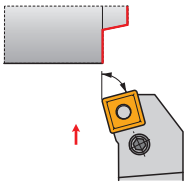
P M K N S H

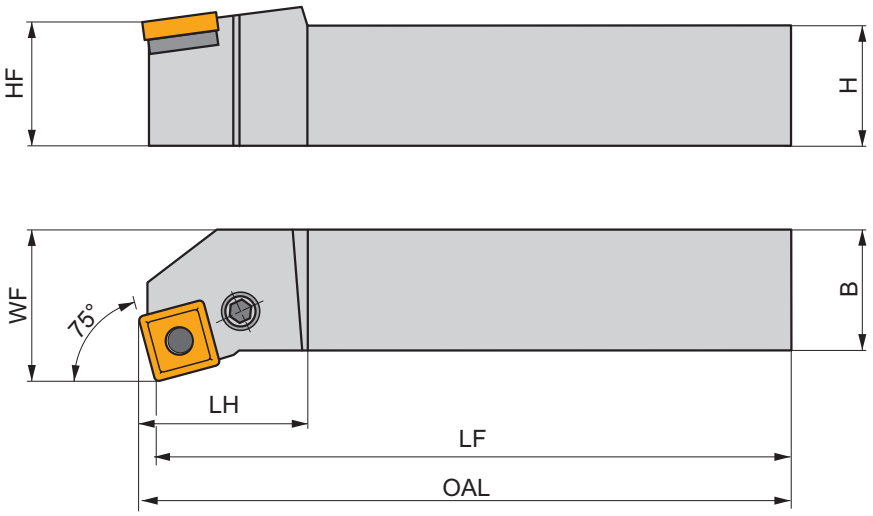
PRAMET

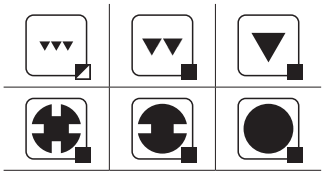
P

External Lever Lock Holder, 75° (Face Turning) Cutting Angle for SN.. Inserts

External Right/Left hand lever lock tool holder with 75° cutting angle. Suited for face turning without shoulder and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	OAL	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PSKNR 2020 K 12	20	20	20	25	125	128.1	28.0	-6	-6	0.42	GI029	PS01
	PSKNR 2525 M 12	25	25	25	32	150	153.1	28.0	-6	-6	0.76	GI029	PS01
	PSKNR 3232 P 19	32	32	32	40	170	174.6	45.0	-6	-6	1.40	GI026	PS02
	PSKNR 4040 S 19	40	40	40	50	250	254.6	45.0	-6	-6	3.23	GI026	PS02
	PSKNR 4040 S 25	40	40	40	50	250	256.5	50.0	-6	-6	3.28	GI027	PS03
	PSKNR 3232 P 15	32	32	32	40	170	173.9	42.0	-6	-6	1.40	GI082	PS04
	PSKNR 5050 T 25	50	50	50	60	300	306.5	50.0	-6	-6	6.05	GI027	PS03
	PSKNR 5050 T 2509	50	50	50	60	300	306.5	50.0	-6	-6	6.20	GI040	PS03
L	PSKNL 2020 K 12	20	20	20	25	125	128.1	28.0	-6	-6	0.42	GI029	PS01
	PSKNL 2525 M 12	25	25	25	32	150	153.1	28.0	-6	-6	0.79	GI029	PS01
	PSKNL 3232 P 15	32	32	32	40	170	173.9	42.0	-6	-6	1.05	GI082	PS04
	PSKNL 3232 P 19	32	32	32	40	170	174.6	42.0	-6	-6	1.41	GI026	PS02
	PSKNL 4040 S 19	40	40	40	50	250	254.6	45.0	-6	-6	3.26	GI026	PS02
	PSKNL 4040 S 25	40	40	40	50	250	256.5	50.0	-6	-6	3.28	GI027	PS03
	PSKNL 5050 T 25	50	50	50	60	300	306.5	50.0	-6	-6	6.00	GI027	PS03
	PSKNL 5050 T 2509	50	50	50	60	300	306.5	50.0	-6	-6	6.20	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

									
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

PSSN(RL) EXT

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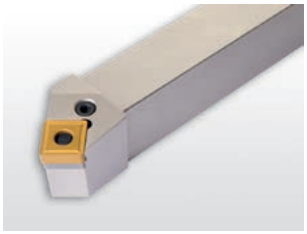
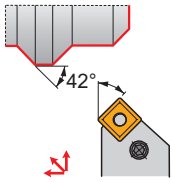
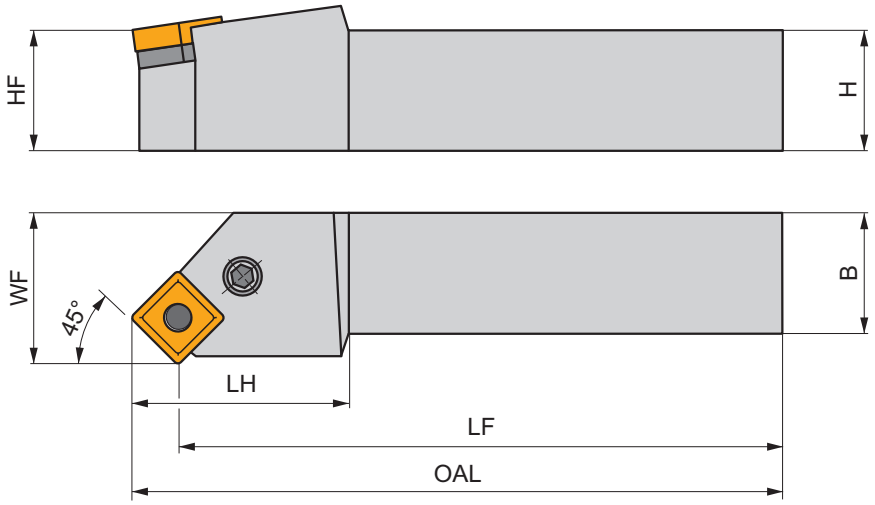
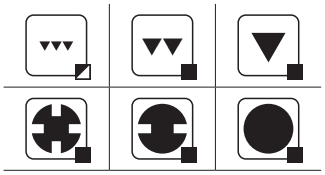


External Lever Lock Holder with 45° Cutting Angle for SN.. Inserts

External Right/Left hand lever lock tool holder with 45° cutting angle. Suited for longitudinal and face turning without shoulder, copy and taper turning and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**PSSNR 2020 K 12**	20	20	20	25	125	133.3	28.0	0	-8	0.42	GI029	PS01
	PSSNR 2525 M 12	25	25	25	32	150	158.3	28.0	0	-8	0.75	GI029	PS01
	PSSNR 3225 P 15	32	25	32	32	170	180.2	42.0	0	-8	1.11	GI082	PS04
	PSSNR 3232 P 19	32	32	32	40	170	182.5	45.0	0	-8	1.42	GI026	PS02
	PSSNR 5050 T 25	50	50	50	60	300	316	50.0	0	-8	6.00	GI027	PS03
	PSSNR 4040 S 19	40	40	40	50	250	262.5	45.0	0	-8	3.18	GI026	PS02
	PSSNR 5050 T 2509	50	50	50	60	300	316	50.0	0	-8	6.05	GI040	PS03
L	**PSSNL 2020 K 12**	20	20	20	25	125	133.3	28.0	0	-8	0.41	GI029	PS01
	PSSNL 2525 M 12	25	25	25	32	150	158.3	28.0	0	-8	0.76	GI029	PS01
	PSSNL 3225 P 15	32	25	32	32	170	180.2	42.0	0	-8	1.13	GI082	PS04
	PSSNL 3232 P 19	32	32	32	40	170	182.5	45.0	0	-8	1.43	GI026	PS02
	PSSNL 4040 S 19	40	40	40	50	250	262.5	45.0	0	-8	3.16	GI026	PS02
	PSSNL 5050 T 25	50	50	50	60	300	316	50.0	0	-8	6.00	GI027	PS03
	PSSNL 5050 T 2509	50	50	50	60	300	316	50.0	0	-8	5.98	GI040	PS03

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	27.2	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	36	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3

C.-DSDNN EXT

P M K N S H

PRAMET

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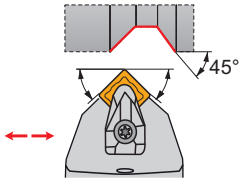
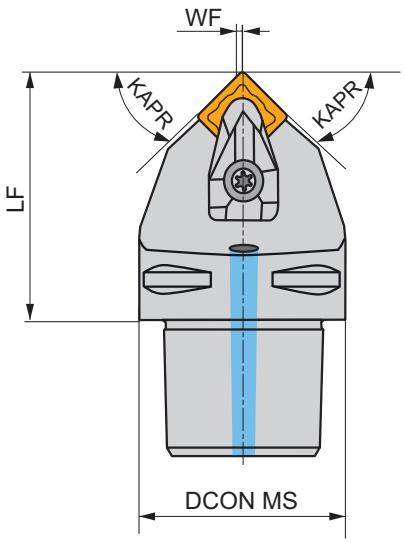
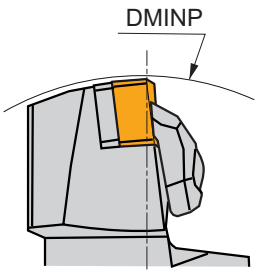
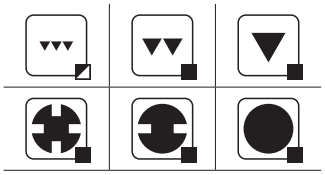
External PSC Quick Change Tool, Double Clamp, 45° Cutting Angle, SN.. Inserts

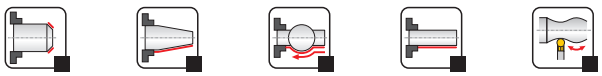
External neutral double clamp tool, through coolant, with 45° cutting angle for longitudinal turning without shoulder, copy turning, taper turning and chamfer turning with negative SN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.











	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
N	**C4-DSDNN-00050-12**	40	140	0.3	50	45	-6	-6	✓	0.39	GI029	C-DS12-2	AT003
	C5-DSDNN-00060-12	50	165	0.3	60	45	-6	-6	✓	0.69	GI029	C-DS12-2	AT003
	C6-DSDNN-00070-19	63	195	0.5	70	45	-6	-6	✓	1.28	GI026	C-DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm					
C-DS12-2	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–	CN 045-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P	CN 045-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSKN(RL) EXT

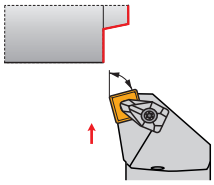
P M K N S H

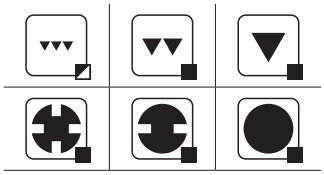
PRAMET

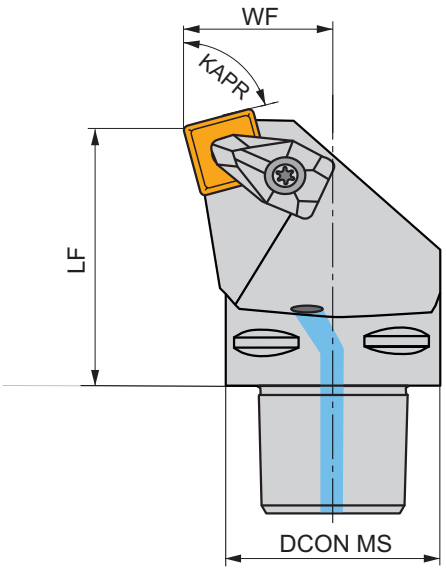
D

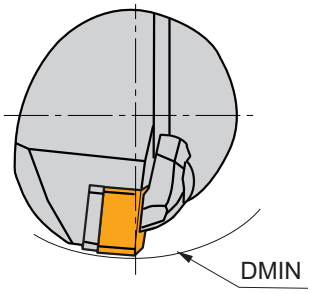
Ext. PSC Quick Change Tool, Double Clamp, 75° (Face) Cutting Angle, SN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 75° cutting angle for face turning without shoulder and chamfering with negative SN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C4-DSKNR-27050-12	40	110	27	50	75	-6	-6	✓	0.46	GI029	C-DS12-1	AT003
L	C4-DSKNL-27050-12	40	110	27	50	75	-6	-6	✓	0.46	GI029	C-DS12-1	AT003

GI029	SN.. 1204..

C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSRN(RL) EXT

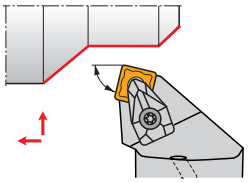
P M K N S H

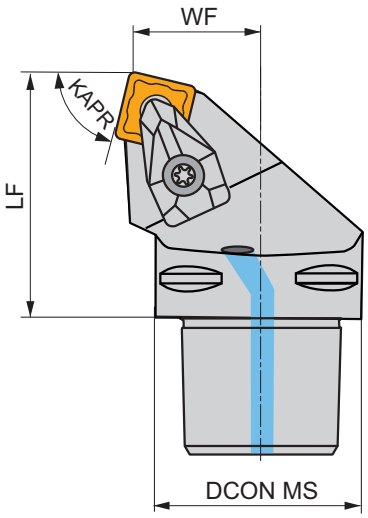
PRAMET

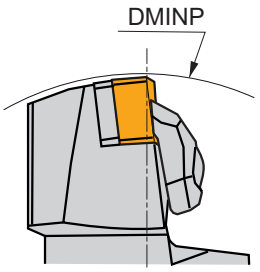
D

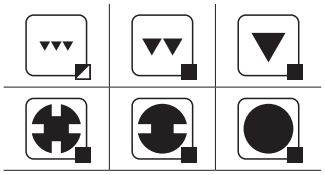
External PSC Quick Change Tool, Double Clamp, 75° Cutting Angle, SN.. Inserts

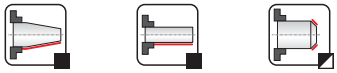
External Right/Left hand double clamp tool, through coolant, with 75° cutting angle for longitudinal turning without shoulder, taper turning and chamfering with negative SN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.











	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C4-DSRNR-22050-12**	40	140	22	50	75	-6	-6	✓	0.40	GI029	C-DS12-1	AT003
	C6-DSRNR-35065-19	63	190	35	65	75	-6	-6	✓	1.30	GI026	C-DS19	–
L	**C4-DSRNL-22050-12**	40	140	22	50	75	-6	-6	✓	0.41	GI029	C-DS12-1	AT003
	C6-DSRNL-35065-19	63	190	35	65	75	-6	-6	✓	1.30	GI026	C-DS19	–

GI029	SN.. 1204..
GI026	SN.. 1906..

		Nm					
C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–	CN 034-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P	CN 045-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSSN(RL) EXT

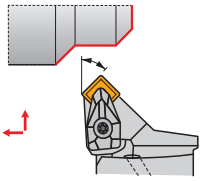
P M K N S H

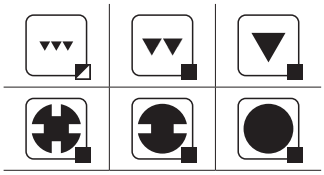
PRAMET

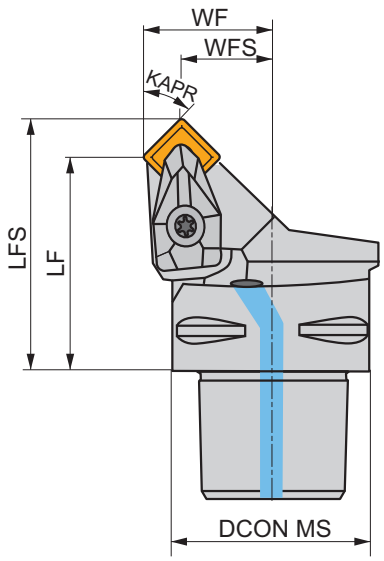
D

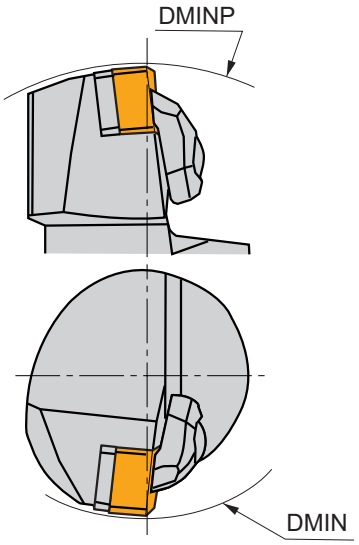
External PSC Quick Change Tool, Double Clamp, 45° Cutting Angle, SN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 45° cutting angle for longitudinal and face turning without shoulder, taper turning, copy turning and chamfering with negative SN.. insert. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	WFS (mm)	LF (mm)	LFS (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	**C4-DSSNR-27042-12**	40	110	140	27	18.7	42	50.3	45	0	-8	✓	0.38	GI029	C-DS12-1	AT003
	C5-DSSNR-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	0.68	GI029	C-DS12-3	AT003
L	**C4-DSSNL-27042-12**	40	110	140	27	18.7	42	50.3	45	0	-8	✓	0.36	GI029	C-DS12-1	AT003
	C5-DSSNL-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	0.69	GI029	C-DS12-3	AT003

GI029	SN.. 1204..

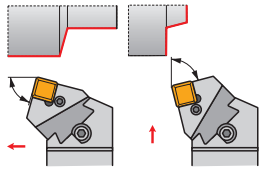
		Nm				
C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DS12-3	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-02

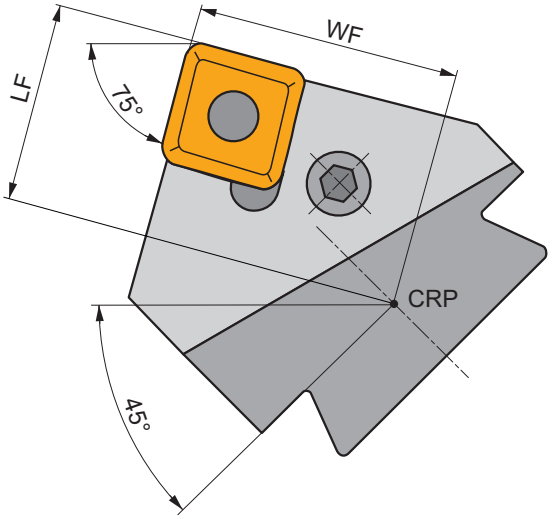
AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

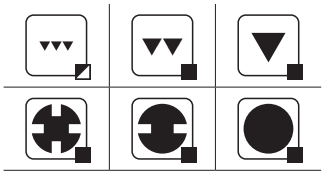
KHP-SBN(RL)

Modular KHP Lever Lock Turning Cartridge, 75° Cutting Angle for SN.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 75° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, taper and chamfer turning with negative SN.. inserts. Tool holder treated for longer tool life.





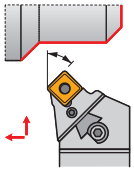


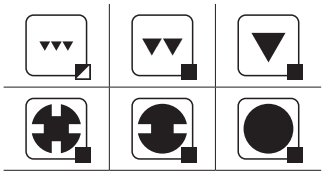
	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	KHP-SBNR 19	47	36	-6	-6	1.51	GI026	PS50
	KHP-SBNR 25	47	36	-6	-6	1.47	GI027	PS60
	KHP-SBNR 2509	47	36	-6	-6	1.45	GI040	PS70
L	KHP-SBNL 19	47	36	-6	-6	1.92	GI026	PS50
	KHP-SBNL 25	47	36	-6	-6	1.48	GI027	PS60
	KHP-SBNL 2509	47	36	-6	-6	1.46	GI040	PS70

GI026	SN.. 1906..
GI027	SN.. 2507..
GI040	SN.. 2509..

PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	29	NT 06	MT 06	HXK 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	33	NT 08	MT 08	HXK 5
PS70	SNU 250624	PU 06	US 47	8.0	M 12x1	36	NT 08	MT 08	HXK 5

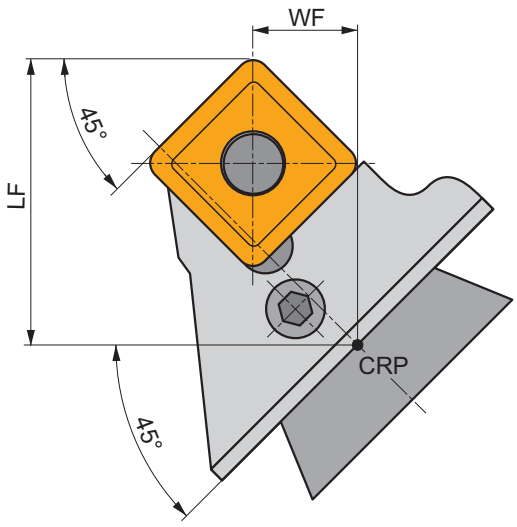
KHP-SSN(RL)

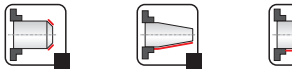




Modular KHP Lever Lock Turning Cartridge, 45° Cutting Angle for SN.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 45° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, copy, taper and chamfer turning with negative SN.. inserts. Tool holder treated for longer tool life.





	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	kg		
R	KHP-SSNR 25	15	45	-6	-6	0.98	GI027	PS60
L	KHP-SSNL 25	15	45	-6	-6	1.30	GI027	PS60

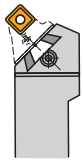
GI027	SN.. 2507..

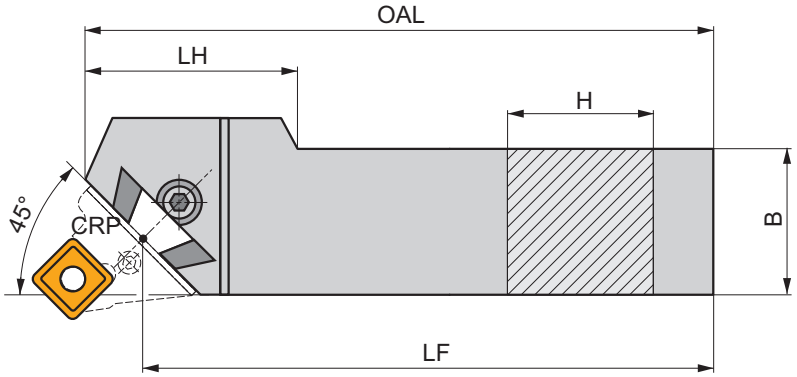
PS60	SNU 250624	PU 06	US 39	8.0 Nm	M 10x1	33	NT 08	MT 08	HXK 5

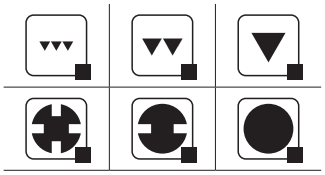
DKH(RL)

External Tool Holder Shank for KHP/KHS Heavy Turning Cartridges

Dovetailed Right/Left hand modular tool shank for KHP/KHS cartridges. Suited for heavy turning applications. Body treated for longer tool life.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	kg		
R	**DKHR 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHR 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHR 6080 W-A	60	80	450	485	90.0	19.65	GI098	DKH10
L	**DKHL 4050 V**	40	50	400	425	100.0	7.10	GI098	DKH10
	DKHL 5060 W	50	60	450	475	110.0	11.30	GI098	DKH10
	DKHL 6080 W-A	60	80	450	485	90.0	19.28	GI098	DKH10

GI098	KHP	KHS

DKH10	SR 14	HXK 10

PSKN(RL) INT

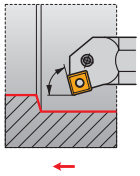
P M K N S H

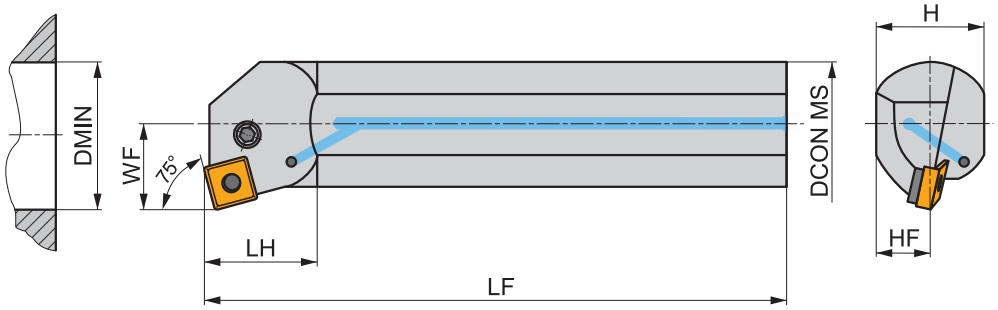
PRAMET

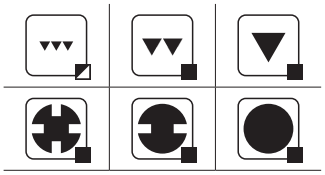
P

Internal Lever Lock Boring Bar with 75° Cutting Angle for SN.. Inserts

Internal Right/Left hand lever lock boring bar, through coolant, 75° cutting angle for SN.. inserts. For internal taper and longitudinal turning without shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A32S-PSKNR 12	32	39	22	30	–	250	-10	-6	✓	1.45	GI029	PS06
	A40T-PSKNR 15	40	48	27	37	–	300	-11	-6	✓	2.90	GI082	PS04
	A50U-PSKNR 15	50	61	35	47	–	350	-11	-6	✓	5.20	GI082	PS04
	A50U-PSKNR 19	50	63	35	47	48.5	350	-12	-6	✓	5.20	GI026	PS07
L	A50U-PSKNL 15	50	61	35	47	–	350	-11	-6	✓	5.20	GI082	PS04

GI029	SN.. 1204..
GI082	SN.. 1506..
GI026	SN.. 1906..

				Nm					
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	22.5	TR 15	MT 07	HXK 3
PS06	PSS 512	CL 312	CS 648	3.0	M 8x1	17	TR 12	MT 05	HXK 3
PS07	PSS 519	CL 219	CS 710	3.5	M 10x1	30.4	TR 29	MT 06	HXK 4

DTFN(RL) EXT

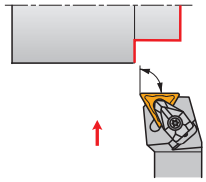
P M K N S H

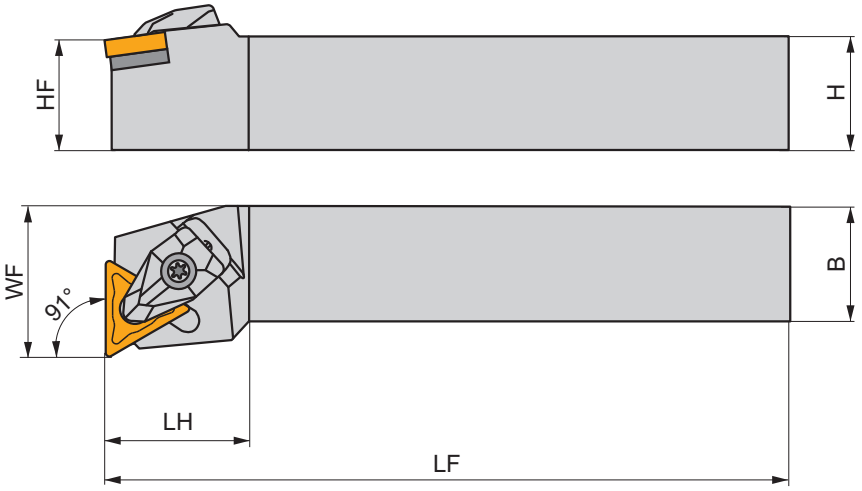
PRAMET

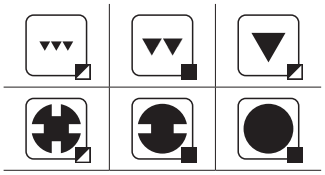
D

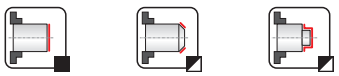
External Double Clamp Holder with 91° (Face) Cutting Angle for TN.. Inserts

External Right/Left hand double clamp tool holder with 91° cutting angle. Suited for face turning with shoulder and chamfering with negative TN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**DTFNR 2020 K 16**	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
	DTFNR 2525 M 16	25	25	25	32	150	23.6	-6	-6	0.77	GI024	DT16
	DTFNR 2525 M 22	25	25	25	32	150	30.5	-6	-6	0.79	GI025	DT22
L	**DTFNL 2020 K 16**	20	20	20	25	125	23.6	-6	-6	0.43	GI024	DT16
	DTFNL 2525 M 16	25	25	25	32	150	23.6	-6	-6	0.76	GI024	DT16

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

DTGN(RL) EXT

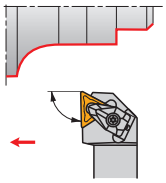
P M K N S H

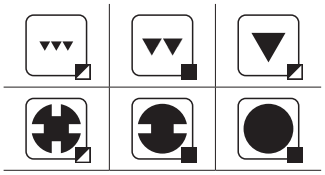
PRAMET

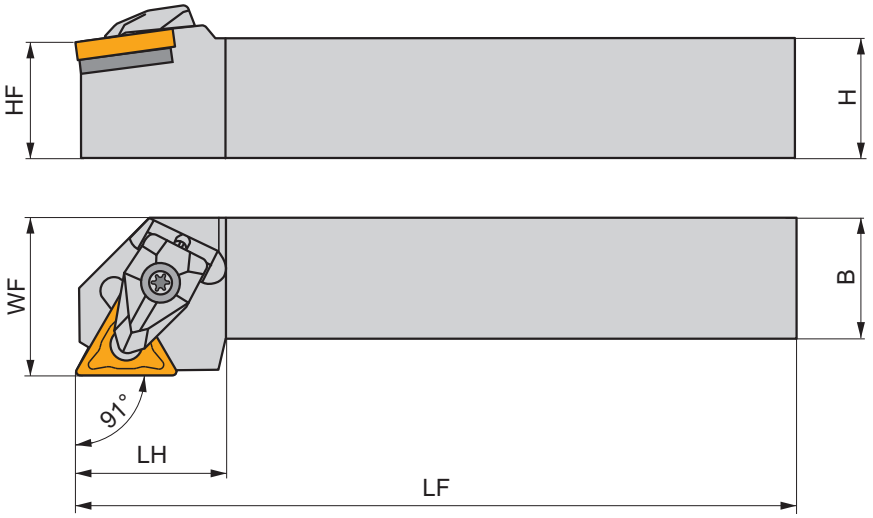
D

External Double Clamp Holder with 91° Cutting Angle for TN.. Inserts

External Right/Left hand double clamp tool holder with 91° cutting angle. Suited for longitudinal turning with shoulder, taper turning and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	DTGNR 2020 K 16	20	20	20	25	125	25.4	-6	-6	0.42	GI024	DT16
	DTGNR 2525 M 16	25	25	25	32	150	24.6	-6	-6	0.76	GI024	DT16
	DTGNR 2525 M 22	25	25	25	32	150	32.1	-6	-6	0.81	GI025	DT22
	DTGNR 3232 P 22	32	32	32	40	170	33.1	-6	-6	1.41	GI025	DT22
L	DTGNL 2020 K 16	20	20	20	25	125	25.4	-6	-6	0.44	GI024	DT16
	DTGNL 2525 M 16	25	25	25	32	150	24.6	-6	-6	0.78	GI024	DT16
	DTGNL 2525 M 22	25	25	25	32	150	32.1	-6	-6	0.78	GI025	DT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

MTJN(RL) EXT

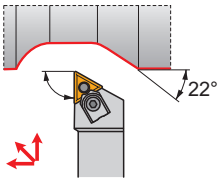
P M K N S H

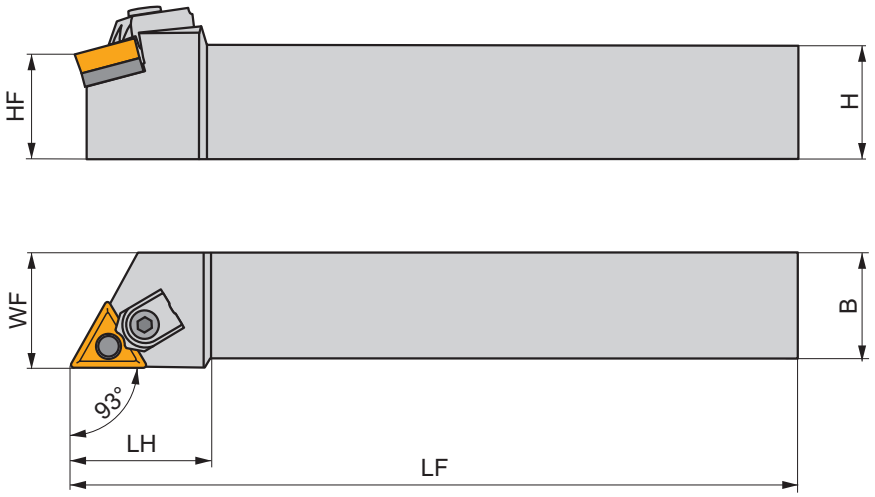
PRAMET

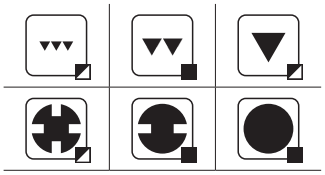
M

External Multi-Clamp Holder with 93° Cutting Angle for TN.. Inserts

External Right/Left hand multi-clamp tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, taper and copy turning up to 22°, and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	MTJNR 2020 K 16	20	20	20	25	125	34.0	-6	-6	0.42	GI024	MT16
	MTJNR 2525 M 16	25	25	25	32	150	34.0	-6	-6	0.76	GI024	MT16
	MTJNR 3232 P 22	32	32	32	40	175	42.0	-6	-6	1.37	GI025	MT22
L	MTJNL 2020 K 16	20	20	20	25	125	34.0	-6	-6	0.43	GI024	MT16
	MTJNL 2525 M 16	25	25	25	32	150	34.0	-6	-6	0.75	GI024	MT16
	MTJNL 3232 P 22	32	32	32	40	175	42.0	-6	-6	1.37	GI025	MT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm				
MT16	UE 16	3.0	MTN 160312	UC 52	HS 93	HXK 5
MT22	UE 22	5.0	MTN 220612	UC 61	HS 94	HXK 5

PTFN(RL) EXT

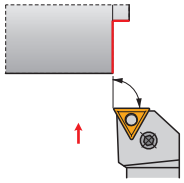
P M K N S H

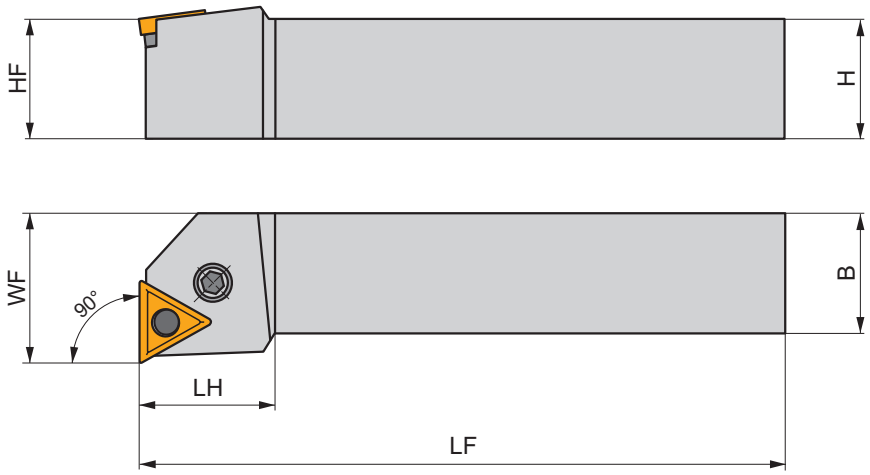
PRAMET

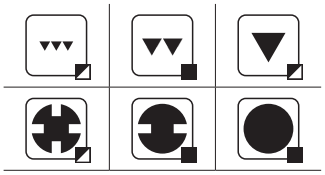
P

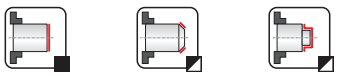
External Lever Lock Holder with 90° (Face) Cutting Angle for TN.. Inserts

External Right/Left hand lever lock tool holder with 90° cutting angle. Suited for face turning with shoulder and chamfering with negative TN.. inserts. Body treated for longer tool life.









	Product	H	B	HF	WF	LF	LH	LAMS	GAMO	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			
R	PTFNR 2020 K 16	20	20	20	25	125	22.0	-6	-6	0.41	GI024	PT01
	PTFNR 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.75	GI024	PT01
	PTFNR 3225 P 22	32	25	32	32	170	36.0	-6	-6	1.05	GI025	PT02
	PTFNR 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.22	GI077	PT03
L	PTFNL 2525 M 22	25	25	25	32	150	28.0	-6	-6	0.70	GI025	PT02
	PTFNL 3225 P 22	32	25	32	32	170	36.0	-6	-6	1.14	GI025	PT02
	PTFNL 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.16	GI077	PT03

GI024	TN.. 1604..
GI025	TN.. 2204..
GI077	TN.. 2706..

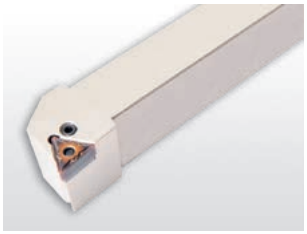
				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT03	PTS 427	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

PTGN(RL) EXT

P M K N S H

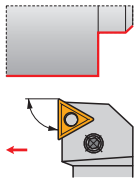
PRAMET

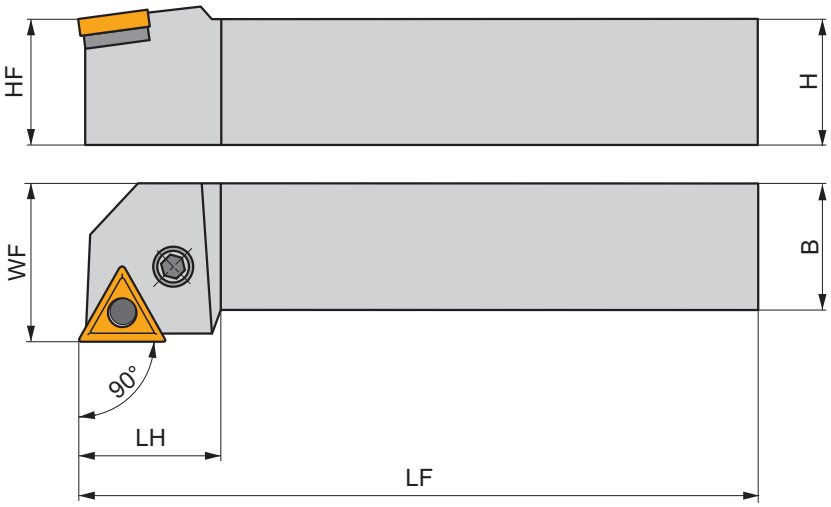
P

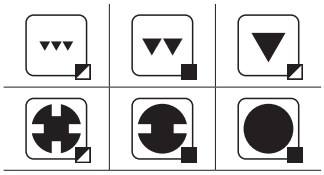


External Lever Lock Holder with 90° Cutting Angle for TN.. Inserts

External Right/Left hand lever lock tool holder with 90° cutting angle. Suited for longitudinal turning with shoulder, taper turning and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	PTGNR 1616 H 16	16	16	16	20	100	22.0	-6	-6	0.20	GI024	PT01
	PTGNR 2020 K 16	20	20	20	25	125	22.0	-6	-6	0.40	GI024	PT01
	PTGNR 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.73	GI024	PT01
	PTGNR 2525 M 22	25	25	25	32	150	28.0	-6	-6	0.76	GI025	PT02
	PTGNR 3232 P 22	32	32	32	40	170	28.0	-6	-6	1.35	GI025	PT02
	PTGNR 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.15	GI077	PT03
L	PTGNL 1616 H 16	16	16	16	20	100	22.0	-6	-6	0.21	GI024	PT01
	PTGNL 2020 K 16	20	20	20	25	125	22.0	-6	-6	0.40	GI024	PT01
	PTGNL 2525 M 16	25	25	25	32	150	28.0	-6	-6	0.76	GI024	PT01
	PTGNL 2525 M 22	25	25	25	32	150	28.0	-6	-6	0.76	GI025	PT02
	PTGNL 3232 P 22	32	32	32	40	170	28.0	-6	-6	1.34	GI025	PT02
	PTGNL 4040 S 27	40	40	40	50	250	45.0	-6	-6	3.14	GI077	PT03

GI024	TN.. 1604..
GI025	TN.. 2204..
GI077	TN.. 2706..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT03	PTS 427	CL 015	CS 708	3.0	M 8x1	23.5	TR 15	MT 07	HXK 3

PTTN(RL) EXT

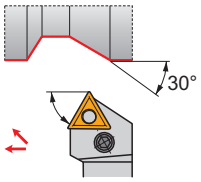
P M K N S H

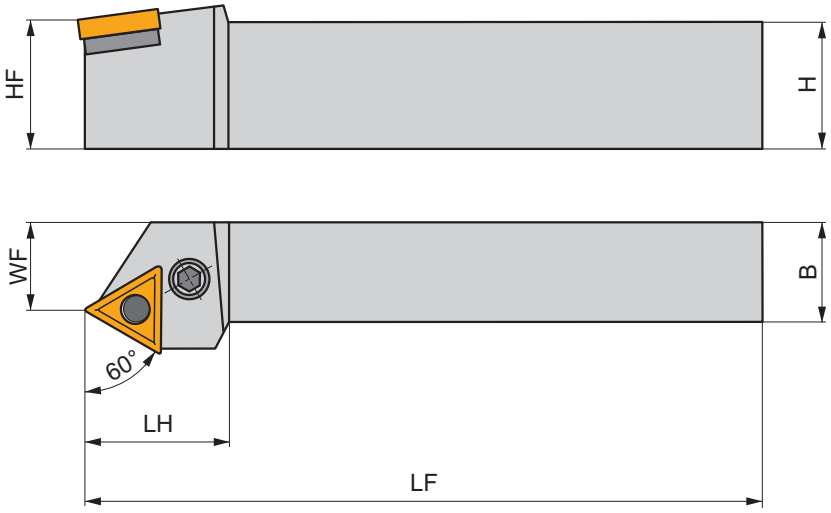
PRAMET

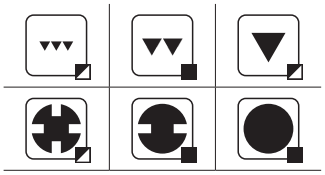
P

External Lever Lock Holder with 60° Cutting Angle for TN.. Inserts

External Right/Left hand lever lock tool holder with 60° cutting angle. Suited for longitudinal turning with shoulder, taper and copy turning up to 30° and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	PTTNR 2020 K 16	20	20	20	17	125	28.0	-6	-6	0.43	GI024	PT01
	PTTNR 2525 M 16	25	25	25	22	150	28.0	-6	-6	0.63	GI024	PT01
	PTTNR 2525 M 22	25	25	25	22	150	34.0	-6	-6	0.73	GI025	PT02
	PTTNR 3225 P 22	32	25	32	22	170	34.0	-6	-6	1.07	GI025	PT02
L	PTTNL 2020 K 16	20	20	20	17	125	28.0	-6	-6	0.38	GI024	PT01
	PTTNL 3225 P 22	32	25	32	22	170	34.0	-6	-6	1.04	GI025	PT02

GI024	TN.. 1604..
GI025	TN.. 2204..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3

C.-DTJN(RL) EXT

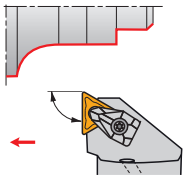
P M K N S H

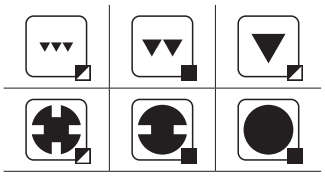
PRAMET

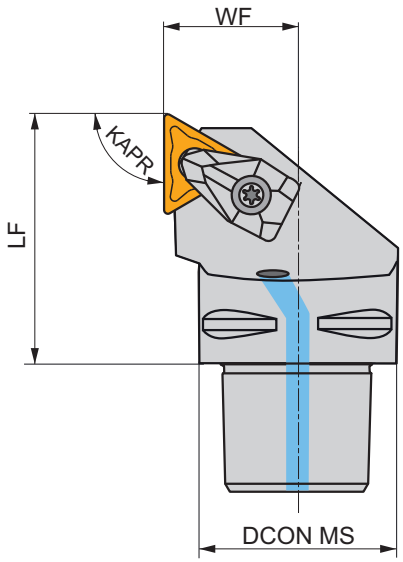
D

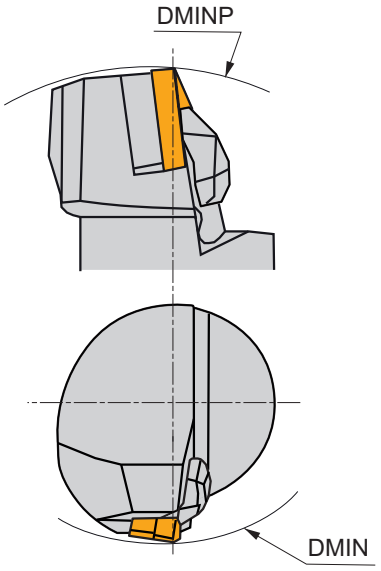
External PSC Quick Change Tool, Double Clamp, 93° Cutting Angle, TN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 93° cutting angle for longitudinal turning with shoulder, taper turning and chamfering with negative TN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DTJNR-27050-16	40	110	140	27	50	93	-6	-6	✓	0.43	GI024	C-DT16
	C5-DTJNR-35060-16	50	110	165	35	60	93	-6	-6	✓	0.79	GI024	C-DT16
L	C4-DTJNL-27050-16	40	110	140	27	50	93	-6	-6	✓	0.43	GI024	C-DT16
	C5-DTJNL-35060-16	50	110	165	35	60	93	-6	-6	✓	0.79	GI024	C-DT16

GI024	TN.. 1604..

C-DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P	CN 045-01

DTFN(RL) INT

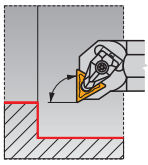
P M K N S H

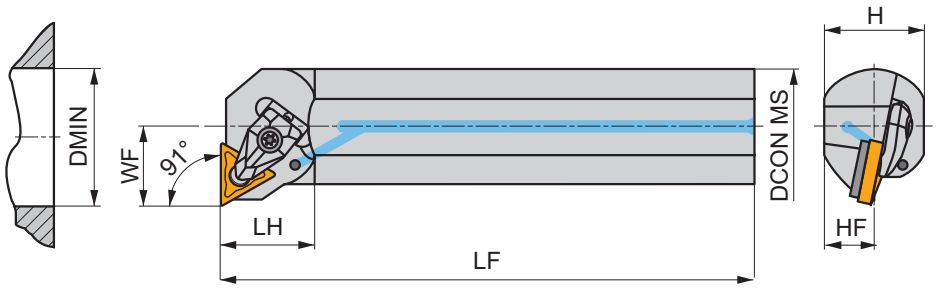
PRAMET

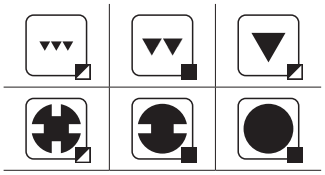
D

Internal Double Clamp Holder with 91° Cutting Angle for TN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 91° cutting angle for TN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A25T-DTFNR 16	25	32	17	23	11.5	300	32.0	-12	-6	✓	0.96	GI024	DTI16
	A32T-DTFNR 16	32	40	22	30	15	300	33.0	-10	-6	✓	1.67	GI024	DTI16
	A40T-DTFNR 22	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.58	GI025	DT22
L	A25T-DTFNL 16	25	32	17	23	11.5	300	32.0	-12	-6	✓	0.96	GI024	DTI16
	A32T-DTFNL 16	32	40	22	30	15	300	33.0	-10	-6	✓	1.67	GI024	DTI16
	A40T-DTFNL 22	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.58	GI025	DT22

GI024	TN.. 1604..
GI025	TN.. 2204..

		Nm			
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5
DTI16	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

PTFN(RL) INT

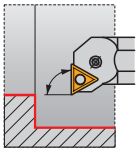
P M K N S H

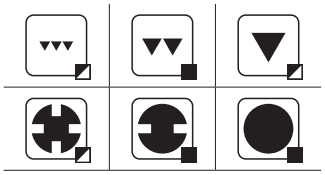
PRAMET

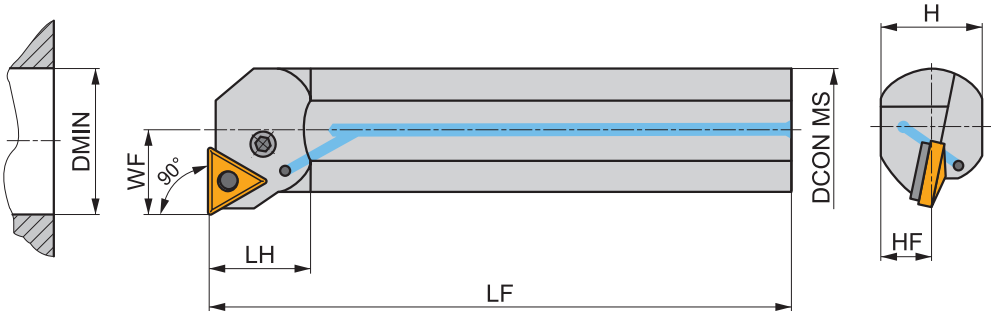
P

Internal Lever Lock Holder with 90° Cutting Angle for TN.. Inserts

Internal Right/Left hand lever lock boring bar, through coolant available, 90° cutting angle for TN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	**A25R-PTFNR 16**	25	31	17	23	–	200	-13	-6	–	0.71	GI024	PT04
	A32S-PTFNR 16	32	39	22	30	–	250	-12	-6	✓	1.45	GI024	PT01
L	**A25R-PTFNL 16**	25	31	17	23	–	200	-13	-6	–	0.71	GI024	PT04

GI024	TN.. 1604..

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PT04	–	CL 216	CS 605	1.4	M 5x1	12	–	–	HXK 2

C.-DTFN(RL) INT

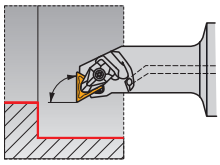
P M K N S H

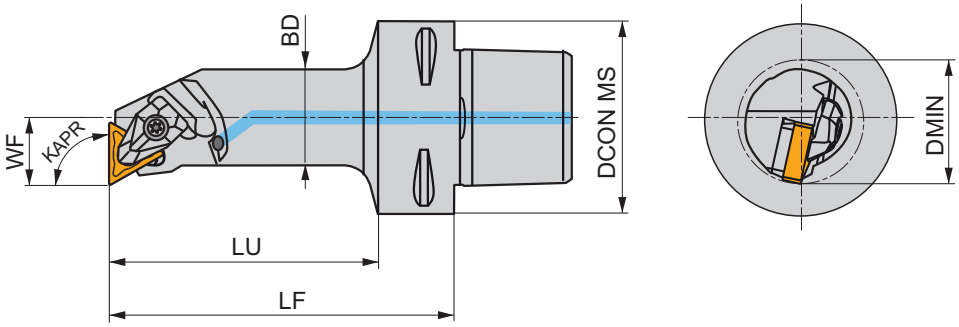
PRAMET

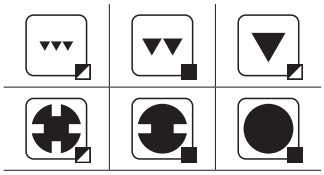
D

Internal PSC Quick Change Tool, Double Clamp, 91° Cutting Angle, TN.. Inserts

Internal Right/Left hand double clamp tool, through coolant, with 91° cutting angle for a wide range of internal turning applications with TN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DTFNR-17090-16	40	32	17	90	68	25	91	-12	-6	✓	0.51	GI024	DTI16

GI024	TN.. 1604..

DTI16	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

DVJN(RL) EXT

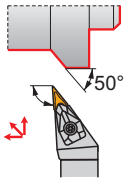
P M K N S H

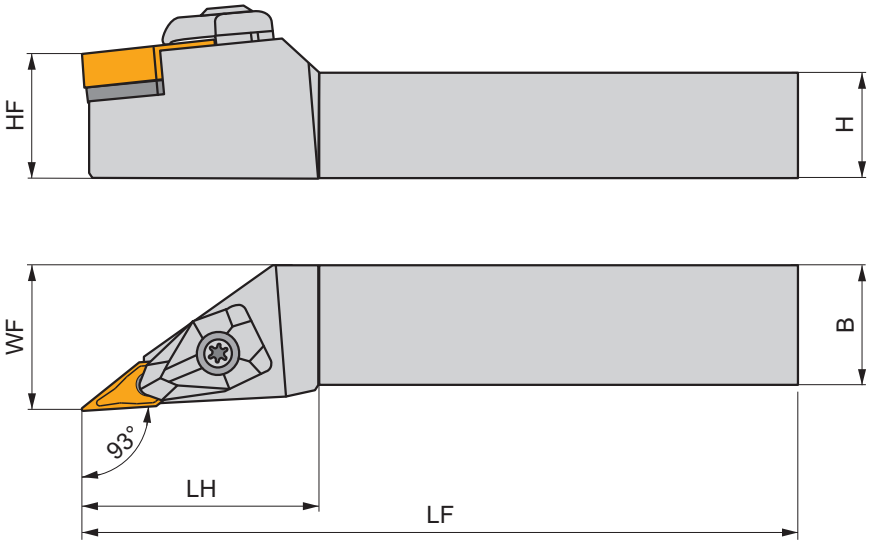
PRAMET

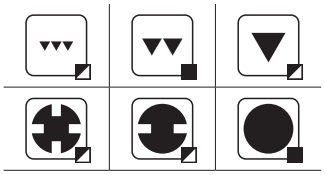
D

External Double Clamp Holder with 93° Cutting Angle for VN.. Inserts

External Right/Left hand double clamp tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copy and taper turning and chamfering with negative VN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**DVJNR 2020 K 16**	20	20	20	25	125	46.4	-13	-4	0.43	GI048	DV16
	DVJNR 2525 M 16	25	25	25	32	150	46.4	-13	-4	0.74	GI048	DV16
	DVJNR 3225 P 16	32	25	32	32	170	46.4	-13	-4	1.05	GI048	DV16
L	**DVJNL 2020 K 16**	20	20	20	25	125	46.4	-13	-4	0.43	GI048	DV16
	DVJNL 2525 M 16	25	25	25	32	150	46.4	-13	-4	0.75	GI048	DV16
	DVJNL 3225 P 16	32	25	32	32	170	46.4	-13	-4	1.06	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

DVPN(RL) EXT

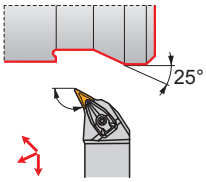
P M K N S H

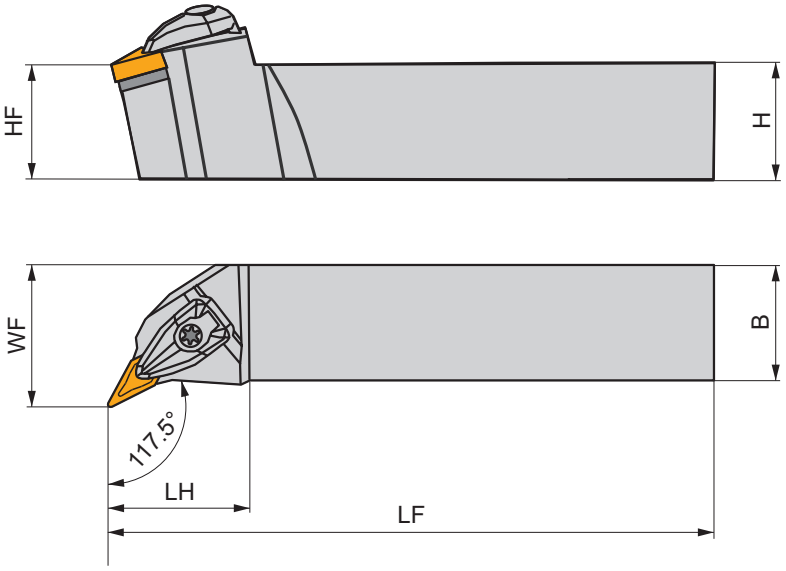
PRAMET

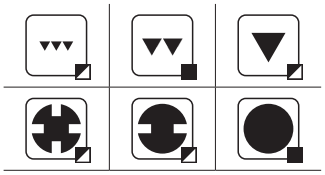
D

External Double Clamp Holder with 117.5° Cutting Angle for VN.. Inserts

External Right/Left hand double clamp tool holder with 117.5° cutting angle. Suited for longitudinal and face turning with shoulder, copy and taper turning and chamfering with negative VN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	DVPNR 2525 M 16	25	25	25	32	150	39.2	-13	-4	0.75	GI048	DV16
L	DVPNL 2525 M 16	25	25	25	32	150	39.2	-13	-4	0.74	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0 Nm	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

MVJN(RL) EXT

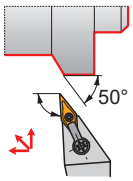
P M K N S H

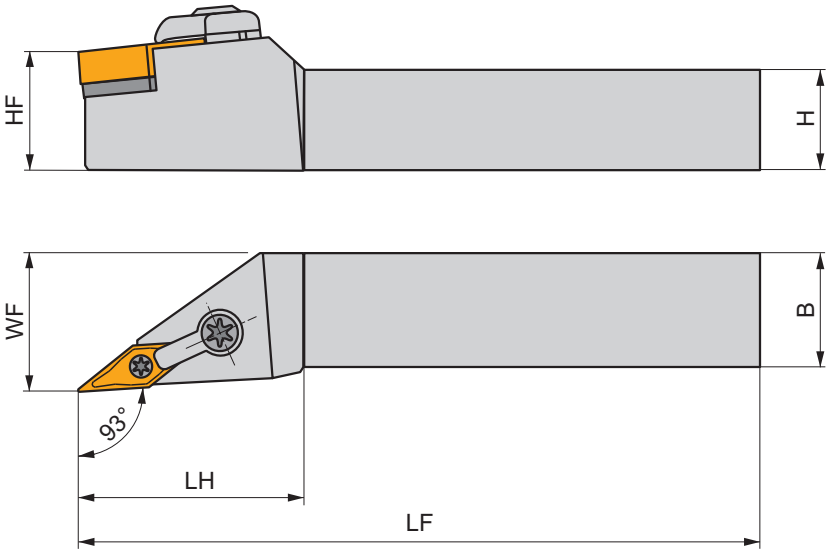
PRAMET

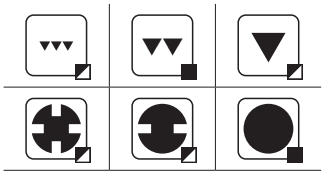
M

External Multi-Clamp Holder with 93° Cutting Angle for VN.. Inserts

External Right/Left hand multi-clamp turning holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copy turning up to 50°, taper and chamfer turning with negative VN.. insert. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	MVJNR 2020 K 16-A	20	20	20	25	125	41.0	-4.5	-13.5	0.40	GI048	MV2
	MVJNR 2525 M 16-A	25	25	25	32	150	41.0	-4.5	-13.5	0.70	GI048	MV2
	MVJNR 3225 P 16-A	32	25	32	32	170	41.0	-4.5	-13.5	0.98	GI048	MV2
L	MVJNL 2020 K 16-A	20	20	20	25	125	41.0	-4.5	-13.5	0.40	GI048	MV2
	MVJNL 2525 M 16-A	25	25	25	32	150	41.0	-4.5	-13.5	0.70	GI048	MV2
	MVJNL 3225 P 16-A	32	25	32	32	170	41.0	-4.5	-13.5	0.99	GI048	MV2

GI048	VN.. 1604..

MV2	UPC 22	MVN 160316	UP 0909-T09P	2.0	PS 6026-T09P	2.0	FLAG T09P

C.-DVJN(RL) EXT

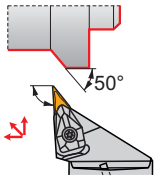
P M K N S H

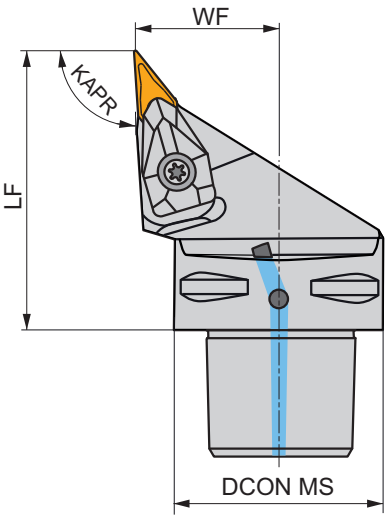
PRAMET

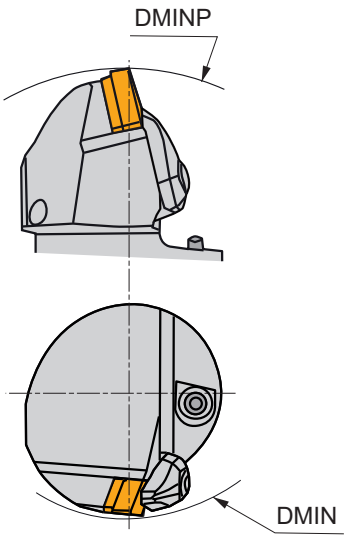
D

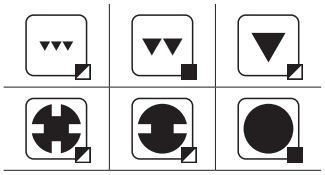
External PSC Quick Change Tool, Double Clamp, 93° Cutting Angle, VN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 93° cutting angle for longitudinal turning with shoulder, copy and taper turning and chamfering with negative VN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DVJNR-27062-16	40	60	152	27	62	93	-13	-4	✓	0.45	GI048	C-DV16-1
	C5-DVJNR-35065-16	50	65	170	35	65	93	-13	-4	✓	0.47	GI048	C-DV16-2
	C6-DVJNR-45065-16	63	81	190	45	65	93	-13	-4	✓	1.13	GI048	C-DV16-2
L	C4-DVJNL-27062-16	40	60	152	27	62	93	-13	-4	✓	0.45	GI048	C-DV16-1
	C5-DVJNL-35065-16	50	65	170	35	65	93	-13	-4	✓	0.71	GI048	C-DV16-2
	C6-DVJNL-45065-16	63	81	190	45	65	93	-13	-4	✓	1.13	GI048	C-DV16-2

GI048	VN.. 1604..

		Nm				
C-DV16-1	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5	CN 034-01
C-DV16-2	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5	CN 034-02

DVUN(RL) INT

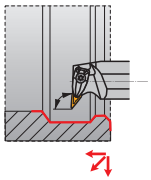
P M K N S H

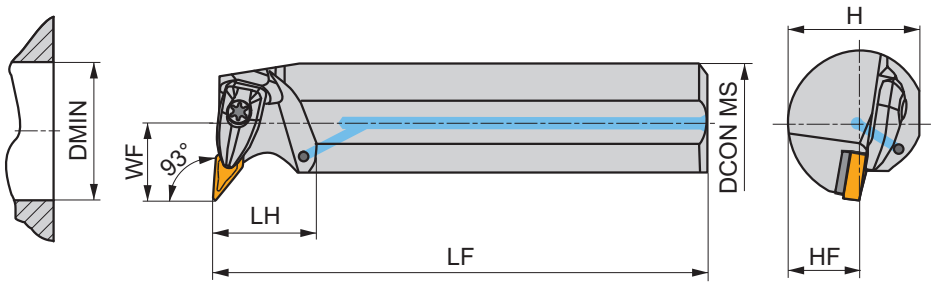
PRAMET

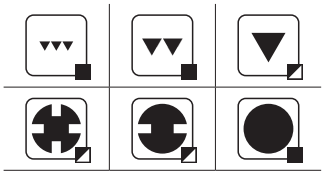
D

Internal Double Clamp Boring Bar with 93° Cutting Angle for VN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, with 93° cutting angle for VN.. inserts. Suited for internal taper, longitudinal turning with shoulder, copying and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A40T-DVUNR 16	40	50	27	37	18.5	300	36.0	-9	-6	✓	2.59	GI048	DV16
L	A40T-DVUNL 16	40	50	27	37	18.5	300	36.0	-9	-6	✓	2.58	GI048	DV16

GI048	VN.. 1604..

DV16	DCS 16V	3.0 Nm	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

DWLN(RL) EXT

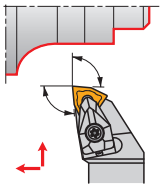
P M K N S H

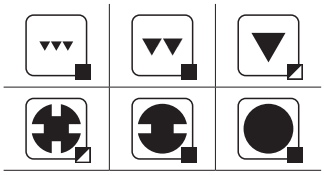
PRAMET

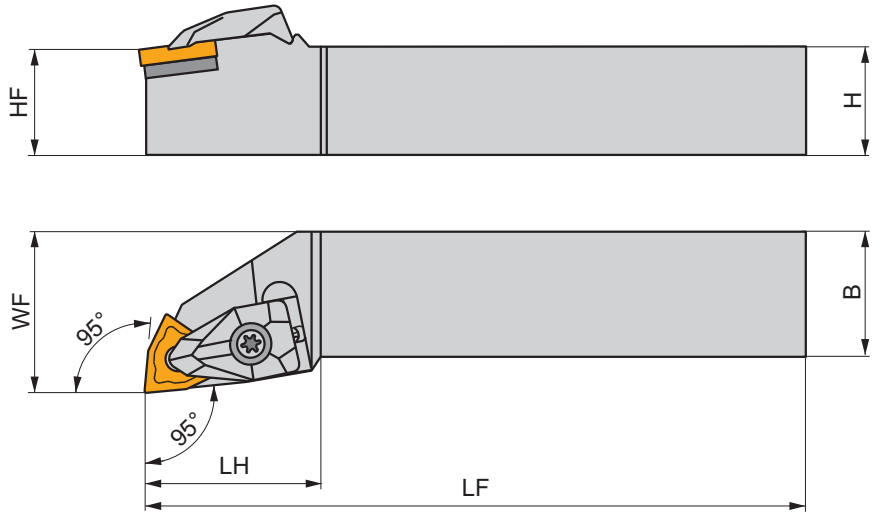
D

External Double Clamp Holder with 95° Cutting Angle for WN.. Inserts

External Right/Left hand double clamp turning holder with 95° cutting angle. Suited for longitudinal turning with shoulder, face, taper and chamfer turning with negative WN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO				
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg			
R	DWLNR 1616 H 06	16	16	16	20	100	26.4	-6	-6	0.22	GI028	DW06	–
	DWLNR 2020 K 06	20	20	20	25	125	27.1	-6	-6	0.41	GI028	DW06	–
	DWLNR 2525 M 06	25	25	25	32	150	27.1	-6	-6	0.75	GI028	DW06	–
	DWLNR 2020 K 08	20	20	20	25	125	34.3	-6	-6	0.43	GI072	DW08	AT004
	DWLNR 2525 M 08	25	25	25	32	150	35.0	-6	-6	0.75	GI072	DW08	AT004
	DWLNR 3225 P 08	32	25	32	32	170	35.0	-6	-6	1.01	GI072	DW08	AT004
	DWLNR 3225 P 10	32	25	32	32	170	38.0	-6	-6	1.06	GI166	DW10	–
	DWLNR 3232 P 13	32	32	32	40	170	40.0	-6	-6	1.40	GI167	DW13	–
	DWLNR 4040 S 13	40	40	40	50	250	41.0	-6	-6	3.19	GI167	DW13	–
L	DWLNL 1616 H 06	16	16	16	20	100	26.4	-6	-6	0.22	GI028	DW06	–
	DWLNL 2020 K 06	20	20	20	25	125	27.1	-6	-6	0.41	GI028	DW06	–
	DWLNL 2525 M 06	25	25	25	32	150	27.1	-6	-6	0.76	GI028	DW06	–
	DWLNL 2020 K 08	20	20	20	25	125	34.3	-6	-6	0.43	GI072	DW08	AT004
	DWLNL 2525 M 08	25	25	25	32	150	35.0	-6	-6	0.74	GI072	DW08	AT004
	DWLNL 3225 P 08	32	25	32	32	170	35.0	-6	-6	1.10	GI072	DW08	AT004
	DWLNL 3225 P 10	32	25	32	32	170	38.0	-6	-6	1.14	GI166	DW10	–
	DWLNL 3232 P 13	32	32	32	40	170	40.0	-6	-6	1.43	GI167	DW13	–
	DWLNL 4040 S 13	40	40	40	50	250	41.0	-6	-6	3.17	GI167	DW13	–

GI028	WN.. 0604..
GI072	WN.. 0804..
GI166	WN.. 1006..
GI167	WN.. 1306..

						
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P	–
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	–
DW10	DCS 16	6.4	DWN 100612	US 5018-T20P	–	LK T20P
DW13	DCS 19	6.4	DWN 130612	US 6013-T20P	–	LK T20P

		
AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

MWLN(RL) EXT

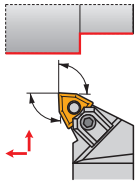
P M K N S H

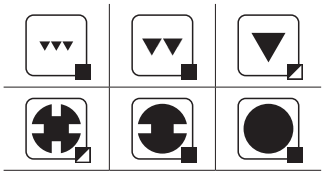
PRAMET

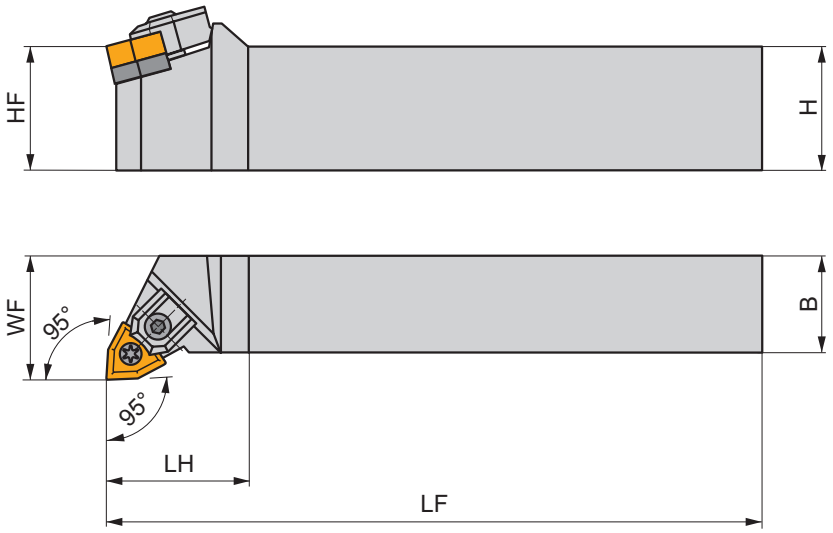
M

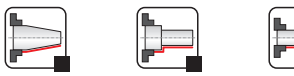
External Multi-Clamp Holder with 95° Cutting Angle for WN.. Inserts

External Right/Left hand multi-clamp turning holder with 95° cutting angle. Suited for longitudinal turning with shoulder, face, taper and chamfer turning with negative WN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	kg		
R	**MWLNR 2525 M 08**	25	25	25	32	150	34.0	-6	-6	0.73	GI072	MW02
	MWLNR 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.09	GI072	MW02
	MWLNR 4040 S 08	40	40	40	50	250	45.0	-6	-6	3.14	GI072	MW02
L	**MWLNL 2525 M 08**	25	25	25	32	150	34.0	-6	-6	0.78	GI072	MW02
	MWLNL 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.02	GI072	MW02
	MWLNL 4040 S 08	40	40	40	50	250	45.0	-6	-6	3.14	GI072	MW02

GI072	WN.. 0804..

MW02	UE 11	4.0 Nm	MWS 433	UC 61	HS 94	HXK 5

PWLN(RL) EXT

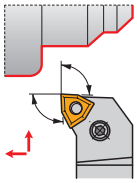
P M K N S H

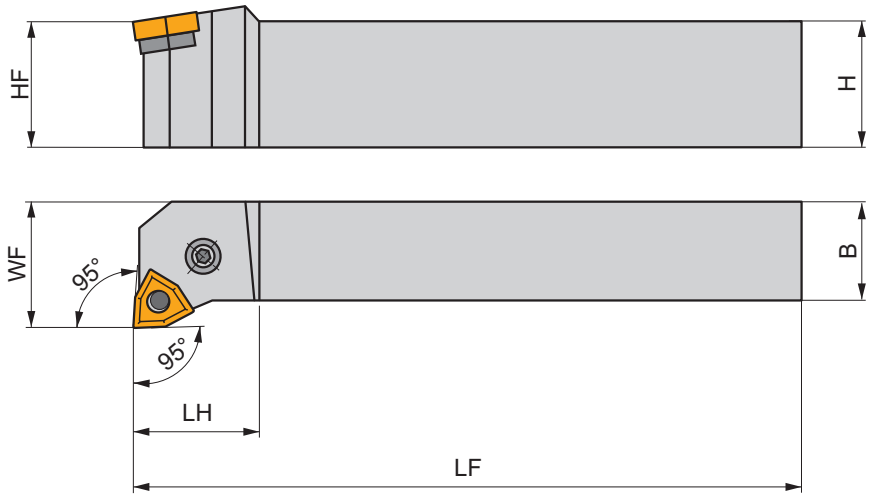
PRAMET

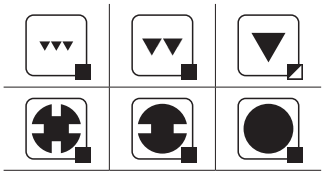
P

External Lever Lock Holder with 95° Cutting Angle for WN.. Inserts

External Right/Left hand lever lock turning holder with 95° cutting angle. Suited for longitudinal turning with shoulder, face, taper and chamfer turning with negative WN.. inserts. Body treated for longer tool life.







	Product	H	B	HF	WF	LF	LH	LAMS	GAMO			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	kg		
R	PWLNR 1616 H 0604	16	16	16	20	100	22.0	-6	-6	0.22	GI028	PW01
	PWLNR 2020 K 0604	20	20	20	25	125	22.0	-6	-6	0.40	GI028	PW01
	PWLNR 2525 M 0604	25	25	25	32	150	25.0	-6	-6	0.75	GI028	PW01
	PWLNR 2020 K 08	20	20	20	25	125	28.0	-6	-6	0.41	GI072	PW02
	PWLNR 2525 M 08	25	25	25	32	150	28.0	-6	-6	0.76	GI072	PW02
	PWLNR 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.05	GI072	PW02
L	PWLNL 1616 H 0604	16	16	16	20	100	22.0	-6	-6	0.21	GI028	PW01
	PWLNL 2020 K 0604	20	20	20	25	125	22.0	-6	-6	0.41	GI028	PW01
	PWLNL 2525 M 0604	25	25	25	32	150	25.0	-6	-6	0.75	GI028	PW01
	PWLNL 2020 K 08	20	20	20	25	125	28.0	-6	-6	0.40	GI072	PW02
	PWLNL 2525 M 08	25	25	25	32	150	28.0	-6	-6	0.74	GI072	PW02
	PWLNL 3225 P 08	32	25	32	32	170	34.0	-6	-6	1.05	GI072	PW02

GI028	WN.. 0604..
GI072	WN.. 0804..

				Nm					
PW01	PWS 007	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PW02	PWS 008	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3

C.-DWLN(RL) EXT

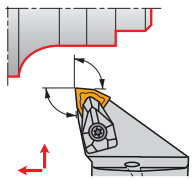
P M K N S H

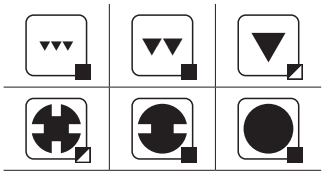
PRAMET

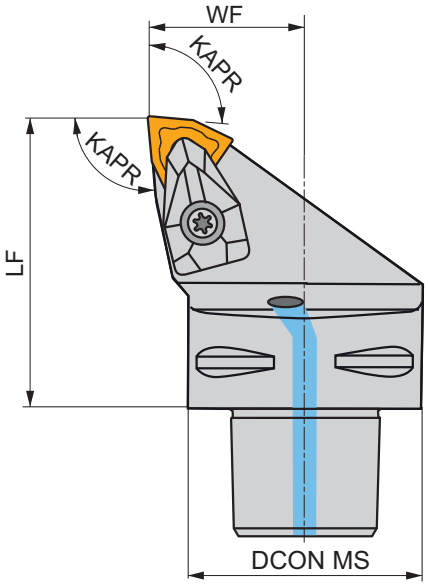
D

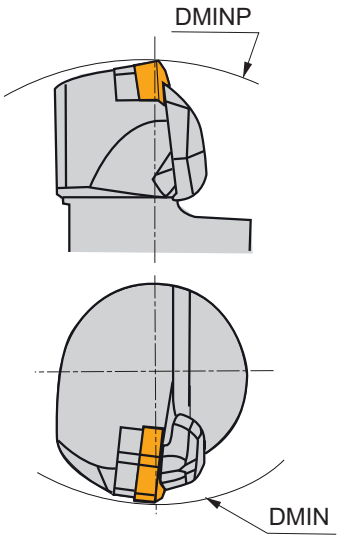
External PSC Quick Change Tool, Double Clamp, 95° Cutting Angle, WN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 95° cutting angle for face and longitudinal turning with shoulder, taper and chamfering with negative WN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg			
R	C4-DWLNR-27050-06	40	60	140	27	50	95	-6	-6	✓	0.42	GI028	C-DW06	–
	C4-DWLNR-27050-08	40	110	140	27	50	95	-6	-6	✓	0.42	GI072	C-DW08-1	AT004
	C5-DWLNR-35060-08	50	110	165	35	60	95	-6	-6	✓	0.74	GI072	C-DW08-2	AT004
	C6-DWLNR-45065-08	63	110	190	45	65	95	-6	-6	✓	1.34	GI072	C-DW08-2	AT004
L	C4-DWLNL-27050-06	40	60	140	27	50	95	-6	-6	✓	0.43	GI028	C-DW06	–
	C4-DWLNL-27050-08	40	110	140	27	50	95	-6	-6	✓	0.42	GI072	C-DW08-1	AT004
	C5-DWLNL-35060-08	50	110	165	35	60	95	-6	-6	✓	0.76	GI072	C-DW08-2	AT004
	C6-DWLNL-45065-08	63	110	190	45	65	95	-6	-6	✓	1.34	GI072	C-DW08-2	AT004

GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm				
C-DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P	CN 034-01
C-DW08-1	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DW08-2	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	CN 045-01

AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

DWLN(RL) INT

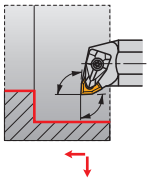
P M K N S H

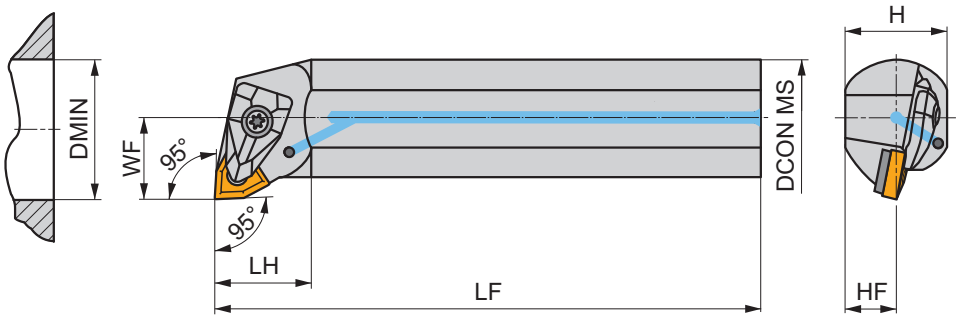
PRAMET

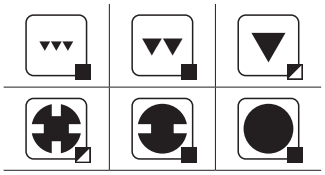
D

Internal Double Clamp Boring Bar with 95° Cutting Angle for WN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 95° cutting angle for negative WN.. inserts. For internal taper, longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg		
R	A25T-DWLNR 06	25	32	17	23	11.5	300	31.0	-14	-6	✓	0.97	GI028	DW06
	A25T-DWLNR 08	25	33	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI072	DWI08
	A32T-DWLNR 08	32	40	22	30	15	300	33.0	-10	-6	✓	1.70	GI072	DWI08
	A40T-DWLNR 08	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.59	GI072	DW08
	A50U-DWLNR 08	50	63	35	47	23.5	350	39.0	-11	-6	✓	5.24	GI072	DW08
L	A25T-DWLNL 06	25	32	17	23	11.5	300	31.0	-14	-6	✓	0.97	GI028	DW06
	A25T-DWLNL 08	25	33	17	23	11.5	300	31.0	-12	-6	✓	0.98	GI072	DWI08
	A32T-DWLNL 08	32	40	22	30	15	300	33.0	-10	-6	✓	1.70	GI072	DWI08
	A40T-DWLNL 08	40	50	27	37	18.5	300	36.0	-13	-6	✓	2.59	GI072	DW08
	A50U-DWLNL 08	50	63	35	47	23.5	350	39.0	-11	-6	✓	5.25	GI072	DW08

GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm			
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

PWLN(RL) INT

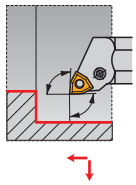
P M K N S H

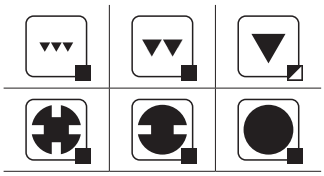
PRAMET

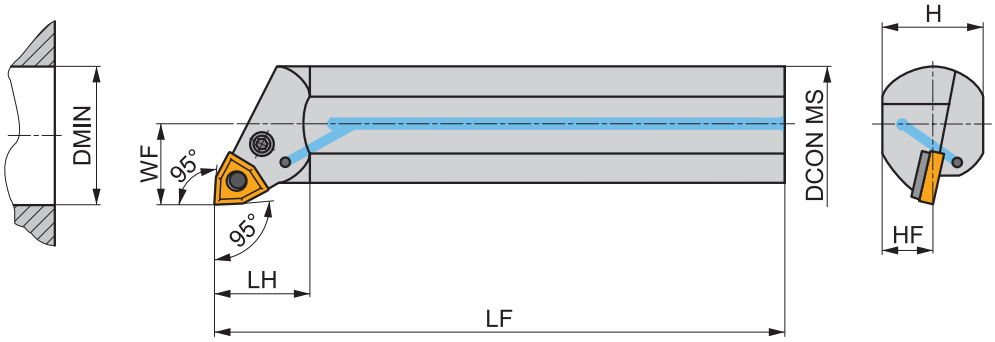
P

Internal Lever Lock Boring Bar with 95° Cutting Angle for WN.. Inserts

Internal Right/Left hand lever lock boring bar, through coolant available, 95° cutting angle for WN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		kg		
R	A16M-PWLNR 0604	16	20	11	15	–	150	-18	-4	✓	0.24	GI028	PT04
	A20Q-PWLNR 0604	20	27	13	18	–	180	-18	-4	✓	0.36	GI028	PT04
	A25R-PWLNR 0604	25	31	17	23	–	200	-14	-4	✓	0.72	GI028	PW01
	A32S-PWLNR 0604	32	39	22	30	–	250	-12	-4	✓	1.30	GI028	PW01
	A25R-PWLNR 08	25	31	17	23	–	200	-14	-4	✓	0.66	GI072	PC06
	A32S-PWLNR 08	32	39	22	30	–	250	-12	-4	✓	1.46	GI072	PW02
	A40T-PWLNR 08	40	48	27	37	–	300	-12	-4	✓	2.40	GI072	PW02
	A50U-PWLNR 08	50	61	35	47	–	350	-12	-4	✓	4.88	GI072	PW02
	A60V-PWLNR 08	60	80	43	57	–	400	-12	-4	–	8.10	GI072	PW02
L	A16M-PWLNL 0604	16	20	11	15	–	150	-18	-4	✓	0.22	GI028	PT04
	A20Q-PWLNL 0604	20	27	13	18	–	180	-18	-4	✓	0.36	GI028	PT04
	A25R-PWLNL 0604	25	31	17	23	–	200	-14	-4	✓	0.71	GI028	PW01
	A25R-PWLNL 08	25	31	17	23	–	200	-14	-4	✓	0.71	GI072	PC06
	A32S-PWLNL 08	32	39	22	30	–	250	-12	-4	✓	1.43	GI072	PW02
	A40T-PWLNL 08	40	48	27	37	–	300	-12	-4	–	2.70	GI072	PW02
	A50U-PWLNL 08	50	61	35	47	–	350	-12	-4	✓	4.88	GI072	PW02

GI028	WN.. 0604..
GI072	WN.. 0804..

				Nm					
PW01	PWS 007	CL 009	CS 606	2.0	M 6x1	16.7	TR 09	MT 04	HXK 2.5
PW02	PWS 008	CL 012	CS 608	3.0	M 8x1	20.7	TR 12	MT 05	HXK 3
PT04	–	CL 216	CS 605	1.4	M 5x1	12	–	–	HXK 2
PC06	–	CL 212	CS 626	2.0	M 6x1	13.4	–	–	HXK 2.5

C.-DWLN(RL) INT

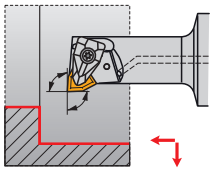
P M K N S H

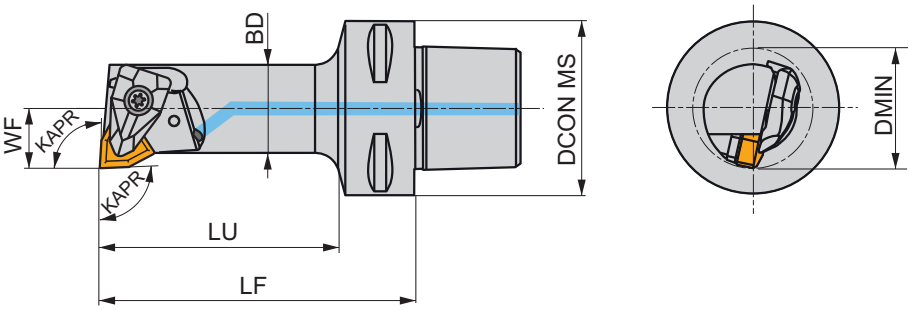
PRAMET

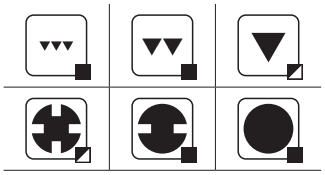
D

Internal PSC Quick Change Tool, Double Clamp, 95° Cutting Angle, WN.. Inserts

Internal Right/Left hand double clamp tool, through coolant, with 95° cutting angle for internal taper and longitudinal turning with shoulder and chamfering with WN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.





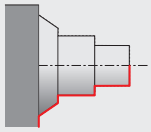


	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		kg		
R	C4-DWLNR-13075-06	40	27	13	75	52	20	95	-17	-6	✓	0.42	GI028	DW06
	C4-DWLNR-17090-08	40	33	17	90	68	25	95	-12	-6	✓	0.53	GI072	DWI08
L	C4-DWLNL-13075-06	40	27	13	75	52	20	95	-17	-6	✓	0.42	GI028	DW06
	C4-DWLNL-17090-08	40	33	17	90	68	25	95	-12	-6	✓	0.53	GI072	DWI08

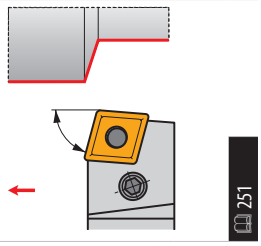
GI028	WN.. 0604..
GI072	WN.. 0804..

		Nm			
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

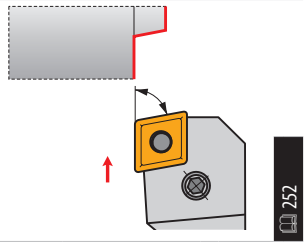
ISO TURNING – EXTERNAL
SHORT AND STABLE COMPONENTS (negative inserts)



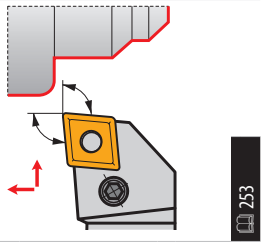
PCBN(RL) EXT 75°
CN..



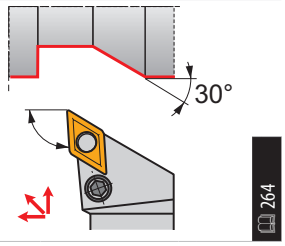
PCKN(RL) EXT 75°
CN..



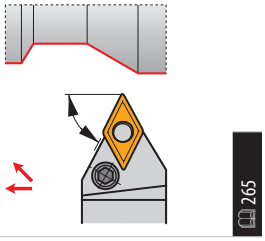
PCLN(RL) EXT 95°
CN..



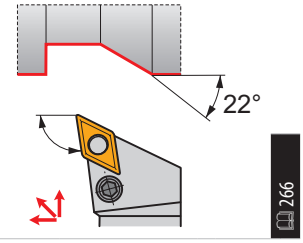
PDJN(RL) EXT 93°
DN..



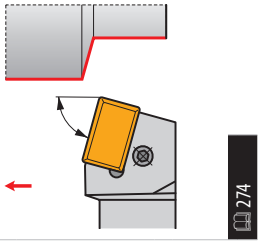
PDNN(RL) EXT 62°30´
DN..



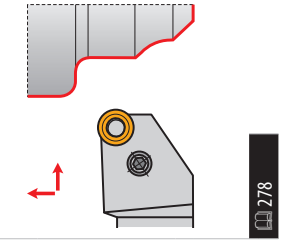
PDXN(RL) EXT 98°
DN..



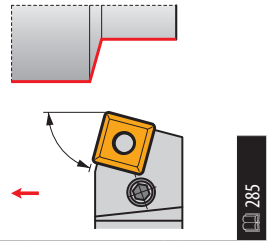
PLBN(RL) EXT 75°
LN..



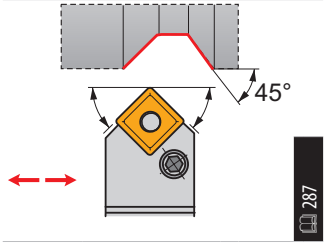
PRSN(RL) EXT
RN..



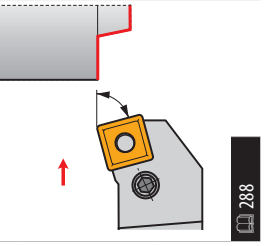
PSBN(RL) EXT 75°
SN..



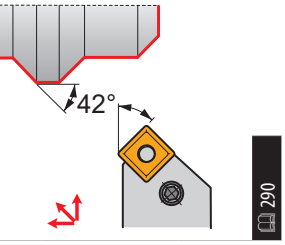
PSDNN EXT 45°
SN..



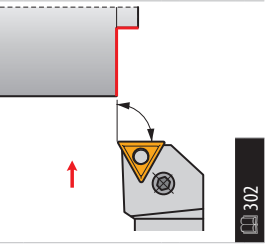
PSKN(RL) EXT 75°
SN..



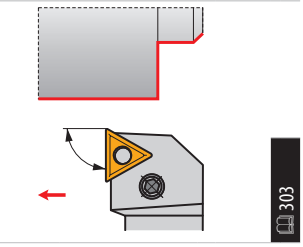
PSSN(RL) EXT 45°
SN..



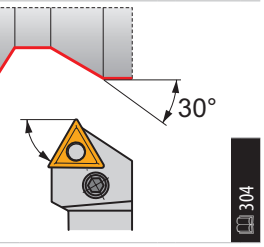
PTFN(RL) EXT 90°
TN..



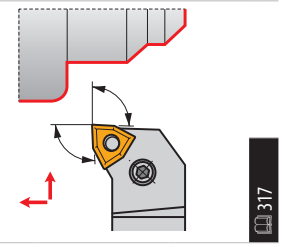
PTGN(RL) EXT 90°
TN..



PTTN(RL) EXT 60°
TN..



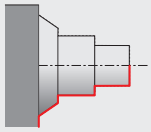
PWLN(RL) EXT 95°
WN..



D CLAMPING DESIGNATION

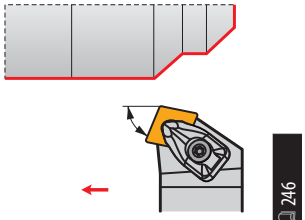
ISO TURNING – EXTERNAL

SHORT AND STABLE COMPONENTS (negative inserts)



DCBN(RL) EXT 75°

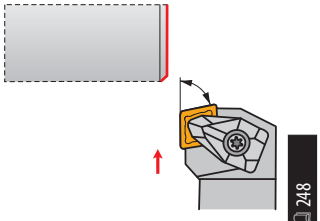
CN..



246

DCKN(RL) EXT 75°

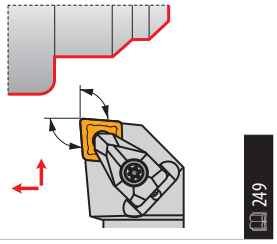
CN..



248

DCLN(RL) EXT 95°

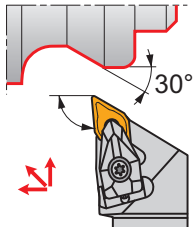
CN..



249

DDJN(RL) EXT 93°

DN..



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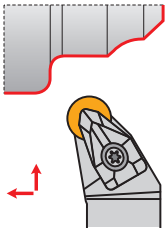
DRSN(RL) EXT

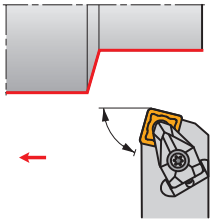
RN..



277

DSBN(RL) EXT 45°

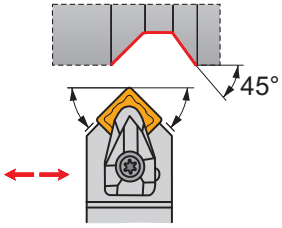
SN..



280

DSDNN EXT 45°

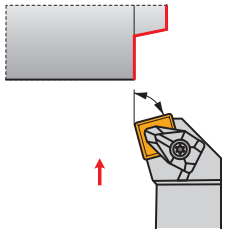
SN..



281

DSKN(RL) EXT 75°

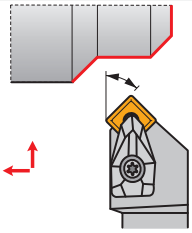
SN..



282

DSSN(RL) EXT 45°

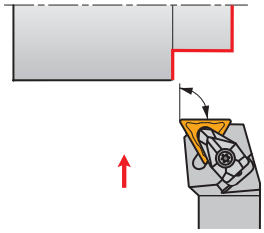
SN..



283

DTFN(RL) EXT 90°

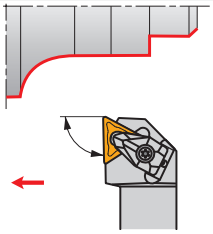
TN..



299

DTGN(RL) EXT 90°

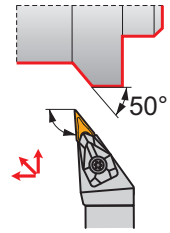
TN..



300

DVJN(RL) EXT 93°

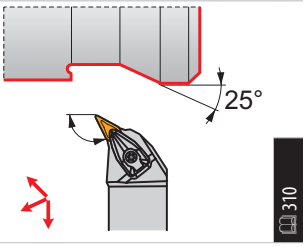
VN..



309

DVPN(RL) EXT 62°30′

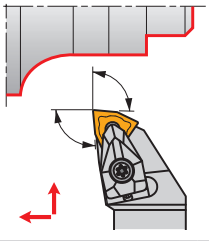
VN..



310

DWLN(RL) EXT 95°

WN..

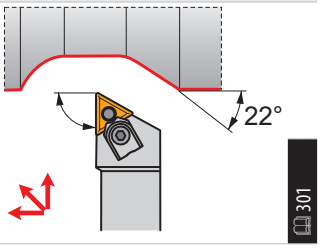


314

M CLAMPING DESIGNATION

MTJN(RL) EXT 93°

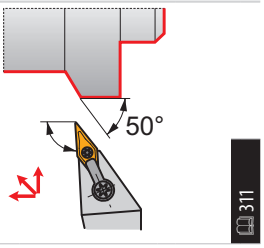
TN..



301

MVJN(RL) EXT 93°

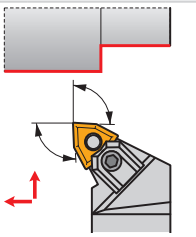
VN..



311

MWLN(RL) EXT 95°

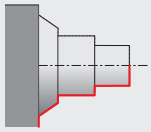
WN..



316

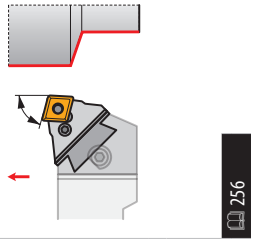
ISO TURNING – HEAVY ROUGHING – EXTERNAL

HEAD (KH)



KHP-CBNR 75°

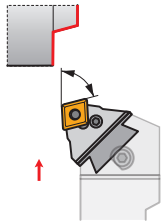
CN..



256

KHP-CBNL 75°

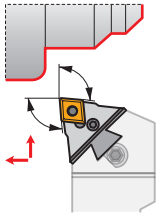
CN..



256

KHP-CLNR/L 95°

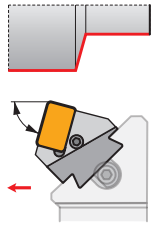
CN..



257

KHP-LBNR 75°

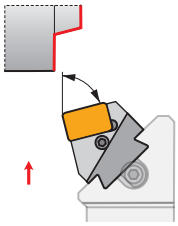
LN..



275

KHP-LBNL 75°

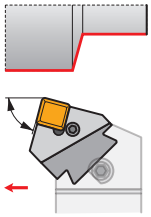
LN..



275

KHP-SBNR 75°

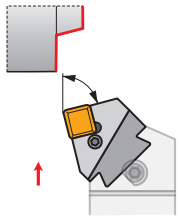
SN..



295

KHP-SBNL 75°

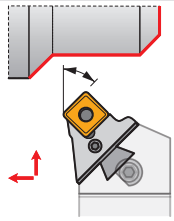
SN..



295

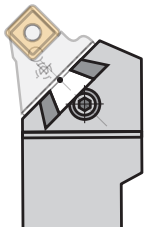
KHP-SSNR/L 45°

SN..



296

DKH(RL)



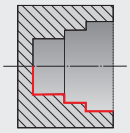
258, 276, 297

P CLAMPING DESIGNATION

TOOLS – NAVIGATOR

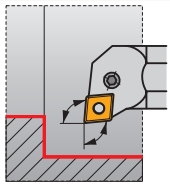
ISO TURNING – INTERNAL

SHORT AND STABLE COMPONENTS (negative inserts)



PCLN(RL) INT 95°

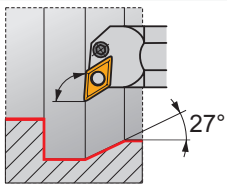
CN..



260

PDUN(RL) INT 93°

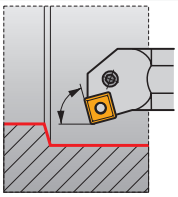
DN..



271

PSKN(RL) INT 93°

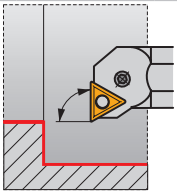
SN..



298

PTFN(RL) INT 90°

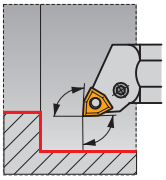
TN..



307

PWLN(RL) INT 95°

WN..



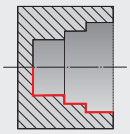
320

D CLAMPING DESIGNATION

TOOLS – NAVIGATOR

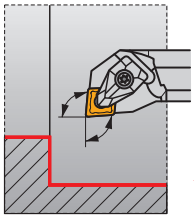
ISO TURNING – INTERNAL

SHORT AND STABLE COMPONENTS (negative inserts)



DCLN(RL) INT 95°

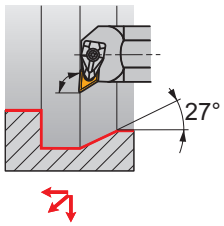
CN..



259

DDUN(RL) INT 93°

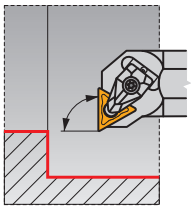
DN..



270

DTFN(RL) INT 90°

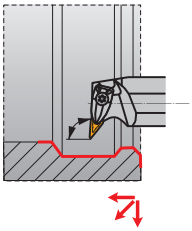
TN..



306

DVUN(RL) INT

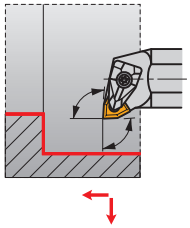
VN..



313

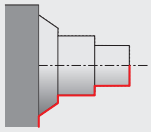
DWLN(RL) INT 95°

WN..

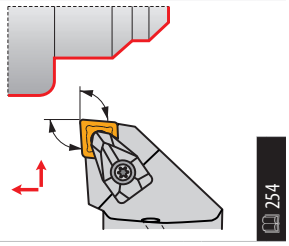


319

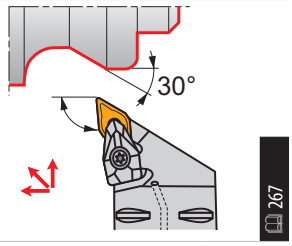
ISO TURNING – EXTERNAL PSC
SHORT AND STABLE COMPONENTS (negative inserts)



C.-DCLN(RL) EXT 95°
CN..

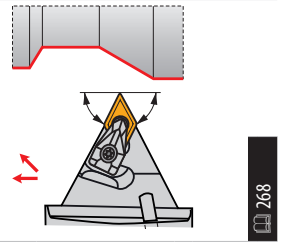

254

C.-DDJN(RL) EXT 93°
DN..

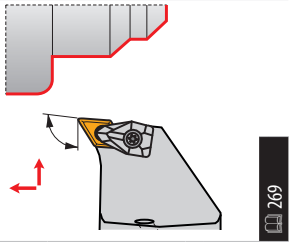


267

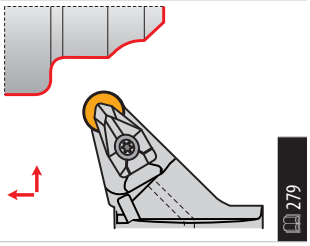
C.-DDNNN EXT 62.5°
DN..


268

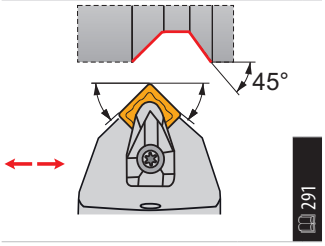
C.-DDUN(RL) EXT 93°
DN..


269

C.-DRSN(RL) EXT
RN..

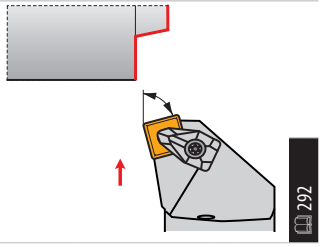

279

C.-DSDNN EXT 45°
SN..

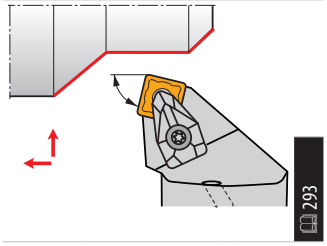


291

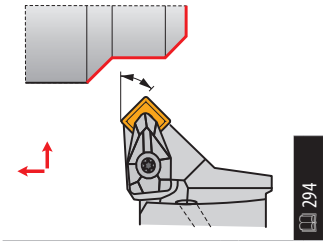
C.-DSKN(RL) EXT 75°
SN..


292

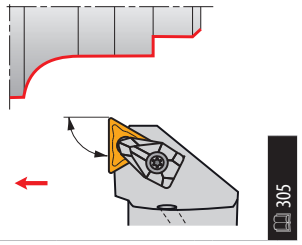
C.-DSRN(RL) EXT 75°
SN..


293

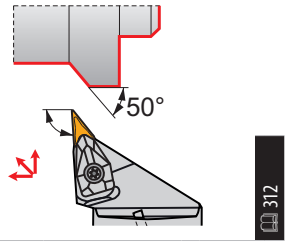
C.-DSSN(RL) EXT 45°
SN..


294

C.-DTJN(RL) EXT 93°
TN..

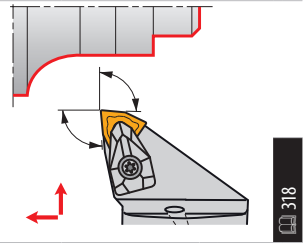

305

C.-DVJN(RL) EXT 93°
VN..

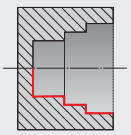


312

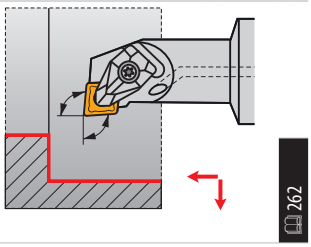
C.-DWLN(RL) EXT 95°
WN..


318

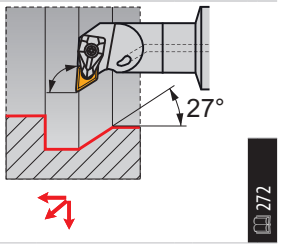
ISO TURNING – INTERNAL PSC
SHORT AND STABLE COMPONENTS (negative inserts)



C.-DCLN(RL) INT 95°
CN..

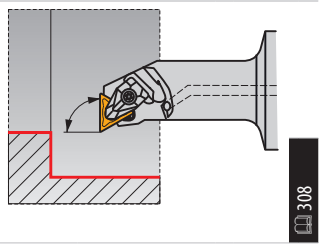

262

C.-DDUN(RL) INT 93°
DN..

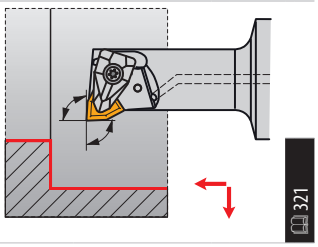


272

C.-DTFN(RL) INT 91°
TN..


308

C.-DWLN(RL) INT 95°
WN..

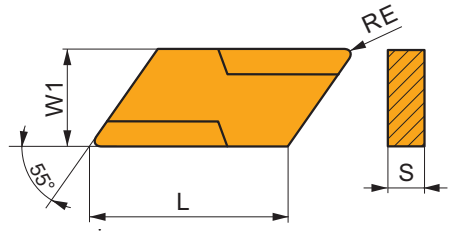

321

OTHER CARBIDE & CERMET INSERTS

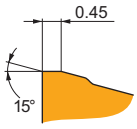
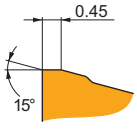
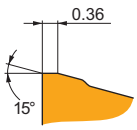
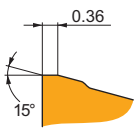
KNUX

PRAMET

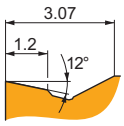
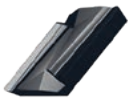
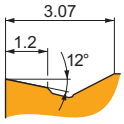
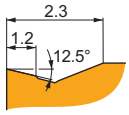
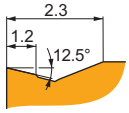
	W1	L	S
	(mm)	(mm)	(mm)
1604	9.525	19.50	4.76



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	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)
	(mm)																		
		**L-22** geometry with left-handed design for finish to semi-rough machining, and continuous cuts.																	
KNUX 160405L-22:T5315	0.5	190	0.25	2.7	–	–	–	180	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T7325	0.5	130	0.25	2.7	100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T7335	0.5	125	0.25	2.7	95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T9325	0.5	155	0.25	2.7	90	0.25	2.7	145	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405L-22:T9335	0.5	135	0.25	2.7	80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160410L-22:T9335	1.0	155	0.32	2.7	90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
		**R-22** geometry with right-handed design for finish to semi-rough machining, and continuous cuts.																	
KNUX 160405R-22:T5315	0.5	190	0.25	2.7	–	–	–	180	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T7325	0.5	130	0.25	2.7	100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T7335	0.5	125	0.25	2.7	95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T9325	0.5	155	0.25	2.7	90	0.25	2.7	145	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405R-22:T9335	0.5	135	0.25	2.7	80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160410R-22:T9335	1.0	155	0.32	2.7	90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
		**L-32** geometry with left-handed design for finish to semi-rough machining, and continuous cuts.																	
KNUX 160405L-32:T5315	0.5	190	0.25	2.7	–	–	–	180	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T7325	0.5	130	0.25	2.7	100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T7335	0.5	125	0.25	2.7	95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T9325	0.5	155	0.25	2.7	90	0.25	2.7	145	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405L-32:T9335	0.5	135	0.25	2.7	80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160410L-32:T9325	1.0	175	0.32	2.7	105	0.29	2.7	165	0.32	2.7	–	–	–	–	–	–	–	–	–
KNUX 160410L-32:T9335	1.0	155	0.32	2.7	90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–
		**R-32** geometry with right-handed design for finish to semi-rough machining, and continuous cuts.																	
KNUX 160405R-32:T5315	0.5	190	0.25	2.7	–	–	–	180	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T7325	0.5	130	0.25	2.7	100	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T7335	0.5	125	0.25	2.7	95	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T9325	0.5	155	0.25	2.7	90	0.25	2.7	145	0.25	2.7	–	–	–	–	–	–	–	–	–
KNUX 160405R-32:T9335	0.5	135	0.25	2.7	80	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–
KNUX 160410R-32:T9325	1.0	175	0.32	2.7	105	0.29	2.7	165	0.32	2.7	–	–	–	–	–	–	–	–	–
KNUX 160410R-32:T9335	1.0	155	0.32	2.7	90	0.29	2.7	–	–	–	–	–	–	–	–	–	–	–	–

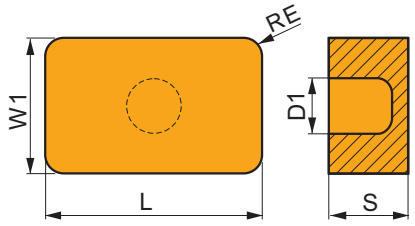
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
ER-72 geometry with right-handed design for fine to finish machining, and continuous cuts.																			
KNUX 160405ER-72:T5315	0.5	250	0.20	2.0	–	–	–	235	0.20	2.0	–	–	–	–	–	–	–	–	–
KNUX 160405ER-72:T9325	0.5	215	0.20	2.0	125	0.18	2.0	200	0.20	2.0	–	–	–	45	0.16	1.6	–	–	–
KNUX 160405ER-72:T9335	0.5	185	0.20	2.0	110	0.18	2.0	–	–	–	–	–	–	40	0.16	1.6	–	–	–
 																			
EL-72 geometry with left-handed design for fine to finish machining, and continuous cuts.																			
KNUX 160405EL-72:T5315	0.5	250	0.20	2.0	–	–	–	235	0.20	2.0	–	–	–	–	–	–	–	–	–
KNUX 160405EL-72:T9325	0.5	215	0.20	2.0	125	0.18	2.0	200	0.20	2.0	–	–	–	45	0.16	1.6	–	–	–
KNUX 160405EL-72:T9335	0.5	185	0.20	2.0	110	0.18	2.0	–	–	–	–	–	–	40	0.16	1.6	–	–	–
 																			
ER-73 geometry with right-handed design for finish to semi-rough machining, and continuous cuts.																			
KNUX 160405SR-73:6640	0.5	150	0.25	3.0	90	0.23	3.0	140	0.25	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SR-73:6640	1.0	150	0.40	3.0	90	0.36	3.0	140	0.40	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SR-73:T5315	1.0	235	0.40	3.0	–	–	–	220	0.40	3.0	–	–	–	–	–	–	–	–	–
 																			
EL-73 geometry with left-handed design for finish to semi-rough machining, and continuous cuts.																			
KNUX 160405SL-73:6640	0.5	150	0.25	3.0	90	0.23	3.0	140	0.25	3.0	–	–	–	–	–	–	–	–	–
KNUX 160410SL-73:6640	1.0	150	0.40	3.0	90	0.36	3.0	140	0.40	3.0	–	–	–	–	–	–	–	–	–

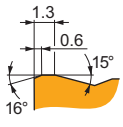
LNUX 40, LN.X 50

PRAMET

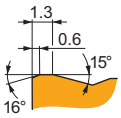
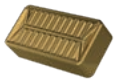
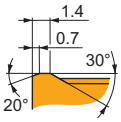
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
40-1	25.200	9.30	40.00	14.00
50-1	25.400	9.30	50.80	14.00
5014	25.400	6.35	50.80	14.00



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
LN.X for heavy rough machining and continuous to interrupted cuts.																			
LNUX 40-1129003:6630	3.2	45	1.35	25.0	–	–	–	40	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 40-1129003:T9325	3.2	55	1.35	25.0	–	–	–	50	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 40-1129003:T9335	3.2	40	1.35	25.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

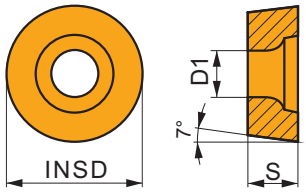
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
LN.X for heavy rough machining and continuous to interrupted cuts.																			
LNUX 50-1275000:6630	3.2	45	1.35	25.0	–	–	–	40	1.35	25.0	–	–	–	–	–	–	–	–	–
LNUX 50-1275000:T9325	3.2	55	1.35	25.0	–	–	–	50	1.35	25.0	–	–	–	–	–	–	–	–	–
 																			
LN.X design for heavy rough machining and continuous to heavy interrupted cuts.																			
LNMX 501432E:T9335	3.2	45	1.50	25.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

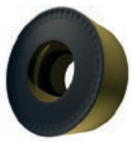
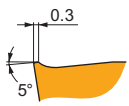
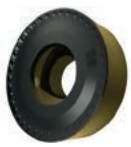
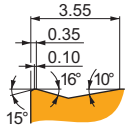
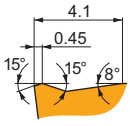
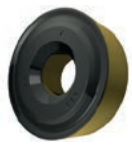
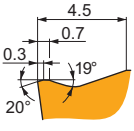
RCMT

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1606	16.000	5.50	6.35
2006	20.000	6.50	6.35
2507	25.000	8.60	7.94
3009	30.000	10.00	9.53

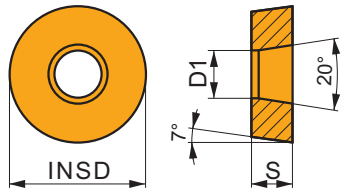


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

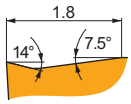
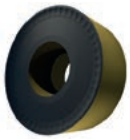
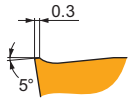
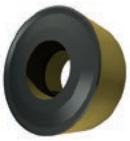
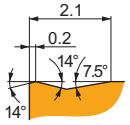
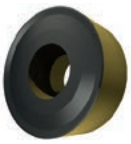
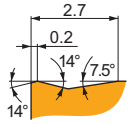
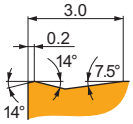
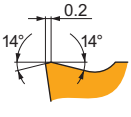
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
37 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																			
RCMT 1606MOS-37:T9325	–	145	0.60	3.0	–	–	–	135	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMT 1606MOS-37:T9415	–	200	0.60	3.0	–	–	–	190	0.60	3.0	–	–	–	–	–	–	–	–	–
 																			
371 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																			
RCMT 2006MOS-371:T9325	–	125	0.80	3.0	–	–	–	115	0.80	3.0	–	–	–	–	–	–	–	–	–
RCMT 2006MOS-371:T9415	–	185	0.80	3.0	–	–	–	175	0.80	3.0	–	–	–	–	–	–	–	–	–
 																			
372 for semi-rough to heavy-rough machining, continuous to interrupted cuts.																			
RCMT 2507MOS-372:T9325	–	90	0.80	3.0	–	–	–	85	0.80	3.0	–	–	–	–	–	–	–	–	–
 																			
RR4 geometry for heavy rough machining, and continuous to heavy interrupted cuts.																			
RCMT 3009MO-RR4:T9310	–	90	1.10	4.0	–	–	–	85	1.10	4.0	–	–	–	–	–	–	–	–	–
RCMT 3009MO-RR4:T9315	–	85	1.10	4.0	–	–	–	80	1.10	4.0	–	–	–	–	–	–	–	–	–
RCMT 3009MO-RR4:T9415	–	95	1.10	4.0	–	–	–	90	1.10	4.0	–	–	–	–	–	–	–	–	–

RCMX

	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.60	3.18
1204	12.000	4.20	4.76
1606	16.000	5.20	6.35
2006	20.000	6.50	6.35
2507	25.000	7.20	7.94
3209	32.000	9.50	9.53



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
RCMX 1003MOS-31:T9325	–	165	0.50	2.0	95	0.45	2.0	155	0.50	2.0	–	–	–	–	–	–	–	–	–
 																			
RCMX 1606MOS-37:T9325	–	145	0.60	3.0	–	–	–	135	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-37:T9415	–	200	0.60	3.0	–	–	–	190	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 2006MOS-37:6630	–	135	0.60	3.0	–	–	–	125	0.60	3.0	–	–	–	–	–	–	–	–	–
RCMX 2507MOS-37:6630	–	90	0.60	3.0	–	–	–	85	0.60	3.0	–	–	–	–	–	–	–	–	–
 																			
RCMX 1204MOS-321:T9325	–	120	1.00	3.0	–	–	–	110	1.00	3.0	–	–	–	–	–	–	–	–	–
RCMX 1204MOS-321:T9415	–	170	1.00	3.0	–	–	–	160	1.00	3.0	–	–	–	–	–	–	–	–	–
 																			
RCMX 1606MOS-331:6630	–	100	1.20	3.5	–	–	–	95	1.20	3.5	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9325	–	105	1.20	3.5	–	–	–	95	1.20	3.5	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9335	–	110	0.80	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 1606MOS-331:T9415	–	155	1.20	3.5	–	–	–	145	1.20	3.5	–	–	–	–	–	–	–	–	–
 																			
RCMX 2006MOS-341:6630	–	105	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006MOS-341:6640	–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
 																			
RCMX 2507MOS-351:6630	–	70	1.00	3.5	–	–	–	65	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507MOS-351:6640	–	60	1.00	3.5	–	–	–	55	1.00	3.5	–	–	–	–	–	–	–	–	–

31 for finish to semi-rough machining, and continuous to interrupted cuts.

37 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

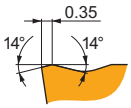
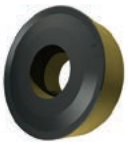
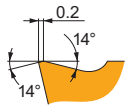
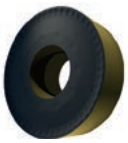
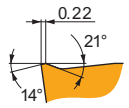
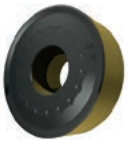
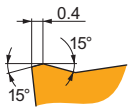
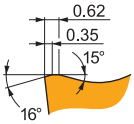
321 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

331 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

341 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

351 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

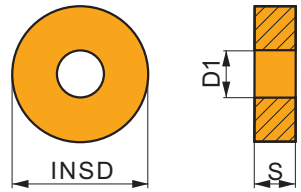
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
361 for rough to heavy-rough machining and continuous to heavy interrupted cuts.																				
RCMX 3209M0S-361:6640	✱	–	50	1.40	4.5	–	–	–	45	1.40	4.5	–	–	–	–	–	–	–	–	–
																				
RF1 geometry for finish to semi-rough machining, and continuous to interrupted cuts.																				
RCMX 2006M0-RF1:T5305	●	–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9310	●	–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9315	●	–	100	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9325	✱	–	90	0.80	3.5	–	–	–	85	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9335	–	–	110	0.80	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RF1:T9415	●	–	105	0.80	3.5	–	–	–	95	0.80	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T8345	✱	–	45	1.00	3.5	–	–	–	40	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9310	●	–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9325	✱	–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9335	✱	–	65	1.00	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RF1:T9415	●	–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
																				
RM1 geometry for finish to rough machining, and continuous to interrupted cuts.																				
RCMX 2006M0-RM1:T9310	●	–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9315	●	–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9325	✱	–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9335	✱	–	125	0.60	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2006M0-RM1:T9415	●	–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9310	●	–	95	1.00	3.5	–	–	–	90	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9315	●	–	90	1.00	3.5	–	–	–	85	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9325	✱	–	80	1.00	3.5	–	–	–	75	1.00	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9335	✱	–	80	0.60	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM1:T9415	●	–	100	1.00	3.5	–	–	–	95	1.00	3.5	–	–	–	–	–	–	–	–	–
																				
RM2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.																				
RCMX 2507M0-RM2:T9310	●	–	90	1.10	3.5	–	–	–	85	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM2:T9325	✱	–	75	1.10	3.5	–	–	–	70	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 2507M0-RM2:T9415	●	–	95	1.10	3.5	–	–	–	90	1.10	3.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T5315	●	–	95	1.00	4.5	–	–	–	90	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9310	●	–	90	1.00	4.5	–	–	–	85	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9315	●	–	85	1.00	4.5	–	–	–	80	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9325	✱	–	75	1.00	4.5	–	–	–	70	1.00	4.5	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9335	✱	–	55	1.40	4.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RCMX 3209M0-RM2:T9415	●	–	95	1.00	4.5	–	–	–	90	1.00	4.5	–	–	–	–	–	–	–	–	–
																				
RR2 geometry for heavy rough machining, and continuous to interrupted cuts.																				
RCMX 3209M0-RR2:T9315	✱	–	60	1.40	4.5	–	–	–	55	1.40	4.5	–	–	–	–	–	–	10	0.70	2.0
RCMX 3209M0-RR2:T9415	✱	–	70	1.40	4.5	–	–	–	65	1.40	4.5	–	–	–	–	–	–	10	0.70	2.0

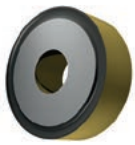
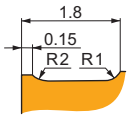
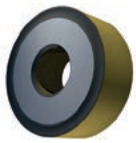
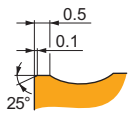
RNMG

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1204	12.700	5.16	4.76
1506	15.875	6.35	6.35
1906	19.050	7.94	6.35
2509	25.400	9.12	9.53



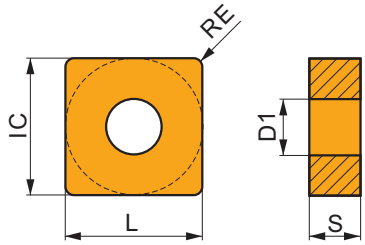
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
08 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																			
RNMG 120400E-08:T5305	–	195	0.70	3.0	–	–	–	185	0.70	3.0	–	–	–	–	–	–	35	0.35	0.8
RNMG 120400E-08:T9325	–	135	0.70	3.0	–	–	–	125	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 120400E-08:T9415	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	0.8
RNMG 150600E-08:T5305	–	195	0.70	3.0	–	–	–	185	0.70	3.0	–	–	–	–	–	–	35	0.35	1.0
RNMG 150600E-08:T9325	–	205	0.70	3.0	–	–	–	190	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 150600E-08:T9415	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	1.0
RNMG 190600E-08:T9325	–	135	0.70	3.0	–	–	–	125	0.70	3.0	–	–	–	–	–	–	–	–	–
RNMG 190600E-08:T9415	–	190	0.70	3.0	–	–	–	180	0.70	3.0	–	–	–	–	–	–	35	0.35	1.3
 																			
081 for rough to heavy-rough machining, and continuous to interrupted cuts.																			
RNMG 250900E-081:T9325	–	130	0.90	5.0	–	–	–	120	0.90	5.0	–	–	–	–	–	–	–	–	–
RNMG 250900E-081:T9415	–	100	0.90	5.0	–	–	–	95	0.90	5.0	–	–	–	–	–	–	20	0.45	1.7

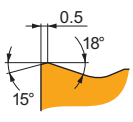
SNMM

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53

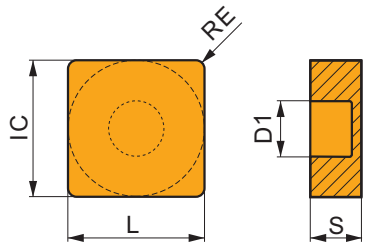


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

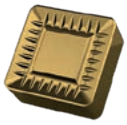
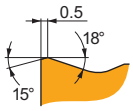
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
SR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																				
SNMM 250724S-SR:T9325		2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR:6630		2.4	65	1.00	14.0	35	0.90	14.0	60	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR:T9335		2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–

SNMX

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
2512	25.400	9.17	25.40	12.00

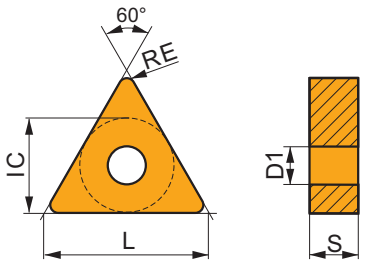


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

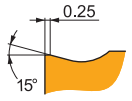
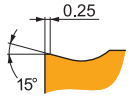
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
SR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																			
SNMX 251224S-SR:6630	2.4	65	1.00	14.0	35	0.90	14.0	60	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T8345	2.4	45	1.00	14.0	25	0.90	14.0	40	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T9325	2.4	80	1.00	14.0	45	0.90	14.0	75	1.00	14.0	–	–	–	–	–	–	–	–	–
SNMX 251224S-SR:T9335	2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–

TNMM

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
2204	12.700	5.16	22.00	4.76



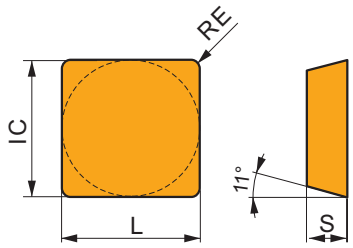
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
ER geometry with right-handed design for medium to semi-rough machining, and continuous cuts.																			
TNMM 220412ER:T9335	1.2	190	0.35	2.1	110	0.32	2.1	–	–	–	–	–	–	40	0.25	1.7	–	–	–
																			
EL geometry with left handed design for medium to semi-rough machining, and continuous cuts.																			
TNMM 220412EL:T9335	1.2	190	0.35	2.1	110	0.32	2.1	–	–	–	–	–	–	40	0.25	1.7	–	–	–

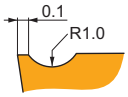
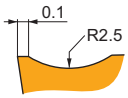
SPMR

PRAMET

	IC (mm)	L (mm)	S (mm)
0903	9.525	9.53	3.18
1203	12.700	12.70	3.18



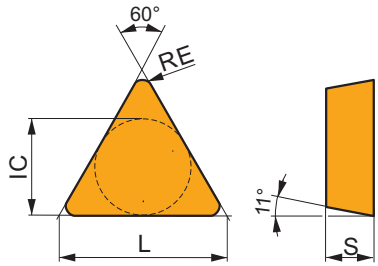
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
46 for fine to finish machining, and continuous to interrupted cuts.																				
SPMR 090304E-46:T9325	●	0.4	215	0.15	1.0	125	0.15	1.0	200	0.15	1.0	–	–	–	–	–	–	–	–	–
SPMR 090308E-46:T9325	●	0.8	255	0.15	1.0	150	0.15	1.0	240	0.15	1.0	–	–	–	–	–	–	–	–	–
																				
48 for finish to semi-rough machining, and continuous to interrupted cuts.																				
SPMR 120304E-48:T9325	●	0.4	170	0.22	2.2	100	0.22	2.2	160	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120304E-48:T9335	●	0.4	145	0.22	2.2	85	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:6640	●	0.8	160	0.22	2.2	95	0.22	2.2	150	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:T9325	●	0.8	205	0.22	2.2	120	0.22	2.2	190	0.22	2.2	–	–	–	–	–	–	–	–	–
SPMR 120308E-48:T9335	●	0.8	175	0.22	2.2	105	0.22	2.2	–	–	–	–	–	–	–	–	–	–	–	–
SPMR 120312E-48:T9325	●	1.2	215	0.22	2.2	125	0.22	2.2	200	0.22	2.2	–	–	–	–	–	–	–	–	–

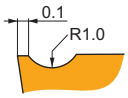
TPMR

PRAMET

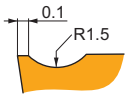
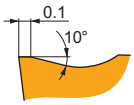
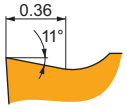
	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
46 for fine to finish machining, and continuous to interrupted cuts.																				
TPMR 110304E-46:6640	●	0.4	140	0.15	1.0	80	0.14	1.0	130	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110304E-46:T9325	●	0.4	175	0.15	1.0	105	0.15	1.0	165	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110304E-46:T9335	●	0.4	150	0.15	1.0	90	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:6640	●	0.8	170	0.15	1.0	100	0.14	1.0	160	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:T9325	●	0.8	205	0.15	1.0	120	0.15	1.0	190	0.15	1.0	–	–	–	–	–	–	–	–	–
TPMR 110308E-46:T9335	●	0.8	180	0.15	1.0	105	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–

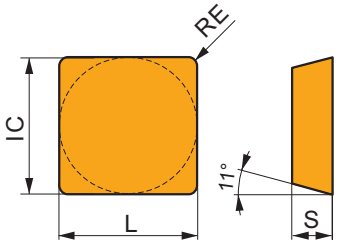
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			**47** for finish to semi-rough machining, and continuous to interrupted cuts.																	
TPMR 160304E-47:6640	●	0.4	120	0.20	1.5	70	0.18	1.5	110	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160304E-47:T9325	●	0.4	150	0.20	1.5	90	0.18	1.5	140	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160304E-47:T9335	●	0.4	125	0.20	1.5	75	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:6640	●	0.8	140	0.20	1.5	80	0.18	1.5	130	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:T9325	●	0.8	175	0.20	1.5	105	0.18	1.5	165	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160308E-47:T9335	●	0.8	150	0.20	1.5	90	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160312E-47:T9325	●	1.2	185	0.20	1.5	110	0.18	1.5	175	0.20	1.5	–	–	–	–	–	–	–	–	–
TPMR 160312E-47:T9335	●	1.2	160	0.20	1.5	95	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
			**61** for finish machining with moderate feeds and depths of cut, and continuous to interrupted cuts.																	
TPMR 160308E-61:T9325	●	0.8	135	0.35	1.8	80	0.32	1.8	125	0.35	1.8	–	–	–	–	–	–	–	–	–
TPMR 160308E-61:T9335	●	0.8	120	0.35	1.8	70	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–
			**PF2** geometry for fine to finish machining, and continuous cuts.																	
TPMR 110304-PF2:TT010	●	0.4	255	0.10	0.5	150	0.10	0.5	–	–	–	–	–	–	–	–	–	–	–	–
TPMR 160304-PF2:TT010	●	0.4	255	0.10	0.5	150	0.10	0.5	–	–	–	–	–	–	–	–	–	–	–	–

SPUN-IT

PRAMET

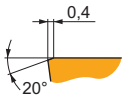
	IC	L	M	S
	(mm)	(mm)	(mm)	(mm)
1203	12.700	12.70	2.3	3.18
1504	15.875	15.88	2.8	4.76
1904	19.050	19.05	3.5	4.76
2506	25.400	25.40	4.4	6.35



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	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			**SPUN** for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
SPUN 120308:6640	◆	0.8	180	0.15	4.0	–	–	–	170	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 120312:6640	◆	1.2	190	0.15	4.0	–	–	–	180	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 150408:6640	◆	0.8	155	0.20	5.0	–	–	–	145	0.20	5.0	–	–	–	–	–	–	–	–	–

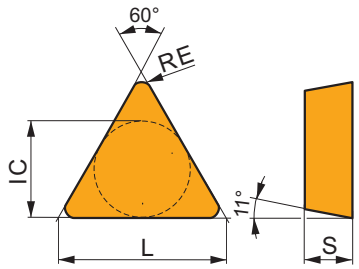
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
SPUN for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																			
SPUN 150412:6640	1.2	165	0.20	5.0	–	–	–	155	0.20	5.0	–	–	–	–	–	–	–	–	–
SPUN 190408:6640	0.8	150	0.20	6.0	–	–	–	140	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190412:6640	1.2	160	0.20	6.0	–	–	–	150	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190416:6640	1.6	165	0.20	6.0	–	–	–	155	0.20	6.0	–	–	–	–	–	–	–	–	–
  																			
SPUN..S for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																			
SPUN 250620S:6640	2.0	80	0.40	12.0	–	–	–	75	0.40	12.0	–	–	–	–	–	–	–	–	–

TPUN-IT

PRAMET

	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76
2706	15.875	27.50	6.35
3306	19.050	33.00	6.35



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

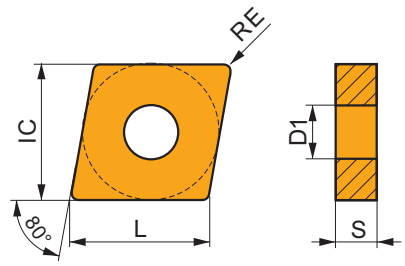
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  																			
TPUN for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																			
TPUN 110304:6640	0.4	135	0.10	1.2	–	–	–	125	0.10	1.2	–	–	–	–	–	–	–	–	–
TPUN 110308:6640	0.8	125	0.18	1.2	–	–	–	115	0.18	1.2	–	–	–	–	–	–	–	–	–
TPUN 160304:6640	0.4	135	0.10	1.5	–	–	–	125	0.10	1.5	–	–	–	–	–	–	–	–	–
TPUN 160308:6640	0.8	125	0.18	1.5	–	–	–	115	0.18	1.5	–	–	–	–	–	–	–	–	–
TPUN 160312:6640	1.2	125	0.20	1.5	–	–	–	115	0.20	1.5	–	–	–	–	–	–	–	–	–
TPUN 220408:6640	0.8	120	0.18	2.0	–	–	–	110	0.18	2.0	–	–	–	–	–	–	–	–	–
TPUN 220412:6640	1.2	120	0.20	2.0	–	–	–	110	0.20	2.0	–	–	–	–	–	–	–	–	–
  																			
SPUN..S for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																			
TPUN 270616S:6640	1.6	65	0.30	5.0	–	–	–	60	0.30	5.0	–	–	–	–	–	–	–	–	–
TPUN 330620S:6640	2.0	65	0.30	5.0	–	–	–	60	0.30	5.0	–	–	–	–	–	–	–	–	–

ADVANCED MATERIALS INSERTS

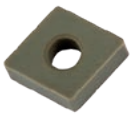
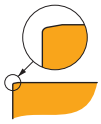
CNGA CER

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.90	4.76



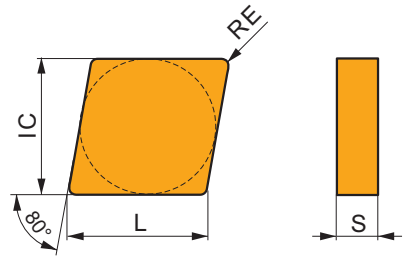
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC		T	**CER** for machining with high speeds and continuous cuts.															
CNGA 120404 T02020:TC100	●	0.4	–	–	–	–	–	–	■ 590	0.10	2.0	–	–	–	–	–	–	–	–	–
CNGA 120408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGA 120412 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 540	0.25	2.0	–	–	–	–	–	–	–	–	–

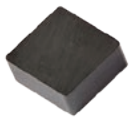
CNGN CER

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
1204	12.700	12.90	4.76
1207	12.700	12.90	7.94



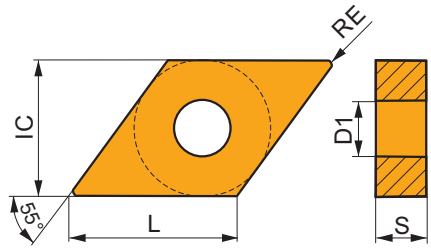
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC		T	**CER** for machining with high speeds and continuous cuts.															
CNGN 120408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGN 120708 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 550	0.20	2.0	–	–	–	–	–	–	–	–	–
CNGN 120712 T01020:TC100	●	1.2	–	–	–	–	–	–	■ 540	0.25	2.0	–	–	–	–	–	–	–	–	–

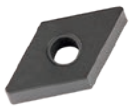
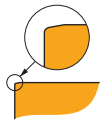
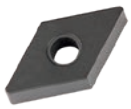
DNGA CER

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1504	12.700	5.16	15.50	4.76



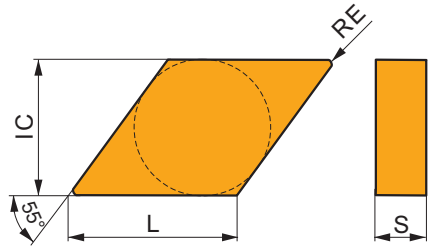
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC S																	
CER for machining with high speeds and continuous cuts.																				
DNGA 150408 S02020:TC100	●	0.8	–	–	–	–	–	–	■	450	0.20	1.5	–	–	–	–	–	–	–	–	–
			HSC T																	
CER for machining with high speeds and continuous cuts.																				
DNGA 150404 T01020:TC100	●	0.4	–	–	–	–	–	–	■	475	0.10	1.5	–	–	–	–	–	–	–	–	–
DNGA 150408 T00520:TC100	●	0.8	–	–	–	–	–	–	■	450	0.20	1.5	–	–	–	–	–	–	–	–	–

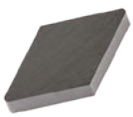
DNGN CER

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
1504	12.700	15.50	4.76



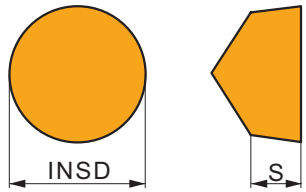
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC T																	
CER for machining with high speeds and continuous cuts.																				
DNGN 150408 T01020:TC100	●	0.8	–	–	–	–	–	–	■	450	0.20	1.5	–	–	–	–	–	–	–	–	–

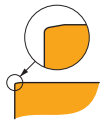
RCGX CER

PRAMET

	INSD (mm)	S (mm)
0606	6.350	6.35
0907	9.525	7.94
1207	12.700	7.94



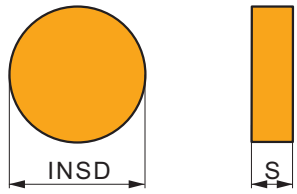
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  HSC K																			
CER for machining with high speeds and continuous cuts.																			
RCGX 060600 K15015:TC100	–	–	–	–	–	–	–	365	0.30	0.8	–	–	–	–	–	–	–	–	–
RCGX 090700 K15015:TC100	–	–	–	–	–	–	–	410	0.20	1.2	–	–	–	–	–	–	–	–	–
RCGX 120700 K15015:TC100	–	–	–	–	–	–	–	405	0.20	1.5	–	–	–	–	–	–	–	–	–

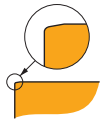
RNGN CER

PRAMET

	INSD (mm)	S (mm)
0903	9.525	3.18
1204	12.700	4.76
1207	12.700	7.94



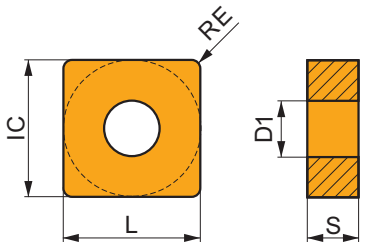
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  HSC T																			
CER for machining with high speeds and continuous cuts.																			
RNGN 090300 T01020:TC100	–	–	–	–	–	–	–	460	0.20	1.2	–	–	–	–	–	–	–	–	–
RNGN 120400 T01020:TC100	–	–	–	–	–	–	–	455	0.20	1.5	–	–	–	–	–	–	–	–	–
RNGN 120700 T01020:TC100	–	–	–	–	–	–	–	455	0.20	1.5	–	–	–	–	–	–	–	–	–
RNGN 120700 T15015:TC100	–	–	–	–	–	–	–	455	0.20	1.5	–	–	–	–	–	–	–	–	–

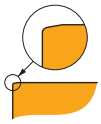
SNGA CER

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



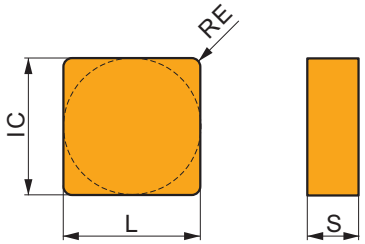
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  HSC T **CER** for machining with high speeds and continuous cuts.																			
SNGA 120408 T01025:TC100	0.8	–	–	–	–	–	–	575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGA 120412 T01020:TC100	1.2	–	–	–	–	–	–	565	0.25	2.0	–	–	–	–	–	–	–	–	–

SNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
0903	9.525	9.53	3.18
1204	12.700	12.70	4.76
1207	12.700	12.70	7.94

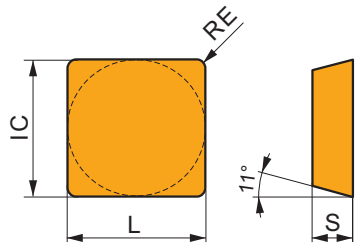


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

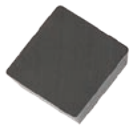
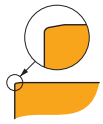
Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  HSC T **CER** for machining with high speeds and continuous cuts.																			
SNGN 090308 T01020:TC100	0.8	–	–	–	–	–	–	580	0.20	1.8	–	–	–	–	–	–	–	–	–
SNGN 090312 T01020:TC100	1.2	–	–	–	–	–	–	565	0.25	1.8	–	–	–	–	–	–	–	–	–
SNGN 120404 T01020:TC100	0.4	–	–	–	–	–	–	620	0.10	2.0	–	–	–	–	–	–	–	–	–
SNGN 120408 T01020:TC100	0.8	–	–	–	–	–	–	575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGN 120708 T01020:TC100	0.8	–	–	–	–	–	–	575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGN 120712 T01020:TC100	1.2	–	–	–	–	–	–	565	0.25	2.0	–	–	–	–	–	–	–	–	–

SPGN CER

	IC	L	S
	(mm)	(mm)	(mm)
1203	12.700	12.70	3.18



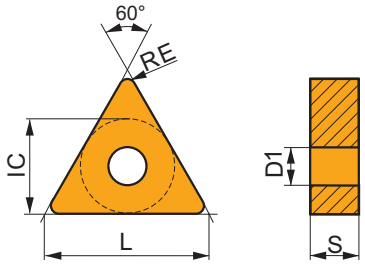
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
SPGN 120308 T01020:TC100	●	0.8	–	–	–	–	–	–	■	530	0.20	1.5	–	–	–	–	–	–	–	–	–

CER for machining with high speeds and continuous cuts.

TNGA CER

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.50	4.76



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

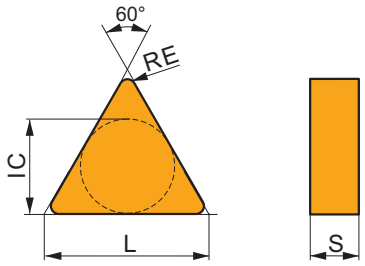
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
TNGA 160408 T01020:TC100	●	0.8	–	–	–	–	–	–	■	475	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGA 160412 T01020:TC100	●	1.2	–	–	–	–	–	–	■	500	0.20	1.5	–	–	–	–	–	–	–	–	–

CER for machining with high speeds and continuous cuts.

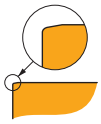
TNGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1604	9.525	16.50	4.76
1607	9.525	16.50	7.94



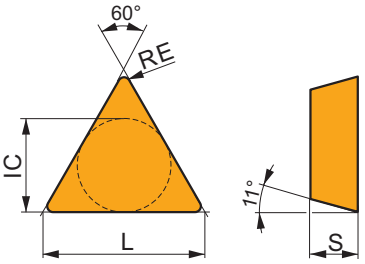
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  HSC T **CER** for machining with high speeds and continuous cuts.																			
TNGN 160408 T01020:TC100	0.8	–	–	–	–	–	–	475	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGN 160412 T01020:TC100	1.2	–	–	–	–	–	–	500	0.20	1.5	–	–	–	–	–	–	–	–	–
TNGN 160708 T02020:TC100	0.8	–	–	–	–	–	–	475	0.20	1.5	–	–	–	–	–	–	–	–	–

TPGN CER

PRAMET

	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



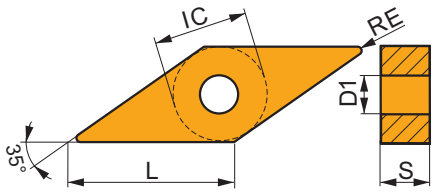
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  HSC T **CER** for machining with high speeds and continuous cuts.																			
TPGN 110304 T01020:TC100	0.4	–	–	–	–	–	–	460	0.10	1.5	–	–	–	–	–	–	–	–	–
TPGN 110308 T01020:TC100	0.8	–	–	–	–	–	–	425	0.20	1.5	–	–	–	–	–	–	–	–	–
TPGN 160304 T01020:TC100	0.4	–	–	–	–	–	–	460	0.10	1.5	–	–	–	–	–	–	–	–	–
TPGN 160308 T01020:TC100	0.8	–	–	–	–	–	–	425	0.20	1.5	–	–	–	–	–	–	–	–	–
TPGN 160312 T01020:TC100	1.2	–	–	–	–	–	–	450	0.20	1.5	–	–	–	–	–	–	–	–	–

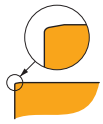
VNGA CER

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.60	4.76



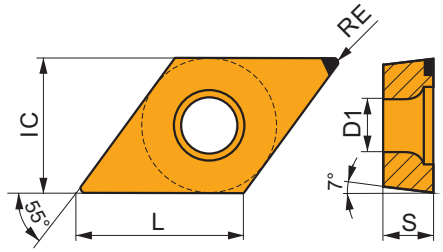
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC		T	**CER** for machining with high speeds and continuous cuts.															
VNGA 160404 T01020:TC100	●	0.4	–	–	–	–	–	–	■ 425	0.10	1.0	–	–	–	–	–	–	–	–	–
VNGA 160408 T01020:TC100	●	0.8	–	–	–	–	–	–	■ 395	0.20	1.0	–	–	–	–	–	–	–	–	–

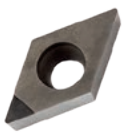
DCMW PCD

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	9.525	4.40	11.60	3.97



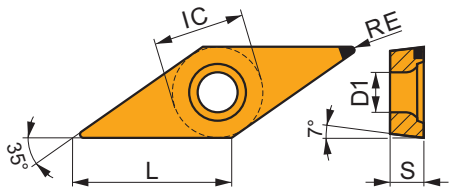
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC		F	**PCD** for finish machining, high speeds and stable cutting conditions.															
DCMW 11T304FN:PD1	●	0.4	–	–	–	–	–	–	–	–	–	■ 1035	0.12	0.5	–	–	–	–	–	–
DCMW 11T308FN:PD1	●	0.8	–	–	–	–	–	–	–	–	–	■ 1200	0.12	1.0	–	–	–	–	–	–

VCMW PCD

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.40	16.60	4.76



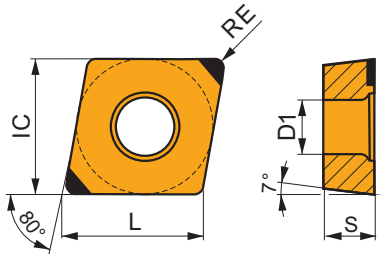
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC F																	
PCD tipped for finish to semi-rough machining, high speeds and stable cutting conditions.																				
VCMW 160404FN:PD1	●	0.4	–	–	–	–	–	–	–	–	–	■ 900	0.12	0.5	–	–	–	–	–	–
VCMW 160408FN:PD1	●	0.8	–	–	–	–	–	–	–	–	–	■ 1050	0.12	1.0	–	–	–	–	–	–

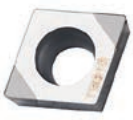
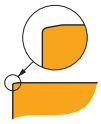
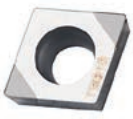
CCGW CBN

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.50	2.38
09T3	9.525	4.50	9.70	3.97



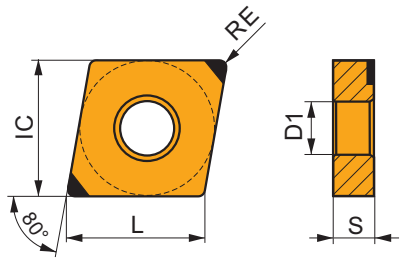
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			HSC E																	
CBN for finish machining.																				
CCGW 060204E-B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
CCGW 09T304E-B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
			HSC S																	
CBN for finish machining.																				
CCGW 060204S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3
CCGW 09T304S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 460	0.10	0.4	–	–	–	◪ 120	0.07	0.3	■ 95	0.07	0.3

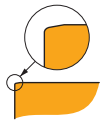
CNGA CBN

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.90	4.76



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

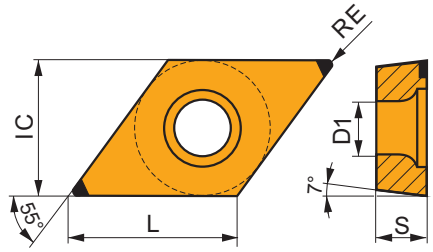
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
CNGA 120404S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 510	0.10	0.4	–	–	–	◪ 135	0.07	0.3	■ 105	0.07	0.3
CNGA 120408S01020B:TB310	●	0.8	–	–	–	–	–	–	◪ 530	0.15	0.6	–	–	–	◪ 140	0.11	0.5	■ 110	0.08	0.7

CBN for finish machining and continuous cuts.

DCGW CBN

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	9.525	4.50	11.60	3.97



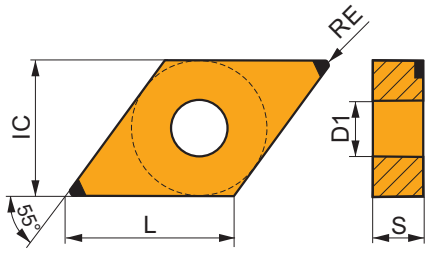
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
DCGW 11T304S01020B:TB310	●	0.4	–	–	–	–	–	–	◪ 370	0.10	0.4	–	–	–	◪ 95	0.07	0.3	■ 75	0.07	0.3
DCGW 11T308S01020B:TB310	●	0.8	–	–	–	–	–	–	◪ 380	0.15	0.6	–	–	–	◪ 100	0.11	0.5	■ 80	0.08	0.7

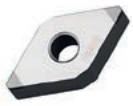
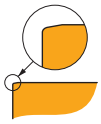
CBN for finish machining.

DNGA CBN

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35

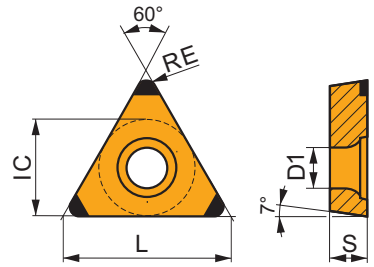


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  HSC S																			
CBN for finish machining and continuous cuts.																			
DNGA 150608S01020B:TB310	0.8	–	–	–	–	–	–	420	0.15	0.6	–	–	–	110	0.11	0.5	85	0.08	0.7

TCGW CBN

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.90	11.00	2.38



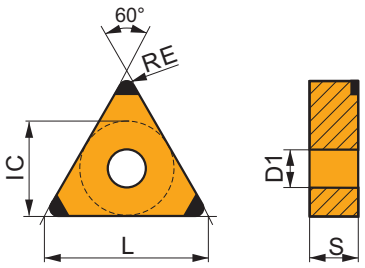
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
  HSC E																			
CBN for finish machining, and continuous cuts.																			
TCGW 110204E-C:TB310	0.4	–	–	–	–	–	–	390	0.10	0.4	–	–	–	100	0.07	0.3	80	0.07	0.3
  HSC S																			
CBN for finish machining, and continuous cuts.																			
TCGW 110204S01020C:TB310	0.4	–	–	–	–	–	–	390	0.10	0.4	–	–	–	100	0.07	0.3	80	0.07	0.3
TCGW 110208S01020C:TB310	0.8	–	–	–	–	–	–	400	0.15	0.6	–	–	–	105	0.11	0.5	85	0.08	0.7

TNGA CBN

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.50	4.76



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

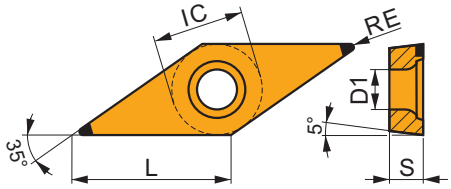
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
TNGA 160408S01020C:TB310	●	0.8	–	–	–	–	–	–	450	0.15	0.6	–	–	–	115	0.11	0.5	95	0.08	0.7

CBN for finish machining and continuous cuts.

VBGW CBN

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.50	16.00	4.76



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

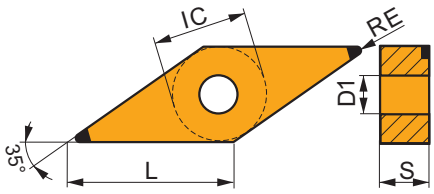
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
VBGW 160404S01020B:TB310	●	0.4	–	–	–	–	–	–	340	0.10	0.4	–	–	–	90	0.07	0.3	70	0.07	0.3
VBGW 160408S01020B:TB310	●	0.8	–	–	–	–	–	–	350	0.15	0.6	–	–	–	90	0.11	0.5	70	0.08	0.7

CBN for finish machining and continuous cuts.

VNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.00	4.76



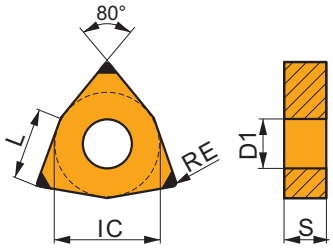
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			 **CBN** for finish machining and continuous cuts.																	
VNGA 160404S01020B:TB310	●	0.4	–	–	–	–	–	–	360	0.10	0.4	–	–	–	95	0.07	0.3	75	0.07	0.3
VNGA 160408S01020B:TB310	●	0.8	–	–	–	–	–	–	370	0.15	0.6	–	–	–	95	0.11	0.5	75	0.08	0.7

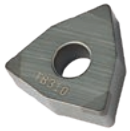
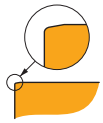
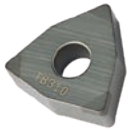
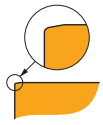
WNGA CBN

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			 **CBN** for finish machining and continuous cuts.																	
WNGA 080408S01020C:TB310	●	0.8	–	–	–	–	–	–	530	0.15	0.6	–	–	–	140	0.11	0.5	110	0.08	0.7
			 **CBN** for finish machining and continuous cuts.																	
WNGA080408S01020WC:TB310	–	0.8	–	–	–	–	–	–	530	0.15	0.6	–	–	–	140	0.11	0.5	110	0.08	0.7

PARTING-OFF & GROOVING

INSERT SEAT	GL1	GL2	GL3	GL4	GL5	GL6	
NEW **GLAF(RL)EXT** 20×20 / 25×25		CDX 20 mm	CDX 20 – 40 mm	CDX 20 – 32 mm	CDX 24 – 32 mm	CDX 24 – 32 mm	
NEW **GLAF(RL)EXT-S** 12×12 / 16×16		CDX 12 – 16 mm	CDX 12 – 16 mm	CDX 16 mm			
GLSF(RL)EXT 20×20 / 25×25	CDX 16 mm NEW	CDX 20 – 24 mm	CDX 20 – 32 mm	CDX 20 – 32 mm	CDX 20 – 32 mm	CDX 20 – 32 mm	
GLSF(RL)EXT-S 12×12 / 16×16	CDX 12 – 16 mm NEW	CDX 12 – 16 mm	CDX 12 – 16 mm	CDX 16 mm			
GLSF(RL)EXT-G 20×20 / 32×32 NEW		CDX 10 mm	CDX 10 – 20 mm	CDX 12 – 24 mm	CDX 12 – 32 mm	CDX 12 – 32 mm	
Cutting width (mm) CW	1.5	2	3 (2.5)	4	5	6	8
NEW **Deep parting-off** (single sided insert)			SINGLE SIDED INSERT PM 1 PR	SINGLE SIDED INSERT PM 1 PR			
Parting-off (tube / full bar)	NEW PM	PM 1 PR	CW = 2.5 / 3 PM 1 PR	PM 1 PR	PM 1 PR	PM 1 PR	
Grooving (deep / shallow)		PR GM	PR GM	PR GM	PR GM	GM	NEW GM
Turning (longitudinal)		GM	GM	GM	GM	GM	NEW GM
Profiling (multiaxial)		MM	MM	MM	MM	MM	

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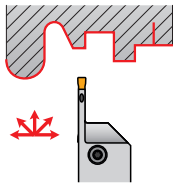
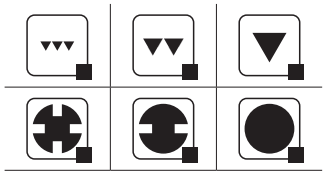
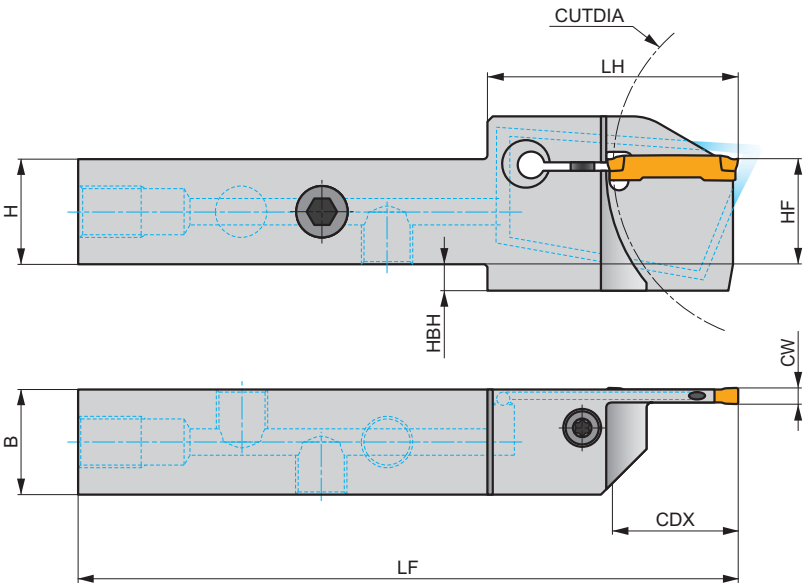
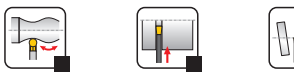
Grooving and Parting-Off tool with internal coolant for GL Inserts

External Right/Left handed tool holder with internal coolant for GL inserts. Suited for radial grooving, parting-off, turning and profiling applications. Reinforced body design for longer tool life and low vibrations. Body treated for longer tool life.









	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
R	GL2-A2020KFR-20-80	20	5	20	20	125	43.5	2.00	20	80	✓	0.33	GI334	GL11	CC01
	GL2-A2525MFR-20-80	25	–	25	25	150	43.5	2.00	20	80	✓	0.65	GI334	GL11	CC01
	GL3-A2020KFR-20-80	20	5	20	20	125	43.5	3.00	20	80	✓	0.33	GI335	GL11	CC01
	GL3-A2020KFR-24-80	20	5	20	20	125	47.5	3.00	24	80	✓	0.32	GI335	GL11	CC01
	GL3-A2525MFR-20-80	25	–	25	25	150	43.5	3.00	20	80	✓	0.66	GI335	GL11	CC01
	GL3-A2525PFR-32-80	25	5	25	25	170	55.5	3.00	32	80	✓	0.73	GI335	GL11	CC01
	GL3-A2525PFR-40-100	25	7	25	25	170	63.5	3.00	40	100	✓	0.70	GI335	GL11	CC01
	GL4-A2020KFR-20-80	20	5	20	20	125	43.6	4.00	20	80	✓	0.38	GI336	GL11	CC01
	GL4-A2020KFR-24-80	20	5	20	20	125	47.6	4.00	24	80	✓	0.37	GI336	GL11	CC01
	GL4-A2525MFR-20-80	25	–	25	25	150	43.6	4.00	20	80	✓	0.58	GI336	GL11	CC01
	GL4-A2525PFR-32-80	25	5	25	25	170	55.6	4.00	32	80	✓	0.67	GI336	GL11	CC01
	GL5-A2020KFR-24-80	20	5	20	20	125	47.6	5.00	24	80	✓	0.32	GI337	GL11	CC01
	GL5-A2525PFR-32-100	25	5	25	25	170	55.6	5.00	32	100	✓	0.67	GI337	GL11	CC01
	GL6-A2020KFR-24-80	20	5	20	20	125	47.6	6.00	24	80	✓	0.37	GI338	GL11	CC01
	GL6-A2525PFR-32-100	25	5	25	25	170	55.6	6.00	32	100	✓	0.68	GI338	GL11	CC01
L	GL2-A2020KFL-20-80	20	5	20	20	125	43.5	2.00	20	80	✓	0.33	GI334	GL11	CC01
	GL2-A2525MFL-20-80	25	–	25	25	150	43.5	2.00	20	80	✓	0.66	GI334	GL11	CC01
	GL3-A2020KFL-20-80	20	5	20	20	125	43.5	3.00	20	80	✓	0.33	GI335	GL11	CC01
	GL3-A2020KFL-24-80	20	5	20	20	125	47.5	3.00	24	80	✓	0.36	GI335	GL11	CC01
	GL3-A2525MFL-20-80	25	–	25	25	150	43.5	3.00	20	80	✓	0.65	GI335	GL11	CC01
	GL3-A2525PFL-32-80	25	5	25	25	170	55.5	3.00	32	80	✓	0.67	GI335	GL11	CC01
	GL3-A2525PFL-40-100	25	7	25	25	170	63.5	3.00	40	100	✓	0.70	GI335	GL11	CC01
	GL4-A2020KFL-20-80	20	5	20	20	125	43.6	4.00	20	80	✓	0.33	GI336	GL11	CC01
	GL4-A2020KFL-24-80	20	5	20	20	125	47.6	4.00	24	80	✓	0.37	GI336	GL11	CC01
	GL4-A2525MFL-20-80	25	–	25	25	150	43.6	4.00	20	80	✓	0.65	GI336	GL11	CC01
	GL4-A2525PFL-32-80	25	5	25	25	170	55.6	4.00	32	80	✓	0.73	GI336	GL11	CC01
	GL5-A2020KFL-24-80	20	5	20	20	125	47.6	5.00	24	80	✓	0.32	GI337	GL11	CC01

	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
L	**GL5-A2525PFL-32-100**	25	5	25	25	170	55.6	5.00	32	100	✓	0.67	GI337	GL11	CC01
	GL6-A2020KFL-24-80	20	5	20	20	125	47.6	6.00	24	80	✓	0.33	GI338	GL11	CC01
	GL6-A2525PFL-32-100	25	5	25	25	170	55.6	6.00	32	100	✓	0.68	GI338	GL11	CC01

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

Cutting depths on machined diameter on page 364.

GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

CC01	CHP-P1/8	G1/8"	HXK 4

Coolant accessories can be found on page 366.

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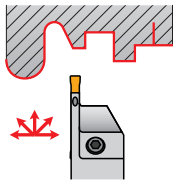
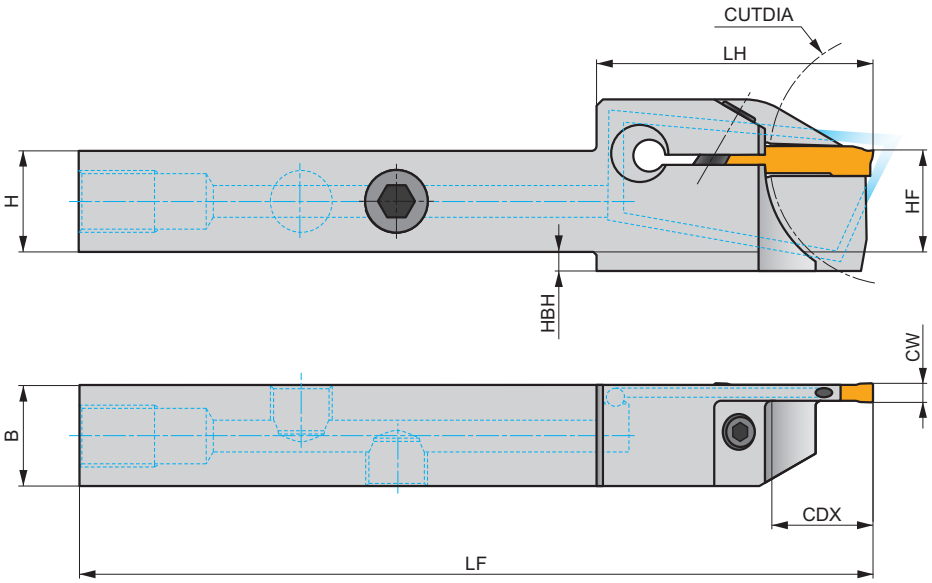
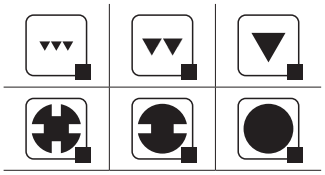
Grooving tool with internal coolant for GL Inserts, for Sliding head machines

External Right/Left handed tool holder with internal coolant for GL inserts, designed for sliding head machines and easy access to insert clamping. Suited for radial grooving, parting-off, turning and profiling applications. Body treated for longer tool life.







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		kg			
R	GL2-A1212HFR-12-40	12	3	12	12	100	33.0	2.00	12	40	✓	0.12	GI334	GL13	CC02
	GL2-A1616KFR-16-45	16	3	16	16	125	43.5	2.00	16	45	✓	0.21	GI334	GL12	CC01
	GL3-A1212HFR-12-40	12	3	12	12	100	33.0	3.00	12	40	✓	0.12	GI335	GL13	CC02
	GL3-A1616KFR-16-45	16	3	16	16	125	43.5	3.00	16	45	✓	0.21	GI335	GL12	CC01
	GL4-A1616KFR-16-45	16	4	16	16	125	43.6	4.00	16	45	✓	0.21	GI336	GL12	CC01
L	GL2-A1212HFL-12-40	12	3	12	12	100	33.0	2.00	12	40	✓	0.11	GI334	GL13	CC02
	GL2-A1616KFL-16-45	16	3	16	16	125	43.5	2.00	16	45	✓	0.27	GI334	GL12	CC01
	GL3-A1212HFL-12-40	12	3	12	12	100	33.0	3.00	12	40	✓	0.12	GI335	GL13	CC02
	GL3-A1616KFL-16-45	16	3	16	16	125	43.5	3.00	16	45	✓	0.25	GI335	GL12	CC01
	GL4-A1616KFL-16-45	16	4	16	16	125	43.6	4.00	16	45	✓	0.21	GI336	GL12	CC01

GI334	GL2..
GI335	GL3..
GI336	GL4..

Cutting depths on machined diameter on page 364.

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

CC01	CHP-P1/8	–	G1/8"	HXK 4	–	–
CC02	–	CHP-P6	M6	HXK 3	CHP-G06	CHP-R1/8-6

Coolant accessories can be found on page 366.

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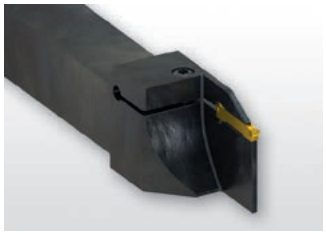
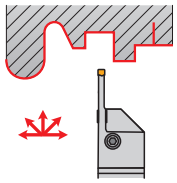
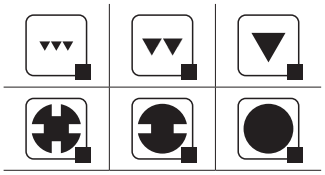
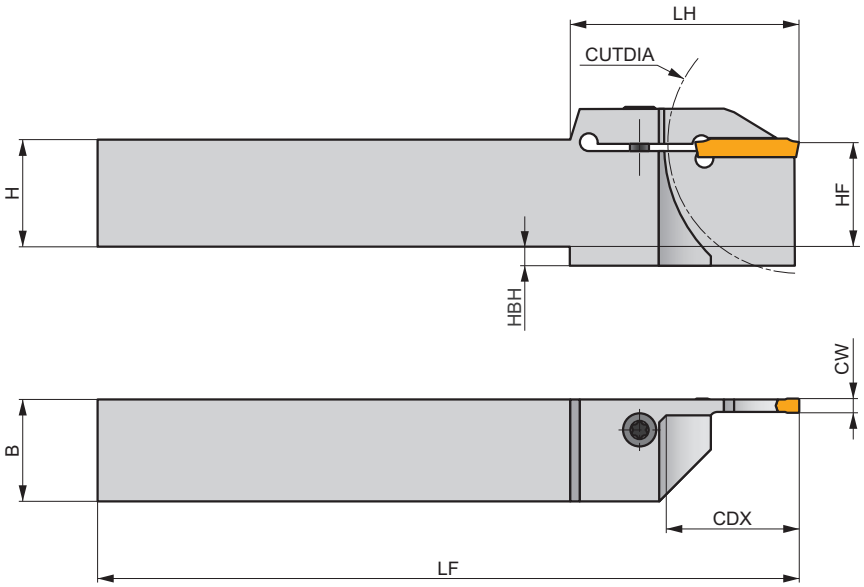


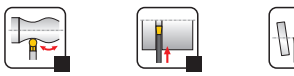
Grooving and Parting-Off tool for GL Inserts

External Right/Left handed tool holder for GL inserts. Suited for radial grooving, parting-off, turning and profiling applications. Reinforced body design for longer tool life and low vibrations. Body treated for longer tool life.









	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL1-S2020KFR-16-60	20	–	20	20	125	34.2	1.50	16	60	0.35	GI333	GL11
	GL2-S2020KFR-20-80	20	–	20	20	125	43.5	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFR-24-80	20	5	20	20	125	48.5	2.00	24	80	0.38	GI334	GL11
	GL2-S2525MFR-20-80	25	–	25	25	150	43.5	2.00	20	80	0.70	GI334	GL11
	GL2-S2525MFR-24-80	25	–	25	25	150	47.5	2.00	24	80	0.68	GI334	GL11
	GL3-S2020KFR-20-80	20	–	20	20	125	43.5	3.00	20	80	0.38	GI335	GL11
	GL3-S2020KFR-24-80	20	5	20	20	125	47.5	3.00	24	80	0.36	GI335	GL11
	GL3-S2525MFR-20-80	25	–	25	25	150	43.5	3.00	20	80	0.70	GI335	GL11
	GL3-S2525MFR-24-80	25	–	25	25	150	47.5	3.00	24	80	0.65	GI335	GL11
	GL3-S2525PFR-32-80	25	5	25	25	170	55.5	3.00	32	80	0.78	GI335	GL11
	GL4-S2020KFR-20-80	20	–	20	20	125	43.5	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFR-24-80	20	5	20	20	125	47.5	4.00	24	80	0.37	GI336	GL11
	GL4-S2525MFR-20-80	25	–	25	25	150	43.5	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFR-24-80	25	–	25	25	150	47.5	4.00	24	80	0.69	GI336	GL11
	GL4-S2525PFR-32-80	25	5	25	25	170	55.5	4.00	32	80	0.78	GI336	GL11
	GL5-S2020KFR-20-80	20	–	20	20	125	43.5	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFR-20-80	25	–	25	25	150	43.5	5.00	20	80	0.68	GI337	GL11
	GL5-S2525PFR-32-100	25	5	25	25	170	55.5	5.00	32	100	0.78	GI337	GL11
	GL6-S2020KFR-20-80	20	–	20	20	125	43.5	6.00	20	80	0.39	GI338-1	GL11
	GL6-S2525MFR-20-80	25	–	25	25	150	43.5	6.00	20	80	0.68	GI338-1	GL11
	GL6-S2525PFR-32-100	25	5	25	25	170	55.5	6.00	32	100	0.75	GI338	GL11
L	GL1-S2020KFL-16-60	20	–	20	20	125	34.2	1.50	16	60	0.35	GI333	GL11
	GL2-S2020KFL-20-80	20	–	20	20	125	43.5	2.00	20	80	0.38	GI334	GL11
	GL2-S2020KFL-24-80	20	5	20	20	125	47.5	2.00	24	80	0.39	GI334	GL11
	GL2-S2525MFL-20-80	25	–	25	25	150	43.5	2.00	20	80	0.70	GI334	GL11
	GL2-S2525MFL-24-80	25	–	25	25	150	47.5	2.00	24	80	0.64	GI334	GL11
	GL3-S2020KFL-20-80	20	–	20	20	125	43.5	3.00	20	80	0.38	GI335	GL11

	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
L	**GL3-S2020KFL-24-80**	20	5	20	20	125	47.5	3.00	24	80	0.39	GI335	GL11
	GL3-S2525MFL-20-80	25	–	25	25	150	43.5	3.00	20	80	0.68	GI335	GL11
	GL3-S2525MFL-24-80	25	–	25	25	150	47.5	3.00	24	80	0.68	GI335	GL11
	GL3-S2525PFL-32-80	25	5	25	25	170	55.5	3.00	32	80	0.78	GI335	GL11
	GL4-S2020KFL-20-80	20	–	20	20	125	43.5	4.00	20	80	0.38	GI336	GL11
	GL4-S2020KFL-24-80	20	5	20	20	125	47.5	4.00	24	80	0.39	GI336	GL11
	GL4-S2525MFL-20-80	25	–	25	25	150	43.5	4.00	20	80	0.68	GI336	GL11
	GL4-S2525MFL-24-80	25	–	25	25	150	47.5	4.00	24	80	0.65	GI336	GL11
	GL4-S2525PFL-32-80	25	5	25	25	170	55.5	4.00	32	80	0.78	GI336	GL11
	GL5-S2020KFL-20-80	20	–	20	20	125	43.5	5.00	20	80	0.38	GI337	GL11
	GL5-S2525MFL-20-80	25	–	25	25	150	43.5	5.00	20	80	0.71	GI337	GL11
	GL5-S2525PFL-32-100	25	5	25	25	170	55.5	5.00	32	100	0.78	GI337	GL11
	GL6-S2020KFL-20-80	20	–	20	20	125	43.5	6.00	20	80	0.39	GI338-1	GL11
	GL6-S2525MFL-20-80	25	–	25	25	150	43.5	6.00	20	80	0.71	GI338-1	GL11
	GL6-S2525PFL-32-100	25	5	25	25	170	55.5	6.00	32	100	0.75	GI338	GL11

GI333	GL1..	–
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..
GI338-1	GL6-D600..	–

Cutting depths on machined diameter on page 364.

		Nm			
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P

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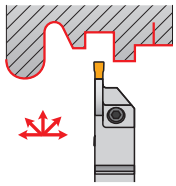
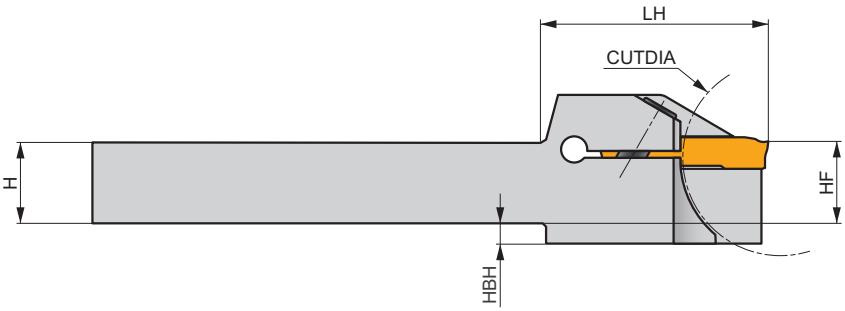
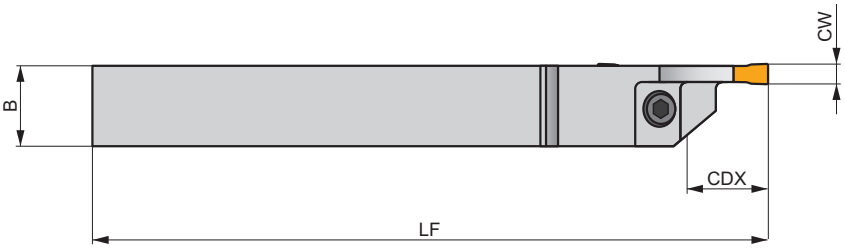
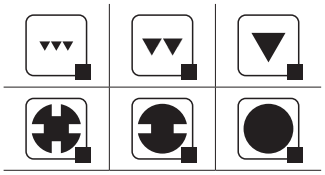
Grooving and Parting-Off tool for GL Inserts, for Sliding head machines

External Right/Left handed tool holder for GL inserts, designed for sliding head machines and easy access to insert clamping. Suited for radial grooving, parting-off, turning and profiling applications. Body treated for longer tool life.









	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL1-S1212HFR-12-40	12	–	12	12	100	30.2	1.50	12	40	0.10	GI333	GL13
	GL1-S1616KFR-16-45	16	–	16	16	125	34.2	1.50	16	45	0.23	GI333	GL12
	GL2-S1212HFR-12-40	12	3	12	12	100	33.0	2.00	12	40	0.14	GI334	GL13
	GL2-S1616KFR-16-45	16	3	16	16	125	39.5	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFR-12-40	12	3	12	12	100	33.0	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFR-16-45	16	3	16	16	125	39.5	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFR-16-45	16	4	16	16	125	39.5	4.00	16	45	0.28	GI336	GL12
L	GL1-S1212HFL-12-40	12	–	12	12	100	30.2	1.50	12	40	0.10	GI333	GL13
	GL1-S1616KFL-16-45	16	–	16	16	125	34.2	1.50	16	45	0.23	GI333	GL12
	GL2-S1212HFL-12-40	12	3	12	12	100	33.0	2.00	12	40	0.11	GI334	GL13
	GL2-S1616KFL-16-45	16	3	16	16	125	39.5	2.00	16	45	0.23	GI334	GL12
	GL3-S1212HFL-12-40	12	3	12	12	100	33.0	3.00	12	40	0.11	GI335	GL13
	GL3-S1616KFL-16-45	16	3	16	16	125	39.5	3.00	16	45	0.23	GI335	GL12
	GL4-S1616KFL-16-45	16	4	16	16	125	39.5	4.00	16	45	0.24	GI336	GL12

GI333	GL1..
GI334	GL2..
GI335	GL3..
GI336	GL4..

Cutting depths on machined diameter on page 364.

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

GLSF(RL) EXT-G

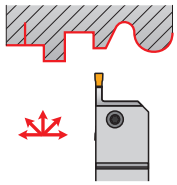
P M K N S H

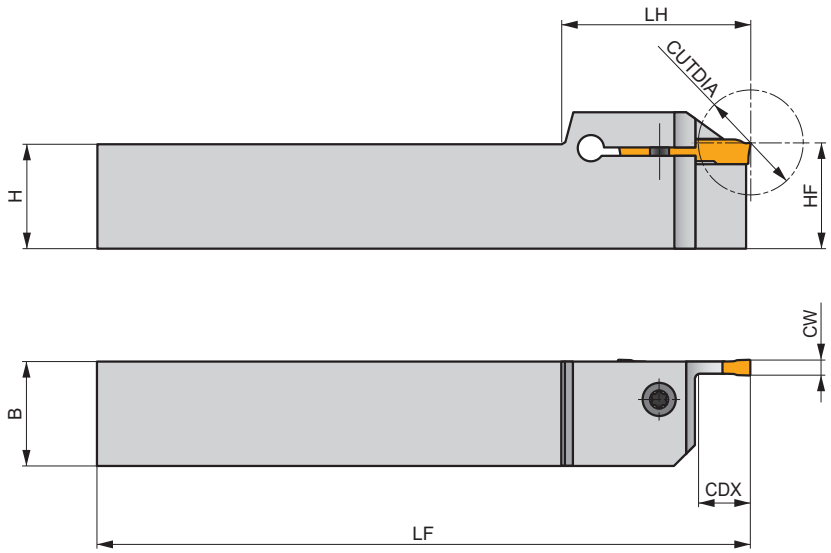
PRAMET

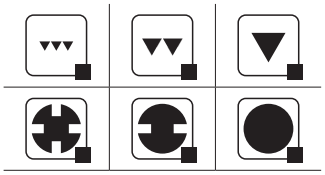
G

Grooving and Turning tool for GL Inserts

External Right/Left handed tool holder for GL inserts. Best suited for longitudinal turning and profiling applications, usable also for grooving and parting-off. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
R	GL2-S2020KFR-10	20	20	20	125	36.0	2.00	10	20	0.38	GI334	GL11
	GL2-S2525MFR-10	25	25	25	150	36.0	2.00	10	20	0.69	GI334	GL11
	GL3-S2020KFR-10	20	20	20	125	36.0	3.00	10	20	0.39	GI335	GL11
	GL3-S2525MFR-10	25	25	25	150	36.0	3.00	10	20	0.73	GI335	GL11
	GL3-S3232MFR-20	32	32	32	150	46.0	3.00	20	40	1.12	GI335	GL15
	GL4-S2020KFR-12	20	20	20	125	36.0	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFR-12	25	25	25	150	36.0	4.00	12	24	0.69	GI336	GL11
	GL4-S3232MFR-24	32	32	32	150	50.0	4.00	24	48	1.04	GI336	GL15
	GL5-S2020KFR-12	20	20	20	125	36.0	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFR-12	25	25	25	150	36.0	5.00	12	24	0.72	GI337	GL11
	GL5-S3232PFR-32	32	32	32	170	58.0	5.00	32	64	1.21	GI337	GL15
	GL6-S2020KFR-12	20	20	20	125	36.0	6.00	12	24	0.36	GI338-1	GL11
	GL6-S2525MFR-12	25	25	25	150	36.0	6.00	12	24	0.68	GI338-1	GL11
	GL6-S3232PFR-32	32	32	32	170	58.0	6.00	32	64	1.22	GI338	GL15
L	GL2-S2020KFL-10	20	20	20	125	36.0	2.00	10	20	0.37	GI334	GL11
	GL2-S2525MFL-10	25	25	25	150	36.0	2.00	10	20	0.70	GI334	GL11
	GL3-S2020KFL-10	20	20	20	125	36.0	3.00	10	20	0.36	GI335	GL11
	GL3-S2525MFL-10	25	25	25	150	36.0	3.00	10	20	0.70	GI335	GL11
	GL3-S3232MFL-20	32	32	32	150	46.0	3.00	20	40	1.12	GI335	GL15
	GL4-S2020KFL-12	20	20	20	125	36.0	4.00	12	24	0.37	GI336	GL11
	GL4-S2525MFL-12	25	25	25	150	36.0	4.00	12	24	0.69	GI336	GL11
	GL4-S3232MFL-24	32	32	32	150	50.0	4.00	24	48	1.04	GI336	GL15
	GL5-S2020KFL-12	20	20	20	125	36.0	5.00	12	24	0.36	GI337	GL11
	GL5-S2525MFL-12	25	25	25	150	36.0	5.00	12	24	0.72	GI337	GL11
	GL5-S3232PFL-32	32	32	32	170	58.0	5.00	32	64	1.15	GI337	GL15
	GL6-S2020KFL-12	20	20	20	125	36.0	6.00	12	24	0.36	GI338-1	GL11
	GL6-S2525MFL-12	25	25	25	150	36.0	6.00	12	24	0.72	GI338-1	GL11

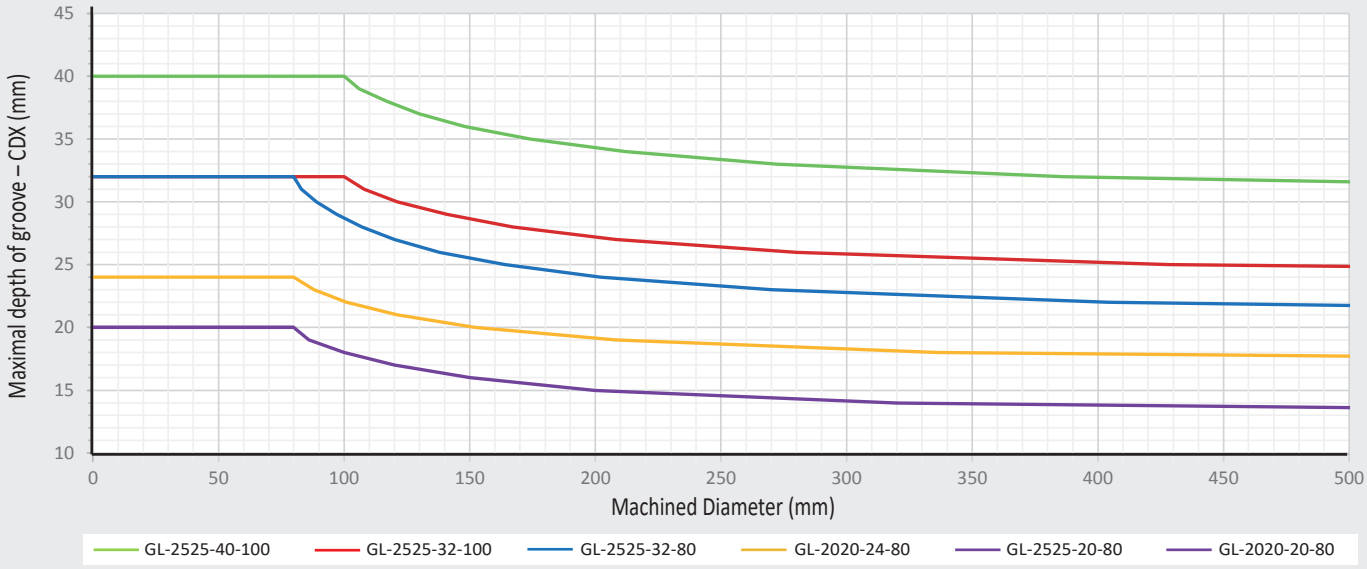
	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg		
L	**GL6-S3232PFL-32**	32	32	32	170	58.0	6.00	32	64	1.15	GI338	GL15

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..
GI338-1	GL6-D600..	–

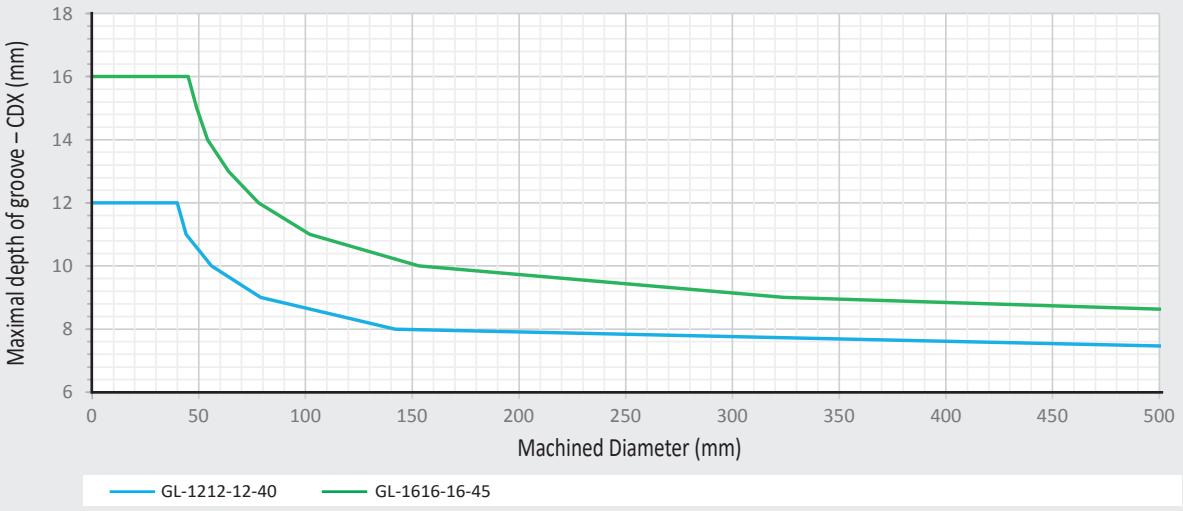
		Nm			
GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P
GL15	SR 88026-T30P	5.0	M8	26	LK T30P

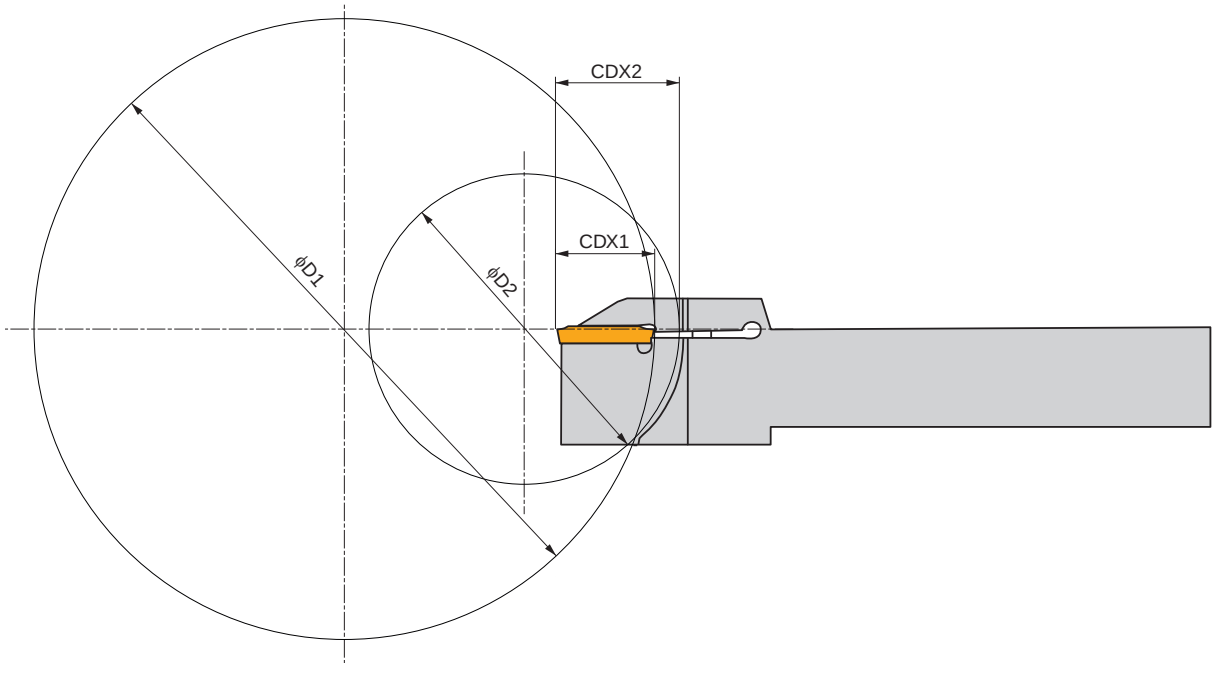
CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER

GLAF(RL) EXT



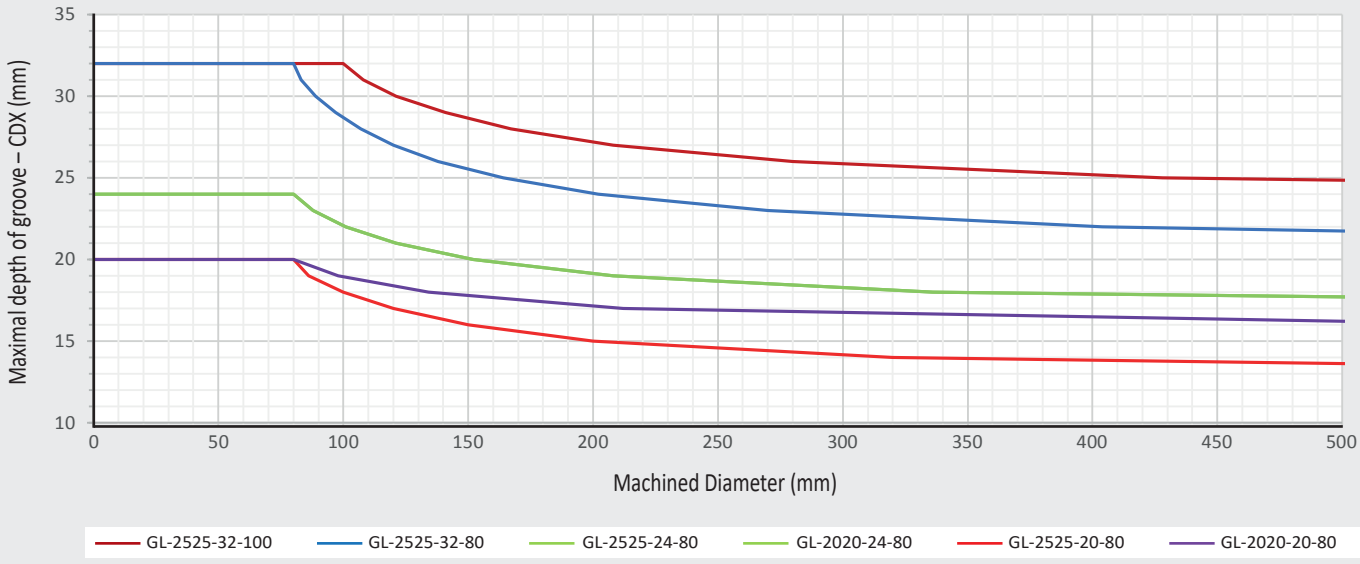
GLAF(RL) EXT-S



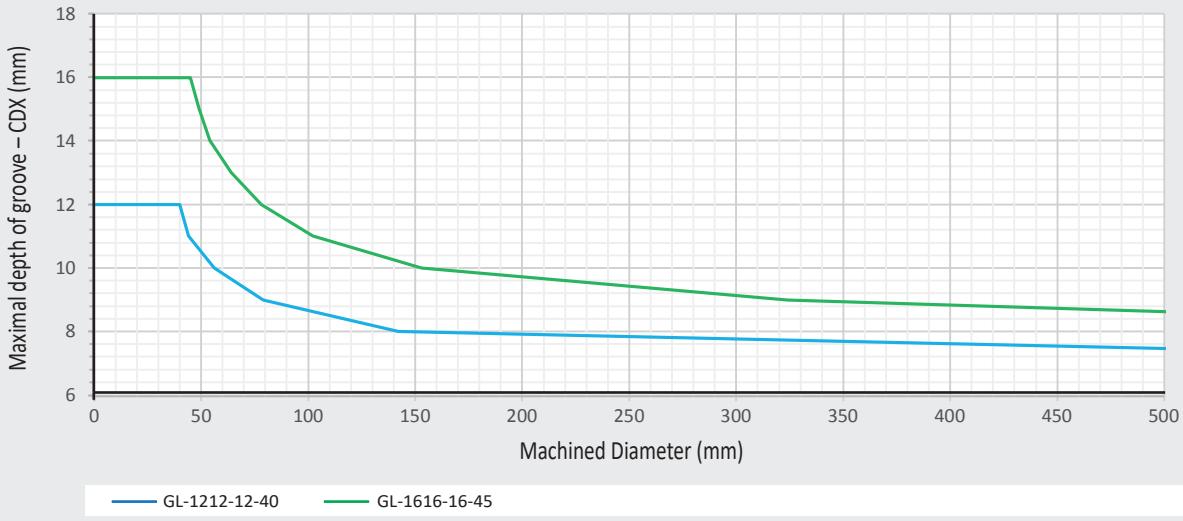


CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER

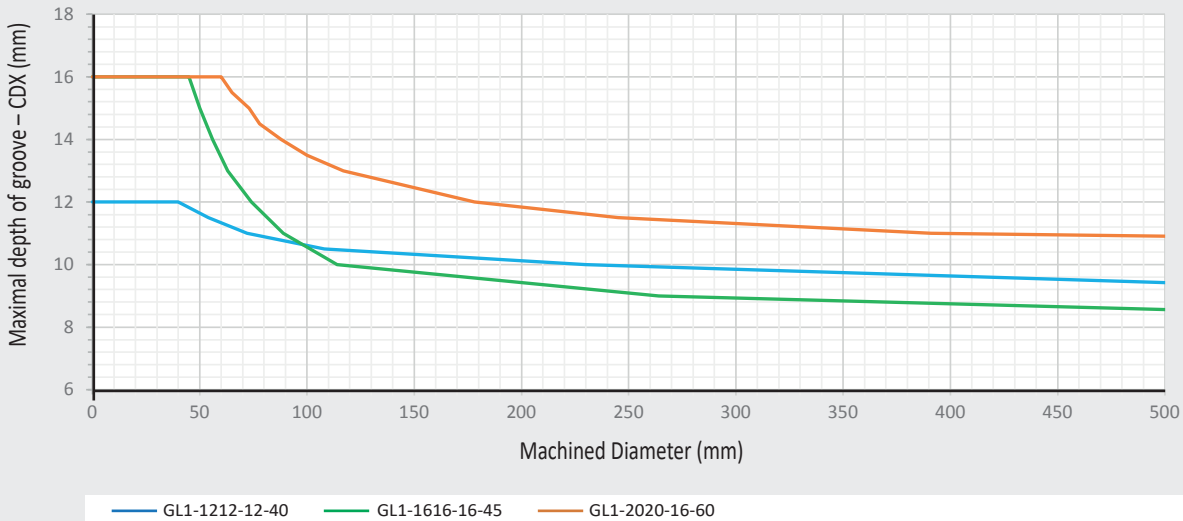
GLSF (RL) EXT



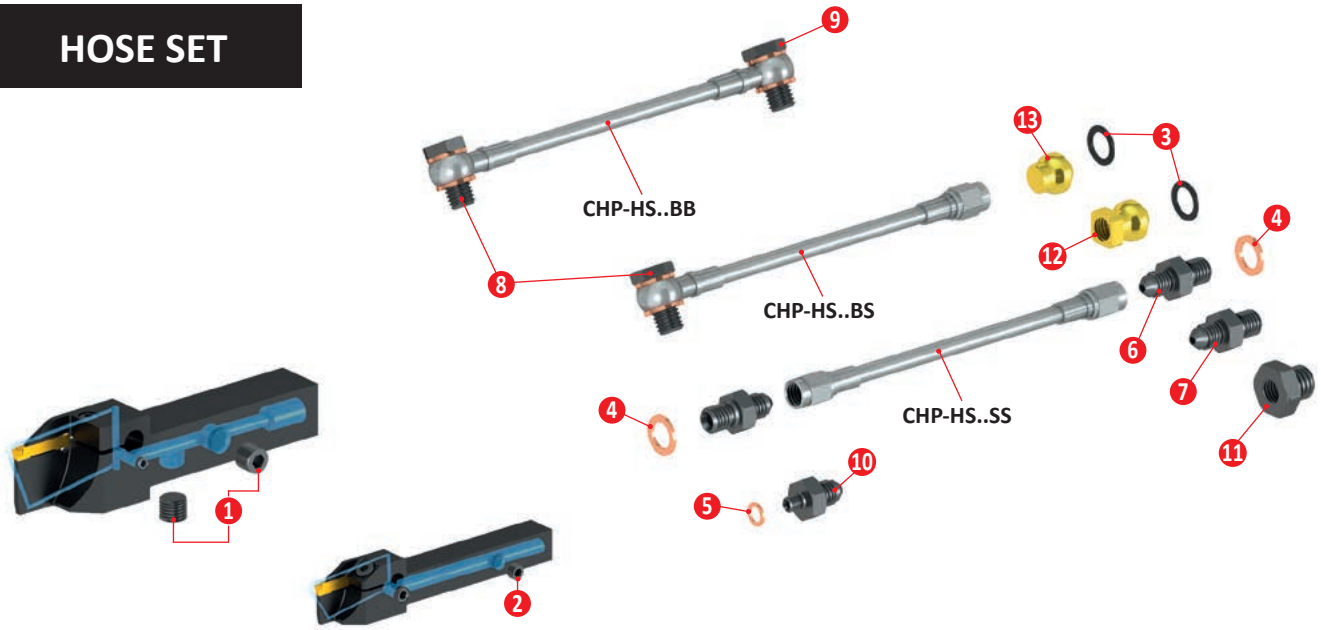
GLSF (RL) EXT-S



GL1



HOSE SET



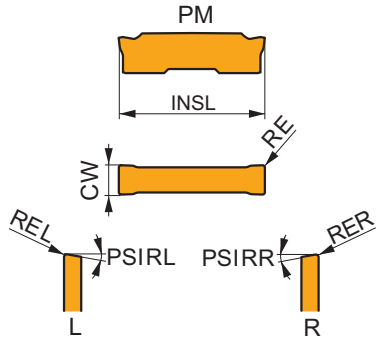
			Designation	lenght			
				150 mm	CHP-HS150 SS	CHP-HS150 BS	CHP-HS150 BB
				250 mm	CHP-HS250 SS	CHP-HS250 BS	CHP-HS250 BB
				300 mm	CHP-HS300 SS	CHP-HS300 BS	CHP-HS300 BB
1		Plug G⅛“	CHP-P1/8		1 x	1 x	1 x
2		Plug 6*	CHP-P6		–	–	–
3		O-ring	CHP-010×1		2 x	2 x	2 x
4		Copper gasket	CHP-G10		2 x	3 x	4 x
5		Copper gasket*	CHP-G06		–	–	–
6		Conector straight G⅛“	CHP-CS1/8		2 x	1 x	–
7		Conector straight M10	CHP-CS10		1 x	–	–
8		Conector banjo G⅛“	CHP-CB1/8		–	1 x	2 x
9		Conector banjo M10	CHP-CB10		–	1 x	1 x
10		Reduction G⅛“ to M6*	CHP-R1/8-6		–	–	–
11		Reduction G¼" to G⅛“	CHP-R1/4-1/8		–	1 x	1 x
12		Coolant nozzle G⅛“	CHP-PV1/8-12		1 x	1 x	1 x
13		Coolant nozzle plug	CHP-PV14		1 x	1 x	1 x

* included in tool shank 12 × 12 delivery

More information in the package leaflet

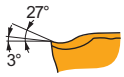
GL. D - PM

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
150	1.50	-0.04	0.04	16.5
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



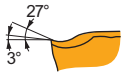
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

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



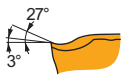
PM geometry with highly positive rake, first choice for parting-off, and continuous to slightly interrupted cuts.

GL1-D150M015-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	–
GL2-D200M02-PM:G8330	●●●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	–
GL2-D200M02-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	–	–
GL3-D250G02-PM:G8330	●●●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	–
GL3-D300M02-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	–
GL3-D300M02-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	–	–
GL4-D400M02-PM:G8330	●●●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	–
GL4-D400M02-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	–	–
GL5-D500M03-PM:G8330	●●●	0.3	■	130	0.15	■	75	0.14	◪	120	0.15	◪	390	0.18	◪	30	0.12	–	–	–	–
GL6-D600M03-PM:G8330	●●●	0.3	■	130	0.15	■	75	0.14	◪	120	0.15	◪	390	0.18	◪	30	0.12	–	–	–	–



R-PM right-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.

GL1-D150G015R06-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	6	–
GL1-D150G015R12-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	12	–
GL2-D200G02R06-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	6	–
GL2-D200G02R06-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	6	–
GL2-D200G02R12-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	12	–
GL3-D300G02R06-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	6	–
GL3-D300G02R06-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	6	–
GL3-D300G02R12-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	12	–
GL4-D400G02R06-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	6	–
GL4-D400G02R06-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	6	–
GL4-D400G02R12-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	12	–

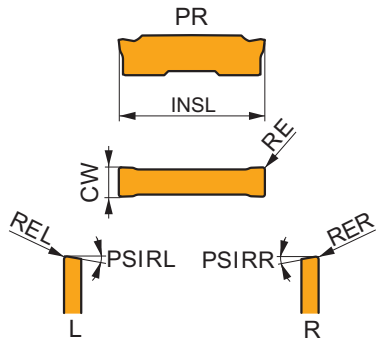


L-PM left-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.

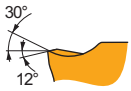
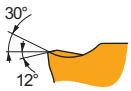
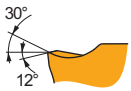
GL1-D150G015L06-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	6
GL1-D150G015L12-PM:G8330	●	0.1	■	130	0.05	■	75	0.05	◪	120	0.05	◪	390	0.06	◪	30	0.04	–	–	–	12
GL2-D200G02L06-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	6
GL2-D200G02L06-PM:T7325	●	0.2	◪	150	0.08	■	115	0.07	◪	140	0.08		–	–	◪	45	0.06	–	–	–	6
GL2-D200G02L12-PM:G8330	●	0.2	■	130	0.08	■	75	0.07	◪	120	0.08	◪	390	0.10	◪	30	0.06	–	–	–	12
GL3-D300G02L06-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	6
GL3-D300G02L06-PM:T7325	●	0.2	◪	150	0.10	■	115	0.09	◪	140	0.10		–	–	◪	45	0.07	–	–	–	6
GL3-D300G02L12-PM:G8330	●	0.2	■	130	0.10	■	75	0.09	◪	120	0.10	◪	390	0.12	◪	30	0.07	–	–	–	12
GL4-D400G02L06-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	6
GL4-D400G02L06-PM:T7325	●	0.2	◪	150	0.12	■	115	0.11	◪	140	0.12		–	–	◪	45	0.10	–	–	–	6
GL4-D400G02L12-PM:G8330	●	0.2	■	130	0.12	■	75	0.11	◪	120	0.12	◪	390	0.14	◪	30	0.10	–	–	–	12

GL. D - PR

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



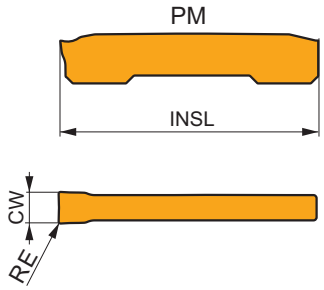
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
			**PR** geometry with negative T-land, first choice for difficult grooving and parting-off, and continuous to interrupted cuts.													
GL2-D200M02-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
GL2-D200M02-PR:T7325		0.2	150	0.10	115	0.09	140	0.10	–	–	–	–	–	–	–	–
GL3-D300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL3-D300M02-PR:T7325		0.2	150	0.12	115	0.11	140	0.12	–	–	–	–	–	–	–	–
GL4-D400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
GL4-D400M02-PR:T7325		0.2	150	0.15	115	0.14	140	0.15	–	–	–	–	–	–	–	–
GL5-D500M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
GL6-D600M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
			**R-PR** right-handed geometry with negative T-land, first choice for difficult bars parting-off, and continuous to interrupted cuts.													
GL2-D200G02R06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	6	–
GL2-D200G02R12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	12	–
GL3-D300G02R06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	6	–
GL3-D300G02R12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	12	–
GL4-D400G02R06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	6	–
GL4-D400G02R12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	12	–
			**L-PR** left-handed geometry with negative T-land, first choice for difficult bars parting-off, and continuous to interrupted cuts.													
GL2-D200G02L06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	6
GL2-D200G02L12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	12
GL3-D300G02L06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	6
GL3-D300G02L12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	12
GL4-D400G02L06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	6
GL4-D400G02L12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	12

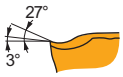
GL. S - PM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



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

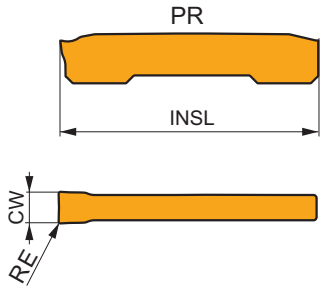
Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
															
GL3-S300M02-PM:G8330	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL4-S400M02-PM:G8330	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	–

PM geometry with highly positive rake on single sided insert, first choice for deep parting-off, and continuous to slightly interrupted cuts.

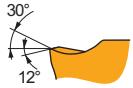
GL. S - PR

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



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

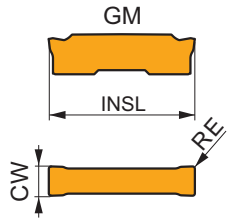
Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
															
GL3-S300M02-PR:G8330	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL4-S400M02-PR:G8330	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

PR geometry with negative T-land on single sided insert, first choice for difficult deep grooving and parting-off, and continuous to interrupted cuts.

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



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	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
																			
GL2-D200M02-GM:G8330	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–

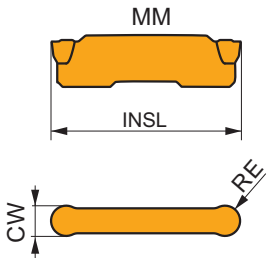
GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.

[1] Usable only in holders with CDX ≥ 24.

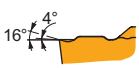
GL. D - MM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0

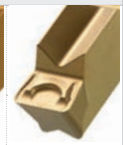


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
																			
GL2-D200MM0-MM:G8330	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–

MM geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.

LCM. – EXTERNAL TOOLS NAVIGATOR

INSERT SEAT	0316	0416	0516	0616	0830
GFI(RL) EXT 16×16 – 32×25					
GFM(RL) EXT 20×20 – 32×25					
Cutting width (mm) CW	3	4	5	6	8
Deep parting-off (single sided insert)	 LCMR CM	 LCMR CM			
Parting-off (tube / full bar)	 CM  F	 CM  F	 CM  F	 CM  F	 F
Grooving (deep / shallow)	 F  M	 F  M	 F  M	 F  M	 F
Turning (longitudinal)	 F  M	 F  M	 F  M	 F  M	 F
Profiling (multiaxial)	 MP	 MP	 MP	 MP	 MP

GFI(RL) EXT

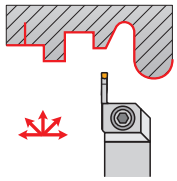
P M K N S H

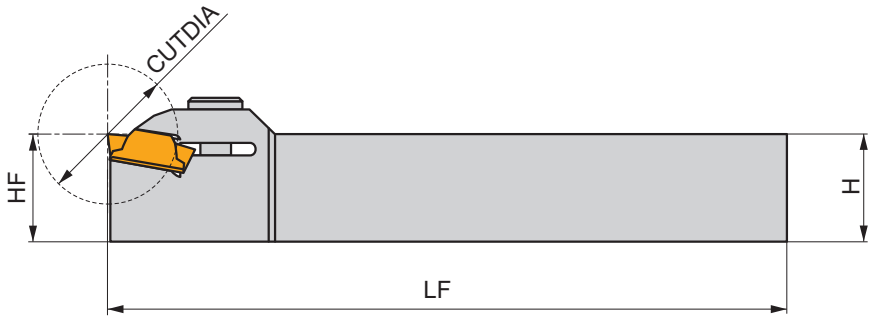
PRAMET

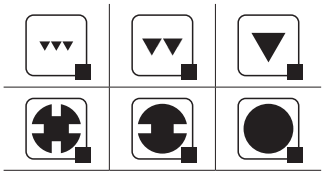
G

External V-Groove Top Clamp Grooving and Turning Tool for LCM. Inserts

External Right/Left hand tool holder for grooving with LCM. inserts. Suited for parting-off, grooving, profiling and longitudinal turning applications. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	kg		
R	GFIR 1616 H 03	16	16	16	100	3.00	18	0.22	GI136	GL03
	GFIR 2020 K 03	20	20	20	125	3.00	18	0.40	GI136	GL04
	GFIR 2525 M 03	25	25	25	150	3.00	18	0.73	GI136	GL05
	GFIR 1616 H 04	16	16	16	100	4.00	24	0.21	GI137	GL03
	GFIR 2020 K 04	20	20	20	125	4.00	24	0.39	GI137	GL04
	GFIR 2525 M 04	25	25	25	150	4.00	24	0.71	GI137	GL05
	GFIR 2020 K 05	20	20	20	125	5.00	28	0.38	GI138	GL04
	GFIR 2525 M 05	25	25	25	150	5.00	28	0.70	GI138	GL05
	GFIR 2020 K 06	20	20	20	125	6.00	28	0.38	GI139	GL04
	GFIR 2525 M 06	25	25	25	150	6.00	28	0.70	GI139	GL05
	GFIR 2525 M 08	25	25	25	150	8.00	48	0.74	GI193	GL09
	GFIR 3225 P 08	32	32	25	170	8.00	48	1.01	GI193	GL09
L	GFIL 1616 H 03	16	16	16	100	3.00	18	0.22	GI136	GL03
	GFIL 2020 K 03	20	20	20	125	3.00	18	0.39	GI136	GL04
	GFIL 2525 M 03	25	25	25	150	3.00	18	0.73	GI136	GL05
	GFIL 1616 H 04	16	16	16	100	4.00	24	0.20	GI137	GL03
	GFIL 2020 K 04	20	20	20	125	4.00	24	0.38	GI137	GL04
	GFIL 2525 M 04	25	25	25	150	4.00	24	0.71	GI137	GL05
	GFIL 2020 K 05	20	20	20	125	5.00	28	0.38	GI138	GL04
	GFIL 2525 M 05	25	25	25	150	5.00	28	0.71	GI138	GL05
	GFIL 2020 K 06	20	20	20	125	6.00	28	0.40	GI139	GL04
	GFIL 2525 M 06	25	25	25	150	6.00	28	0.70	GI139	GL05
	GFIL 2525 M 08	25	25	25	150	8.00	48	0.74	GI193	GL09
	GFIL 3225 P 08	32	32	25	170	8.00	48	1.02	GI193	GL09

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..
GI193	LCM. 0830..

GL03	HS 0616C	6.0	M 6	16	HXK 5
GL04	HS 0620C	6.0	M 6	20	HXK 5
GL05	HS 0625C	6.0	M 6	25	HXK 5
GL09	HSI 1020	8.0	M 10	20	HXK 8

GFM(RL) EXT

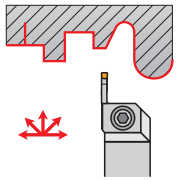
P M K N S H

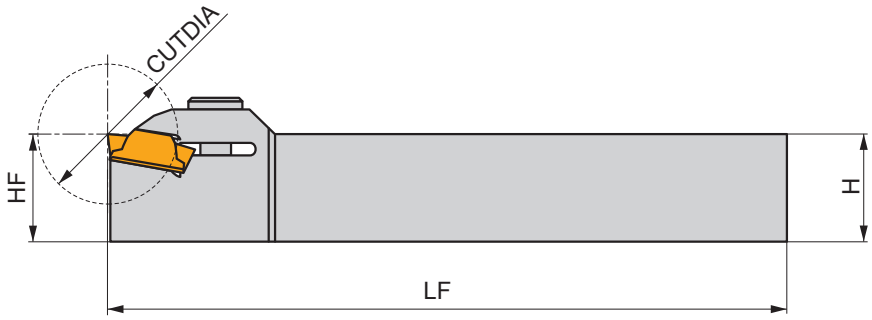
PRAMET

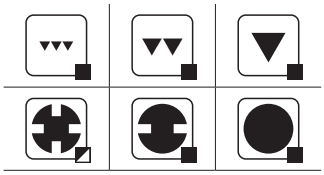
G

External V-Groove Top Clamp Grooving and Turning Tool for LCM. Inserts

External Right/Left hand tool holder for grooving with LCM. inserts. Suited for parting-off, grooving, profiling and longitudinal turning applications. Body treated for longer tool life.







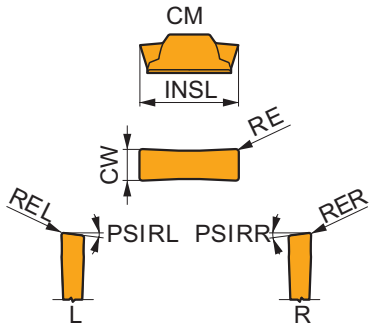
	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	kg		
R	GFMR 2020 K 0316	20	20	20	125	3.00	30	0.37	GI136	GL04
	GFMR 2525 M 0316	25	25	25	150	3.00	30	0.68	GI136	GL04
	GFMR 2020 K 0416	20	20	20	125	4.00	40	0.37	GI137	GL04
	GFMR 2525 M 0416	25	25	25	150	4.00	40	0.67	GI137	GL04
	GFMR 2525 M 0516	25	25	25	150	5.00	50	0.65	GI138	GL04
	GFMR 3225 P 0516	32	32	25	170	5.00	50	0.96	GI138	GL04
	GFMR 2525 M 0616	25	25	25	150	6.00	60	0.66	GI139	GL04
	GFMR 3225 P 0616	32	32	25	170	6.00	60	0.95	GI139	GL04
	GFMR 3225 P 0830	32	32	25	170	8.00	80	0.97	GI193	GL10
L	GFML 2020 K 0316	20	20	20	125	3.00	30	0.36	GI136	GL04
	GFML 2525 M 0316	25	25	25	150	3.00	30	0.69	GI136	GL04
	GFML 2020 K 0416	20	20	20	125	4.00	40	0.37	GI137	GL04
	GFML 2525 M 0416	25	25	25	150	4.00	40	0.67	GI137	GL04
	GFML 2525 M 0516	25	25	25	150	5.00	50	0.66	GI138	GL04
	GFML 3225 P 0516	32	32	25	170	5.00	50	0.96	GI138	GL04
	GFML 2525 M 0616	25	25	25	150	6.00	60	0.64	GI139	GL04
	GFML 3225 P 0616	32	32	25	170	6.00	60	0.95	GI139	GL04
	GFML 3225 P 0830	32	32	25	170	8.00	80	0.97	GI193	GL10

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..
GI193	LCM. 0830..

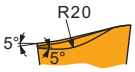
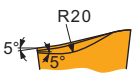
		Nm			
GL04	HS 0620C	6.0	M 6	20	HXK 5
GL10	HSI 1020	8.0	M 10	20	HXK 8

LCMF 16 - CM

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



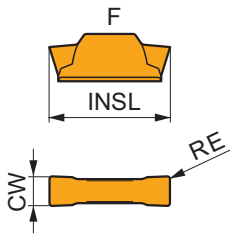
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
			**CM** geometry, first choice for parting-off and grooving, and continuous to slightly interrupted cuts.													
LCMF 031602-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 031604-CM:T8330	●	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041602-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041604-CM:T8330	●	0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 051604-CM:T8330	●	0.4	130	0.11	75	0.11	120	0.11	–	–	–	–	–	–	–	–
LCMF 061604-CM:T8330	●	0.4	130	0.11	75	0.11	120	0.11	–	–	–	–	–	–	–	–
			**R-CM** geometry, right-handed design, first choice for parting-off and continuous to slightly interrupted cuts.													
LCMF 031602R15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	15	–
LCMF 031602R6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	6	–
LCMF 041602R15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	15	–
LCMF 041602R6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	6	–
			**L-CM** geometry, left-handed design, first choice for parting-off and continuous to slightly interrupted cuts.													
LCMF 031602L15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	15
LCMF 031602L6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	6
LCMF 041602L15-CM:T8330[1]	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	15
LCMF 041602L6-CM:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	6

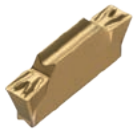
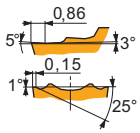
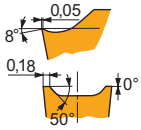
[1] Toolholders have to be modified.

LCMF 16, LCMF 30 - F

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4
0830	8.00	-0.05	0.05	30.0



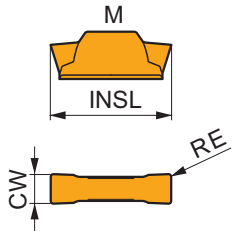
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
			**F** geometry for parting-off, grooving and axial turning, fine and finish machining, and continuous to slightly interrupted cuts.																	
LCMF 031602-F:T8330	●	0.2	195	0.10	0.3	115	0.09	0.3	185	0.10	0.3	–	–	–	–	–	–	–	–	–
LCMF 031604-F:T8330	●	0.4	200	0.10	0.5	120	0.09	0.5	190	0.10	0.5	–	–	–	–	–	–	–	–	–
LCMF 041604-F:T8330	●	0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041604-F:T9325	●	0.4	275	0.13	0.5	165	0.12	0.5	260	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041608-F:T8330	●	0.8	205	0.13	1.0	120	0.12	1.0	190	0.13	1.0	–	–	–	–	–	–	–	–	–
LCMF 041608-F:T9325	●	0.8	305	0.13	1.0	180	0.12	1.0	285	0.13	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-F:T8330	●	0.8	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-F:T9325	●	0.8	285	0.15	1.0	170	0.14	1.0	270	0.15	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-F:T8330	●	0.8	190	0.17	1.0	110	0.15	1.0	180	0.17	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-F:T9325	●	0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	–	–	–	–	–	–	–	–	–
			**F** geometry for parting-off, grooving and axial turning, fine and finish machining, and continuous to slightly interrupted cuts.																	
LCMF 083008-F:T8330	●	0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	–	–	–
LCMF 083012-F:T8330	●	1.2	170	0.25	1.5	100	0.23	1.5	160	0.25	1.5	–	–	–	–	–	–	–	–	–

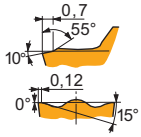
LCMF 16 - M

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



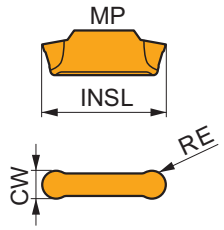
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
M geometry for grooving and longitudinal turning, and continuous to interrupted cuts.																			
LCMF 031602-M:T8330	0.2	160	0.13	1.0	95	0.12	1.0	150	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMF 031604-M:T8330	0.4	170	0.13	1.0	100	0.12	1.0	160	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMF 041604-M:T8330	0.4	155	0.18	1.0	90	0.16	1.0	145	0.18	1.0	–	–	–	–	–	–	30	0.12	0.8
LCMF 041604-M:T9325	0.4	225	0.18	1.0	135	0.16	1.0	210	0.18	1.0	–	–	–	–	–	–	–	–	–
LCMF 041608-M:T8330	0.8	185	0.18	1.0	110	0.16	1.0	175	0.18	1.0	–	–	–	–	–	–	35	0.12	0.8
LCMF 041608-M:T9325	0.8	265	0.18	1.0	155	0.16	1.0	250	0.18	1.0	–	–	–	–	–	–	–	–	–
LCMF 051608-M:T8330	0.8	180	0.20	1.0	105	0.18	1.0	170	0.20	1.0	–	–	–	–	–	–	35	0.13	1.0
LCMF 051608-M:T9325	0.8	255	0.20	1.0	150	0.18	1.0	240	0.20	1.0	–	–	–	–	–	–	–	–	–
LCMF 061608-M:T8330	0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	35	0.13	1.0
LCMF 061608-M:T9325	0.8	230	0.25	1.0	135	0.23	1.0	215	0.25	1.0	–	–	–	–	–	–	–	–	–

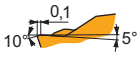
LCMF 16, LCMF 30 - MP

PRAMET

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
0316	3.00	-0.05	0.05	17.5
0416	4.00	-0.05	0.05	17.6
0516	5.00	-0.05	0.05	18.3
0616	6.00	-0.05	0.05	18.5
0830	8.00	-0.05	0.05	30.9



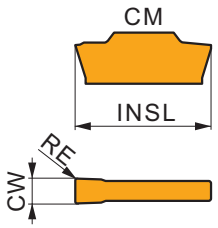
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																			
MP geometry for longitudinal turning and copy profiling, and continuous to interrupted cuts.																			
LCMF 0316MO-MP:T8330	1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0416MO-MP:T8330	2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMF 0416MO-MP:T9325	2.0	220	0.40	1.0	130	0.36	1.0	205	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMF 0516MO-MP:T8330	2.5	170	0.45	1.0	100	0.41	1.0	160	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMF 0516MO-MP:T9325	2.5	205	0.45	1.0	120	0.41	1.0	190	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMF 0616MO-MP:T8330	3.0	165	0.50	1.0	95	0.45	1.0	155	0.50	1.0	–	–	–	–	–	–	–	–	–
LCMF 0616MO-MP:T9325	3.0	200	0.50	1.0	120	0.45	1.0	190	0.50	1.0	–	–	–	–	–	–	–	–	–
LCMF 0830MO-MP:T8330	4.0	150	0.60	1.2	90	0.54	1.2	140	0.60	1.2	–	–	–	–	–	–	–	–	–

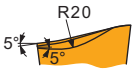
LCMR 16 - CM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4



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

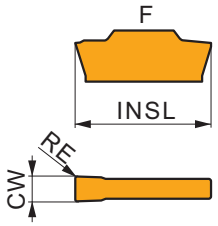
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
LCMR 031602-CM:T8330		0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMR 041604-CM:T8330		0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–

CM geometry, first choice for parting-off and grooving, and continuous to slightly interrupted cuts.

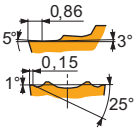
LCMR 16, LCMR 30 - F

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



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

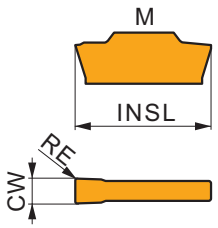
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
LCMR 031604-F:T8330		0.4	200	0.10	0.5	120	0.09	0.5	190	0.10	0.5	–	–	–	–	–	–	–	–	–
LCMR 041604-F:T8330		0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMR 051604-F:T8330		0.4	180	0.15	0.5	105	0.14	0.5	170	0.15	0.5	–	–	–	–	–	–	–	–	–
LCMR 061608-F:T8330		0.8	190	0.17	1.0	110	0.15	1.0	180	0.17	1.0	–	–	–	–	–	–	–	–	–

F geometry for parting-off, grooving and longitudinal turning, fine and finish machining, and continuous to slightly interrupted cuts.

LCMR 16 - M

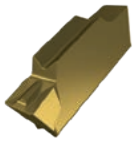
PRAMET

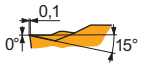
	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	16.4
0416	4.00	-0.05	0.05	16.4
0516	5.00	-0.05	0.05	16.4
0616	6.00	-0.05	0.05	16.4



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	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
LCMR 031604-M:T8330		0.4	170	0.13	1.0	100	0.12	1.0	160	0.13	1.0	–	–	–	–	–	–	30	0.10	0.7
LCMR 041604-M:T8330		0.4	155	0.18	1.0	90	0.16	1.0	145	0.18	1.0	–	–	–	–	–	–	30	0.12	0.8
LCMR 051604-M:T8330		0.4	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	–	–	–	30	0.13	1.0
LCMR 061608-M:T8330		0.8	175	0.25	1.0	105	0.23	1.0	165	0.25	1.0	–	–	–	–	–	–	35	0.13	1.0



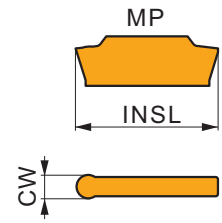


M geometry for grooving and longitudinal turning, and continuous to interrupted cuts.

LCMR 16 - MP

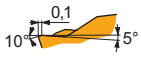
PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0316	3.00	-0.05	0.05	17.4
0416	4.00	-0.05	0.05	17.5
0516	5.00	-0.05	0.05	18.1
0616	6.00	-0.05	0.05	18.3



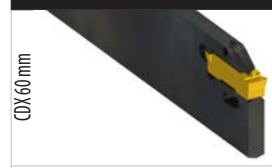
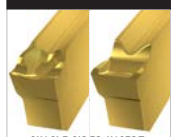
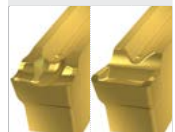
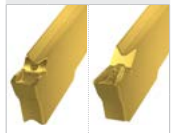
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
LCMR 0316MO-MP:T8330		1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMR 0416MO-MP:T8330		2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	–	–	–	–	–	–	–	–	–
LCMR 0516MO-MP:T8330		2.5	170	0.45	1.0	100	0.41	1.0	160	0.45	1.0	–	–	–	–	–	–	–	–	–
LCMR 0616MO-MP:T8330		3.0	165	0.50	1.0	95	0.45	1.0	155	0.50	1.0	–	–	–	–	–	–	–	–	–



MP geometry for longitudinal turning and copy profiling, and continuous to interrupted cuts.

GL – BLADES & ACCESSORIES NAVIGATOR

INSERT SEAT	GL1	GL2	GL3	GL4	GL5	GL6	
Blades H = 26; 32 mm	 CDX 16 mm NEW	 CDX 35–50 mm	 CDX 35–50 mm	 CDX 50 mm	 CDX 60 mm	 CDX 60 mm	
NEW **MS Blades**		 CDX 24 mm	 CDX 24 mm	 CDX 24 mm	 CDX 24 mm	 CDX 24 mm	
Cutting width (mm) CW	1.5	2	3 (2.5)	4	5	6	8
NEW **Deep parting-off** (single sided insert)			 SINGLE SIDED INSERT PM 1 PR	 SINGLE SIDED INSERT PM 1 PR			
Parting-off (tube / full bar)	NEW  PM	 PM 1 PR	 CW = 2.5 / 3 PM 1 PR	 PM 1 PR	 PM 1 PR	 PM 1 PR	
Grooving (deep / shallow)		 PR GM	 PR GM	 PR GM	 PR GM	 NEW PR GM	GM

MS-EN

- Modular Tool Holder
- Shank sizes:
  20 × 20, 25 × 25, 32 × 32 mm

DU, D

- Tool Holder Block
- Shank sizes:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm

GLS B

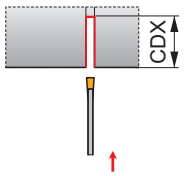
P M K N S H

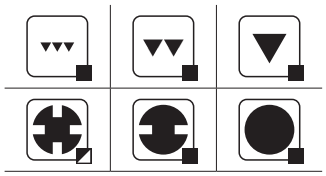
PRAMET

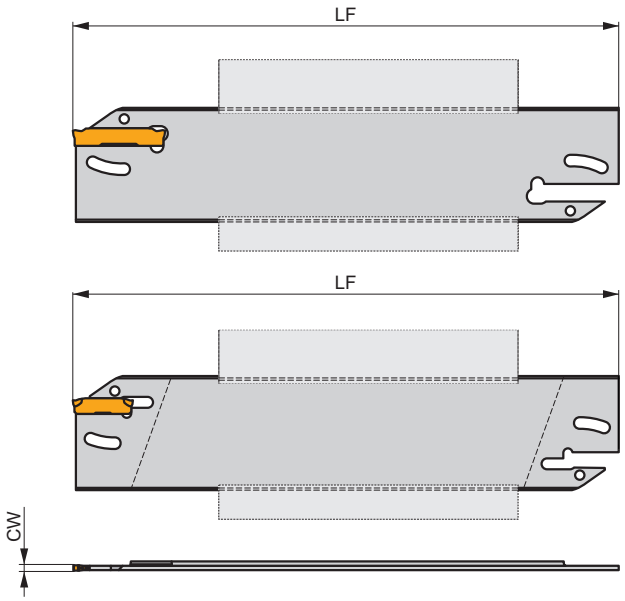
X

Double-Ended Parting-off and Grooving Blade for GL Inserts

Blade for GL inserts, suited for parting-off and grooving applications. Easy inserts replacement by specific key (included in package). Can be fitted into the DU, D tool holder block. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
R	GL1-S26KBR-16	21.4	26	125	1.50	16	0.05	GI333	KV2
	GL1-S32MBR-16	32	32	150	1.50	16	0.07	GI333	KV2
L	GL1-S26KBL-16	21.4	26	125	1.50	16	0.05	GI333	KV2
	GL1-S32MBL-16	32	32	150	1.50	16	0.07	GI333	KV2
N	GL2-S26KB	21.4	26	125	2.00	35	0.13	GI334	KV2
	GL2-S32MB	25	32	150	2.00	50	0.15	GI334	KV2
	GL3-S26KB	21.4	26	125	3.00	35	0.15	GI335	KV2
	GL3-S32MB	25	32	150	3.00	50	0.15	GI335	KV2
	GL4-S32MB	25	32	150	4.00	50	0.19	GI336	KV2
	GL5-S32MB	25	32	150	5.00	60	0.22	GI337	KV2
	GL6-S32MB	25	32	150	6.00	60	0.25	GI338	KV2

GI333	GL1..	–
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

KV2	KV 15x150

GLS BS

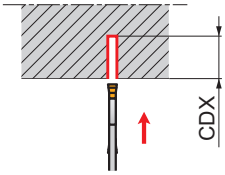
P M K N S H

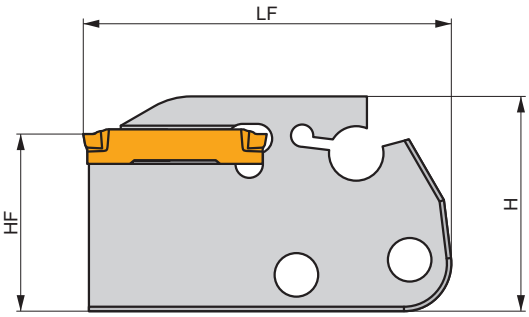
PRAMET

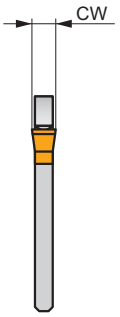
G

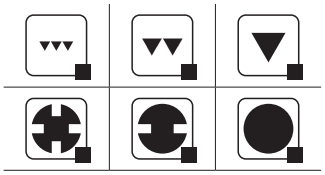
Grooving and Parting-off Blade for GL Inserts, for MS-EN Tool Holder

Blade for modular tool holder MS-EN, designed for GL inserts. Suited for grooving and parting-off applications. Blades treated for longer tool life.







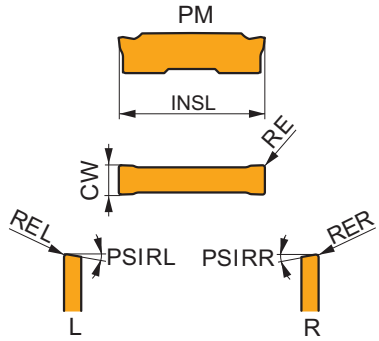


	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg	
	GL2-S29CBS	24	29	50	2.00	24	0.01	GI334
	GL3-S29CBS	24	29	50	3.00	24	0.02	GI335
	GL4-S29CBS	24	29	50	4.00	24	0.02	GI336
	GL5-S29CBS	24	29	50	5.00	24	0.03	GI337
	GL6-S29CBS	24	29	50	6.00	24	0.04	GI338

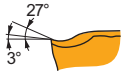
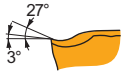
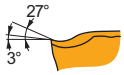
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

GL. D - PM

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
150	1.50	-0.04	0.04	16.5
200	2.00	-0.05	0.05	25.0
250	2.55	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0

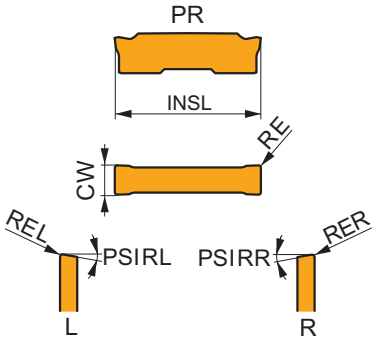


Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

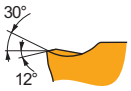
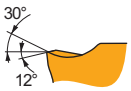
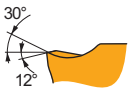
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
PM geometry with highly positive rake, first choice for parting-off, and continuous to slightly interrupted cuts.																
GL1-D150M015-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	–
GL2-D200M02-PM:G8330	⁂	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	–
GL2-D200M02-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	–	–
GL3-D250G02-PM:G8330	⁂	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL3-D300M02-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL3-D300M02-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	–	–
GL4-D400M02-PM:G8330	⁂	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	–
GL4-D400M02-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	–	–
GL5-D500M03-PM:G8330	⁂	0.3	130	0.15	75	0.14	120	0.15	390	0.18	30	0.12	–	–	–	–
GL6-D600M03-PM:G8330	⁂	0.3	130	0.15	75	0.14	120	0.15	390	0.18	30	0.12	–	–	–	–
																
R-PM right-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.																
GL1-D150G015R06-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	6	–
GL1-D150G015R12-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	12	–
GL2-D200G02R06-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	6	–
GL2-D200G02R06-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	6	–
GL2-D200G02R12-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	12	–
GL3-D300G02R06-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	6	–
GL3-D300G02R06-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	6	–
GL3-D300G02R12-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	12	–
GL4-D400G02R06-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	6	–
GL4-D400G02R06-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	6	–
GL4-D400G02R12-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	12	–
																
L-PM left-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.																
GL1-D150G015L06-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	6
GL1-D150G015L12-PM:G8330	●	0.1	130	0.05	75	0.05	120	0.05	390	0.06	30	0.04	–	–	–	12
GL2-D200G02L06-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	6
GL2-D200G02L06-PM:T7325	●	0.2	150	0.08	115	0.07	140	0.08	–	–	45	0.06	–	–	–	6
GL2-D200G02L12-PM:G8330	●	0.2	130	0.08	75	0.07	120	0.08	390	0.10	30	0.06	–	–	–	12
GL3-D300G02L06-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	6
GL3-D300G02L06-PM:T7325	●	0.2	150	0.10	115	0.09	140	0.10	–	–	45	0.07	–	–	–	6
GL3-D300G02L12-PM:G8330	●	0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	12
GL4-D400G02L06-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	6
GL4-D400G02L06-PM:T7325	●	0.2	150	0.12	115	0.11	140	0.12	–	–	45	0.10	–	–	–	6
GL4-D400G02L12-PM:G8330	●	0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	12

GL. D - PR

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0



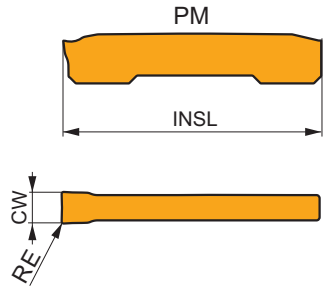
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
			**PR** geometry with negative T-land, first choice for difficult grooving and parting-off, and continuous to interrupted cuts.													
GL2-D200M02-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
GL2-D200M02-PR:T7325		0.2	150	0.10	115	0.09	140	0.10	–	–	–	–	–	–	–	–
GL3-D300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL3-D300M02-PR:T7325		0.2	150	0.12	115	0.11	140	0.12	–	–	–	–	–	–	–	–
GL4-D400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
GL4-D400M02-PR:T7325		0.2	150	0.15	115	0.14	140	0.15	–	–	–	–	–	–	–	–
GL5-D500M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
GL6-D600M04-PR:G8330		0.4	130	0.18	75	0.16	120	0.18	–	–	–	–	–	–	–	–
			**R-PR** right-handed geometry with negative T-land, first choice for difficult bars parting-off, and continuous to interrupted cuts.													
GL2-D200G02R06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	6	–
GL2-D200G02R12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	12	–
GL3-D300G02R06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	6	–
GL3-D300G02R12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	12	–
GL4-D400G02R06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	6	–
GL4-D400G02R12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	12	–
			**L-PR** left-handed geometry with negative T-land, first choice for difficult bars parting-off, and continuous to interrupted cuts.													
GL2-D200G02L06-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	6
GL2-D200G02L12-PR:G8330		0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	12
GL3-D300G02L06-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	6
GL3-D300G02L12-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	12
GL4-D400G02L06-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	6
GL4-D400G02L12-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	12

GL. S - PM

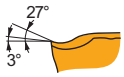
PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



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

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
GL3-S300M02-PM:G8330		0.2	130	0.10	75	0.09	120	0.10	390	0.12	30	0.07	–	–	–	–
GL4-S400M02-PM:G8330		0.2	130	0.12	75	0.11	120	0.12	390	0.14	30	0.10	–	–	–	–

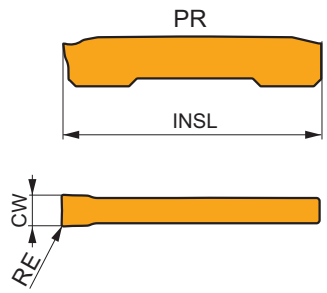


PM geometry with highly positive rake on single sided insert, first choice for deep parting-off, and continuous to slightly interrupted cuts.

GL. S - PR

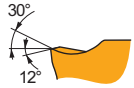
PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



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

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
GL3-S300M02-PR:G8330		0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
GL4-S400M02-PR:G8330		0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

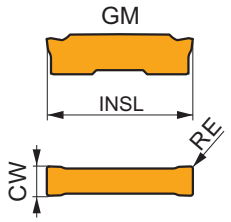


PR geometry with negative T-land on single sided insert, first choice for difficult deep grooving and parting-off, and continuous to interrupted cuts.

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



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	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
																			
GL2-D200M02-GM:G8330	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–

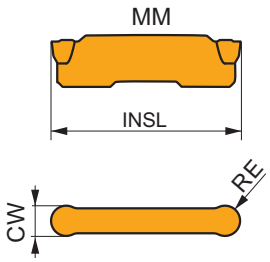
GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.

[1] Usable only in holders with CDX ≥ 24.

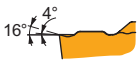
GL. D - MM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0

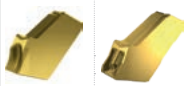
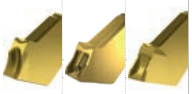
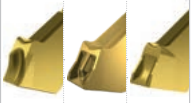
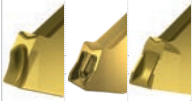
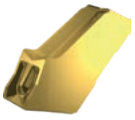
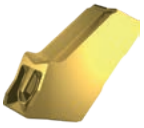


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
																			
GL2-D200MM0-MM:G8330	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–

MM geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.

LFMX – BLADES & ACCESSORIES NAVIGATOR

INSERT SEAT	1.60	2.00	3.00	4.00	5.00	6.35
XLCFN B Blades H = 26 mm H = 32; 45 mm						
XLCF(NRL) BS MS Blades						
Cutting width (mm) CW	1.5 / 1.6	2.0 / 2.2	3.1	4.1	5.1	6.35
Parting-off inserts (sharp / with T-land)	 F1 F2	 F1 F2 M2	 F1 F2 M2	 F1 F2 M2	 F2	 F2

MS-EN

- Modular Tool Holder
- Shank sizes:
  20 × 20, 25 × 25, 32 × 32 mm

DU, D

- Tool Holder Block
- Shank sizes:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm

XLCFN B

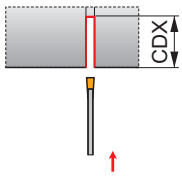
P M K N S H

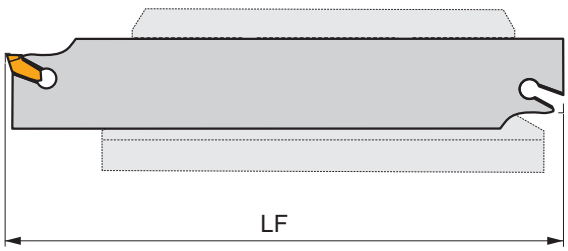
PRAMET

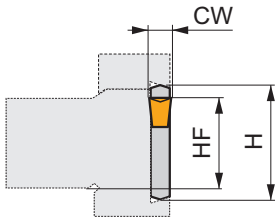
X

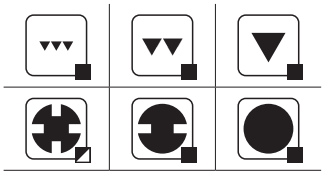
Double-Ended Parting-off Blade for LFMX Inserts

Blade for parting-off applications Suited for single-sided LFMX inserts. Can be fitted into the DU Pramet basic holders. Blade treated for longer tool life.









	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	XLCFN 2601 J 1.60	21.4	26	110	1.50	15	0.06	GI132	KV
	XLCFN 2601 J 2.00	21.4	26	110	2.00	25	0.07	GI061	KV
	XLCFN 2602 J 3.00	21.4	26	110	3.10	37.5	0.08	GI001	KV
	XLCFN 2603 J 4.00	21.4	26	110	4.10	40	0.10	GI002	KV
	XLCFN 3201 M 1.60	25	32	150	1.50	15	0.11	GI132	KV
	XLCFN 3201 M 2.00	25	32	150	2.00	25	0.11	GI061	KV
	XLCFN 3202 M 3.00	25	32	150	3.10	50	0.08	GI001	KV
	XLCFN 3203 M 4.00	25	32	150	4.10	50	0.14	GI002	KV
	XLCFN 3204 M 5.00	25	32	150	5.10	60	0.18	GI004	KV
	XLCFN 3205 M 6.35	25	32	150	6.35	60	0.21	GI005	KV
	XLCFN 4502 S 3.00	32	45	250	3.10	80	0.25	GI001	KV
	XLCFN 4503 S 4.00	32	45	250	4.10	80	0.33	GI002	KV
	XLCFN 4504 S 5.00	32	45	250	5.10	80	0.41	GI004	KV
	XLCFN 4505 S 6.35	32	45	250	6.35	80	0.48	GI005	KV

GI001	LFMX 3.1-.	–
GI002	LFMX 4.1-.	–
GI004	LFMX 5.1-.	–
GI005	LFMX 6.35-.	–
GI061	LFMX 2.0-.	LFMX 2.2-.
GI132	LFMX 1.5-.	LFMX 1.6-.

KV	KV 5x70

XLCF(NRL) BS

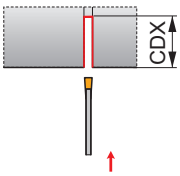
P M K N S H

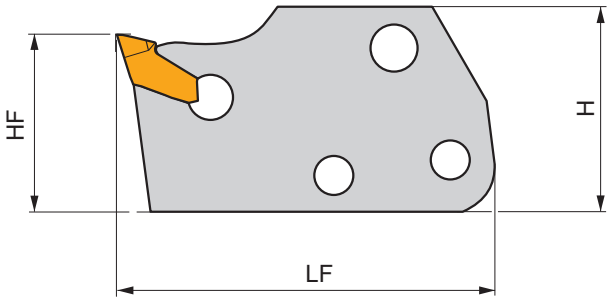
PRAMET

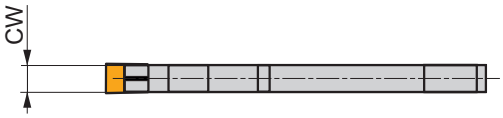
X

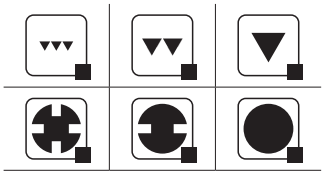
Radial Grooving Blade for Modular MS-EN Tool Holder for LFMX Inserts

Modular grooving blade for grooving with single-sided LFMX inserts. Suited for grooving or parting-off (max. 25 mm cutting depth) applications. Blades treated for longer tool life.









	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
R	XLCFR 160115-1.60	12	25	35	1.50	15	0.03	GI132	KV
	XLCFR 160115-2.00	12	25	35	2.00	15	0.01	GI061	KV
	XLCFR 250115-1.60	24	29	40	1.50	15	0.01	GI132	KV
	XLCFR 250115-2.00	24	29	40	2.00	15	0.05	GI061	KV
L	XLCFL 160115-1.60	12	25	35	1.50	15	0.03	GI132	KV
	XLCFL 160115-2.00	12	25	35	2.00	15	0.04	GI061	KV
	XLCFL 250115-1.60	24	29	40	1.50	15	0.04	GI132	KV
	XLCFL 250115-2.00	24	29	40	2.00	15	0.05	GI061	KV
N	XLCFN 160215-3.00	12	25	35	3.10	15	0.01	GI001	KV
	XLCFN 160220-3.00	12	25	40	3.10	20	0.04	GI001	KV
	XLCFN 250215-3.00	24	29	40	3.10	15	0.04	GI001	KV
	XLCFN 250225-3.00	24	29	50	3.10	25	0.02	GI001	KV
	XLCFN 250315-4.00	24	29	40	4.10	15	0.04	GI002	KV
	XLCFN 250325-4.00	24	29	50	4.10	25	0.04	GI002	KV
	XLCFN 250425-5.00	24	29	50	5.10	25	0.04	GI004	KV
	XLCFN 250525-6.35	24	29	50	6.35	25	0.07	GI005	KV

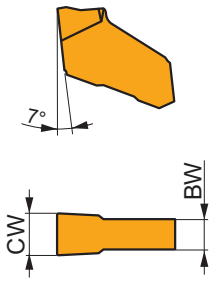
GI001	LFMX 3.1-.	–
GI002	LFMX 4.1-.	–
GI004	LFMX 5.1-.	–
GI005	LFMX 6.35-.	–
GI061	LFMX 2.0-.	LFMX 2.2-.
GI132	LFMX 1.5-.	LFMX 1.6-.

KV	KV 5x70

LFMX - F1

PRAMET

	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.5	1.50	-0.03	0.03	1.30
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60



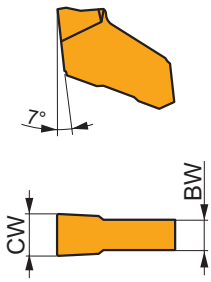
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
EN-F1 geometry for parting-off and grooving, and continuous cuts.																
LFMX 1.5-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 1.6-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 2.0-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 3.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–

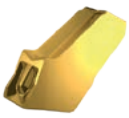
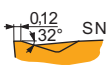
LFMX - F2

PRAMET

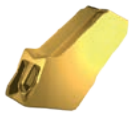
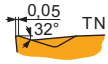
	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



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

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
SN-F2 geometry for parting-off and grooving, and continuous cuts.																
LFMX 1.6-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNF2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

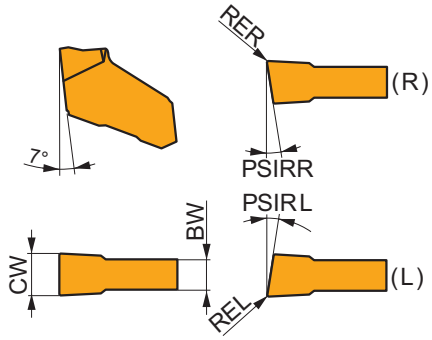
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
TN-F2 geometry for parting-off and grooving, and continuous cuts.																
LFMX 3.1-.20TNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–

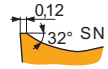
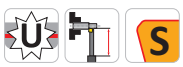
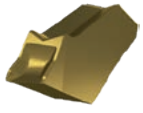
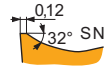
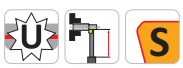
LFMX - M2

PRAMET

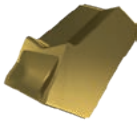
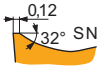
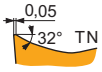
	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
2.0	2.00	-0.03	0.03	1.60
2.2	2.20	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



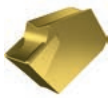
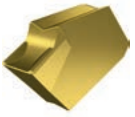
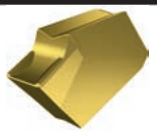
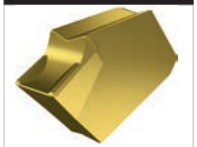
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
SN-M2 geometry for parting-off and grooving, and continuous to slightly interrupted cuts.																
LFMX 2.0-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:6640	⬢	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:T8330	⬢	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:6640	⬢	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:T8330	⬢	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:6640	⬢	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:T8330	⬢	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:6640	⬢	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:T8330	⬢	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
																
SR-M2 geometry, with right-handed design, for parting-off, and continuous to slightly interrupted cuts.																
LFMX 2.0-.16SR12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	12	–
LFMX 2.0-.16SR6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	6	–
LFMX 3.1-.20SR8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	8	–
LFMX 4.1-.20SR8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	8	–

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

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(°)	(°)
																
SL-M2 geometry, with left-handed design, for parting-off, and continuous to slightly interrupted cuts.																
LFMX 2.0-.16SL12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	12
LFMX 2.0-.16SL6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	6
LFMX 3.1-.20SL8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	8
LFMX 4.1-.20SL8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	8
																
TN-M2 geometry for parting-off and grooving, and continuous to slightly interrupted cuts.																
LFMX 3.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

LFUX – BLADES & ACCESSORIES NAVIGATOR

	03	04	05	06		
XLCFN B LFUX H = 26 mm H = 32; 47 mm						
CW	3	4	5			
						
	LFUX	LFUX	LFUX	LFUX		

DU, D

- Tool Holder Block
- Shank sizes:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm

XLCFN B LFUX

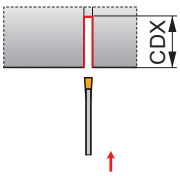
P M K N S H

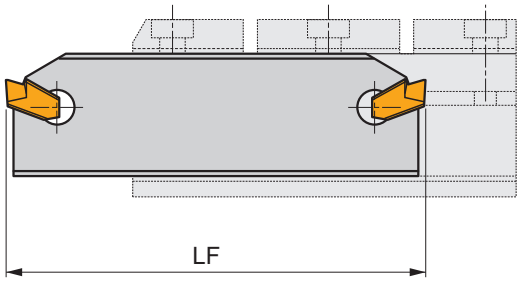
PRAMET

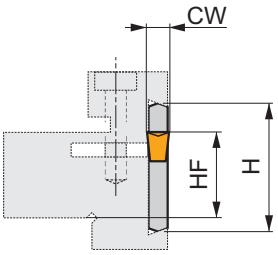
X

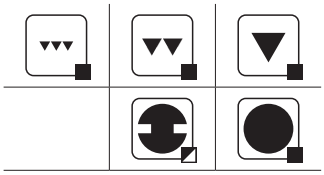
Double-Ended Parting-off Blade for LFUX Inserts

Blade for parting-off applications Suited for single sided LFUX inserts. Available in heights of 26, 32 or 47 mm. Can be fitted into the DU, D Pramet basic holders. Blade treated for longer tool life.









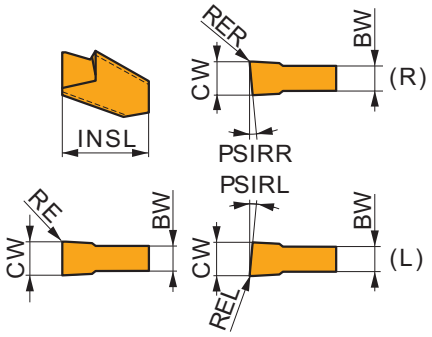
	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	kg		
N	**XLCFN 2603 J 03**	21.4	26	110	3.10	37.5	0.06	GI018	KV
	XLCFN 3202 M 03	25	32	150	3.10	50	0.11	GI018	KV
	XLCFN 3203 M 04	25	32	150	4.10	50	0.15	GI019	KV
	XLCFN 3204 M 05	25	32	150	5.10	60	0.17	GI020	KV
	XLCFN 4704 S 05	38	47	270	5.10	100	0.46	GI020	KV
	XLCFN 4705 S 06	38	47	270	6.10	100	0.50	GI021	KV

GI018	LFUX 0308..
GI019	LFUX 0408..
GI020	LFUX 0508..
GI021	LFUX 0608..

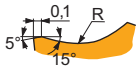
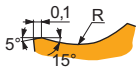
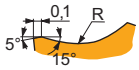
KV	KV 5x70

LFUX

	CW	BW	INSL
	(mm)	(mm)	(mm)
0308	3.00	2.51	11.5
0408	4.00	3.44	11.5
0508	5.00	4.30	11.5
0608	6.00	5.30	11.5



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

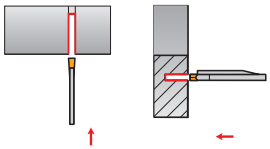
Product	RE	P		M		K		N		S		H		PSIRR	PSIRL
		vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
	(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
															
TN geometry for parting-off and grooving, and continuous to slightly interrupted cuts.															
LFUX 030802TN:6640	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	–	–
LFUX 030802TN:T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	–	–
LFUX 040802TN:6640	0.2	150	0.12	–	–	140	0.12	–	–	–	–	–	–	–	–
LFUX 040802TN:T8330	0.2	130	0.12	–	–	120	0.12	–	–	–	–	–	–	–	–
LFUX 050802TN:6640	0.2	150	0.15	–	–	140	0.15	–	–	–	–	–	–	–	–
LFUX 050802TN:T8330	0.2	130	0.15	–	–	120	0.15	–	–	–	–	–	–	–	–
LFUX 060802TN:6640	0.2	150	0.20	–	–	140	0.20	–	–	–	–	–	–	–	–
LFUX 060802TN:T8330	0.2	130	0.20	–	–	120	0.20	–	–	–	–	–	–	–	–
															
TR geometry, right-handed, for parting-off and continuous to slightly interrupted cuts.															
LFUX 030800TR:6640	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	5	–
LFUX 030800TR:T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	5	–
LFUX 040800TR:6640	0.2	150	0.12	–	–	140	0.12	–	–	–	–	–	–	5	–
LFUX 040800TR:T8330	0.2	130	0.12	–	–	120	0.12	–	–	–	–	–	–	5	–
															
TL geometry, left-handed, for parting-off and continuous to slightly interrupted cuts.															
LFUX 030800TL:6640	0.2	150	0.10	–	–	140	0.10	–	–	–	–	–	–	–	5
LFUX 030800TL:T8330	0.2	130	0.10	–	–	120	0.10	–	–	–	–	–	–	–	5

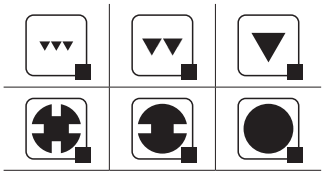
MS-EN

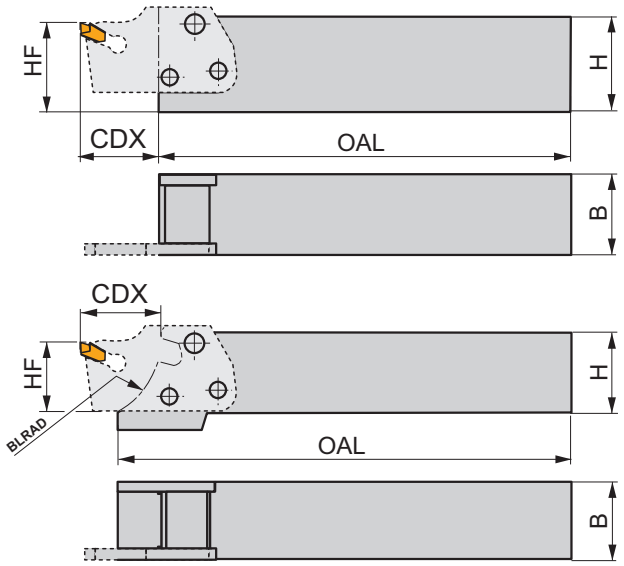
PRAMET

Modular Tool Holder for Grooving and Parting-off Blades

Modular tool holder for BS type grooving and parting-off blades. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	OAL (mm)	BLRAD (mm)	kg		
	MS-EN-1212 F	12	12	12	75	–	0.12	GI006	ND4
	MS-EN-1616 H	16	16	16	90	–	0.21	GI006	ND4
	MS-EN-2020 K	20	20	20	115	–	0.23	GI003	ND5
	MS-EN-2020 KS	20	20	20	129	25	0.42	GI060	ND5
	MS-EN-2525 M	25	25	25	140	–	0.65	GI003	ND5
	MS-EN-2525 MS	25	25	25	153	25	0.73	GI060	ND5
	MS-EN-3225 P	32	32	25	160	–	0.95	GI003	ND5
	MS-EN-3225 PS	32	32	25	174	25	1.00	GI060	ND5

GI003	XLC.. 25..15...	XLC.. 25..25…	GL.BS	XLXFL 25…
GI006	XLCF. 16..15…	XLCF. 16..20…	–	–
GI060	XLC.. 25..15…	XLC.. 25..25…	GL.BS	–

ND4	US 4011-T15P	3.5	M 4	10.6	–	–	–	–	FLAG T15P
ND5	US 45013-T20P	5.0	M 5	13	US 46017-T20P	5.0	M6	17	FLAG T20P

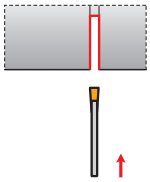
ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

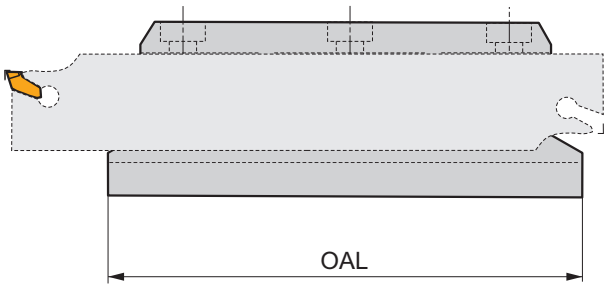
DU, D

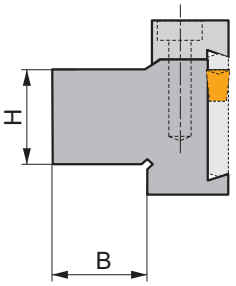
PRAMET

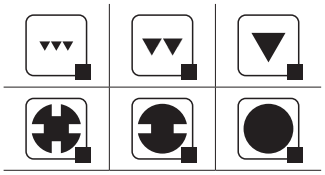
Tool Holder Block for Parting-off Blades

Tool holder to fit GL or XLC. blades for parting-off. Body treated for longer tool life.





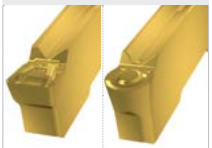
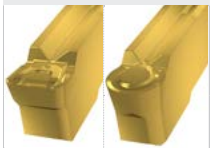




	Product	H (mm)	B (mm)	OAL (mm)	kg		
	26-DU 2020	20	20	90	0.76	GI007	ND2
	26-D 2020	20	20	100	0.82	GI007	ND2
	32-DU 2523	25	23	110	1.06	GI008	ND2
	32-DU 2532	25	32	110	1.24	GI008	ND2
	32-D 2530	25	30	115	1.28	GI008	ND2
	32-DU 3229	32	29	110	1.25	GI008	ND2
	45-DU 3229	32	29	110	1.50	GI009	ND7
	45-DU 4036	40	36	110	2.05	GI009	ND7
	47-D 4040	40	40	150	3.84	GI091	ND3

GI007	XLC.N 26..	GL.-S26.B.
GI008	XLC.N 32..	GL.-S32.B.
GI009	XLC.N 45..	–
GI091	XLC.N 47..	–

		Nm			
ND2	HS 0625	6.0	M 6	25	HXK 5
ND3	HS 1030	8.0	M 10	30	HXK 8
ND7	HS 0630	6.0	M 6	30	HXK 5

INSERT SEAT	LNMX 3.00	GL3	GL4	GL5	GL6	
NEW Face axial, Right 20 × 20 32 × 32						
NEW Face axial, Left 25 × 25 32 × 32						
NEW Face 90°, Right 25 × 25						
MS Blades						
Cutting width (mm) CW	3.1	3	4	5	6	8
Face grooving	 LFMX	 GM	 GM	 GM	 GM	 GM
Face turning Face profiling		 GM MM	 GM MM	 GM MM	 GM MM	 GM

GLSF L-R AXIAL

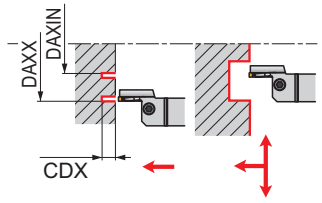
P M K N S H

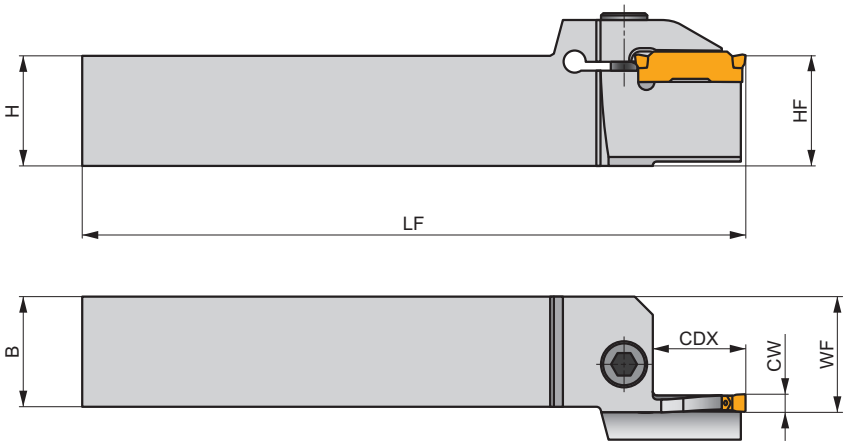
PRAMET

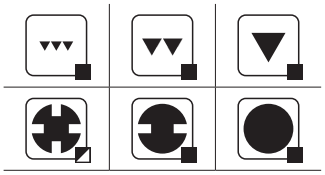
G

Axial Face Grooving tool for GL inserts

Left handed axial face grooving tool holder for GL inserts. Suited for face grooving, turning and profiling applications. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
L	GL3-S2525MFL-12-R035027	25	25	25	26	150	3.00	12	35	27	0.69	GI361	GL16
	GL3-S2525MFL-15-R044033	25	25	25	26	150	3.00	15	44	33	0.68	GI361	GL16
	GL3-S2525MFL-15-R055040	25	25	25	26	150	3.00	15	55	40	0.68	GI361	GL16
	GL3-S2525MFL-20-R080051	25	25	25	26	150	3.00	20	80	51	0.65	GI361	GL16
	GL3-S2525MFL-25-R110076	25	25	25	26	150	3.00	25	110	76	0.63	GI361	GL16
	GL4-S2525MFL-20-R065050	25	25	25	26	150	4.00	20	65	50	0.71	GI362	GL16
	GL4-S2525MFL-20-R095060	25	25	25	26	150	4.00	20	95	60	0.65	GI362	GL16
	GL4-S2525MFL-25-R160090	25	25	25	26	150	4.00	25	160	90	0.63	GI362	GL16
	GL4-S2525MFL-25-R400150	25	25	25	25.7	150	4.00	25	400	150	0.63	GI362	GL16
	GL4-S2525MFL-25-R950380	25	25	25	25.7	150	4.00	25	950	380	0.63	GI362	GL16
	GL5-S2525MFL-25-R095060	25	25	25	25.3	150	5.00	25	95	60	0.63	GI363	GL16
	GL5-S2525MFL-25-R200090	25	25	25	25.3	150	5.00	25	200	90	0.63	GI363	GL16
	GL5-S2525MFL-25-R950180	25	25	25	25.3	150	5.00	25	950	180	0.63	GI363	GL16
	GL6-S2525MFL-25-R095060	25	25	25	25.4	150	6.00	25	95	60	0.69	GI364	GL16
	GL6-S2525MFL-25-R200090	25	25	25	25.4	150	6.00	25	200	90	0.64	GI364	GL16
	GL6-S2525MFL-25-R950180	25	25	25	25.4	150	6.00	25	950	180	0.64	GI364	GL16
	GL6-S3232PFL-32-R200090	32	32	32	32.4	170	6.00	32	200	90	1.20	GI364	GL17
	GL6-S3232PFL-32-R950180	32	32	32	32.4	170	6.00	32	950	180	1.20	GI364	GL17

GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM
GI363	GL5-GM	GL5-MM
GI364	GL6-GM	GL6-MM

		Nm			
GL16	HS 0620	6.0	M6	20	HXK 5
GL17	HS 0825	8.0	M8	25	HXK 6

GLSF R-L AXIAL

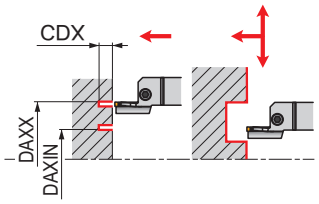
P M K N S H

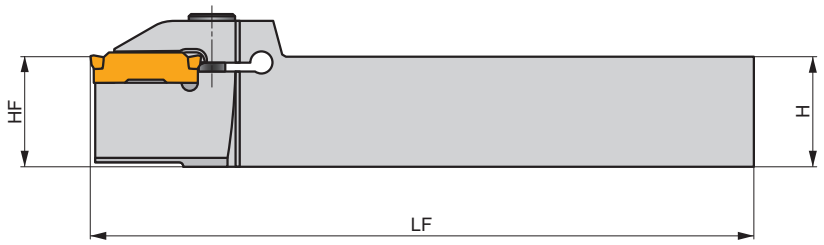
PRAMET

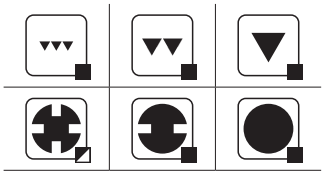
G

Axial Face Grooving tool for GL inserts

Right handed axial face grooving tool holder for GL inserts. Suited for face grooving, turning and profiling applications. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
R	GL3-S2020KFR-12-L035027	20	20	20	20.5	125	3.00	12	35	27	0.40	GI361	GL16
	GL3-S2020KFR-15-L044033	20	20	20	20.5	125	3.00	15	44	33	0.39	GI361	GL16
	GL3-S2020KFR-15-L055040	20	20	20	20.5	125	3.00	15	55	40	0.39	GI361	GL16
	GL3-S2020KFR-20-L080051	20	20	20	20.5	125	3.00	20	80	51	0.38	GI361	GL16
	GL3-S2525MFR-12-L035027	25	25	25	26	150	3.00	12	35	27	0.69	GI361	GL16
	GL3-S2525MFR-15-L044033	25	25	25	26	150	3.00	15	44	33	0.68	GI361	GL16
	GL3-S2525MFR-15-L055040	25	25	25	26	150	3.00	15	55	40	0.68	GI361	GL16
	GL3-S2525MFR-20-L080051	25	25	25	26	150	3.00	20	80	51	0.65	GI361	GL16
	GL3-S2525MFR-25-L110076	25	25	25	26	150	3.00	25	110	76	0.63	GI361	GL16
	GL4-S2525MFR-20-L065050	25	25	25	26	150	4.00	20	65	50	0.66	GI362	GL16
	GL4-S2525MFR-20-L095060	25	25	25	26	150	4.00	20	95	60	0.65	GI362	GL16
	GL4-S2525MFR-25-L160090	25	25	25	26	150	4.00	25	160	90	0.63	GI362	GL16
	GL4-S2525MFR-25-L400150	25	25	25	25.7	150	4.00	25	400	150	0.63	GI362	GL16
	GL4-S2525MFR-25-L950380	25	25	25	25.7	150	4.00	25	950	380	0.63	GI362	GL16
	GL5-S2525MFR-25-L095060	25	25	25	25.3	150	5.00	25	95	60	0.63	GI363	GL16
	GL5-S2525MFR-25-L200090	25	25	25	25.3	150	5.00	25	200	90	0.63	GI363	GL16
	GL5-S2525MFR-25-L950180	25	25	25	25.3	150	5.00	25	950	180	0.63	GI363	GL16
	GL6-S2525MFR-25-L095060	25	25	25	25.4	150	6.00	25	95	60	0.64	GI364	GL16
	GL6-S2525MFR-25-L200090	25	25	25	25.4	150	6.00	25	200	90	0.64	GI364	GL16
	GL6-S2525MFR-25-L950180	25	25	25	25.4	150	6.00	25	950	180	0.64	GI364	GL16
	GL6-S3232PFR-32-L200090	32	32	32	32.4	170	6.00	32	200	90	1.20	GI364	GL17
	GL6-S3232PFR-32-L950180	32	32	32	32.4	170	6.00	32	950	180	1.21	GI364	GL17

GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM
GI363	GL5-GM	GL5-MM
GI364	GL6-GM	GL6-MM

GL16	HS 0620	6.0	M6	20	HXK 5
GL17	HS 0825	8.0	M8	25	HXK 6

GLSG R-R AXIAL

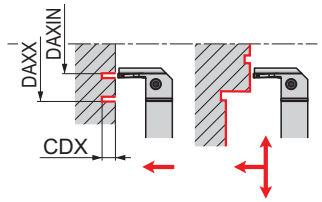
P M K N S H

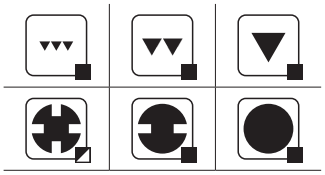
PRAMET

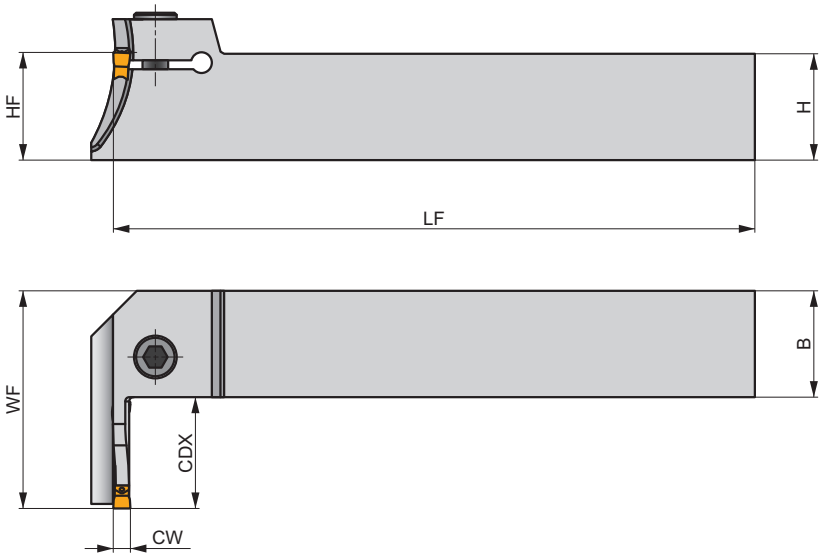
G

Radial Face Grooving tool for GL inserts

Right handed radial face grooving tool holder for GL inserts. Suited for face grooving, turning and profiling applications. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg		
R	GL3-S2525MGR-15-R044033	25	25	25	40.9	150	3.00	15	44	33	0.75	GI361	GL16
	GL3-S2525MGR-15-R055040	25	25	25	40.9	150	3.00	15	55	40	0.75	GI361	GL16
	GL3-S2525MGR-20-R080051	25	25	25	45.9	150	3.00	20	80	51	0.75	GI361	GL16
	GL3-S2525MGR-25-R110076	25	25	25	50.9	150	3.00	25	110	76	0.75	GI361	GL16
	GL4-S2525MGR-20-R065050	25	25	25	46	150	4.00	20	65	50	0.77	GI362	GL16
	GL4-S2525MGR-25-R095060	25	25	25	51	150	4.00	25	95	60	0.76	GI362	GL16
	GL4-S2525MGR-25-R160090	25	25	25	51	150	4.00	25	160	90	0.76	GI362	GL16
	GL4-S2525MGR-25-R400150	25	25	25	51	150	4.00	25	400	150	0.75	GI362	GL16

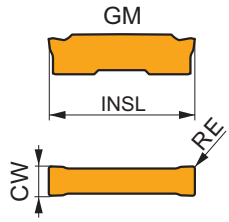
GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM

		Nm			
GL16	HS 0620	6.0	M6	20	HXK 5

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



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	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
GL2-D200M02-GM:G8330	0.2	■	190	0.10	0.8	■	110	0.09	0.8	■	180	0.10	0.8	–	–	–	◪	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	0.2	◪	220	0.10	0.8	■	170	0.09	0.8	■	205	0.10	0.8	–	–	–	◪	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	0.2	■	150	0.20	1.0	■	90	0.18	1.0	■	140	0.20	1.0	–	–	–	◪	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	0.2	◪	175	0.20	1.0	■	135	0.18	1.0	■	165	0.20	1.0	–	–	–	◪	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	0.4	■	160	0.20	1.0	■	95	0.18	1.0	■	150	0.20	1.0	–	–	–	◪	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	0.4	◪	185	0.20	1.0	■	140	0.18	1.0	■	175	0.20	1.0	–	–	–	◪	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	0.4	■	150	0.25	1.2	■	90	0.23	1.2	■	140	0.25	1.2	–	–	–	◪	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	0.4	◪	170	0.25	1.2	■	130	0.23	1.2	■	160	0.25	1.2	–	–	–	◪	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	0.8	■	180	0.25	1.2	■	105	0.23	1.2	■	170	0.25	1.2	–	–	–	◪	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	0.8	◪	200	0.25	1.2	■	155	0.23	1.2	■	190	0.25	1.2	–	–	–	◪	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	0.8	■	170	0.30	1.2	■	100	0.27	1.2	■	160	0.30	1.2	–	–	–	◪	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	0.8	◪	190	0.30	1.2	■	145	0.27	1.2	■	180	0.30	1.2	–	–	–	◪	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	0.8	■	170	0.30	1.2	■	100	0.27	1.2	■	160	0.30	1.2	–	–	–	◪	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	0.8	◪	190	0.30	1.2	■	145	0.27	1.2	■	180	0.30	1.2	–	–	–	◪	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	0.8	■	170	0.30	1.2	■	100	0.27	1.2	■	160	0.30	1.2	–	–	–	◪	40	0.21	1.2	–	–	–

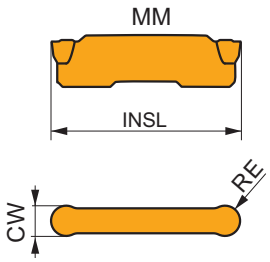
[1] Usable only in holders with CDX ≥ 24.

GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.

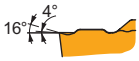
GL. D - MM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



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	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
GL2-D200MM0-MM:G8330	1.0	■	250	0.10	1.0	■	150	0.09	1.0	■	235	0.10	1.0	–	–	–	◪	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	1.0	◪	285	0.10	1.0	■	220	0.09	1.0	■	270	0.10	1.0	–	–	–	◪	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	1.5	■	210	0.20	1.2	■	125	0.18	1.2	■	195	0.20	1.2	–	–	–	◪	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	1.5	◪	240	0.20	1.2	■	185	0.18	1.2	■	225	0.20	1.2	–	–	–	◪	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	2.0	■	220	0.20	1.2	■	130	0.18	1.2	■	205	0.20	1.2	–	–	–	◪	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	2.0	◪	250	0.20	1.2	■	195	0.18	1.2	■	235	0.20	1.2	–	–	–	◪	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	2.5	■	205	0.25	1.2	■	120	0.23	1.2	■	190	0.25	1.2	–	–	–	◪	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	2.5	◪	235	0.25	1.2	■	180	0.23	1.2	■	220	0.25	1.2	–	–	–	◪	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	3.0	■	195	0.30	1.2	■	115	0.27	1.2	■	185	0.30	1.2	–	–	–	◪	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	3.0	◪	220	0.30	1.2	■	170	0.27	1.2	■	205	0.30	1.2	–	–	–	◪	70	0.21	1.0	–	–	–

MM geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.

XLXFL BS AXIAL

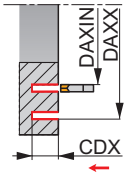
P M K N S H

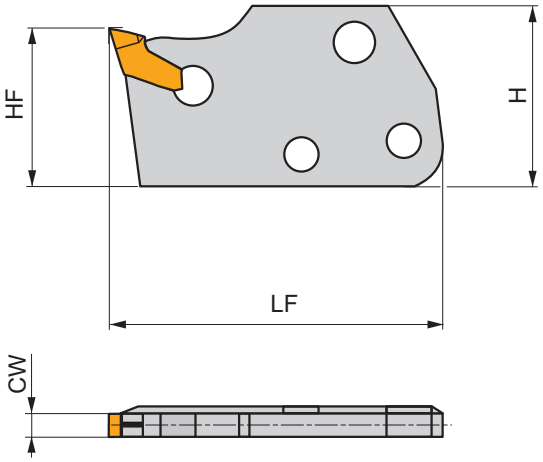
PRAMET

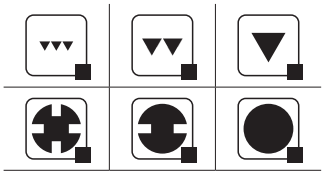
X

Axial Grooving Blade for Modular MS-EN Tool Holder for LFMX Inserts

Modular grooving blade for grooving with single-sided LFMX inserts. Suited for axial grooving (max. 20 mm cutting depth) applications. Can be fitted to MS-EN tool holder. Blades treated for longer tool life.







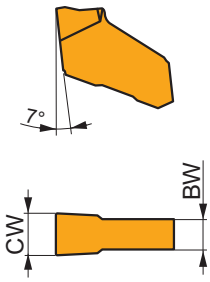
	Product	H	HF	LF	CW	CDX	DAXIN	DAXX	kg		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			
L	**XLXFL 250220-3.00-60**	29	24	46	3.10	20	60	85	0.05	GI001	KV
	XLXFL 250220-3.00-80	29	24	46	3.10	20	80	105	0.05	GI001	KV
	XLXFL 250220-3.00-100	29	24	46	3.10	20	100	155	0.03	GI001	KV
	XLXFL 250220-3.00-150	29	24	46	3.10	20	150	280	0.03	GI001	KV

GI001	LFMX 3.1-.

KV	KV 5x70

LFMX - F1

	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.5	1.50	-0.03	0.03	1.30
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60



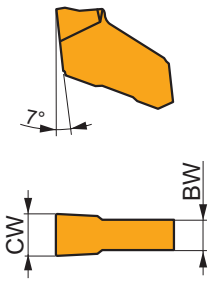
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
LFMX 1.5-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 1.6-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 2.0-.16ENF1:T8330	●	0.2	130	0.08	75	0.07	120	0.08	–	–	–	–	–	–	–	–
LFMX 3.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20ENF1:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–


EN-F1 geometry for parting-off and grooving, and continuous cuts.

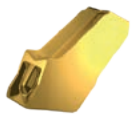
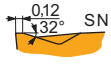
LFMX - F2

	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
1.6	1.60	-0.03	0.03	1.30
2.0	2.00	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



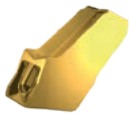
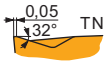
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
LFMX 1.6-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNF2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

SN-F2 geometry for parting-off and grooving, and continuous cuts.

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

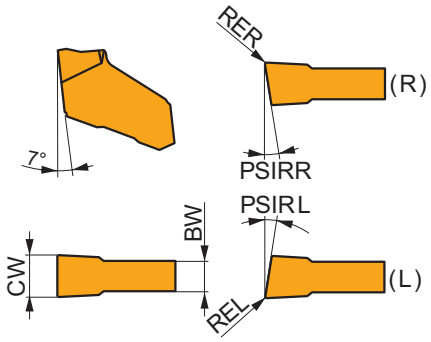
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
																
LFMX 3.1-.20TNF2:6640	●	0.2	150	0.10	90	0.09	140	0.10	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNF2:T8330	●	0.2	130	0.10	75	0.09	120	0.10	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNF2:T8330	●	0.2	130	0.12	75	0.11	120	0.12	–	–	–	–	–	–	–	–

TN-F2 geometry for parting-off and grooving, and continuous cuts.

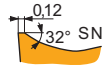
LFMX - M2

PRAMET

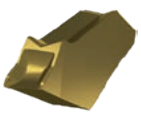
	CW	CWTOLL	CWTOLU	BW
	(mm)	(mm)	(mm)	(mm)
2.0	2.00	-0.03	0.03	1.60
2.2	2.20	-0.03	0.03	1.60
3.1	3.10	-0.04	0.04	2.60
4.1	4.10	-0.04	0.04	3.60
5.1	5.10	-0.04	0.04	4.60
6.35	6.35	-0.04	0.04	5.80



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

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
																
LFMX 2.0-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.0-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:6640	●	0.2	150	0.11	90	0.10	140	0.11	–	–	–	–	–	–	–	–
LFMX 2.2-.16SNM2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20SNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20SNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:6640	●	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 5.1-.20SNM2:T8330	●	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:6640	●	0.2	150	0.20	90	0.18	140	0.20	–	–	–	–	–	–	–	–
LFMX 6.35-.20SNM2:T8330	●	0.2	130	0.20	75	0.18	120	0.20	–	–	–	–	–	–	–	–

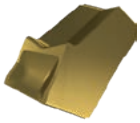
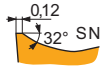
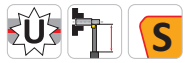
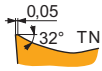
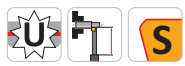
SN-M2 geometry for parting-off and grooving, and continuous to slightly interrupted cuts.

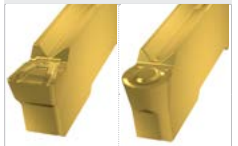


LFMX 2.0-.16SR12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	12	–
LFMX 2.0-.16SR6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	6	–
LFMX 3.1-.20SR8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	8	–
LFMX 4.1-.20SR8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	8	–

SR-M2 geometry, with right-handed design, for parting-off, and continuous to slightly interrupted cuts.

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

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
SL-M2 geometry, with left-handed design, for parting-off, and continuous to slightly interrupted cuts.																
LFMX 2.0-.16SL12M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	12
LFMX 2.0-.16SL6M2:T8330	●	0.2	130	0.09	75	0.08	120	0.09	–	–	–	–	–	–	–	6
LFMX 3.1-.20SL8M2:T8330	●	0.2	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	8
LFMX 4.1-.20SL8M2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	8
																
TN-M2 geometry for parting-off and grooving, and continuous to slightly interrupted cuts.																
LFMX 3.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 3.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:6640	●	0.2	150	0.15	90	0.14	140	0.15	–	–	–	–	–	–	–	–
LFMX 4.1-.20TNM2:T8330	●	0.2	130	0.15	75	0.14	120	0.15	–	–	–	–	–	–	–	–

INSERT SEAT	0313	0413	GL2	GL3	GL4
GG.(RL) INT DCON MS = 16 – 25 mm DMIN = 16 mm					
GLAG (RL)INT DCON MS = 25 – 40 mm DMIN = 32 mm					
Cutting width (mm) CW	3	4	2	3	4
Grooving (internal)	 CM F	 CM F	 GM	 GM	 GM
Turning / Profiling (internal)	 F MP	 F MP	 GM MM	 GM MM	 GM MM

GLAG (RL) INT

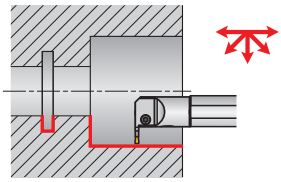
P M K N S H

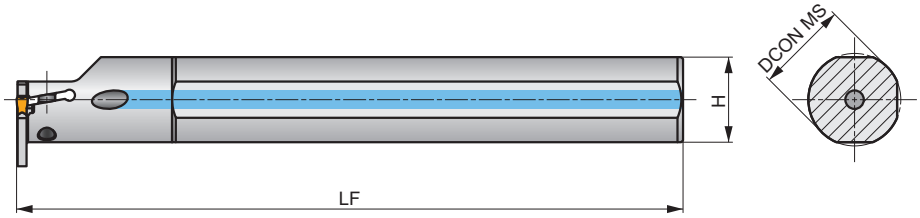
PRAMET

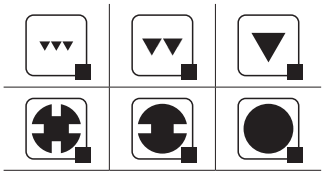
G

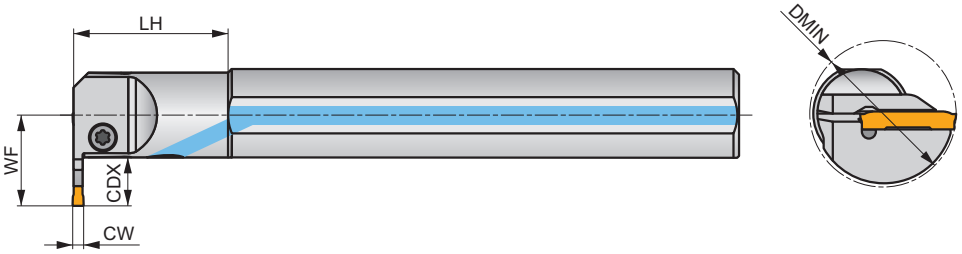
Internal Grooving tool for GL inserts

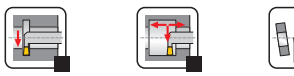
Internal Right/Left handed tool holder with internal coolant for GL inserts, designed with reinforced seating and blade for security. Suited for internal grooving, turning and profiling applications. Body treated for longer tool life.











	Product	DCON MS (mm)	H (mm)	WF (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
R	GL2-A25QGR-06-32	25	23	18.5	180	41.2	2.00	6	32	✓	0.57	GI360	GL14
	GL2-A25QGR-10-38	25	23	22.5	180	41.2	2.00	10	38	✓	0.57	GI360	GL14
	GL3-A25QGR-06-32	25	23	18.5	180	42.0	3.00	6	32	✓	0.57	GI361	GL14
	GL3-A25QGR-12-38	25	23	24.5	180	42.0	3.00	12	38	✓	0.58	GI361	GL14
	GL4-A25QGR-06-40	25	23	18.6	180	43.0	4.00	6	40	✓	0.58	GI362	GL14
	GL4-A25QGR-12-40 [1]	25	23	24.6	180	43.0	4.00	12	40	✓	0.58	GI365	GL14
	GL2-A32SGR-06-40	32	30	22	250	51.2	2.00	6	40	✓	1.38	GI360	GL14
	GL2-A32SGR-10-45	32	30	26	250	51.2	2.00	10	45	✓	1.30	GI360	GL14
	GL3-A32SGR-06-40	32	30	22	250	52.0	3.00	6	40	✓	1.38	GI361	GL14
	GL3-A32SGR-12-45	32	30	28	250	52.0	3.00	12	45	✓	1.30	GI361	GL14
	GL4-A32SGR-06-40	32	30	22.1	250	53.0	4.00	6	40	✓	1.39	GI362	GL14
	GL4-A32SGR-12-45 [1]	32	30	28.1	250	53.0	4.00	12	45	✓	1.39	GI365	GL14
	GL3-A40TGR-12-54	40	38	32	300	52.0	3.00	12	54	✓	2.69	GI361	GL14
	GL4-A40TGR-12-56 [1]	40	38	32.1	300	53.0	4.00	12	56	✓	2.60	GI365	GL14
	GL4-A40TGR-20-62 [1]	40	38	40.1	300	53.0	4.00	20	62	✓	2.70	GI365	GL14
L	GL2-A25QGL-06-32	25	23	18.5	180	41.2	2.00	6	32	✓	0.57	GI360	GL14
	GL2-A25QGL-10-38	25	23	22.5	180	41.2	2.00	10	38	✓	0.57	GI360	GL14
	GL3-A25QGL-06-32	25	23	18.5	180	42.0	3.00	6	32	✓	0.57	GI361	GL14
	GL3-A25QGL-12-38	25	23	24.5	180	42.0	3.00	12	38	✓	0.58	GI361	GL14
	GL4-A25QGL-06-40	25	23	18.6	180	43.0	4.00	6	40	✓	0.58	GI362	GL14
	GL4-A25QGL-12-40 [1]	25	23	24.6	180	43.0	4.00	12	40	✓	0.58	GI365	GL14
	GL2-A32SGL-06-40	32	30	22	250	51.2	2.00	6	40	✓	1.38	GI360	GL14
	GL2-A32SGL-10-45	32	30	26	250	51.2	2.00	10	45	✓	1.38	GI360	GL14
	GL3-A32SGL-06-40	32	30	22	250	52.0	3.00	6	40	✓	1.30	GI361	GL14
	GL3-A32SGL-12-45	32	30	28	250	52.0	3.00	12	45	✓	1.38	GI361	GL14
	GL4-A32SGL-06-40	32	30	22.1	250	53.0	4.00	6	40	✓	1.39	GI362	GL14
	GL4-A32SGL-12-45 [1]	32	30	28.1	250	53.0	4.00	12	45	✓	1.30	GI365	GL14

	Product	DCON MS (mm)	H (mm)	WF (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
L	**GL3-A40TGL-12-54**	40	38	32	300	52.0	3.00	12	54	✓	2.60	GI361	GL14
	GL4-A40TGL-12-56 [1]	40	38	32.1	300	53.0	4.00	12	56	✓	2.70	GI365	GL14
	GL4-A40TGL-20-62 [1]	40	38	40.1	300	53.0	4.00	20	62	✓	2.70	GI365	GL14

[1] Geometry MM is applicable only when DMIN >= 68 mm.

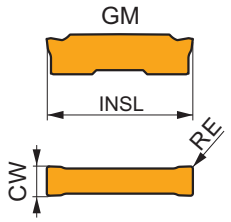
GI360	GL2-GM	GL2-MM
GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM

		Nm			
GL14	US 5015-T20P	5.0	M 5	15	LK T20P

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	25.0
600	6.00	-0.05	0.05	25.0
800	8.00	-0.05	0.05	25.0



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	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
																			
GL2-D200M02-GM:G8330	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	–	–	–	45	0.08	0.6	–	–	–
GL2-D200M02-GM:T7325	0.2	220	0.10	0.8	170	0.09	0.8	205	0.10	0.8	–	–	–	70	0.08	0.6	–	–	–
GL3-D300M02-GM:G8330	0.2	150	0.20	1.0	90	0.18	1.0	140	0.20	1.0	–	–	–	35	0.14	0.8	–	–	–
GL3-D300M02-GM:T7325	0.2	175	0.20	1.0	135	0.18	1.0	165	0.20	1.0	–	–	–	55	0.14	0.8	–	–	–
GL3-D300M04-GM:G8330	0.4	160	0.20	1.0	95	0.18	1.0	150	0.20	1.0	–	–	–	40	0.14	0.8	–	–	–
GL3-D300M04-GM:T7325	0.4	185	0.20	1.0	140	0.18	1.0	175	0.20	1.0	–	–	–	60	0.14	0.8	–	–	–
GL4-D400M04-GM:G8330	0.4	150	0.25	1.2	90	0.23	1.2	140	0.25	1.2	–	–	–	35	0.18	1.0	–	–	–
GL4-D400M04-GM:T7325	0.4	170	0.25	1.2	130	0.23	1.2	160	0.25	1.2	–	–	–	55	0.18	1.0	–	–	–
GL4-D400M08-GM:G8330	0.8	180	0.25	1.2	105	0.23	1.2	170	0.25	1.2	–	–	–	45	0.18	1.0	–	–	–
GL4-D400M08-GM:T7325	0.8	200	0.25	1.2	155	0.23	1.2	190	0.25	1.2	–	–	–	65	0.18	1.0	–	–	–
GL5-D500M08-GM:G8330	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL5-D500M08-GM:T7325	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D600M08-GM:G8330	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.0	–	–	–
GL6-D600M08-GM:T7325	0.8	190	0.30	1.2	145	0.27	1.2	180	0.30	1.2	–	–	–	60	0.21	1.0	–	–	–
GL6-D800M08-GM:G8330 [1]	0.8	170	0.30	1.2	100	0.27	1.2	160	0.30	1.2	–	–	–	40	0.21	1.2	–	–	–

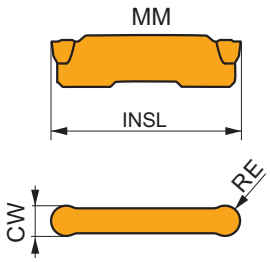
GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.

[1] Usable only in holders with CDX ≥ 24.

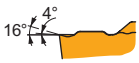
GL. D - MM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
200	2.00	-0.05	0.05	25.0
300	3.00	-0.05	0.05	25.0
400	4.00	-0.05	0.05	25.0
500	5.00	-0.05	0.05	26.0
600	6.00	-0.05	0.05	26.0



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	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																			
																			
GL2-D200MM0-MM:G8330	1.0	250	0.10	1.0	150	0.09	1.0	235	0.10	1.0	–	–	–	60	0.08	0.8	–	–	–
GL2-D200MM0-MM:T7325	1.0	285	0.10	1.0	220	0.09	1.0	270	0.10	1.0	–	–	–	90	0.08	0.8	–	–	–
GL3-D300MM0-MM:G8330	1.5	210	0.20	1.2	125	0.18	1.2	195	0.20	1.2	–	–	–	50	0.14	1.0	–	–	–
GL3-D300MM0-MM:T7325	1.5	240	0.20	1.2	185	0.18	1.2	225	0.20	1.2	–	–	–	75	0.14	1.0	–	–	–
GL4-D400MM0-MM:G8330	2.0	220	0.20	1.2	130	0.18	1.2	205	0.20	1.2	–	–	–	55	0.14	1.0	–	–	–
GL4-D400MM0-MM:T7325	2.0	250	0.20	1.2	195	0.18	1.2	235	0.20	1.2	–	–	–	80	0.14	1.0	–	–	–
GL5-D500MM0-MM:G8330	2.5	205	0.25	1.2	120	0.23	1.2	190	0.25	1.2	–	–	–	50	0.18	1.0	–	–	–
GL5-D500MM0-MM:T7325	2.5	235	0.25	1.2	180	0.23	1.2	220	0.25	1.2	–	–	–	75	0.18	1.0	–	–	–
GL6-D600MM0-MM:G8330	3.0	195	0.30	1.2	115	0.27	1.2	185	0.30	1.2	–	–	–	45	0.21	1.0	–	–	–
GL6-D600MM0-MM:T7325	3.0	220	0.30	1.2	170	0.27	1.2	205	0.30	1.2	–	–	–	70	0.21	1.0	–	–	–

MM geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.

GG.(RL) INT

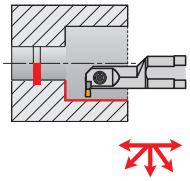
P M K N S H

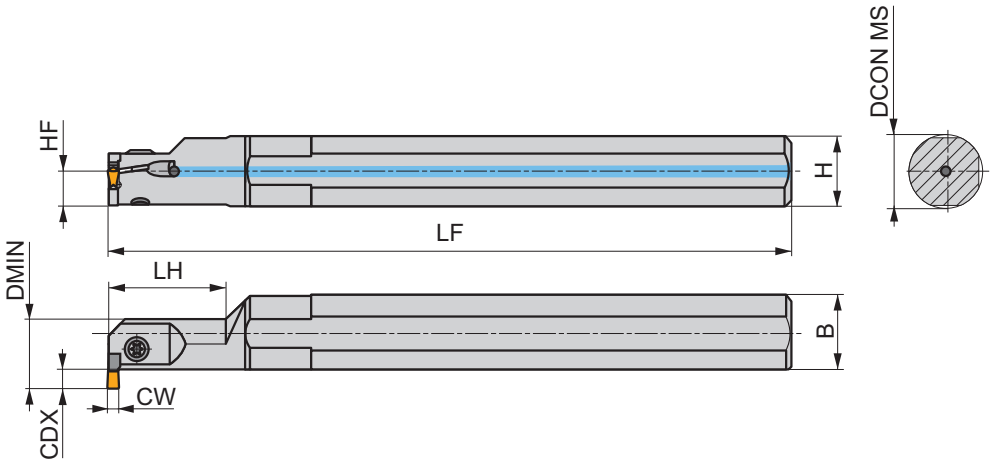
PRAMET

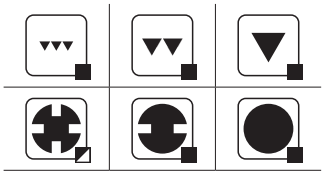
G

Internal Grooving Boring Bar for LCM. Inserts

Internal Right/Left hand grooving boring bar for grooving with LCM. inserts. Suited for internal grooving and multi-directional turning. Body treated for longer tool life.







	Product	DCON MS (mm)	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		kg		
R	A16Q-GGER 0313	16	7.5	15	15.5	180	25.0	3.00	3	16	✓	0.26	GI143	GL06
	A20R-GGFR 0313	20	9	18	19	200	30.0	3.00	4.5	20	✓	0.38	GI143	GL06
	A25S-GGHR 0313	25	11.5	23	24	250	40.0	3.00	6.5	25	✓	0.78	GI143	GL06
	A25S-GGFR 0413	25	11.5	23	24	250	40.0	4.00	6.5	25	✓	0.78	GI170	GL06
L	A16Q-GGEL 0313	16	7.5	15	15.5	180	25.0	3.00	3	16	✓	0.27	GI143	GL06
	A20R-GGFL 0313	20	9	18	19	200	30.0	3.00	4.5	20	✓	0.38	GI143	GL06
	A25S-GGHL 0313	25	11.5	23	24	250	40.0	3.00	6.5	25	✓	0.78	GI143	GL06

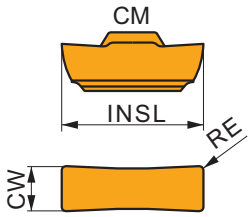
GI143	LCM. 0313..
GI170	LCM. 0413..

		Nm			
GL06	SR 85011-T15P	5.0	M 5	9	FLAG T15P

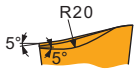
LCMF 13 - CM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



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

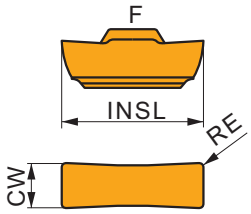
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(°)	(°)
																
LCMF 031304-CM:T8330		0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–
LCMF 041304-CM:T8330		0.4	130	0.11	75	0.10	120	0.11	–	–	–	–	–	–	–	–

CM geometry and first choice for grooving.

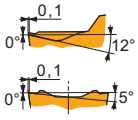
LCMF 13 - F

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



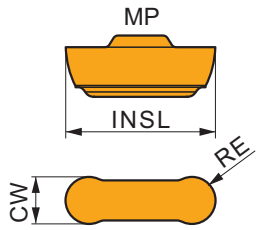
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
																				
LCMF 031302-F:T8330		0.2	195	0.10	0.3	115	0.09	0.3	185	0.10	0.3	–	–	–	–	–	–	–	–	–
LCMF 031304-F:T8330		0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–
LCMF 041304-F:T8330		0.4	185	0.13	0.5	110	0.12	0.5	175	0.13	0.5	–	–	–	–	–	–	–	–	–

F geometry and first choice for turning.

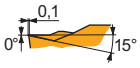
LCMF 13 - MP

	CW	CWTOLL	CWTOLU	INSL
	(mm)	(mm)	(mm)	(mm)
0313	3.00	-0.05	0.05	12.6
0413	4.00	-0.05	0.05	12.6



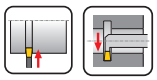
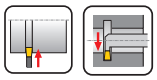
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
LCMF 0313MO-MP:T8330		1.5	190	0.30	0.8	110	0.27	0.8	180	0.30	0.8	–	–	–	–	–	–	–	–	–
LCMF 0413MO-MP:T8330		2.0	175	0.40	1.0	105	0.36	1.0	165	0.40	1.0	–	–	–	–	–	–	–	–	–



MP geometry for longitudinal turning and copy profiling, fine and finish machining, and continuous to interrupted cuts.

O-RING AND CIRCLIPS GROOVING

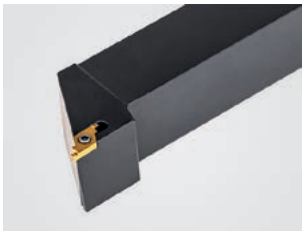
	EXTERNAL		INTERNAL			
P61(RL) EXT 16x16 20x20 25x25	R 	L 				
P61(RL) INT DCON MS = 12 – 32 mm DMIN = 16 – 40 mm			R 	L 		
P61S(RL)-1 INT DCON MS = 10 – 12 mm DMIN = 12.5 mm					R 	L 
Grooving for circlips 	R  **X61** CW = 0,85 – 3,2	L  **X61** CW = 0,85 – 3,2	L  **X61** CW=0,85 – 3,2	R  **X61** CW =0,85 – 3,2	L  **X61-1** CW=0,85 – 2,2	R  **X61-1** CW=0,85 – 2,2
Grooving for o-rings 	R  **X61 R** RE = 1 – 1.5	L  **X61 R** RE = 1 – 1.5	L  **X61 R** RE = 1 – 1.5	R  **X61 R** RE = 1 – 1.5	L  **X61 R-1** RE = 0.5 – 1	R  **X61 R-1** RE = 0.5–1

P61(RL) EXT

P M K N S

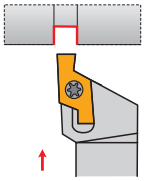
PRAMET

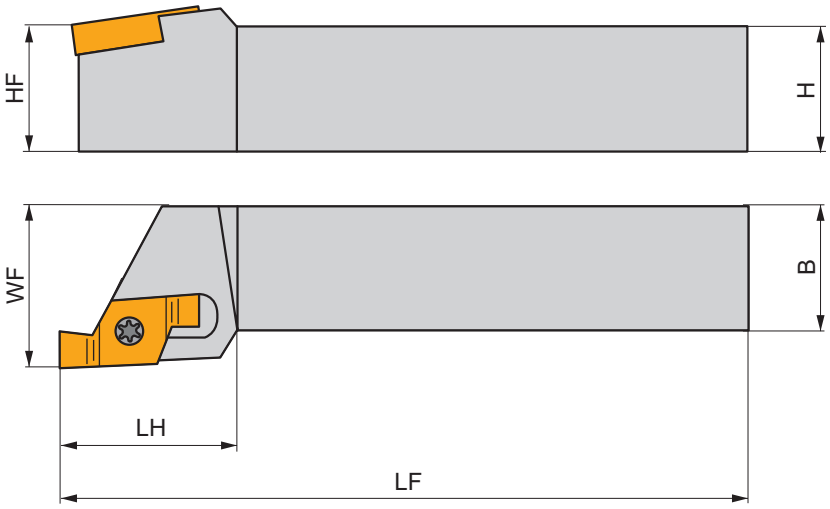
S

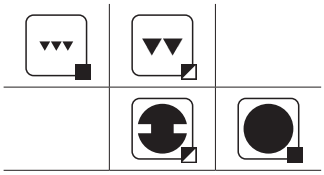


External Grooving Tool Holder for X61 Circlips and O-Ring Inserts

External Right/Left hand radial tool holder for grooving with X61 double-sided circlip or O-ring inserts. Gives smooth cutting action for high tolerated dimensions. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	kg		
R	P61.SFR-1616H-06	16	16	16	20	100	21.0	0.23	GI332_1	SV11
	P61.SFR-2020K-06	20	20	20	25	125	25.0	0.40	GI332_1	SV11
	P61.SFR-2525M-06	25	25	25	32	150	32.0	0.72	GI332_1	SV11
L	P61.SFL-1616H-06	16	16	16	20	100	21.0	0.22	GI332_2	SV11
	P61.SFL-2020K-06	20	20	20	25	125	25.0	0.41	GI332_2	SV11
	P61.SFL-2525M-06	25	25	25	32	150	32.0	0.73	GI332_2	SV11

GI332_1	X61 0602.. R

		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

P61(RL) INT

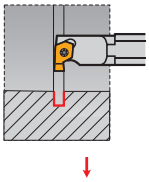
P M K N S

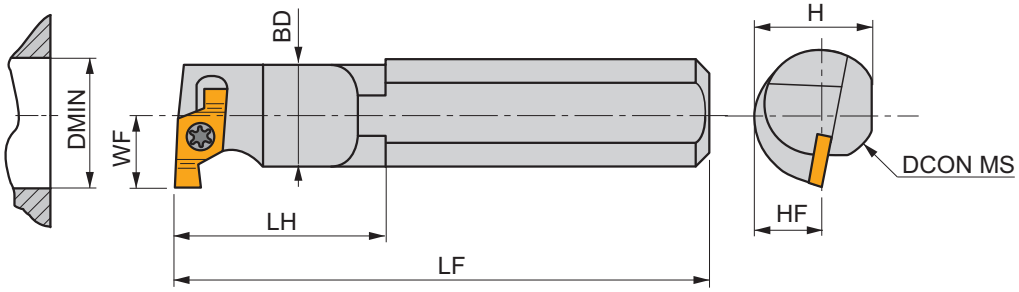
PRAMET

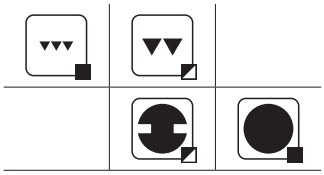
S

Internal Circlip Grooving Boring bar for X61 Inserts

Internal Right/Left hand grooving boring bar for grooving with X61 double-sided inserts. Suited for internal cutting of circlip or O-ring grooves. Body treated for longer tool life.







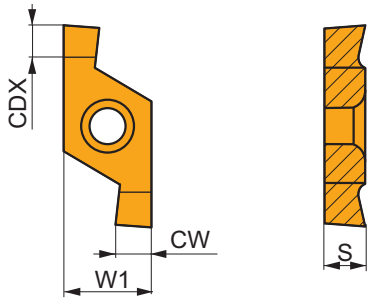
	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	KAPR (°)		kg		
R	P61.SGR-0012M-06	12	16	11.5	9	11	150	22.0	0	–	0.16	GI332_2	SV11
	P61.SGR-A-0016M-06	16	20	15	11	15	150	29.0	0	✓	0.23	GI332_2	SV11
	P61.SGR-A-0020P-06	20	25	19	13	18	170	29.0	0	✓	0.38	GI332_2	SV11
	P61.SGR-A-0025R-06	25	32	24	17	23	200	31.0	0	✓	0.70	GI332_2	SV11
	P61.SGR-A-0032T-06	32	40	31	22	30	300	49.0	0	✓	1.72	GI332_2	SV11
L	P61.SGL-0012M-06	12	16	11.5	9	11	150	22.0	0	–	0.16	GI332_1	SV11
	P61.SGL-A-0016M-06	16	20	15	11	15	150	29.0	0	✓	0.23	GI332_1	SV11
	P61.SGL-A-0020P-06	20	25	19	13	18	170	29.0	0	✓	0.39	GI332_1	SV11
	P61.SGL-A-0025R-06	25	32	24	17	23	200	31.0	0	✓	0.71	GI332_1	SV11
	P61.SGL-A-0032T-06	32	40	31	22	30	300	49.0	0	✓	1.72	GI332_1	SV11

		Nm			
SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

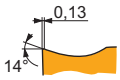
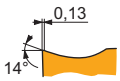
Left hand insert mount to righ hand boring bar.

X 61

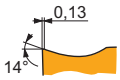
	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



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

Product		RE	P		M		K		N		S		H		CW	CDX
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)
																
X61-R external and internal, right-handed geometry, for o-ring and circlip groove machining, with continuous cuts.																
X61 0602-080 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-080 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-090 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-100 R:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-100 R:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-110 R:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-110 R:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 R:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-130 R:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-150 R:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-150 R:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-160 R:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-160 R:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 R:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-185 R:G8330	●	–	120	0.09	70	0.08	110	0.09	–	–	–	–	–	–	1.90	2
X61 0602-200 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.05	2.2
X61 0602-215 R:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-215 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-250 R:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.55	2.6
X61 0602-265 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-265 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-300 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.05	3
X61 0602-300 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.05	3
X61 0602-315 R:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.20	3
X61 0602-315 R:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.20	3
																
X61-L external and internal, left-handed geometry, for o-ring and circlip groove machining, with continuous cuts.																
X61 0602-080 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-080 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-090 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-100 L:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-100 L:G8330	●	–	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.05	0.8
X61 0602-110 L:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-110 L:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 L:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-130 L:G8330	●	–	140	0.06	80	0.05	130	0.06	–	–	–	–	–	–	1.35	1.4

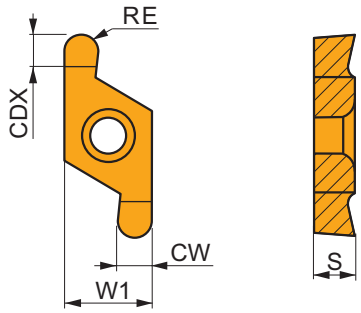
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
 															
X61-L external and internal, left-handed geometry, for o-ring and circlip groove machining, with continuous cuts.															
X61 0602-150 L:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-150 L:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.55	1.6
X61 0602-160 L:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-160 L:G8330	●	–	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 L:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-185 L:G8330	●	–	120	0.09	70	0.08	110	0.09	–	–	–	–	–	–	1.90	2
X61 0602-200 L:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.05	2.2
X61 0602-215 L:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-215 L:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.20	2.4
X61 0602-250 L:G8330	●	–	115	0.09	65	0.08	105	0.09	–	–	–	–	–	–	2.55	2.6
X61 0602-265 L:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-265 L:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	2.70	2.7
X61 0602-300 L:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.05	3
X61 0602-300 L:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.05	3
X61 0602-315 L:6640	●	–	125	0.12	75	0.11	115	0.12	–	–	–	–	–	–	3.20	3
X61 0602-315 L:G8330	●	–	105	0.12	60	0.11	95	0.12	–	–	–	–	–	–	3.20	3

X 61 R

PRAMET

	W1 (mm)	CWTOLL (mm)	CWTOLU (mm)	S (mm)
0602	6.350	-0.03	0.03	2.33



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

Product	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	CW (mm)	CDX (mm)
 															
X61R-R external and internal, right-handed geometry, for o-ring and circlip groove machining, with continuous cuts.															
X61 0602-R100 R:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R100 R:G8330	●	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R150 R:6640	●	1.5	175	0.06	105	0.05	165	0.06	–	–	–	–	–	–	3.09	3
X61 0602-R150 R:G8330	●	1.5	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	3.09	3
 															
X61R-L external and internal, left-handed geometry, for o-ring and circlip groove machining, with continuous cuts.															
X61 0602-R100 L:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R100 L:G8330	●	1.0	130	0.06	75	0.05	120	0.06	–	–	–	–	–	–	2.09	3
X61 0602-R150 L:6640	●	1.5	175	0.06	105	0.05	165	0.06	–	–	–	–	–	–	3.09	3
X61 0602-R150 L:G8330	●	1.5	135	0.06	80	0.05	125	0.06	–	–	–	–	–	–	3.09	3

P61S(RL)-1 INT

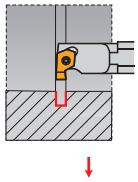
P M K N S

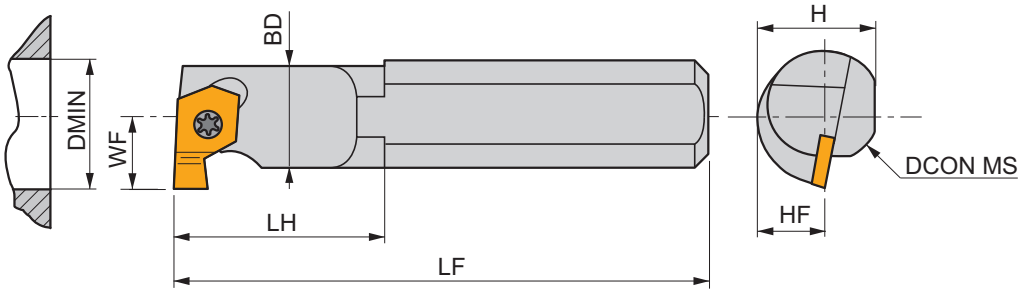
PRAMET

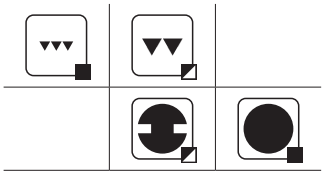
S

Internal Circlip Grooving Boring Bar for X61-1 Inserts

Internal Right/Left hand grooving boring bar for grooving with single-sided X61-1 inserts. Suited for internal cutting of circlip or O-ring grooves. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	KAPR (°)	kg		
R	**P61.SGR-0010M-06/1**	10	12.5	10	7.5	9	150	19.0	0	0.12	GI333_2	SV11
	P61.SGR-0012M-06/1	12	12.5	10	7.5	11	150	19.0	0	0.16	GI333_2	SV11
L	**P61.SGL-0010M-06/1**	10	12.5	10	7.5	9	150	19.0	0	0.12	GI333_1	SV11
	P61.SGL-0012M-06/1	12	12.5	10	7.5	11	150	19.0	0	0.16	GI333_1	SV11

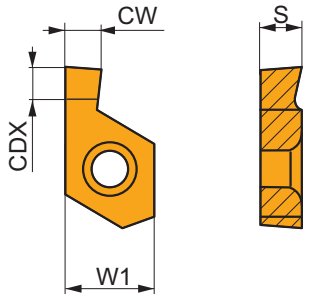
GI333_1	X61 0602..-1 R

SV11	US 2003-T07P	0.8	M 2.5	6.5	FLAG T07P

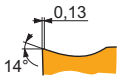
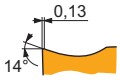
Left hand insert mount to righ hand boring bar.

X 61-1

	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33

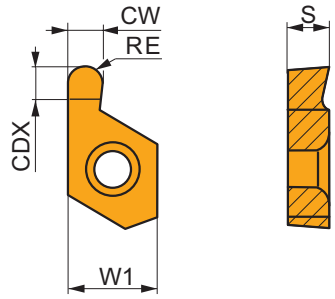


Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		CW	CDX
			vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	vc (m/min)	f (mm/rev)	(mm)	(mm)
																
X61-1-R internal, right-handed design, with one cutting edge for o-ring and circlip groove machining, with continuous cuts.																
X61 0602-080 R1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 R1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-110 R1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 R1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-160 R1:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 R1:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-215 R1:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.2
																
X61-1-L internal, left-handed design, with one cutting edge for o-ring and circlip groove machining, with continuous cuts.																
X61 0602-080 L1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.85	0.8
X61 0602-090 L1:6640	●	–	195	0.06	115	0.05	185	0.06	–	–	–	–	–	–	0.95	0.8
X61 0602-110 L1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.15	1.2
X61 0602-130 L1:6640	●	–	185	0.06	110	0.05	175	0.06	–	–	–	–	–	–	1.35	1.4
X61 0602-160 L1:6640	●	–	180	0.06	105	0.05	170	0.06	–	–	–	–	–	–	1.65	1.7
X61 0602-185 L1:6640	●	–	150	0.09	90	0.08	140	0.09	–	–	–	–	–	–	1.90	2
X61 0602-215 L1:6640	●	–	145	0.09	85	0.08	135	0.09	–	–	–	–	–	–	2.20	2.2

X 61 R-1

	W1	CWTOLL	CWTOLU	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	-0.03	0.03	2.33



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

Product		RE	P		M		K		N		S		H		CW	CDX
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f		
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)
																
X61 0602-R050 R1:6640	●	0.5	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.09	1.3
X61 0602-R100 R1:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	2.8
																
X61 0602-R050 L1:6640	●	0.5	145	0.06	85	0.05	135	0.06	–	–	–	–	–	–	1.09	1.3
X61 0602-R100 L1:6640	●	1.0	170	0.06	100	0.05	160	0.06	–	–	–	–	–	–	2.09	2.8

X 61 R-1-R internal, right-handed design, with one cutting edge for o-ring and circlip groove machining, with continuous cuts.

X 61 R-1-L internal, left-handed design, with one cutting edge for o-ring and circlip groove machining, with continuous cuts.

THREAD TURNING

THEARDING – CONTENT

FULL PROFILE

EXTERNAL

ECONOMY LINE -P1 (directly pressed)

- M 60°
- UN 60°
- W 55°
- NPT 60°

PRECISION LINE (all-ground)

- M 60°
- M-AL 60°
- UN 60°
- W 55°
- TR-S 30°

INTERNAL

ECONOMY LINE -P1 (directly pressed)

- M 60°
- UN 60°
- W 55°
- NPT 60°

PRECISION LINE (all-ground)

- M 60°
- M-AL 60°
- UN 60°
- W 55°
- TR-S 30°

PARTIAL PROFILE

EXTERNAL

PRECISION LINE (all-ground)

- 60°-PP 60°
- 55°-PP 55°
- M-S PP 60°

INTERNAL

PRECISION LINE (all-ground)

- 60°-PP 60°
- 55°-PP 55°
- M-S PP 60°

FULL PROFILE

EXTERNAL

PRECISION LINE (all-ground)

- TR 30°
- BSPT 55°
- RD 30°

INTERNAL

PRECISION LINE (all-ground)

- TR 30°
- BSPT 55°
- RD 30°

EXTERNAL

PRECISION LINE (all-ground)

- ACME 29°
- NPT 60°
- API RD 60°

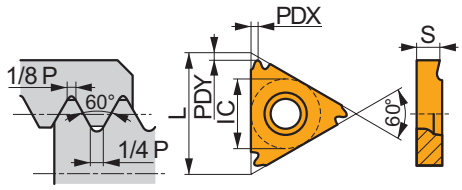
INTERNAL

PRECISION LINE (all-ground)

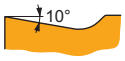
- ACME 29°
- STACME 29°
- NPT 60°
- API RD 60°

TN M EXT -P1

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47

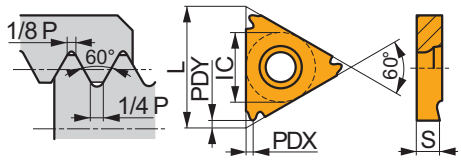


Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
			**TN** M-P1 ER pressed external, right-handed design, for machining ISO Metric threads, and continuous cuts.									
TN 16ER100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16ER125M-P1:T8030	●	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16ER150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16ER175M-P1:T8030	●	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16ER200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16ER250M-P1:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16ER300M-P1:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2

TN M INT -P1

	IC	L	S
	(mm)	(mm)	(mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



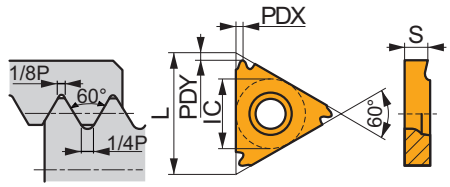
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
			**TN** M-P1 NR pressed internal, right-handed design, for machining ISO Metric threads, and continuous cuts.									
TN 11NR100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NR150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 11NR200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	–	–
TN 16NR100M-P1:T8030	●	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NR150M-P1:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16NR200M-P1:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16NR250M-P1:T8030	●	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16NR300M-P1:T8030	●	–	160	95	150	480	40	–	3.00	–	1.5	1.2

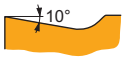
TN UN EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



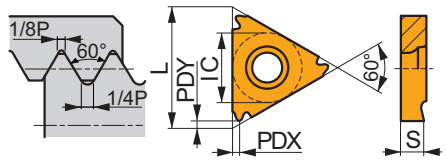
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN UN-P1 ER pressed external, right-handed design, for machining Unified threads, and continuous cuts.												
TN 16ER200UN-P1:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER180UN-P1:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160UN-P1:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140UN-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER120UN-P1:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2

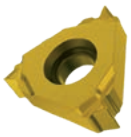
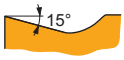
TN UN INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



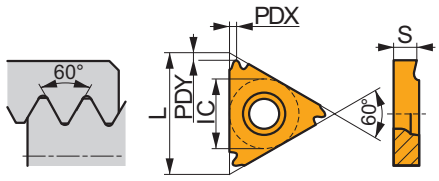
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN UN-P1 NR pressed internal, right-handed design, for machining Unified threads, and continuous cuts.												
TN 16NR200UN-P1:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16NR180UN-P1:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16NR160UN-P1:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140UN-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120UN-P1:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2

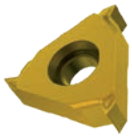
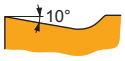
TN 60° PP EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

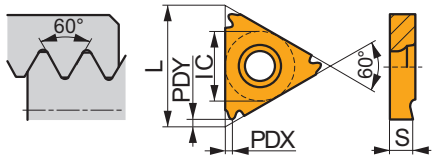
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
													
TN 16ERA60-P1:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG60-P1:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG60-P1:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.2

TN M60-P1 PP ER pressed external, right-handed design, for machining Metric and Unified threads, and continuous cuts.

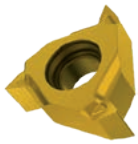
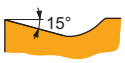
TN 60° PP INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

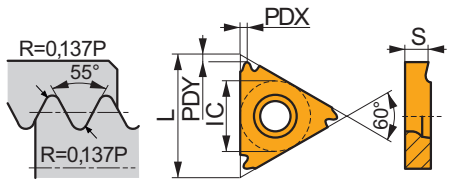
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
													
TN 11NRA60-P1:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRAG60-P1:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG60-P1:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.2

TN M60-P1 PP NR pressed internal, right-handed design, for machining Metric and Unified threads, and continuous cuts.

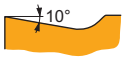
TN W EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



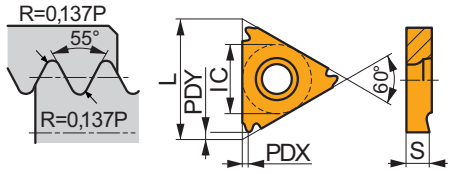
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
  	**TN** W-P1 ER pressed external, right-handed design, for machining Whitworth form threads, and continuous cuts.											
TN 16ER190W-P1:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16ER140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER110W-P1:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

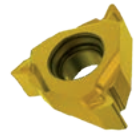
TN W INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



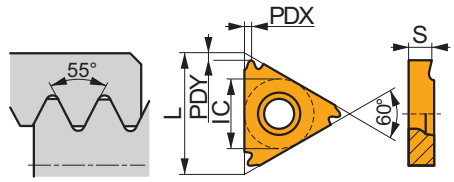
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
  	**TN** W-P1 NR pressed internal, right-handed design, for machining Whitworth form threads, and continuous cuts.											
TN 11NR190W-P1:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 11NR140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	0.9	0.7
TN 16NR140W-P1:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR110W-P1:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

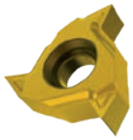
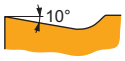
TN 55° PP EXT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



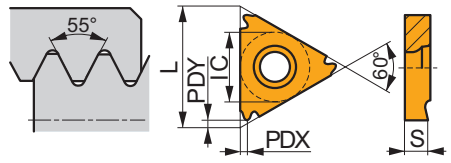
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 													
TN W55-P1 PP ER pressed external, right-handed design, for machining Whitworth threads, and continuous cuts.													
TN 16ERAG55-P1:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	–	–
TN 16ERG55-P1:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	–	–

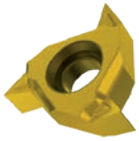
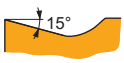
TN 55° PP INT -P1

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



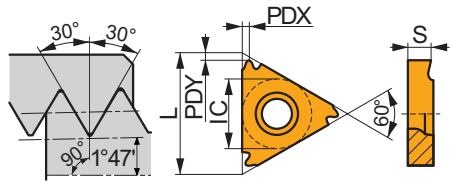
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 													
TN W55-P1 PP NR pressed internal, right-handed design, for machining Whitworth threads, and continuous cuts.													
TN 16NRAG55-P1:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	–	–

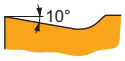
TN NPT EXT -P1

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

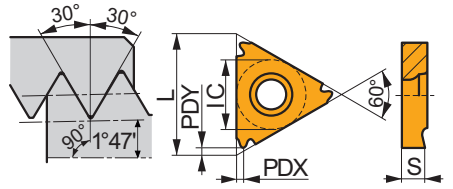
Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN 16ER115NPT-P1:T8030	●	–	160	95	150	480	40	–	–	11.5	–	–

TN NPT-P1 ER pressed external, right-handed design, for machining NPT threads, and continuous cuts.

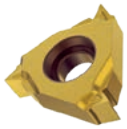
TN NPT INT -P1

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



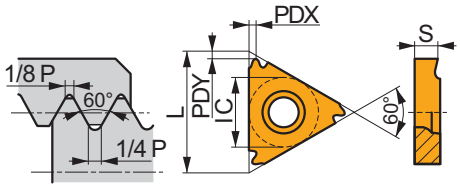
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN 16NR115NPT-P1:T8030	●	–	160	95	150	480	40	–	–	11.5	–	–

TN NPT-P1 NR pressed internal, right-handed design, for machining NPT threads, and continuous cuts.

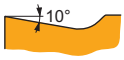
TN M EXT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



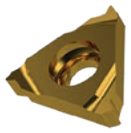
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

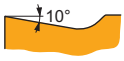
Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)



TN M ER external, right-handed design, for machining ISO Metric threads, and continuous cuts.

TN 16ER050M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	0.50	–	0.8	0.8
TN 16ER050M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.50	–	0.8	0.8
TN 16ER075M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	0.75	–	0.8	0.8
TN 16ER075M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.75	–	0.8	0.8
TN 16ER080M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.80	–	0.6	0.8
TN 16ER100M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.00	–	0.8	0.8
TN 16ER100M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.00	–	0.8	0.8
TN 16ER125M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.25	–	0.8	0.8
TN 16ER125M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.25	–	0.8	0.8
TN 16ER150M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.50	–	0.8	0.8
TN 16ER150M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.50	–	0.8	0.8
TN 16ER175M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.75	–	1.5	1.2
TN 16ER175M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.75	–	1.5	1.2
TN 16ER200M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	2.00	–	1.5	1.2
TN 16ER200M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	2.00	–	1.5	1.2
TN 16ER250M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	2.50	–	1.5	1.2
TN 16ER250M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	2.50	–	1.5	1.2
TN 16ER300M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	3.00	–	1.5	1.2
TN 16ER300M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	3.00	–	1.5	1.2
TN 16ER350M:T8030[1)]	●	–	■	160	■	95	■	150	◪	480	◪	40	–	3.50	–	1.7	1.2
TN 22ER350M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	3.50	–	2.5	1.8
TN 22ER400M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	4.00	–	2.5	1.8
TN 22ER400M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	4.00	–	2.5	1.8
TN 22ER450M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	4.50	–	2.5	1.8
TN 22ER500M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	5.00	–	2.5	1.8





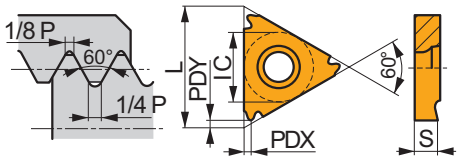
TN M EL external, left-handed design, for machining ISO Metric threads, and continuous cuts.

TN 16EL050M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.50	–	0.8	0.8
TN 16EL075M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.75	–	0.8	0.8
TN 16EL080M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.80	–	0.6	0.8
TN 16EL100M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.00	–	0.8	0.8
TN 16EL100M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.00	–	0.8	0.8
TN 16EL125M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.25	–	0.8	0.8
TN 16EL150M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.50	–	0.8	0.8
TN 16EL150M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.50	–	0.8	0.8
TN 16EL175M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.75	–	1.5	1.2
TN 16EL200M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	2.00	–	1.5	1.2
TN 16EL250M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	2.50	–	1.5	1.2
TN 16EL300M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	3.00	–	1.5	1.2
TN 16EL300M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	3.00	–	1.5	1.2
TN 22EL350M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	3.50	–	2.5	1.8
TN 22EL400M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	4.00	–	2.5	1.8
TN 22EL450M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	4.50	–	2.5	1.8

[1)] Toolholders have to be modified.

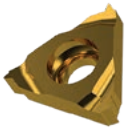
TN M INT

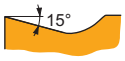
	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)

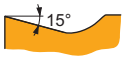




TN M NR internal, right-handed design, for machining ISO Metric threads, and continuous cuts.

TN 11NR050M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.50	–	0.8	0.8
TN 11NR075M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	0.75	–	0.8	0.8
TN 11NR075M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.75	–	0.8	0.8
TN 11NR100M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.00	–	0.8	0.8
TN 11NR125M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.25	–	0.8	0.8
TN 11NR150M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.50	–	0.8	0.8
TN 11NR150M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.50	–	0.8	0.8
TN 11NR200M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	2.00	–	0.9	0.8
TN 11NR200M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	2.00	–	0.9	0.8
TN 16NR050M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.50	–	0.8	0.8
TN 16NR075M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	0.75	–	0.8	0.8
TN 16NR100M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.00	–	0.8	0.8
TN 16NR100M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.00	–	0.8	0.8
TN 16NR125M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.25	–	0.8	0.8
TN 16NR150M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	1.50	–	0.8	0.8
TN 16NR150M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.50	–	0.8	0.8
TN 16NR175M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	1.75	–	1.5	1.2
TN 16NR200M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	2.00	–	1.5	1.2
TN 16NR200M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	2.00	–	1.5	1.2
TN 16NR250M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	2.50	–	1.5	1.2
TN 16NR250M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	2.50	–	1.5	1.2
TN 16NR300M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	3.00	–	1.5	1.2
TN 16NR300M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	3.00	–	1.5	1.2
TN 16NR350M:T8030[1)]	●	–	■	160	■	95	■	150	◪	480	◪	40	–	3.50	–	1.6	1.2
TN 22NR350M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	3.50	–	2.5	1.8
TN 22NR400M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	4.00	–	2.5	1.8
TN 22NR400M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	4.00	–	2.5	1.8
TN 22NR450M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	4.50	–	2.5	1.8
TN 22NR450M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	4.50	–	2.5	1.8
TN 22NR500M:T8010	●	–	■	175	◪	105	■	165		–	◪	40	–	5.00	–	2.5	1.8
TN 22NR500M:T8030	●	–	■	160	■	95	■	150	◪	480	◪	40	–	5.00	–	2.5	1.8

Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

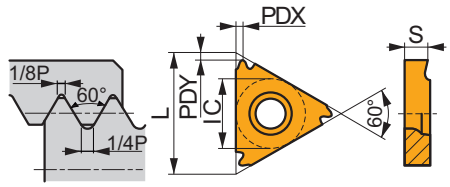
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
 											
TN M NL internal, left-handed design, for machining ISO Metric threads, and continuous cuts.											
TN 11NL050M:T8030	–	160	95	150	480	40	–	0.50	–	0.8	0.8
TN 11NL100M:T8030	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 11NL150M:T8030	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 11NL200M:T8030	–	160	95	150	480	40	–	2.00	–	0.9	0.8
TN 16NL100M:T8030	–	160	95	150	480	40	–	1.00	–	0.8	0.8
TN 16NL125M:T8030	–	160	95	150	480	40	–	1.25	–	0.8	0.8
TN 16NL150M:T8010	–	175	105	165	–	40	–	1.50	–	0.8	0.8
TN 16NL150M:T8030	–	160	95	150	480	40	–	1.50	–	0.8	0.8
TN 16NL175M:T8030	–	160	95	150	480	40	–	1.75	–	1.5	1.2
TN 16NL200M:T8010	–	175	105	165	–	40	–	2.00	–	1.5	1.2
TN 16NL200M:T8030	–	160	95	150	480	40	–	2.00	–	1.5	1.2
TN 16NL250M:T8030	–	160	95	150	480	40	–	2.50	–	1.5	1.2
TN 16NL300M:T8010	–	175	105	165	–	40	–	3.00	–	1.5	1.2
TN 16NL300M:T8030	–	160	95	150	480	40	–	3.00	–	1.5	1.2
TN 22NL350M:T8030	–	160	95	150	480	40	–	3.50	–	2.5	1.8
TN 22NL400M:T8030	–	160	95	150	480	40	–	4.00	–	2.5	1.8

[1] Toolholders have to be modified.

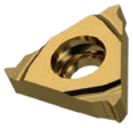
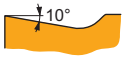
TN UN EXT

PRAMET

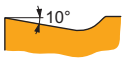
	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
 											
TN UN ER external, right-handed design, for machining Unified threads and continuous cuts.											
TN 16ER320UN:T8030	–	160	95	150	480	40	–	–	32.0	0.8	0.8
TN 16ER280UN:T8030	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16ER240UN:T8030	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16ER200UN:T8010	–	175	105	165	–	40	–	–	20.0	0.8	0.8
TN 16ER200UN:T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER180UN:T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160UN:T8030	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140UN:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER130UN:T8030	–	160	95	150	480	40	–	–	13.0	1.5	1.2
TN 16ER120UN:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16ER110UN:T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16ER100UN:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER090UN:T8030	–	160	95	150	480	40	–	–	9.0	1.5	1.2
TN 16ER080UN:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22ER070UN:T8030	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22ER060UN:T8030	–	160	95	150	480	40	–	–	6.0	2.5	1.8

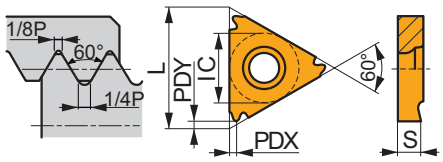
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** UN EL external, left-handed design, for machining Unified threads, and continuous cuts.											
TN 16EL200UN:T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16EL120UN:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16EL100UN:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2

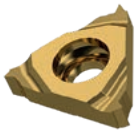
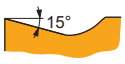
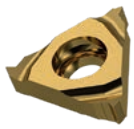
TN UN INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71

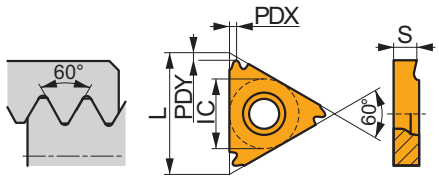


Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

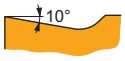
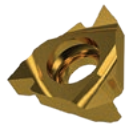
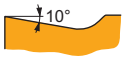
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** UN NR internal, right-handed design, for machining Unified threads, and continuous cuts.											
TN 16NR200UN:T8030	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16NR180UN:T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16NR160UN:T8030	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140UN:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120UN:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NR110UN:T8030	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NR100UN:T8030	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR080UN:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22NR050UN:T8030	–	160	95	150	480	40	–	–	5.0	2.5	1.8
   **TN** UN NL internal, left-handed design, for machining Unified threads, and continuous cuts.											
TN 16NL120UN:T8030	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NL080UN:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.2

TN 60° PP EXT

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71

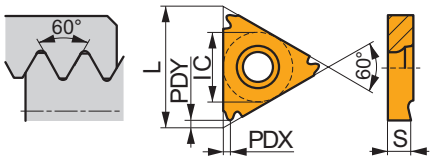


Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

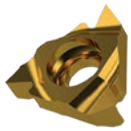
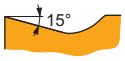
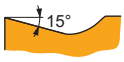
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
			**TN** M60 PP ER external, right-handed design, for machining Metric and Unified threads, and continuous cuts.											
TN 16ERA60:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG60:T8010	●	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERAG60:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG60:T8010	●	–	175	105	165	–	40	–	1.75	3.00	8	14	1.5	1.1
TN 16ERG60:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ERN60:T8010	●	–	175	105	165	–	40	–	3.50	5.00	5	7	2.5	1.8
TN 22ERN60:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8
			**TN** M60 PP EL external, left-handed design, for machining Metric and Unified threads, and continuous cuts.											
TN 16ELA60:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ELAG60:T8010	●	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELAG60:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELG60:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ELN60:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

TN 60° PP INT

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71

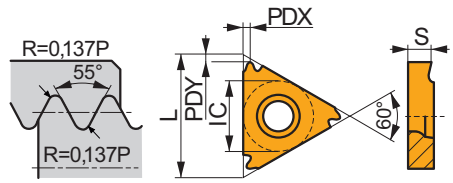


Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

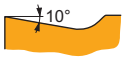
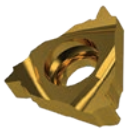
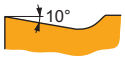
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
			**TN** M60 PP NR internal, right-handed design, for machining Metric and Unified threads, and continuous cuts.											
TN 11NRA60:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRA60:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.7
TN 16NRAG60:T8010	●	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRAG60:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG60:T8030	●	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22NRN60:T8010	●	–	175	105	165	–	40	–	3.50	5.00	5	7	2.5	1.8
TN 22NRN60:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8
			**TN** M60 PP NL internal, left-handed design, for machining Metric and Unified threads, and continuous cuts.											
TN 11NLA60:T8030	●	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.7
TN 16NLAG60:T8030	●	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 22NLN60:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

TN W EXT

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71

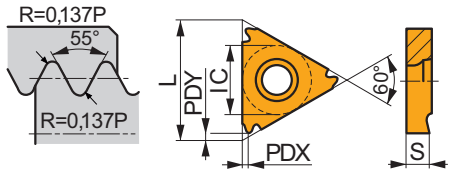


Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

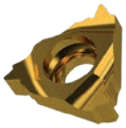
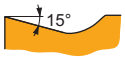
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
			**TN** W ER external, right-handed design, for machining Whitworth form threads, and continuous cuts.									
TN 16ER280W:T8030	●	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16ER240W:T8030	●	–	160	95	150	480	40	–	–	24.0	0.8	0.8
TN 16ER200W:T8030	●	–	160	95	150	480	40	–	–	20.0	0.8	0.8
TN 16ER190W:T8010	●	–	175	105	165	–	40	–	–	19.0	0.8	0.8
TN 16ER190W:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16ER180W:T8030	●	–	160	95	150	480	40	–	–	18.0	0.8	0.8
TN 16ER160W:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16ER140W:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER120W:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16ER110W:T8010	●	–	175	105	165	–	40	–	–	11.0	1.5	1.2
TN 16ER110W:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16ER100W:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER080W:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22ER070W:T8030	●	–	160	95	150	480	40	–	–	7.0	2.5	1.8
TN 22ER060W:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8
TN 22ER050W:T8030	●	–	160	95	150	480	40	–	–	5.0	2.5	1.7
			**TN** W EL external, left-handed design, for machining Whitworth form threads, and continuous cuts.									
TN 16EL190W:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16EL140W:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16EL120W:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16EL110W:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16EL100W:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16EL080W:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

TN W INT

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



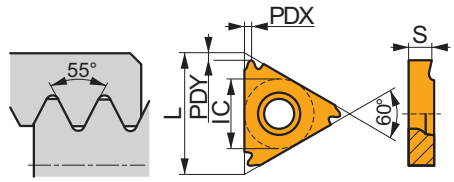
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
			**TN** W NR internal, right-handed design, for machining Whitworth form threads, and continuous cuts.									
TN 11NR190W:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 11NR140W:T8010	●	–	175	105	165	–	40	–	–	14.0	0.9	0.7
TN 11NR140W:T8030	●	–	160	95	150	480	40	–	–	14.0	0.9	0.7
TN 16NR280W:T8030	●	–	160	95	150	480	40	–	–	28.0	0.8	0.8
TN 16NR190W:T8010	●	–	175	105	165	–	40	–	–	19.0	0.8	0.8
TN 16NR190W:T8030	●	–	160	95	150	480	40	–	–	19.0	0.8	0.8
TN 16NR160W:T8030	●	–	160	95	150	480	40	–	–	16.0	0.8	0.8
TN 16NR140W:T8010	●	–	175	105	165	–	40	–	–	14.0	1.5	1.2
TN 16NR140W:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR120W:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NR110W:T8010	●	–	175	105	165	–	40	–	–	11.0	1.5	1.2
TN 16NR110W:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NR100W:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR090W:T8030	●	–	160	95	150	480	40	–	–	9.0	1.5	1.2
TN 16NR080W:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 22NR060W:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8
TN 22NR050W:T8030	●	–	160	95	150	480	40	–	–	5.0	2.5	1.7
			**TN** W NL internal, left-handed design, for machining Whitworth form threads, and continuous cuts.									
TN 16NL140W:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NL120W:T8030	●	–	160	95	150	480	40	–	–	12.0	1.5	1.2
TN 16NL110W:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2
TN 16NL100W:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NL080W:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

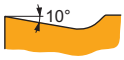
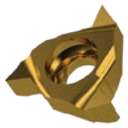
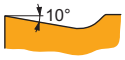
TN 55° PP EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



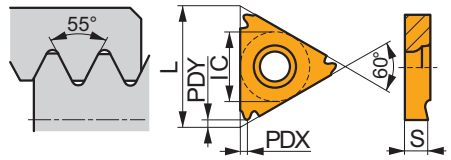
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
   **TN** W55 PP ER external, right-handed design, for machining Whitworth threads, and continuous cuts.													
TN 16ERA55:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16ERAG55:T8010	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERAG55:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ERG55:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ERN55:T8010	–	175	105	165	–	40	–	3.50	5.00	5	7	2.5	1.8
TN 22ERN55:T8030	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8
   **TN** W55 PP EL external, left-handed design, for machining Whitworth threads, and continuous cuts.													
TN 16ELAG55:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16ELG55:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22ELN55:T8030	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

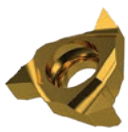
TN 55° PP INT

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
   **TN** W55 PP NR internal, right-handed design, for machining Whitworth threads, and continuous cuts.													
TN 11NRA55:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NRA55:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NRAG55:T8010	–	175	105	165	–	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRAG55:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NRG55:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1
TN 22NRN55:T8030	–	160	95	150	480	40	–	3.50	5.00	5	7	2.5	1.8

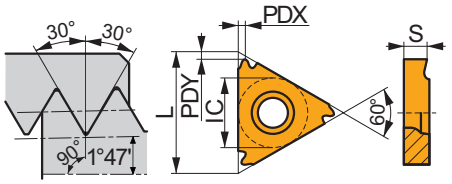
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 													
TN W55 PP NL internal, left-handed design, for machining Whitworth threads, and continuous cuts.													
TN 11NLA55:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NLA55:T8030	–	160	95	150	480	40	–	0.50	1.50	16	48	0.8	0.6
TN 16NLAG55:T8030	–	160	95	150	480	40	–	0.50	3.00	8	48	1.5	1.1
TN 16NLG55:T8030	–	160	95	150	480	40	–	1.75	3.00	8	14	1.5	1.1

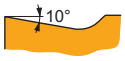
TN NPT EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



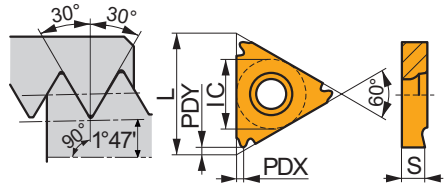
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
 											
TN NPT ER external, right-handed design, for machining NPT threads, and continuous cuts.											
TN 16ER270NPT:T8030	–	160	95	150	480	40	–	–	27.0	0.8	0.7
TN 16ER180NPT:T8030	–	160	95	150	480	40	–	–	18.0	0.8	0.7
TN 16ER140NPT:T8030	–	160	95	150	480	40	–	–	14.0	1.5	1.1
TN 16ER115NPT:T8030	–	160	95	150	480	40	–	–	11.5	1.5	1.1
TN 16ER080NPT:T8030	–	160	95	150	480	40	–	–	8.0	1.6	1.1

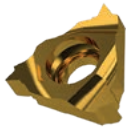
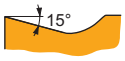
TN NPT INT

PRAMET

	IC (mm)	L (mm)	S (mm)
11	6.350	11.00	3.00
16	9.525	16.50	3.47



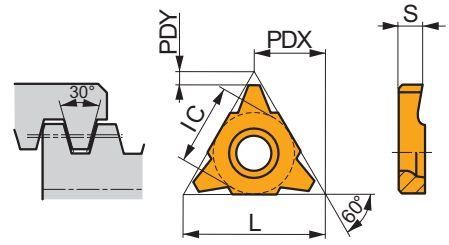
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN NPT NR internal, right-handed design, for machining NPT threads, and continuous cuts.												
TN 11NR180NPT:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	18.0	0.8	0.7
TN 11NR140NPT:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	14.0	1.0	0.7
TN 16NR140NPT:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	–	14.0	1.5	1.1
TN 16NR140NPT:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	14.0	1.5	1.1
TN 16NR115NPT:T8010	●	–	■ 175	◪ 105	■ 165	–	◪ 40	–	–	11.5	1.5	1.1
TN 16NR115NPT:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	11.5	1.5	1.1
TN 16NR080NPT:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	8.0	1.6	1.1

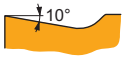
TN TR-S EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



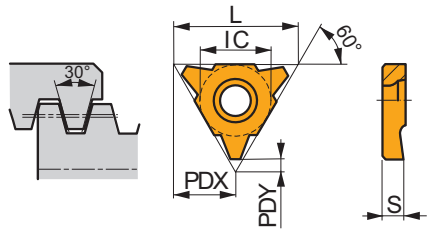
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN TR-S EN external, left and right-handed design for machining Trapezoidal threads, and continuous cuts.												
TN 22EN600TR:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	6.00	–	11.0	1.9
TN 22EN700TR:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	7.00	–	11.0	2.3

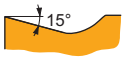
TN TR-S INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

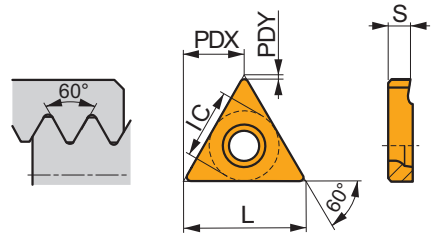
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
 												
TN 22NN600TR:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	6.00	–	11.0	1.9
TN 22NN700TR:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	7.00	–	11.0	2.3

TN TR-S NN internal, left and right-handed design, for machining Metric and Unified threads, and continuous cuts.

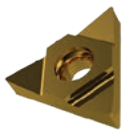
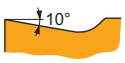
TN 60°-S PP EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

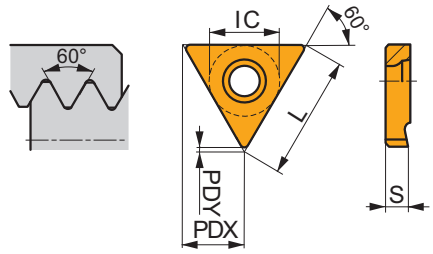
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
 														
TN 22EN350-500M:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	3.50	5.00	5	7	11.0	0.5
TN 22EN550-800M:T8030	●	–	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	5.50	8.00	3	4.5	11.0	0.8

TN M60-S PP EN external, left and right-handed design, for machining Metric and Unified threads, and continuous cuts.

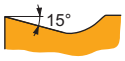
TN 60°-S PP INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.60



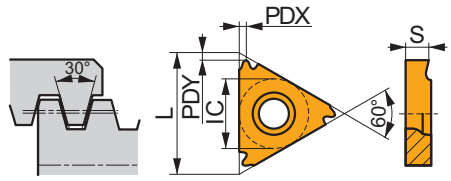
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TPN (mm)	TPX (mm)	TPIN	TPIX	PDX (mm)	PDY (mm)
														
TN M60-S PP NN internal, left and right-handed design, for machining Metric and Unified threads, and continuous cuts.														
TN 22NN350-500M:T8030	●	–	160	95	150	480	40	–	3.50	5.00	5	7	11.0	0.2
TN 22NN550-800M:T8030	●	–	160	95	150	480	40	–	5.50	8.00	3	4.5	11.0	0.5

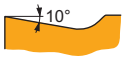
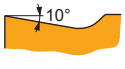
TN TR EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



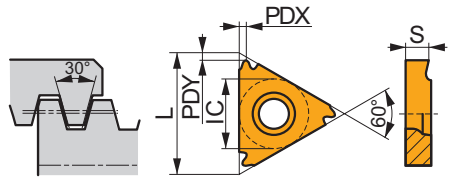
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
												
TN TR ER external, right-handed design, for machining Trapezoidal threads, and continuous cuts.												
TN 16ER150TR:T8030	●	–	160	95	150	480	40	–	1.50	–	0.8	0.9
TN 16ER200TR:T8030	●	–	160	95	150	480	40	–	2.00	–	1.5	1.3
TN 16ER300TR:T8030	●	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22ER400TR:T8030	●	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22ER500TR:T8030	●	–	160	95	150	480	40	–	5.00	–	2.2	1.8
												
TN TR EL external, left-handed design, for machining Trapezoidal threads, and continuous cuts.												
TN 16EL300TR:T8030	●	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22EL400TR:T8030	●	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22EL500TR:T8030	●	–	160	95	150	480	40	–	5.00	–	2.2	1.8

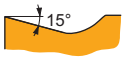
TN TR INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



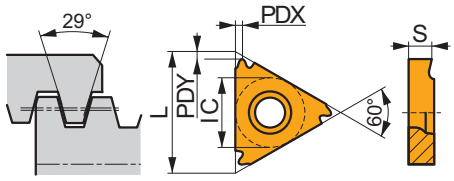
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** TR NR internal, right-handed design, for machining Trapezoidal threads, and continuous cuts.											
TN 16NR150TR:T8030	–	160	95	150	480	40	–	1.50	–	0.8	0.9
TN 16NR200TR:T8030	–	160	95	150	480	40	–	2.00	–	1.5	1.3
TN 16NR300TR:T8030	–	160	95	150	480	40	–	3.00	–	1.6	1.3
TN 22NR400TR:T8030	–	160	95	150	480	40	–	4.00	–	2.2	1.8
TN 22NR500TR:T8030	–	160	95	150	480	40	–	5.00	–	2.2	1.8
   **TN** TR NL internal, left-handed design, for machining Trapezoidal threads, and continuous cuts.											
TN 16NL300TR:T8030	–	160	95	150	480	40	–	3.00	–	1.6	1.3

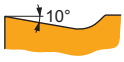
TN ACME EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



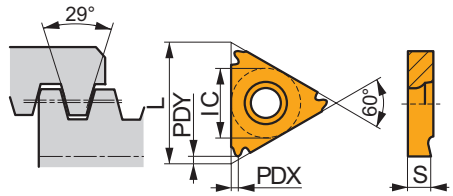
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** ACME ER external, right-handed design, for machining ACME threads, and continuous cuts.											
TN 16ER080ACME:T8030	–	160	95	150	480	40	–	–	8.0	1.5	1.3
TN 22ER060ACME:T8030	–	160	95	150	480	40	–	–	6.0	2.5	2.0
TN 22ER050ACME:T8030	–	160	95	150	480	40	–	–	5.0	2.3	2.0

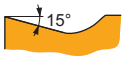
TN ACME INT

PRAMET

	IC (mm)	L (mm)	S (mm)
22	12.700	22.00	4.71



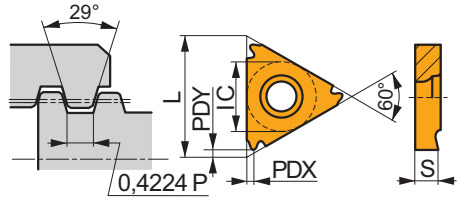
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** ACME NR internal, right-handed design, for machining ACME threads, and continuous cuts.											
TN 22NR060ACME:T8030	● –	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	2.5	2.0

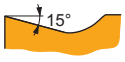
TN STACME INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

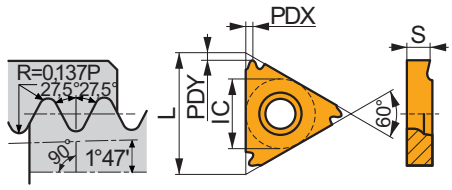
Product	RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** STACME NR internal, right-handed, design for machining Stub ACME threads, and continuous cuts.											
TN 16NR060STACME:T8030[1)]	● –	■ 160	■ 95	■ 150	◪ 480	◪ 40	–	–	6.0	1.3	1.3

[1)] Toolholders have to be modified.

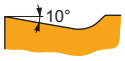
TN BSPT EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

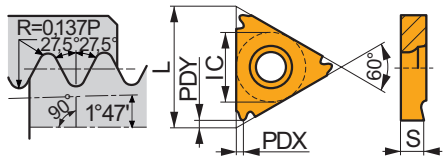
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
 												
TN 16ER190BSPT:T8030	●	–	160	95	150	480	40	–	–	19.0	1.5	1.2
TN 16ER140BSPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16ER110BSPT:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

TN BSPT ER external, right-handed design, for machining BSPT threads, and continuous cuts.

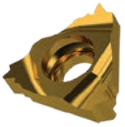
TN BSPT INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

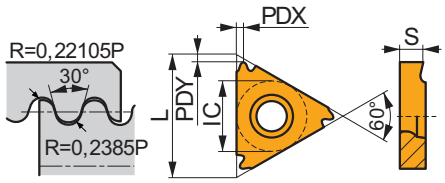
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
 												
TN 16NR140BSPT:T8030	●	–	160	95	150	480	40	–	–	14.0	1.5	1.2
TN 16NR110BSPT:T8030	●	–	160	95	150	480	40	–	–	11.0	1.5	1.2

TN BSPT NR internal, right-handed design, for machining BSPT threads, and continuous cuts.

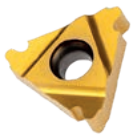
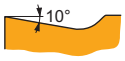
TN RD EXT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

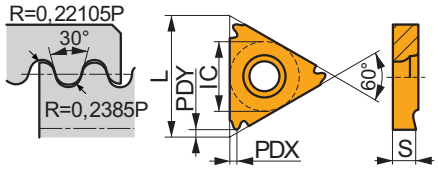
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** RD ER external, right-handed design, for machining Metric Round threads, and continuous cuts.												
TN 16ER080RD:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 16ER060RD:T8030[1)]	●	–	160	95	150	480	40	–	–	6.0	1.5	1.2
TN 22ER060RD:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8

[1)] Toolholders have to be modified.

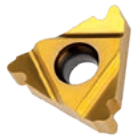
TN RD INT

PRAMET

	IC (mm)	L (mm)	S (mm)
16	9.525	16.50	3.47
22	12.700	22.00	4.71



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

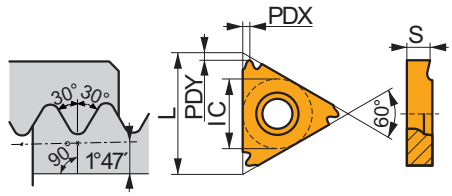
Product		RE (mm)	P vc (m/min)	M vc (m/min)	K vc (m/min)	N vc (m/min)	S vc (m/min)	H vc (m/min)	TP (mm)	TPI	PDX (mm)	PDY (mm)
   **TN** RD NR internal, right-handed design, for machining Metric Round threads, and continuous cuts.												
TN 16NR080RD:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2
TN 16NR060RD:T8030[1)]	●	–	160	95	150	480	40	–	–	6.0	1.5	1.2
TN 22NR060RD:T8030	●	–	160	95	150	480	40	–	–	6.0	2.5	1.8

[1)] Toolholders have to be modified.

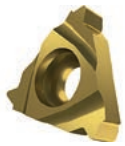
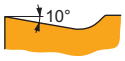
TN API RD EXT

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



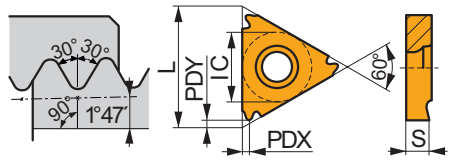
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
			 **TN** API ER external, right-handed design, for machining API threads, and continuous cuts.									
TN 16ER100API-RD01:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16ER080API-RD01:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

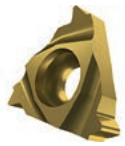
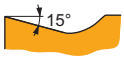
TN API RD INT

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47

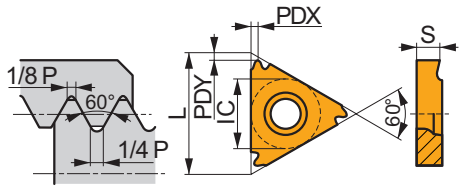


Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

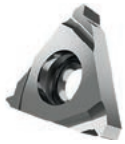
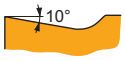
Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
			 **TN** API NR internal, right-handed design, for machining API threads, and continuous cuts.									
TN 16NR100API-RD01:T8030	●	–	160	95	150	480	40	–	–	10.0	1.5	1.2
TN 16NR080API-RD01:T8030	●	–	160	95	150	480	40	–	–	8.0	1.5	1.2

TN M EXT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



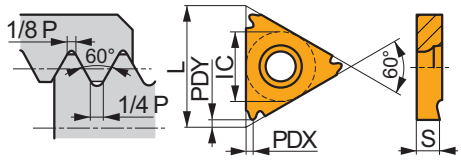
Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN 16ER100M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	1.00	–	0.8	0.8
TN 16ER125M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	1.25	–	0.8	0.8
TN 16ER150M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	1.50	–	0.8	0.8
TN 16ER200M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	2.00	–	1.5	1.2

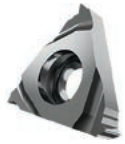
TN M-AL ER external, right-handed design, for machining ISO Metric threads, and continuous cuts.

TN M INT

	IC	L	S
	(mm)	(mm)	(mm)
16	9.525	16.50	3.47



Suitability and starting values for cutting speed (vc). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY
			vc	vc	vc	vc	vc	vc				
		(mm)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(mm)		(mm)	(mm)
												
TN 16NR150M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	1.50	–	0.8	0.8
TN 16NR200M-AL:HF7	●	–	–	◪ 95	–	■ 480	–	–	2.00	–	1.5	1.2

TN M-AL NR internal, right-handed design, for machining ISO Metric threads, and continuous cuts.

SE(RL)

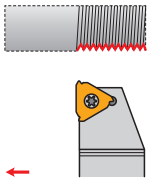
P M K N S H

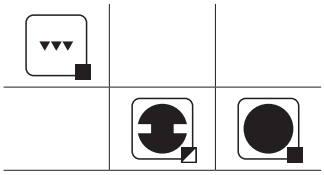
PRAMET

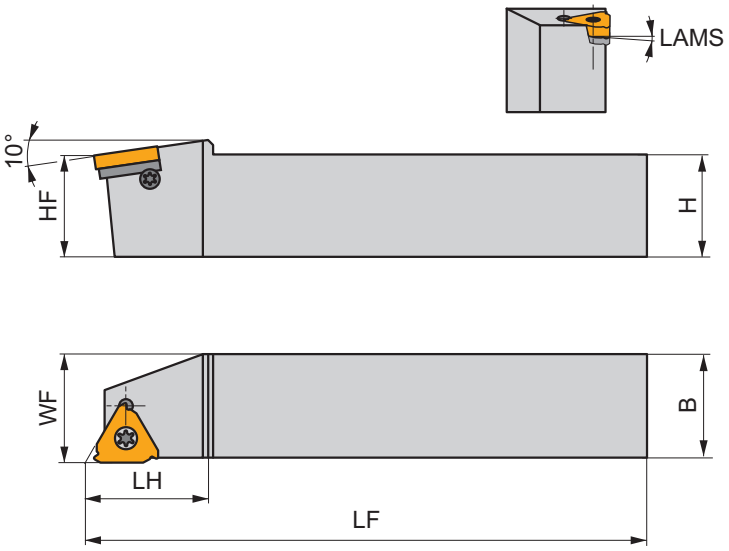
S

External Threading Holder for TN 16, 22 inserts clamped by screw

Right/Left hand tool holder for external threading with TN or ER/EL inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	H (mm)	HF (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)		
R	**SER 2020 K 16**	20	20	20	20	125	22.5	–	GI068	Z12
	SER 2525 M 16	25	25	25	25	150	24.0	–	GI068	Z12
	SER 3225 P 16	32	32	25	25	170	24.5	–	GI068	Z12
	SER 2525 M 22-A	25	25	25	25	150	25.5	–	GI071	Z13
	SER 3225 P 22-A	32	32	25	25	170	25.5	–	GI071	Z13
L	**SEL 2020 K 16**	20	20	20	20	125	22.5	–	GI068	Z12
	SEL 2525 M 16	25	25	25	25	150	24.0	–	GI068	Z12
	SEL 2525 M 22-A	25	25	25	25	150	25.5	–	GI071	Z13

GI068	TN 16ER..	TN 16EL..
GI071	TN 22ER..	TN 22EL..

		Nm							
Z12	US 3512A-T15P	3.0	M 3.5	12.7	–	HS 0304	FLAG T15P	HXK 2.5	Page xx
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	Page xx

SE(RL)-S

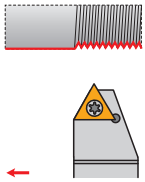
P M K N S H

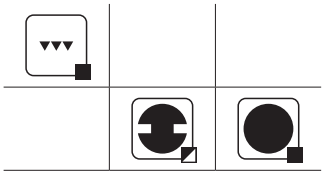
PRAMET

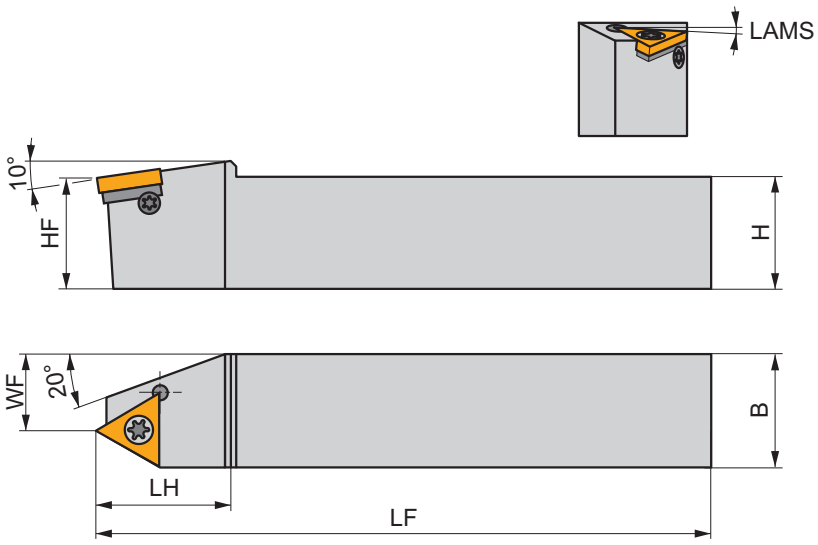
S

External Threading Holder for TN 22 EN inserts clamped by screw

Right/Left hand tool holder for external threading with TN or ER/EL inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	H	HF	B	WF	LF	LH	LAMS		
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)		
R	**SER-S 2525 M 22-A**	25	25	25	14	150	30.0	–	GI086	Z15
	SER-S 3225 P 22-A	32	32	25	14	170	30.0	–	GI086	Z15
L	**SEL-S 2525 M 22-A**	25	25	25	14	150	30.0	–	GI086	Z15

GI086	TN 22EN..

Z15	US 4514A-T20	5.0 Nm	M 4.5	14	SP 0405	FLAG T20	Page xx

SI(RL)

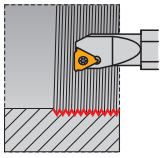
P M K N S H

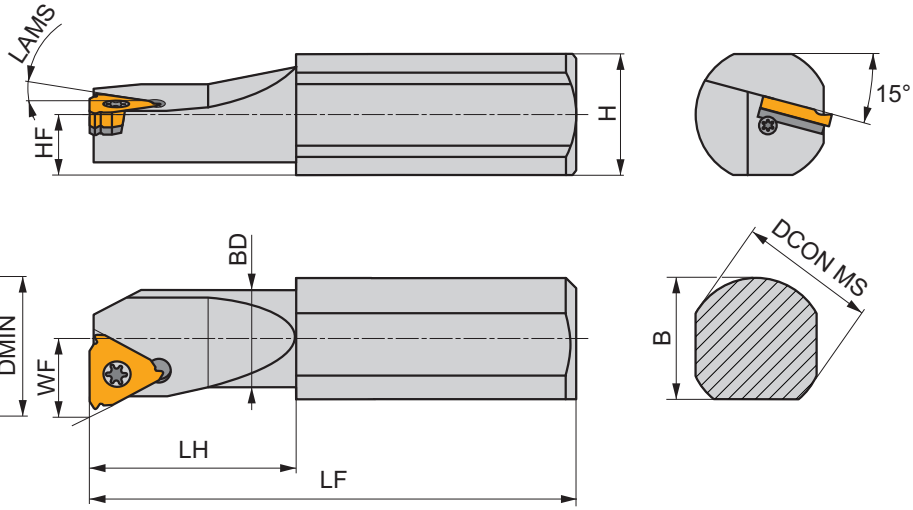
PRAMET

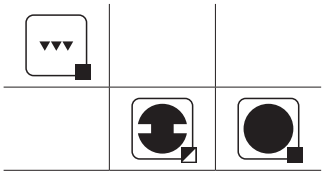
S

Internal Threading Holder for TN 11, 16, 22 inserts clamped by screw

Right/Left hand boring bar for internal threading with TN NR/NL inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	B	DCON MS	DMIN	BD	WF	H	HF	LF	LH	LAMS			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)			
R	SIR 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25.0	0	–	GI085	Z11
	SIR 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25.0	1	–	GI085	Z11
	SIR 0013 M 11-0	14.5	16	16	13	9	14	7	150	32.0	0	–	GI085	Z11
	SIR 0013 M 11-1	14.5	16	16	13	9	14	7	150	32.0	1	–	GI085	Z11
	SIR 1416 N 16-0	14	16	22	17	11.4	14.5	7.25	160	–	0	–	GI022	Z9
	SIR 1416 N 16-1	14	16	22	17	11.4	14.5	7.25	160	–	1	–	GI022	Z9
	SIR 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.25	160	40.0	2	✓	GI022	Z10
	SIR 1820 P 16	18.5	20	27	21	13.85	18	9	170	–	–	–	GI022	Z12
	SIR 2325 Q 16	23.5	25	29	26	16.55	23	11.5	180	–	–	–	GI022	Z12
	SIR 2532 S 16	30	32	36	32	19.75	25	12.5	250	–	–	–	GI022	Z12
	SIR 2532 S 22-2	30	32	25	25	16.65	25	12.5	250	80.0	2	✓	GI076	Z14
	SIR 2532 S 22-A	30	32	36	32	21.65	25	12.5	250	–	–	–	GI076	Z13
	SIR 3240 T 22-A	38	40	48	40	25.85	32	16	300	–	–	–	GI076	Z13
L	SIL 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25.0	0	–	GI085	Z11
	SIL 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25.0	1	–	GI085	Z11
	SIL 0013 M 11-1	14.5	16	16	13	9	14	7	150	32.0	1	–	GI085	Z11
	SIL 1416 N 16-0	14	16	22	17	11.4	14.5	7.25	160	–	0	–	GI022	Z9
	SIL 1416 N 16-1	14	16	22	17	11.4	14.5	7.25	160	–	1	–	GI022	Z9
	SIL 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.25	160	40.0	2	✓	GI022	Z10
	SIL 1820 P 16	18.5	20	24	21	13.85	18	9	170	–	–	–	GI022	Z12
	SIL 2325 Q 16	23.5	25	29	26	16.55	23	11.5	180	–	–	–	GI022	Z12
	SIL 2532 S 16	30	32	36	32	19.75	25	12.5	250	–	–	–	GI022	Z12
	SIL 2532 S 22-2	30	32	25	25	16.65	25	12.5	250	80.0	2	✓	GI076	Z14

GI022	TN 16NR..	TN 16NL..

GI076	TN 22NR..	TN 22NL..
GI085	TN 11NR..	TN 11NL..

		Nm							
Z10	US 3510A-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	–
Z11	US 2506-T07P	0.9	M 2.5	6.3	–	–	FLAG T07P	–	–
Z12	US 3512A-T15P	3.0	M 3.5	12.7	–	HS 0304	FLAG T15P	HXK 2.5	Page xx
Z13	US 4514A-T20	5.0	M 4.5	14	SP 0405	–	FLAG T20	–	Page xx
Z14	US 4514A-T20	5.0	M 4.5	14	–	–	FLAG T20	–	–
Z9	US 3510A-T15P	3.0	M 3.5	10.6	–	–	FLAG T15P	–	P-16

SI(RL)-S

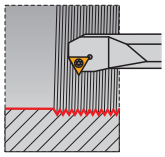
P M K N S H

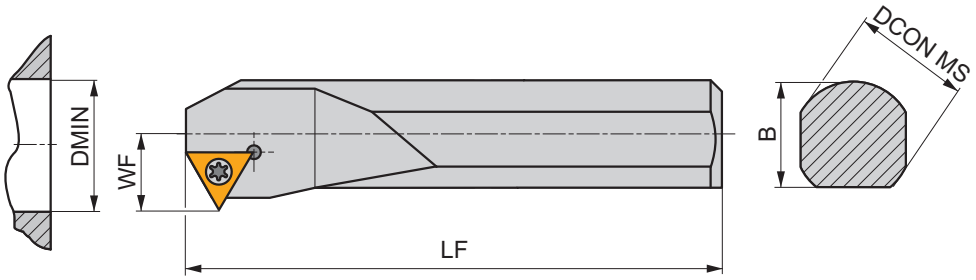
PRAMET

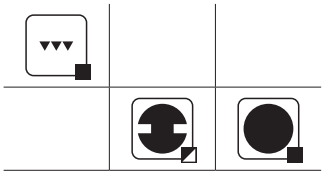
S

Internal Threading Holder for TN 22 NN inserts clamped by screw

Right/Left hand boring bar for internal threading with TN NN neutral inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	B (mm)	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)		
R	**SIR-S 2532 S 22-A**	30	32	39	22.3	25	12.5	250	–	GI107	Z15
	SIR-S 3240 T 22-A	38	40	48	27	32	16	300	–	GI107	Z15

GI107	TN 22NN..

Z15	US 4514A-T20	5.0 Nm	M 4.5	14	SP 0405	FLAG T20	Page xx

BROACHING & TOOL BITS

PHZ

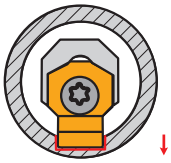
P M K N S H

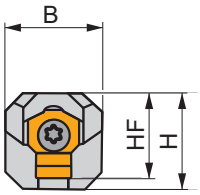
PRAMET

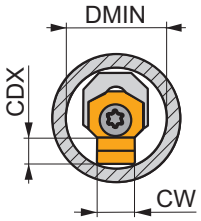
S

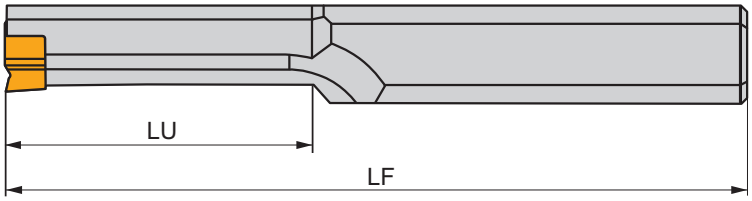
Int. Broaching Tool Holder for Small Diameters with Single-Sided HZ Inserts

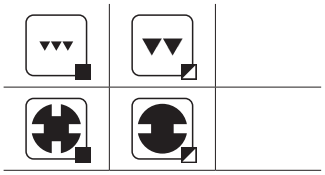
Internal tool holder for broaching up to 12 mm width. Body treated for longer tool life.











	Product	H (mm)	HF (mm)	B (mm)	OAL (mm)	LU (mm)	CW (mm)	DMIN (mm)	CDX (mm)	kg		
N	**PHZ 90 1104-06**	11.3	9	8.5	160	35	3.00	9.5	1.6	0.14	GI239	SH21
	PHZ 90 1107-06	11.3	10	7	200	60	–	–	–	0.19	GI240	SH21
	PHZ 90 1111-06	11.3	12	–	200	60	–	–	–	0.21	GI240	SH21
	PHZ 1512-10	15.5	16.2	–	220	–	–	–	–	0.33	GI224	SH22
	PHZ 2014-13	20.6	21.5	–	250	–	–	–	–	0.58	GI225	SH23

GI224	HZ 1006-60	HZ 1006-80
GI225	HZ 1309-100	HZ 1309-120
GI239	HZ90 0604-30	–
GI240	HZ90 0604-40	HZ90 0604-50

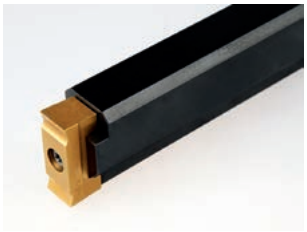
SH21	DVF 3593	0.8	M 2.5	10	TX207PLUS
SH22	DVF 2260	3.6	M 4	15	TX215PLUS
SH23	5513 020-14	8.5	M 6	18	TX225PLUS

PHZ-2

P M K N S H

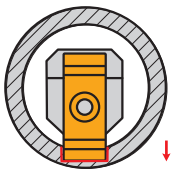
PRAMET

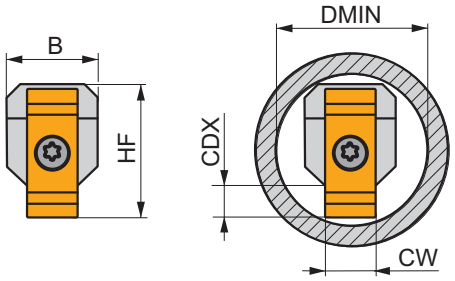
S

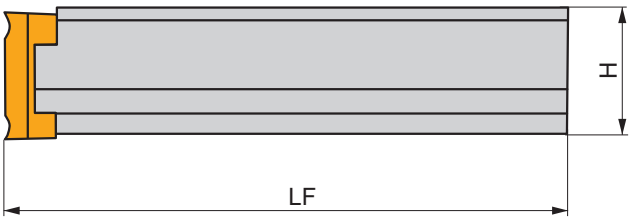


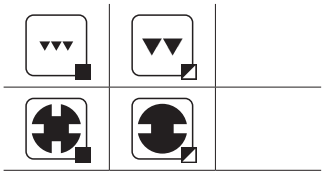
Int. Broaching Tool Holder for Larger Diameters with Double-Sided HZ Inserts

Internal tool holder for broaching up to 20 mm width. Body treated for longer tool life.









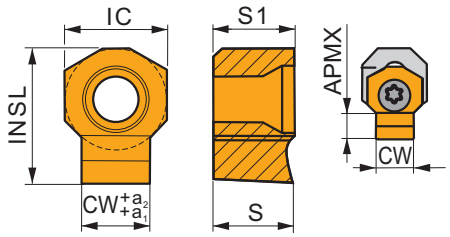
	Product	H (mm)	HF (mm)	B (mm)	OAL (mm)	CW (mm)	DMIN (mm)	CDX (mm)	kg		
N	**PHZ/2 3625-14**	36	37.5	25	300	–	44	–	1.84	GI235	SH23
	PHZ/2 4832-18	48	50	32	400	–	58	–	2.00	GI241	SH24

GI235	HZ/2 14-14	HZ/2 16-16
GI241	HZ/2 18-18	HZ/2 20-20

		Nm			
SH23	5513 020-14	8.5	M 6	18	TX225PLUS
SH24	5513 021-03	13.0	M 8	22	DMN 3124

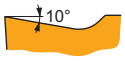
HZ

	CW	INSL	APMX	S	S1
	(mm)	(mm)	(mm)	(mm)	(mm)
0604-30	3.00	7.5	1.60	4.66	4.76
0604-40	4.00	8.0	2.50	4.66	4.76
0604-50	5.00	8.0	3.00	4.66	4.76
1006-60	6.00	13.5	4.20	6.25	6.35
1006-80	8.00	13.5	5.20	6.25	6.35
1309-100	10.00	18.5	6.20	9.40	9.53
1309-120	12.00	18.5	7.20	9.40	9.53



Suitability and starting values for cutting speed (vc) and feed (fz). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f			
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)	(mm)

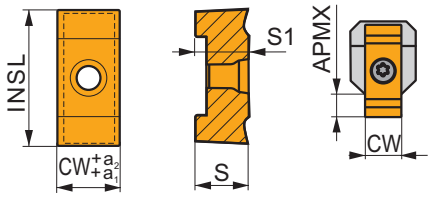


Positive geometry for broaching (one cutting edge).

HZ 1006-60 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	6.00	0.07	0.14
HZ 1006-60 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	6.00	0.03	0.08
HZ 1006-60 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	6.00	0.00	0.01
HZ 1006-60 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	6.00	-0.04	-0.01
HZ 1006-80 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	8.00	0.08	0.17
HZ 1006-80 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	8.00	0.04	0.10
HZ 1006-80 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	8.00	0.00	0.01
HZ 1006-80 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	8.00	-0.05	-0.01
HZ 1309-100 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	10.00	0.08	0.17
HZ 1309-100 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	10.00	0.04	0.10
HZ 1309-100 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	10.00	0.00	0.01
HZ 1309-100 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	10.00	-0.05	-0.01
HZ 1309-120 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	12.00	0.10	0.20
HZ 1309-120 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	12.00	0.05	0.12
HZ 1309-120 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	12.00	0.00	0.02
HZ 1309-120 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	12.00	-0.06	-0.02
HZ90 0604-30 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	3.00	0.06	0.12
HZ90 0604-30 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	3.00	0.02	0.06
HZ90 0604-30 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	3.00	0.00	0.01
HZ90 0604-30 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	3.00	-0.03	-0.01
HZ90 0604-40 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	4.00	0.07	0.14
HZ90 0604-40 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	4.00	0.03	0.08
HZ90 0604-40 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	4.00	0.00	0.01
HZ90 0604-40 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	4.00	-0.04	-0.01
HZ90 0604-50 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	5.00	0.07	0.14
HZ90 0604-50 D10:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	5.00	0.03	0.08
HZ90 0604-50 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	5.00	0.00	0.01
HZ90 0604-50 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10		–	–		–	–		–	–	5.00	-0.04	-0.01

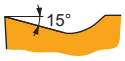
HZ-2

	INSL	APMX	S	S1	CW
	(mm)	(mm)	(mm)	(mm)	(mm)
14-14	36.0	8.00	13.90	14.00	14.00
16-16	36.0	9.00	13.90	14.00	16.00
18-18	45.0	12.00	15.90	16.00	18.00
20-20	45.0	13.00	15.90	16.00	20.00



Suitability and starting values for cutting speed (vc) and feed (fz). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f			
		(mm)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(m/min)	(mm/rev)	(mm)	(mm)	(mm)

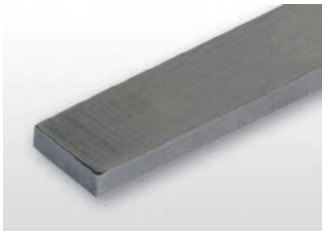


Positive geometry for broaching (two cutting edges).

HZ/2 14-14 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	14.00	0.10	0.20
HZ/2 14-14 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	14.00	0.00	0.02
HZ/2 14-14 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	14.00	-0.06	-0.02
HZ/2 16-16 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	16.00	0.10	0.20
HZ/2 16-16 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	16.00	0.00	0.02
HZ/2 16-16 P9:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	16.00	-0.06	-0.02
HZ/2 18-18 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	18.00	0.10	0.20
HZ/2 18-18 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	18.00	0.00	0.02
HZ/2 18-18 P9:333TN	✱	–	■	50	0.10	◪	30	0.10	◪	45	0.10	–	–	–	–	–	–	18.00	-0.06	-0.02
HZ/2 20-20 C11:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	20.00	0.11	0.24
HZ/2 20-20 H7:333TN	✱	–	■	50	0.10	◪	30	0.09	◪	45	0.10	–	–	–	–	–	–	20.00	0.00	0.02
HZ/2 20-20 P9:333TN	✱	–	■	50	0.10	◪	30	0.10	◪	45	0.10	–	–	–	–	–	–	20.00	-0.07	-0.02

TOOL BITS F

DORMER



HSS-E Rectangular Tool bit

Ground rectangular tool bit according to DIN 4964 D standard. T2000S HSS-E bright steel with 10% Cobalt content in hardness 65-67 HRC.

HSS-E	DIN 4964D	Bright
h13		

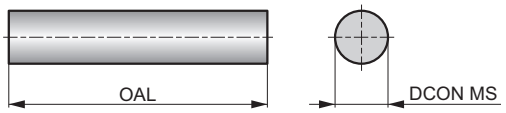
Product	H (mm)	B (mm)	OAL (mm)
8X6X200:T2000S	8	6	200.0
10X2X200:T2000S	10	2	200.0
10X3X200:T2000S	10	3	200.0
10X4X200:T2000S	10	4	200.0
10X5X200:T2000S	10	5	200.0
10X6X200:T2000S	10	6	200.0
10X8X200:T2000S	10	8	200.0
12X3X200:T2000S	12	3	200.0
12X4X200:T2000S	12	4	200.0
12X6X200:T2000S	12	6	200.0
12X8X200:T2000S	12	8	200.0
15X3X200:T2000S	15	3	200.0
15X4X200:T2000S	15	4	200.0
15X5X200:T2000S	15	5	200.0
15X6X200:T2000S	15	6	200.0
15X8X200:T2000S	15	8	200.0
15X10X200:T2000S	15	10	200.0
16X8X200:T2000S	16	8	200.0
16X10X200:T2000S	16	10	200.0

Product	H (mm)	B (mm)	OAL (mm)
16X12X200:T2000S	16	12	200.0
20X3X200:T2000S	20	3	200.0
20X4X200:T2000S	20	4	200.0
20X5X200:T2000S	20	5	200.0
20X6X200:T2000S	20	6	200.0
20X8X200:T2000S	20	8	200.0
20X10X200:T2000S	20	10	200.0
20X12X200:T2000S	20	12	200.0
20X15X200:T2000S	20	15	200.0
25X5X200:T2000S	25	5	200.0
25X6X200:T2000S	25	6	200.0
25X10X200:T2000S	25	10	200.0
25X12X200:T2000S	25	12	200.0
30X4X200:T2000S	30	4	200.0
30X5X200:T2000S	30	5	200.0
30X10X200:T2000S	30	10	200.0
30X15X200:T2000S	30	15	200.0
30X20X200:T2000S	30	20	200.0

TOOL BITS R

HSS-E Round Tool bit

Ground round tool bit according to DIN 4964 A standard. T2000S HSS-E bright steel with 10% Cobalt content in hardness 65-67 HRC.



HSS-E	DIN 4964A	Bright
h9		

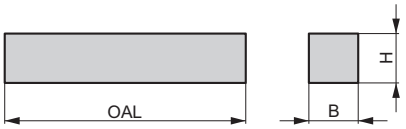
Product	DCON MS (mm)	OAL (mm)
3X200 T:T2000S	3.00	200.0
4X200 T:T2000S	4.00	200.0
5X200 T:T2000S	5.00	200.0
6X200 T:T2000S	6.00	200.0
7X200 T:T2000S	7.00	200.0
8X200 T:T2000S	8.00	200.0
10X200 T:T2000S	10.00	200.0
12X200 T:T2000S	12.00	200.0
14X200 T:T2000S	14.00	200.0
16X200 T:T2000S	16.00	200.0
20X200 T:T2000S	20.00	200.0

TOOL BITS S

DORMER

HSS-E Square Tool bit

Ground square tool bit according to DIN 4964 B standard. T2000S HSS-E bright steel with 10% Cobalt content in hardness 65-67 HRC.

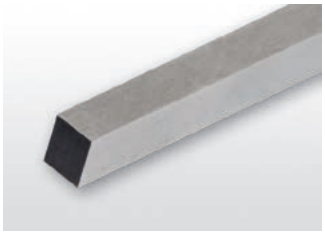


HSS-E	DIN 4964B	Bright
+0 -0.1		

Product	H (mm)	B (mm)	OAL (mm)
4X4X200:T2000S	4	4	200.0
6X6X200:T2000S	6	6	200.0
8X8X200:T2000S	8	8	200.0
10X10X200:T2000S	10	10	200.0
12X12X200:T2000S	12	12	200.0
14X14X200:T2000S	14	14	200.0
15X15X200:T2000S	15	15	200.0
16X16X200:T2000S	16	16	200.0
20X20X200:T2000S	20	20	200.0
25X25X200:T2000S	25	25	200.0

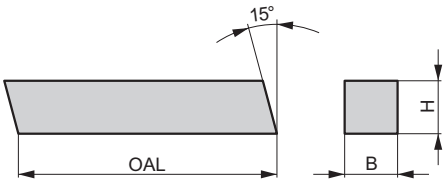
TOOL BITS SA

DORMER



HSS-E Square Tool bit with Bevel

Ground square tool bit with beveled ends according to DIN 4964 B standard. T2000S HSS-E bright steel with 10% Cobalt content in hardness 65-67 HRC.

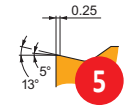


HSS-E	DIN 4964B	Bright
h13		

Product	H (mm)	B (mm)	OAL (mm)	H (inch)	B (inch)	OAL (inch)
4X4X200A:T2000S	4	4	200.0	–	–	–
6X6X100A:T2000S	6	6	100.0	–	–	–
6X6X200A:T2000S	6	6	200.0	–	–	–
8X8X100A:T2000S	8	8	100.0	–	–	–
8X8X160A:T2000S	8	8	160.0	–	–	–
8X8X200A:T2000S	8	8	200.0	–	–	–
10X10X100A:T2000S	10	10	100.0	–	–	–
10X10X160A:T2000S	10	10	160.0	–	–	–
10X10X200A:T2000S	10	10	200.0	–	–	–
12X12X100A:T2000S	12	12	100.0	–	–	–
12X12X200A:T2000S	12	12	200.0	–	–	–
14X14X200A:T2000S	14	14	200.0	–	–	–
15X15X200A:T2000S	15	15	200.0	–	–	–
16X16X200A:T2000S	16	16	200.0	–	–	–
20X20X200A:T2000S	20	20	200.0	–	–	–
25X25X200A:T2000S	25	25	200.0	–	–	–
3/16X3/16X2.1/2A:T2000S	–	–	–	3/16	3/16	2.500
1/4X1/4X2.1/2A:T2000S	–	–	–	1/4	1/4	2.500
1/4X1/4X4A:T2000S	–	–	–	1/4	1/4	4.000
5/16X5/16X2.1/2A:T2000S	–	–	–	5/16	5/16	2.500
5/16X5/16X4A:T2000S	–	–	–	5/16	5/16	4.000
3/8X3/8X3A:T2000S	–	–	–	3/8	3/8	3.000
3/8X3/8X4A:T2000S	–	–	–	3/8	3/8	4.000
3/8X3/8X6A:T2000S	–	–	–	3/8	3/8	6.000
1/2X1/2X4A:T2000S	–	–	–	1/2	1/2	4.000
1/2X1/2X6A:T2000S	–	–	–	1/2	1/2	6.000
5/8X5/8X6A:T2000S	–	–	–	5/8	5/8	6.000

INSTRUCTIONS

SM



SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials. 10

PRAMET

1

CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.1	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35

3

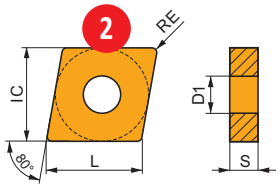
DNMG

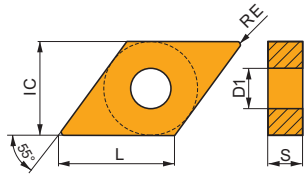
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	4.76

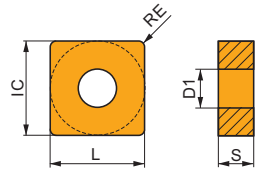
SNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1906	19.050	7.94	19.05	6.35

2







TNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76

VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76

WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76

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 vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
4																			
CNMG 120404E-SM:T6310	0.4	155	0.20	2.0	110	0.18	2.0	125	0.20	2.0	465	0.24	2.0	45	0.18	1.6	30	0.13	0.3
CNMG 120404E-SM:T7325		180	0.20	2.0	140	0.18	2.0	–	–	–	–	–	–	55	0.18	1.6	–	–	–
CNMG 120404E-SM:T7335		175	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.18	1.6	–	–	–
CNMG 120404E-SM:T8415	0.4	200	0.20	2.0	105	0.18	2.0	185	0.20	2.0	510	0.24	2.0	45	0.18	1.6	35	0.13	0.3
CNMG 120404E-SM:T8430	0.4	180	0.20	2.0	95	0.18	2.0	145	0.20	2.0	495	0.24	2.0	35	0.18	1.6	30	0.13	0.3

7 8 9 11

Pos.	Description
1	Designation of insert
2	Schematic drawing of insert
3	Table with insert sizes (mm)
4	Picture of representative insert
5	Profile of main cutting edge
6	Icons – specific features and cutting edge type

Pos.	Description
7	ISO insert code:Grade
8	Working conditions
9	Insert radii (mm)
10	Geometry description
11	Application area of insert

Typical page with turning inserts displayed – specific page details will differ.

1 DDUN(RL) INT

P M K N S H 2

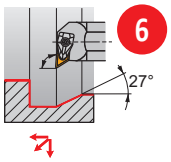
PRAMET

D 3

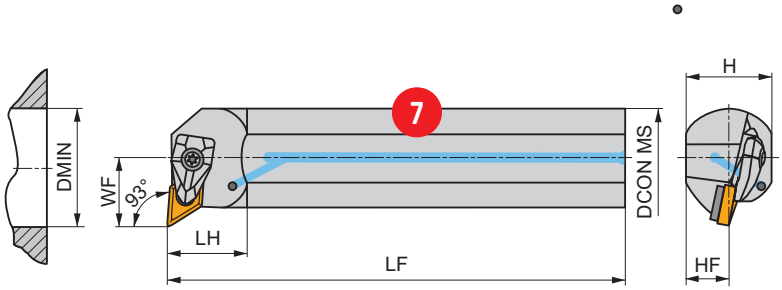

4

Internal Double Clamp Boring Bar with 93° Cutting Angle for DN.. Inserts

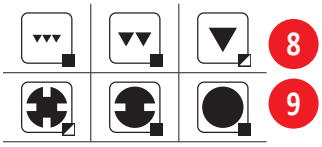
Internal Right/Left hand double clamp boring bar, through coolant, 93° cutting angle for DN.. inserts. Suited for wide range of internal turning applications, copy turning up to 27°.Body treated for longer tool life. 5



6



7


8 9


10

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		kg			
R	A25T-DDUNR 11	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNR 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.68	GI046	DD11	–
	A40T-DDUNR 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.58	GI044	DD154	AT002
	A50U-DDUNR 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.25	GI044	DD154	AT002
L	A25T-DDUNL 11	25	32	17	23	11.5	300	28.0	-12	-6	✓	0.96	GI046	DD11	–
	A32T-DDUNL 11	32	40	22	30	15	300	30.0	-10	-6	✓	1.69	GI046	DD11	–
	A40T-DDUNL 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	2.59	GI044	DD154	AT002
	A50U-DDUNL 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	5.25	GI044	DD154	AT002

11 12 13 14 15 16 17 18

	19
GI044	DN.. 1506..
GI046	DN.. 1104..

		Nm	20		
DD11	DCS 09	1.7	DDS 266-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

		21	
AT002a	DN.. 1504..	DCS 12C4	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

Typical page with turning holder displayed – specific page details will differ.

TURNING HOLDERS – PAGE OVERVIEW

Pos.	Description
1	Designation of turning holder
2	Material group recommendations
3	Clamping system of insert
4	Illustrative picture [1]
5	Tool description
6	Workpiece profile
7	Schematic drawing of tool
8	Achievable quality of surface
9	Character of cut/working conditions
10	Product applications
11	Tool design

Pos.	Description
12	ISO code of holder
13	Dimensions (mm) and angles [2] (°) of holder
14	Internal coolant supply
15	Weight (kg)
16	Group of compatible inserts [3]
17	Group of spare parts [3], [4]
18	Group of accessories [3], [4]
19	Compatible inserts
20	Spare parts
21	Special accessories

[1] Turning holder is primarily displayed in its right design (R)

[2] GAMO = orthogonal rake angle (see technical pages)

LAMS = inclination angle of main cutting edge (see technical pages)

[3] Code of Group of compatible inserts, spare parts and special accessories is used only for purposes of this catalogue. It cannot be used for orders.

[4] Spare parts and special accessories icons are designed schematically for ease of understanding. They aren't included in list of icons. Screws are, in some cases, completed with info on torque value in Nm, length of screw and size of thread.

ICONS OVERVIEW

General Icons

■	Primary use
◪	Possible use

▼▼▼	Finishing – very good surface quality
▼▼	Medium machining – good surface quality
▼	Roughing – unlimited surface roughness

●	Suitable for stable working conditions
◓	Suitable for unstable working conditions
✚	Suitable for very unstable working conditions

Turning operations

	Longitudinal turning without shoulder – external
	Longitudinal turning with shoulder – external
	Cone turning – external
	Chamfering (bevelling)
	Face turning without shoulder
	Face turning with shoulder
	One directional copy turning – external
	Multi directional copy turning – external
	Face copy turning
	Shallow radial groove
	Shallow groove for o-ring
	Wide radial groove (with following expansion)

	Longitudinal turning without shoulder – internal
	Longitudinal turning with shoulder – internal
	Cone turning – internal
	Chamfering (bevelling) in hole
	Chamfering (bevelling) from the back
	Machining the rear face (shoulder) from the back
	One directional copy turning – internal
	Multi directional copy turning – internal
	Face copy turning in hole
	Internal grooving
	Internal groove for o-ring
	Internal grooving (with following expansion)

	Deep radial groove
	Parting off
	Tube parting off
	Shallow axial groove
	Shallow and wide axial groove (with following expansion)
	Deep axial groove
	Deep and wide axial groove (with following expansion)
	Copy turning (multi directional machining)
	Face copy turning
	Thread turning – external
	Thread turning – internal
	Shaping

ICONS OVERVIEW

General Icons

■	Primary use
◪	Possible use

▼▼▼	Finishing – very good surface quality
▼▼	Medium machining – good surface quality
▼	Roughing – unlimited surface roughness

●	Suitable for stable working conditions
⬌	Suitable for unstable working conditions
✚	Suitable for very unstable working conditions

Features

1	First choice
U	Universal wide range option
	For short chipping materials
	For tough materials (long chipping)
	Thin-walled and slim workpieces
	Large overhang
	Heavy working conditions
W	Insert with Wiper geometry
HSC	High Speed Cutting
HFC	High Feed Cutting

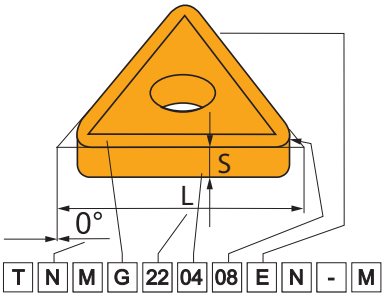
Cutting edge condition code (CECC)

F	Sharp edge
E	Rounded edge
T	Edge with facet
S	Rounded edge with facet
K	Edge with double facet
P	Rounded edge with double facet

Technical parts

FF	Fine finishing
F	Finishing
M	Medium machining
R	Roughing
HR	Heavy roughing
V	Cutting speed
f	Feed (mm/rev)
a_p	Depth of cut (mm)
X.V	Multiplication factor for cutting speed
	Durability (min)
Nm	Clamping torque of screw (Nm)
	Group of heads for roughing
	Internal supply of coolant

INSERTS – ISO CODE DESIGNATION



	1	2	3	4
ISO	T	N	U	N
	T	N	M	G
ANSI	T	N	U	
	T	N	M	G

1 Insert shape

H	O	P	R
S	T	C 80°	D 55°
E 75°	M 86°	V 35°	W 80°
L	A 85°	B 82°	K 55°

2 Insert clearance angle

A	3°	B	5°
C	7°	D	15°
E	20°	F	25°
G	30°	N	0°
P	11°	O	Special

4 Insert type

N	
R	
F	
A	
M	
G	
W	40° – 60°
T	
Q	
U	
B	70° – 90°
H	
C	
J	
X	Special

3 Tolerances

	(mm)			(")		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	.0002"	.001"	.0010"
F	0.005	0.025	0.013	.0002"	.001"	.0005"
C	0.013	0.025	0.025	.0005"	.001"	.0010"
H	0.013	0.025	0.013	.0005"	.001"	.0005"
E	0.025	0.025	0.025	.0010"	.001"	.0010"
G	0.025	0.130	0.025	.0010"	.005"	.0010"
J	0.005	0.025	0.05 – 0.13	.0002"	.001"	.002 – 0.005"
K	0.013	0.025	0.05 – 0.13	.0005"	.001"	.002 – 0.005"
L	0.025	0.025	0.05 – 0.13	.0010"	.001"	.002 – 0.005"
M	0.08 – 0.18	0.130	0.05 – 0.13	.003 – 0.007"	.005"	.002 – 0.005"
N	0.08 – 0.18	0.025	0.05 – 0.13	.003 – 0.007"	.001"	.002 – 0.005"
U	0.05 – 0.38	0.130	0.05 – 0.13	.005 – 0.015"	.005"	.003 – 0.010"

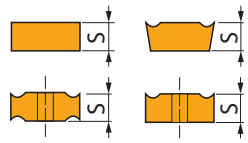
INSERTS – ISO CODE DESIGNATION

5	6	7		8	9		10
22	04	08					
22	04	08		E	N	-	M
5	6	7		8	9		10
4	3	2					
4	3	2		E	N	-	M

5 – Insert cutting edge length (insert size)

d = I.C.		H	O	P	S	T	C	D	E	M	V	W	R	K
(mm)	(in)													
3.97					03	06		04			06	02		
	5/32"	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16"	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32"	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8"	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1"	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"	10												

6 – Insert thickness



	S	
	(mm)	(")
01	1.59	1/16"
T1	1.98	5/64"
02	2.38	3/32"
03	3.18	1/8"
T3	3.97	5.32"
04	4.76	3/16"
05	5.56	7/32"
06	6.35	1/4"
07	7.94	5/16"
09	9.52	3/8"

7 – Insert nose radius

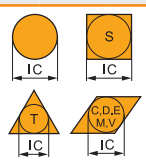
	RE	
	(mm)	(")
00	0	0"
02	0.2	1/128"
04	0.4	1/64"
08	0.8	1/32"
12	1.2	3/64"
16	1.6	1/16"
24	2.4	3/32"
32	3.2	1/8"

Round inserts

d = I.C.	
(")	00
(mm)	M0

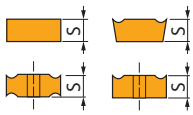
ANSI

5 – Inscribed circle



Symbol	d = I.C.	
	(mm)	(")
1	3.175	1/8"
1.2	3.969	5/32"
1.5	4.763	3/16"
1.8	5.556	7/32"
2	6.350	1/4"
2.5	7.938	5/16"
3	9.525	3/8"
4	12.700	1/2"
5	15.875	5/8"
6	19.050	3/4"
7	22.225	7/8"
8	25.400	1"
10	31.750	5/4"
12	38.100	6/4"

6 – Insert thickness



Symbol	S	
	(mm)	(")
1	1.588	1/16"
1.2	1.984	5/64"
1.5	2.381	3/32"
2	3.175	1/8"
2.5	3.969	5/32"
3	4.763	3/16"
3.5	5.556	7/32"
4	6.350	1/4"
5	7.938	5/16"
6	9.525	3/8"
7	11.113	7/16"
8	12.700	1/2"
9	14.288	9/16"
10	15.875	5/8"

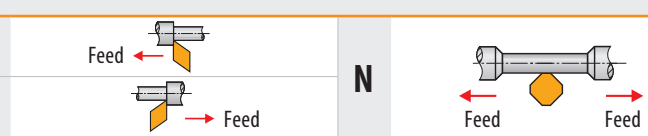
7 – Insert nose radius

Symbol	RE	
	(mm)	(")
0	0	0"
0.2	0.099	1/256"
0.5	0.198	1/128"
1	0.397	1/64"
2	0.794	1/32"
3	1.191	3/64"
4	1.588	1/16"
5	1.984	5/64"
6	2.381	3/32"
7	2.778	7/64"
8	3.175	1/8"
10	3.969	5/32"
12	4.763	3/16"
14	5.556	7/32"
16	6.350	1/4"

8 – Insert cutting edge design

F Sharp edges	E Rounded edges
T Edges with facet	S Rounded edges with facet
K Edges with double facet	P Rounded edges with double facet

9 – Feed direction

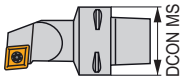


10 – Chip breaker designation

EXTERNAL TURNING TOOLS – ISO CODE DESIGNATION

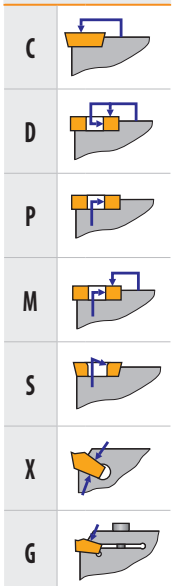
Shank tool	ISO	2	3	4	5	6		7	8	11	12		13	
		P	C	L	N	R	–	32	25	L	12	–	M	
PSC	ISO	1	2	3	4	5	6		9	10		12		
		C4	– D	C	L	N	R	–	27	050	–	12		
Shank tool	ANSI	2	3	4	5	6			7 & 8	12		11		
		D	C	L	N	R	–		16	4		D		

1 – Coupling size

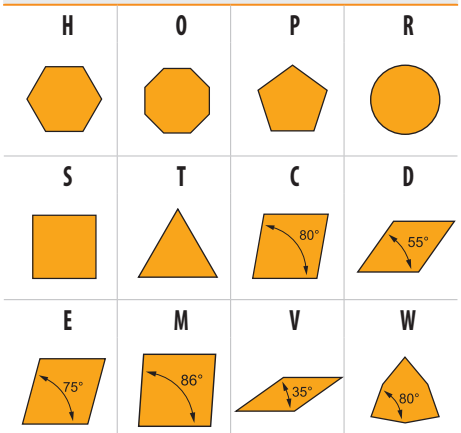


C	DCON MS
C3	32
C4	40
C5	50
C6	63
C8	80

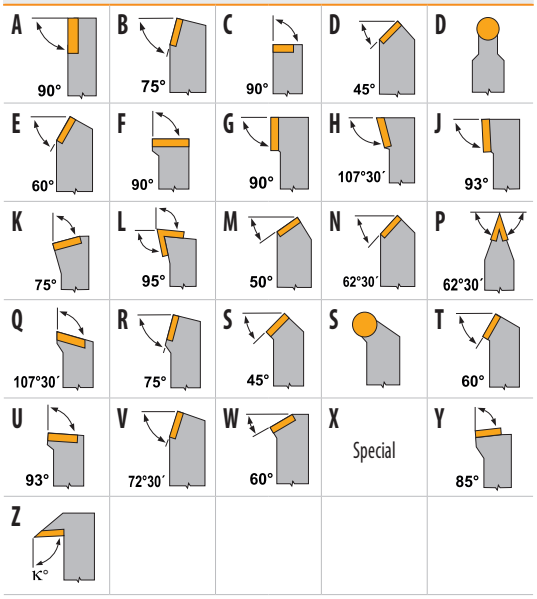
2 – Clamping designation



3 – Insert shape



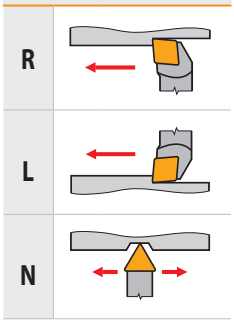
4 – Holder style – cutting edge angle



5 – Insert clearance angle

N	B	C	P
0°	5°	7°	11°

6 – Direction of cut

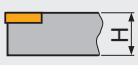


7 & 8 – Shank width & Shank height (")

Symbol	B (")	H (")
05	5/16"	5/16"
06	3/8"	3/8"
08	1/2"	1/2"
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"
24	1 1/2"	1 1/2"
32	2"	2"

For square shanks, the number is the width or height in terms of 16ths. For rectangular shanks the first digit is the width in terms of 8ths and the second digit is the height in terms of 4ths.

7 – Shank height (mm)

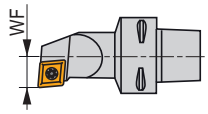


08	10	12	16	20	25
32	38	40	45	50	60

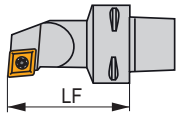
8 – Shank width (mm)

08	10	12	16	20	25
32	38	40	45	50	60

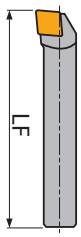
9 – Functional width (mm)



10 – Functional lenght (mm)



11 – Holder total length



	LF (")
A	4.000"
B	4.500"
C	5.000"
D	6.000"
E	7.000"
F	8.000"
M	4.000"
N	4.500"
R	6.000"
S	7.000"
T	8.000"

	LF (mm)
D	60
E	70
F	80
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Spec.
Y	500

INTERNAL TURNING TOOLS – ISO CODE DESIGNATION

	15	16	17		2	3	4	5	6	12		14
ISO	A	25	T	–	P	C	L	N	L	12	–	X
ANSI	A	16	T	–	D	C	L	N	L	4		

12 / 12 – Insert cutting edge length (insert size)

d = I.C. (mm)	(")	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32"	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16"	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32"	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8"	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1"	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"	10												

13 – Manufacturer's designation

M	Clamping system "S" with shim

14 – Manufacturer's designation

X	Special shank style
. .	
93	Z – style tool setting angle
. .	

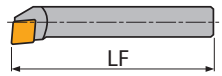
15 / 15 – Shank

S	Steel shank
A	Steel shank with coolant hole
E	Tungsten carbide shank with coolant hole

16 / 16 – Shank Ø (mm)

DCON MS (mm)		DCON MS (")	
08	8	03	.1875"
10	10	04	.250"
12	12	05	.3125"
16	16	06	.375"
20	20	08	.500"
25	25	10	.625"
32	32	12	.750"
40	40	16	1.000"
50	50	20	1.250"
60	60	24	1.500"
		32	2.000"

17 / 17 – Holder total Length



	LF (")
F	3.250"
H	4.000"
K	5.000"
M	6.000"
P	6.250"
Q	7.250"
R	8.000"
S	10.000"
T	12.000"
U	14.000"
V	15.750"
W	17.750"
Y	20.000"
X	Spec.

	LF (mm)
D	60
E	70
F	80
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Spec.
Y	500

HEADS – ISO CODE DESIGNATION

CARTRIDGE

1	2		3	4	5	6	7
KH	P	–	C	L	N	R	25

HOLDER

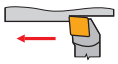
8		6	9	10	11
DKH		R	50	60	W

1 Cartridge

5 Insert clearance angle

N	C	P
0°	7°	11°

6 Direction of cut

R	
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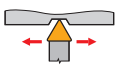
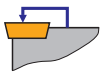
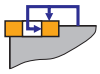
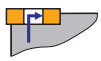
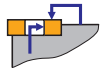
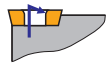
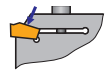
N	

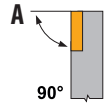
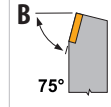
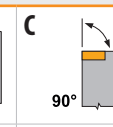
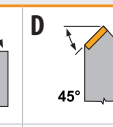
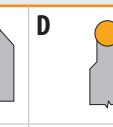
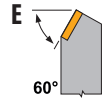
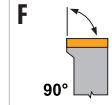
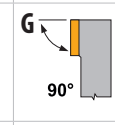
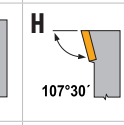
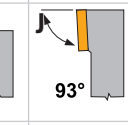
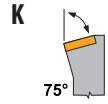
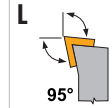
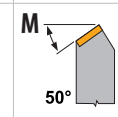
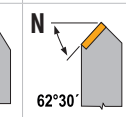
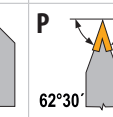
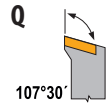
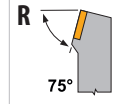
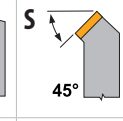
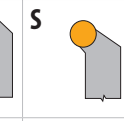
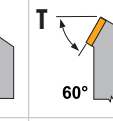
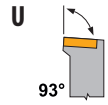
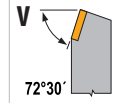
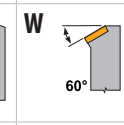
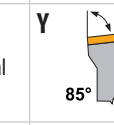
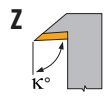
2 Clamping designation

C	
D	
P	
M	
S	
X	
G	

3 Insert shape

S		C	
T		D	
R		K	
W		V	
L		X	Special

4 Holder style – cutting edge angle

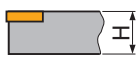
A 	B 	C 	D 	D 
E 	F 	G 	H 	J 
K 	L 	M 	N 	P 
Q 	R 	S 	S 	T 
U 	V 	W 	X Special	Y 
Z 				

7 Insert cutting edge length (insert size)

d = I.C. (mm)	(")	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32"	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16"	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32"	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8"	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1"	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"	10												

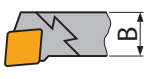
8 Cartridge holder

9 Shank height (mm)



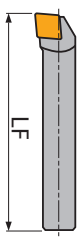
08	10	12	16	20	25
32	40	50	60	70	80

10 Shank width (mm)



08	10	12	16	20	25
32	40	50	60	70	80

11 Holder total length



	LF (mm)
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Spec.
Y	500

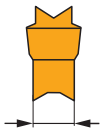
1	2		3	4	5	6	7		8
GL	3	–	D	300	G	02	L06	–	PM

1 Tool group

GL

2 Pocket size

1, 2, 3, 4, 5, 6



3 Number of edges

S	One edge
D	Two edges

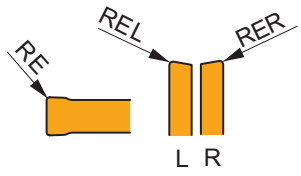
4 Cutting width – CW

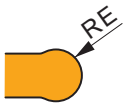
	CW
150	1.50
200	2.00
250	2.50
300	3.00
400	4.00
500	5.00
600	6.00
800	8.00

5 Edge design

G	Ground
M	Direct pressed

6 Nose radius



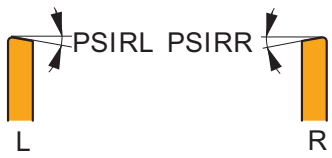


	RE, RER, REL (mm)
015	0.15
02	0.2
03	0.3
04	0.4
08	0.8

ROUND GEOMETRY

	RE (mm)
M0	RE = CW/2

7 Primary cutting edge angle



	(°)
06	6
12	12

8 Chipbreaker designation

PM
PR
GM
MM

PARTING – OFF & GROOVING HOLDERS (EXTERNAL TURNING) – GL – CODE DESIGNATION

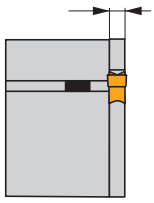
1	2		3	4	5	6	7		8		9	10	11
GL	3	–	S	2525	M	F	R	–	20	–	R	120	090

1 Tool group

GL

2 Pocket size

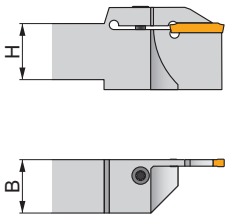
1, 2, 3, 4, 5, 6



3 Shank type

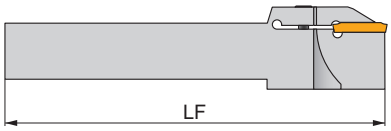
A	steel shank with internal coolant
S	steel shank without internal coolant

4 Shank dimensions



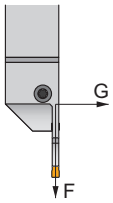
	H × B (mm)
1212 –	12 × 12
1616 –	16 × 16
2020 –	20 × 20
2525 –	25 × 25
3232 –	32 × 32

5 Holder total length – LF

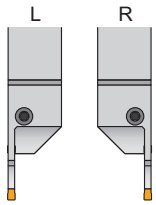


	LF (mm)
H	100
K	125
M	150
P	170

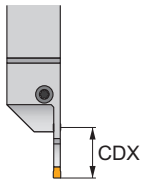
6 Tool style – cutting edge angle



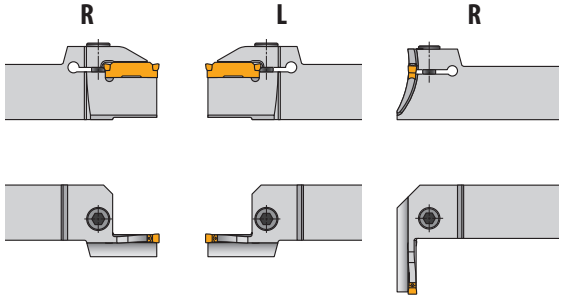
7 Version (right/left)



8 Cutting depth maximum – CDX

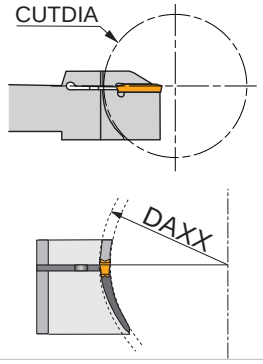


9 Blade curvature direction

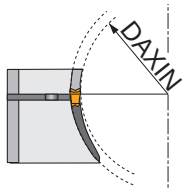


Additional information for axial turning.

10 Maximum diameter



11 Minimum diameter

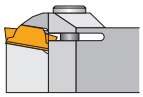


PARTING – OFF & GROOVING TOOLS – EXTERNAL TURNING – ISO CODE DESIGNATION

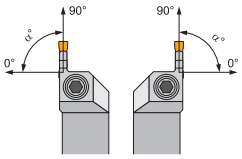
	1	2	3	4	5	6	7	8	9	10	11
ISO	G	F	I	L	25	25	M	0316	R	030	017
	1	2	3	4	5 & 6		7	8	9	10	11
ANSI	G	F	I	L	16		D	0316	R	1.18	.670

1 – Clamping designation

G



2 – Holder style – cutting edge angle

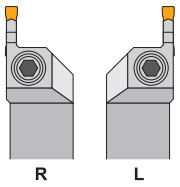


α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

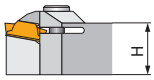
3 – Cutting depth maximum – CDX

G = 2.0 × CW	N = 5.5 × CW
H = 2.5 × CW	O = 6.0 × CW
I = 3.0 × CW	P = 6.5 × CW
J = 3.5 × CW	Q = 7.0 × CW
K = 4.0 × CW	R = 7.5 × CW
L = 4.5 × CW	S = 8.0 × CW
M = 5.0 × CW	T = 8.5 × CW

4 – Version (right/left) R/L

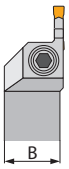


5 – Shank height (mm)



12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

6 – Shank width (mm)



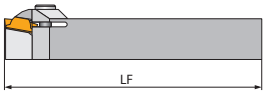
12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

5 & 6

	B (")	H (")
05	5/16"	5/16"
06	3/8"	3/8"
08	1/2"	1/2"
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"
24	1 1/2"	1 1/2"
32	2"	2"

For square shanks, the number is the width or height in terms of 16ths. For rectangular shanks the first digit is the width in terms of 8ths and the second digit is the height in terms of 4ths.

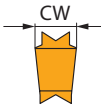
7 – Holder total length



	LF (mm)
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200

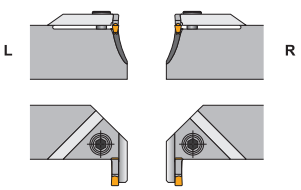
	LF (")
A	4.000"
B	4.500"
C	5.000"
D	6.000"
E	7.000"
F	8.000"

8 – Insert width



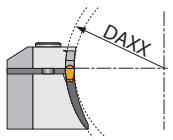
	CW (mm)	CW (")
02	2.0	.079"
03, 0313, 0316	3.0	.118"
04, 0413, 0416	4.0	.157"
05, 0516	5.0	.197"
06, 0616	6.0	.236"
08, 0830	8.0	.315"

9 – Blade curvature direction



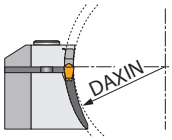
Additional information for axial turning

10 – Maximum diameter – face grooving



Additional information for axial turning

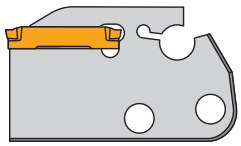
11 – Minimum diameter – face grooving



Additional information for axial turning

PARTING – OFF & GROOVING BLADES (EXTERNAL TURNING) – GL – CODE DESIGNATION

1	2		3	4	5	6	7		8
GL	1	–	S	26	K	B	R	–	16

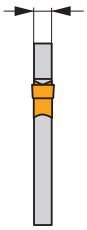


1 – Tool group

GL

2 – Pocket size

1, 2, 3, 4, 5, 6



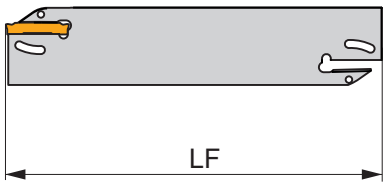
3 – Shank type

A	Steel shank with internal coolant
S	Steel shank without Internal coolant

4 – Shank dimensions

	H (mm)
26	26
29	29
32	32

5 – Blade total length – LF

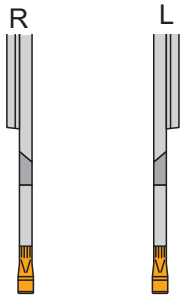


	LF (mm)
C	50
K	125
M	150

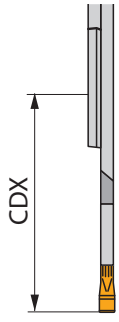
6 – Tool style

B – blade
BS – modular blade

7 – Version (right/left)

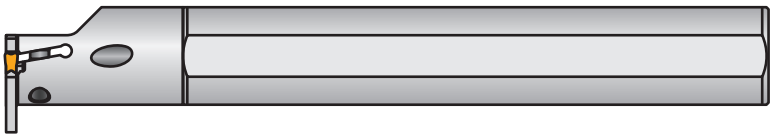


8 – Cutting depth maximum – CDX



PARTING – OFF & GROOVING HOLDERS (INTERNAL TURNING) – GL – CODE DESIGNATION

1	2		3	4	5	6	7		8		9
GL	3	–	A	32	S	G	R	–	12	–	45

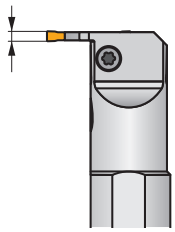


1 Tool group

GL

2 Pocket size

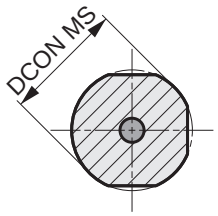
2, 3, 4



3 Shank type

A	Steel shank with internal coolant
S	Steel shank without internal coolant

4 Shank dimensions

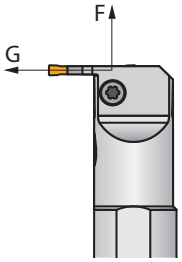


	DCON MS (mm)
25	25
32	32
40	40

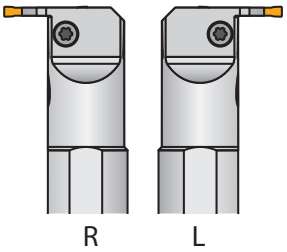
5 Holder total length – LF

	LF (mm)
Q	180
S	250
T	300

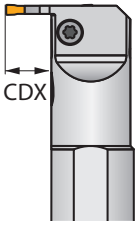
6 Tool style – cutting edge angle



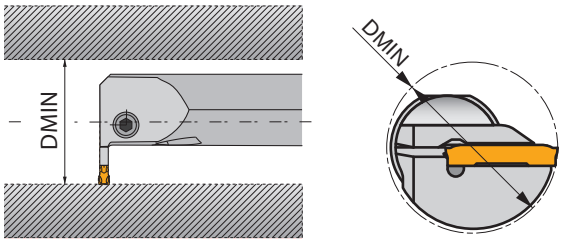
7 Version (right/left)



8 Cutting depth maximum – CDX



9 Minimum diameter



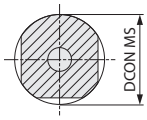
PARTING – OFF & GROOVING TOOLS – INTERNAL TURNING – ISO CODE DESIGNATION

	1	2	3		4	5	6	7	8
ISO	A	25	S	–	G	G	H	L	0313
ANSI	1	2	3		4	5	6	7	8
	A	16	S	–	G	G	H	L	0313

1 Shank

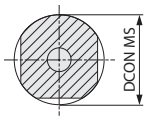
S	Steel shank
A	Steel shank with coolant hole

2 Diameter of shank



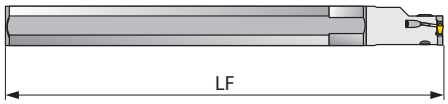
	DCON MS (mm)
12	12
16	16
20	20
25	25
32	32
40	40

2 Diameter of shank



	DCON MS (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

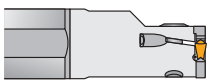
3 Holder total length



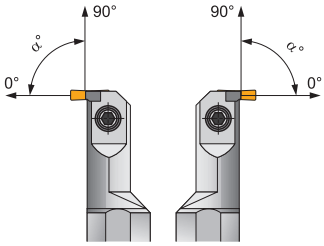
	LF (mm)	LF (")		LF (mm)	LF (")
M	150	6.000"	S	250	10.000"
P	170	6.250"	T	300	12.000"
Q	180	7.250"	U	350	14.000"
R	200	8.000"	V	400	15.750"

4 Clamping designation

G



5 Tool style – cutting edge angle

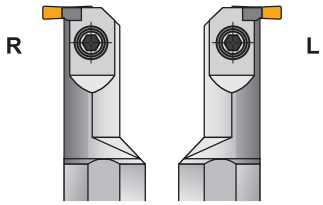


α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

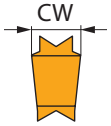
6 Cutting depth maximum – CDX

E = 1.0 × CW	J = 3.5 × CW
F = 1.5 × CW	K = 4.0 × CW
G = 2.0 × CW	L = 4.5 × CW
H = 2.5 × CW	M = 5.0 × CW
I = 3.0 × CW	N = 5.5 × CW
X = Special	

7 Version (right/left) R/L



8 Insert width

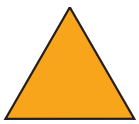


	CW (mm)
0313	3.0
0413	4.0

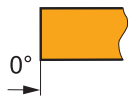
INDEXABLE CUTTING INSERTS FOR THREADING ISO – CODE DESIGNATION

	1	2	3	4	5	6	7		8
ISO	T	N	16	E	R	175	M	–	P1
ANSI	T	N	16	E	R	120	W	–	P1

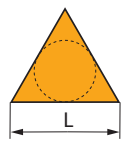
1 Insert shape

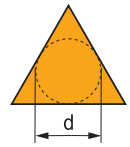
T	

2 Insert clearance angle

N	

3 Insert cutting edge length (insert size)





L		d = IC	
(mm)	(")	(mm)	(")
11	.433"	**6,350**	1/4"
16	.650"	**9,525**	3/8"
22	.866"	**12,7**	1/2"

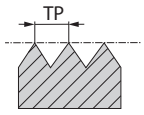
4 External – Internal

E	External
N	Internal

5 Direction of cut

R	Right
L	Left
N	Neutral

6 Thread pitch



s × 100

Thread Pitch mm × 100

6 No. of threads

No. of threads per inch × 10

7 Thread profile

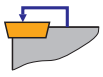
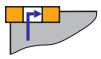
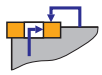
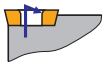
M	Metric 60°	TR	TR 30° ISO 2901/3–1977
MJ	SEA MA1370	UN	American UN 60° ISO 5864–1978
W	Whitworth 55° ISO 228–1982	UNJ	SEA AS8879
RD	Round 30°	ACME	ACME 29° ANSI B1.5–1988
BSPT	ISO 228/1 35 21 1959 ISO 7/1	STACME	ASME/ANSI B1.8-1988
NPT	ANSI B1.1–1983	API RD	API

8 Chip breaker designation

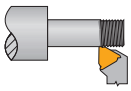
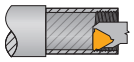
P1	Pressed
AL	For nonferous

	1	2	3		4	5	6	7		8
ISO	S	E	R	–	S	2525	M	16	–	
ANSI	S	E	R	–	S	16	D	16	–	

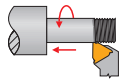
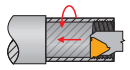
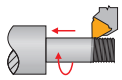
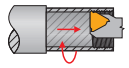
1 Clamping designation

C	
P	
M	
S	

2 Machining orientation

E	External	
I	Internal	

3 Direction of cut

R	Right	External	
		Internal	
L	Left	External	
		Internal	

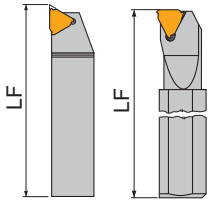
4 Type of construction

–	Normal
S	Special

5 Holder dimensions (mm)

External turning	**2525**	25 × 25 mm
Internal turning	**1416**	Shank – 14 mm Shank height Ø – 16 mm

6 Holder total length (mm)

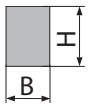


	LF (mm)
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300

7 Insert cutting edge length (insert size)

d = IC (mm)	d = IC (")	T
6.350	1/4"	11
9.525	3/8"	16
12.700	1/2"	22

5 Tool dimensions (")

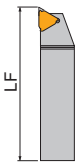


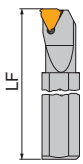
	B (")	H (")
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"

	DCON (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

For square shanks, the number is the width or height in terms of 16ths. For rectangular shanks the first digit is the width in terms of 8ths and the second digit is the height in terms of 4ths.

6 Holder total length (")





	LF (")
C	5.000"
D	6.000"
E	7.000"
F	8.000"
K	5.000"
M	6.000"
P	6.250"
Q	7.250"
R	8.000"
S	10.000"
T	12.000"
U	14.000"

8 Helix angle λ

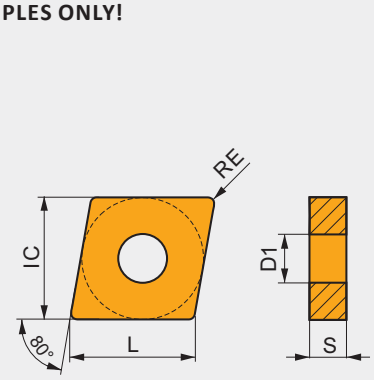
0	Helix angle λ = 0°
1	Helix angle λ = 1°
2	Helix angle λ = 2°

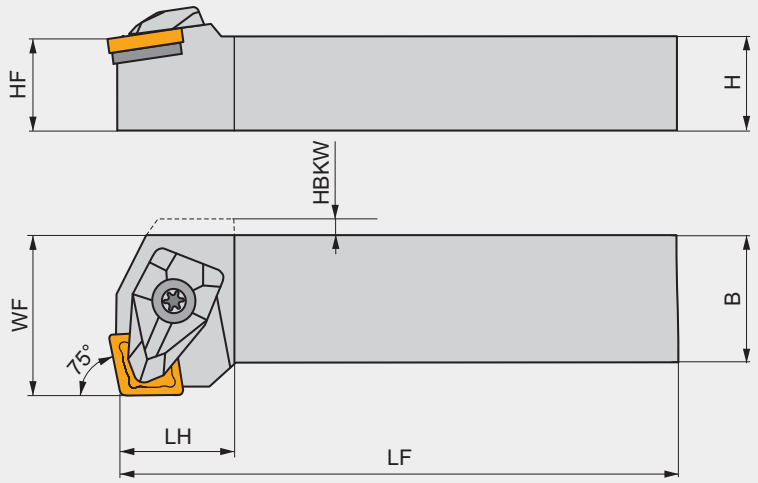
CUTTING TOOL PARAMETERS ACCORDING TO ISO 13399

All cutting tools are defined by a number of parameters according to the standard ISO 13399. This list contains all the parameters used in this catalogue and their definitions.

ISO 13399 is an international cutting tool information standard. It provides dimensions and parameters in a neutral format that is independent of any particular system or company nomenclature. When cutting tools are clearly defined according to a global standard, all types of software can process the electronic data more quickly, improving the quality of communication and helping to make the exchange of information run smoothly. Supporting a common language in our cutting tool descriptions this will assist system to system communication. It will save you a significant amount of time, providing an easier gathering of high-quality data across our 40,000 solid and indexable tools. By using an ISO 13399 compliant system, there will be no need to manually interpret data and key-enter it into your system.

EXAMPLES ONLY!





ISO 13399	Description
APMX	Depth of cut maximum
B	Shank width
BD	Body diameter
BLRAD	Blade reinforcement radius
BW	Insert body width
CDX	Cutting depth maximum
CND	Coolant entry diameter
CUTDIA	Work piece parting diameter maximum
CW	Cutting width
CWTOLL	Cutting width lower tolerance
CWTOLU	Cutting width upper tolerance
D1	Fixing hole diameter
DAXIN	Minimum axial groove inside diameter
DAXN	Minimum axial groove outside diameter
DAXX	Maximum axial groove outside diameter
DCON MS	Connection diameter
DMIN	Minimum bore diameter
DMINP	Minimum bore diameter perpendicular
GAMO	Ortogonal rake angle
GAMP	Axial rake angle
H	Shank height
HBH	Head bottom offset height
HBKW	Head bottom offset width
HF	Functional height
IC	Inscribed circle diameter
INSD	Insert diameter
INSL	Insert length

ISO 13399	Description
KAPR	Tool cutting edge angle
L	Cutting edge length
LAMS	Inclination angle
LB	Body length
LF	Functional length
LFA	A dimension on LF
LFS	Functional length secondary
LH	Head length
LU	Usable length
M	M-dimension
OAL	Overall length
PDX	Profile distance X
PDY	Profile distance Y
PSIRL	Tool lead angle left
PSIRR	Tool lead angle right
RE	Corner radius
S	Insert thickness
S1	Insert thickness total
TP	Thread pitch
TPI	Threads per inch
TPIN	Threads per inch
TPIX	Threads per inch
TPN	Thread pitch minimum
TPX	Thread pitch maximum
W1	Insert width
WF	Functional width
WFS	Functional width secondary

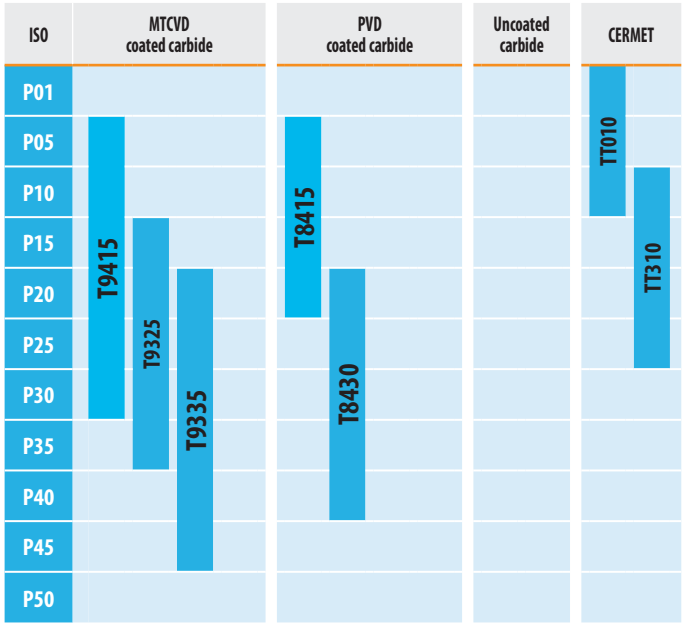
T	9	4	1	5
Operation	Coating/Substrate	Generation	ISO range	

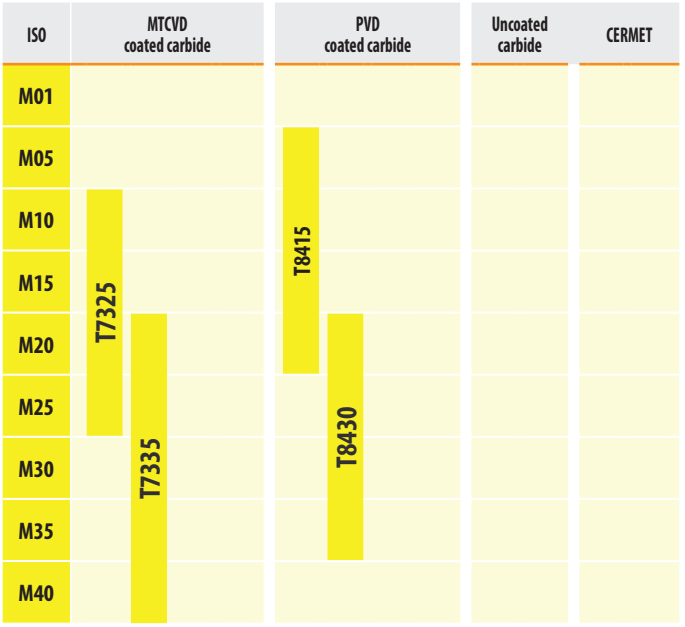
D	Drilling
M	Milling
T	Turning
G	Grooving and Parting off

0 PVD 1 CVD	Special application
2 PVD 3 CVD	Free
4 PVD 5 CVD	Group K, H
6 PVD 7 CVD	Group M, S
8 PVD 9 CVD	Universal
B	CBN
C	Ceramic
D	PCD
T	Cermet

1 – 9

	01 – 50
	**01 – 05**
	**05 – 10**
	**10 – 20**
	**20 – 30**
	**30 – 40**
	**40 – 50**


ISO
MTCVD coated carbide
PVD coated carbide
Uncoated carbide
CERMET
P01
P05
P10
P15
P20
P25
P30
P35
P40
P45
P50
T9415
T9325
T9335
T8415
T8430
TT010
TT310


ISO
MTCVD coated carbide
PVD coated carbide
Uncoated carbide
CERMET
M01
M05
M10
M15
M20
M25
M30
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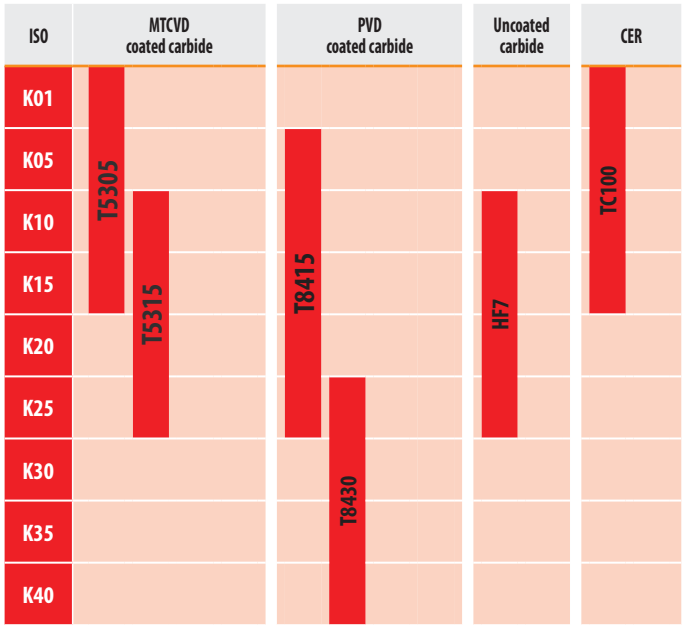
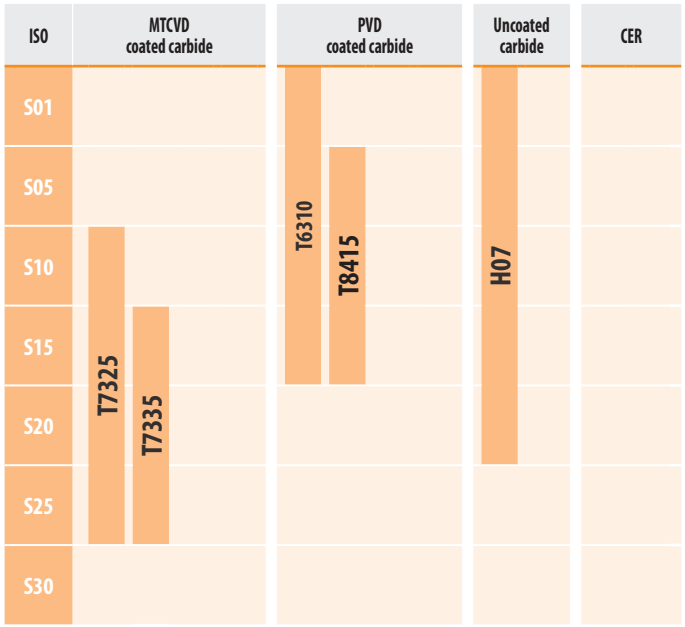
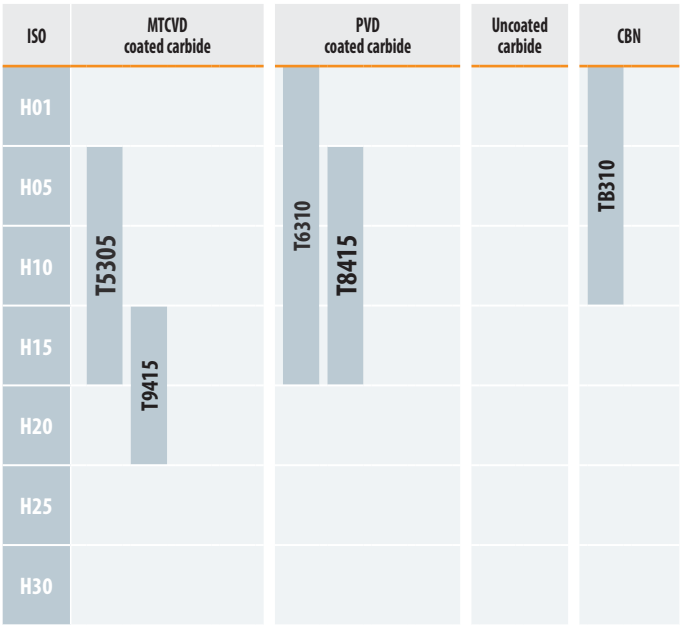
T7335
T8415
T8430


ISO
MTCVD coated carbide
PVD coated carbide
Uncoated carbide
CER
K01
K05
K10
K15
K20
K25
K30
K35
K40
T5305
T5315
T8415
T8430
HF7
TC100


ISO
MTCVD coated carbide
PVD coated carbide
Uncoated carbide
PCD
N01
N05
N10
N15
N20
N25
N30
T0315
HF7
PD1


ISO
MTCVD coated carbide
PVD coated carbide
Uncoated carbide
CER
S01
S05
S10
S15
S20
S25
S30
T7325
T7335
T6310
T8415
H07


ISO
MTCVD coated carbide
PVD coated carbide
Uncoated carbide
CBN
H01
H05
H10
H15
H20
H25
H30
T5305
T9415
T6310
T8415
TB310

CVD TURNING GRADES

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T9415 NEW	P05 - P30 K05 - K25 H10 - H20	■ ◪ ◪				MT-CVD		FGM	+ +	Highly wear-resistant material designed primarily for finish turning of common carbon and alloy steels. Despite its high abrasion resistance, it is also suitable for interrupted cutting operations. We recommend this material as the first choice for most turning operations, especially in high production applications.
T9310	P01 - P15 K05 - K20 H10 - H20	■ ◪ ◪				MT-CVD		FGM	+ +	Grade with high abrasion resistance which can be used for slightly interrupted cutting. It will be used for finishing or semi-roughing operations. This material can also be used for roughing operations provided the machine-tool-workpiece configuration is sufficiently rigid.
T9315	P05 - P25 K05 - K25 H10 - H20	■ ◪ ◪				MT-CVD		FGM	+ +	A versatile grade with excellent wear resistance properties even under intense cutting conditions. It can also be used for operations with interrupted cuts.
T9325	P15 - P35 M10 - M30 K15 - K35 S10 - S20	■ ■ ◪ ◪				MT-CVD		FGM	+ +	From a technological perspective this is an extremely versatile grade with high resistance to mechanical damage in adverse cutting conditions and retains excellent wear resistance. The correct application of this material requires high cutting speeds.
T9335	P20 - P45 M15 - M40 S15 - S25	■ ■ ◪				MT-CVD		FGM	+ + +	One of the toughest grades which is especially suitable for adverse cutting conditions at medium to high feed rates and medium cutting speeds. Compared to its predecessors, M15 – M40 it is not only tougher, but also more abrasion resistant which will be useful when using intensive cutting conditions.
T9226	P15 - P35 M10 - M30 K15 - K35 S15 - S25	■ ■ ◪ □				MT-CVD		FGM	+ + +	Grade designed for heave roughing applications. A versatile grade with high resistance to mechanical damage and retains very good wear resistance. Usable at lower cutting speeds.
T7325	P15 - P35 M10 - M25 S10 - S25	◪ ■ ■				MT-CVD		FGM	+ + +	One of the most universal turning grades. Especially designed for stainless steel machining. Optimal balance between wear resistance and performance reliability. Suitable for broad variety of application in turning operations.
T7335	P20 - P40 M20 - M40 S15 - S25	◪ ■ ■				MT-CVD		FGM	+ + +	Grade with functionally graded substrate, featuring very high operational reliability and very good wear-resistance. It is best suited to use in the machining of very tough M20 – M40 materials.
T5305	P05 - P15 K01 - K15 H05 - H15	◪ ■ ◪				MT-CVD		H	+	Grade with very high resistance to chemical wear; suitable for finishing operations using high cutting speeds. With its high abrasion resistance, it is also suitable for productive K01 – K15, machining of hardened and treated materials.
T5315	P10 - P25 K10 - K25 H15 - H25	◪ ■ ◪				MT-CVD		H	+	Grade intended primarily for productive machining which has high abrasion resistance and good operational reliability. Due to its properties, this material is particularly suitable for roughing and finishing operations for good or slightly adverse cutting conditions.
6640	P20 - P40 M20 - M35 K25 - K40	■ ■ ■				MT-CVD		H	+ + +	One of the toughest turning materials which can be used especially in roughing operations, or where operational reliability under adverse cutting conditions is a priority. Another ideal choice for machines working with low to medium cutting speeds and medium to high feed rates.

PVD TURNING GRADES

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T8415 NEW	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	■ ■ ■ ◪ ■ ■				PVD		submicron H	+ +	A versatile, high performance turning grade primarily intended for steel machining, but well suitable for stainless steels and heat resistant super alloys (HRSA) too, possibly applicable for hardened steels. It is suitable for machining at wide range of cutting speeds, light to medium feeds and under good cutting conditions, preferably with coolant.
T8315	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	◪ ■ ■ ■ ◪ ■				PVD		submicron H	+ +	Grade featuring excellent abrasion resistance while maintaining above average operational reliability, it is suitable for machining at medium to high cutting speeds in short chipping harder materials.
T8430	P20 - P40 M20 - M35 K25 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ◪ ◪ ◪ ◪				PVD		submicron H	+ + +	Undoubtedly the most versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds.
T8345	P30 - P50 M20 - M40 K30 - K40 S20 - S30	■ ◪ ◪ ◪				PVD		submicron H	+ + +	This is the toughest turning grade, which is intended mainly for machining under the worst cutting conditions and in applications with the highest requirements for operating reliability. Because of these properties, this material is recommended for lower cutting speeds.
T6310	P01 - P15 M01 - M15 K05 - K20 N05 - N20 S01 - S15 H01 - H15	■ ■ ■ ■ ■ ■				PVD		ultra submicron H	+ + +	High wear resistant turning grade with top PVD coating. Suitable for finishing operation and applications, where sharp cutting edge together with high flank wear resistance is of high importance
T0315	N05 - N20	■				PVD		submicron H	+ +	Submicron grade for turning non-ferrous metals and their alloys with a balance of wear resistance and toughness. It is provided with a unique coating with excellent friction properties.
G8330 	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25	■ ■ ■ ◪ ◪				PVD		submicron H	+ + +	Universal cutting grade for grooving and parting-off applications. This grade is characterized by its exceptional reliability and versatility. Developed to fit machining conditions for most workpiece materials.
T8330 	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ■ ◪ ◪ ◪				PVD		submicron H	+ + +	Undoubtedly the most versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds.
T8010 	P05 - P15 M05 - M15 K10 - K20 S10 - S15	■ ■ ■ ◪				PVD		submicron H	+ + +	This grade is suitable for continuous high precision thread turning of steels, stainless steel, cast iron and super alloys. Offering excellent wear resistance while ensuring operational reliability
T8030 	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25	■ ■ ■ ◪ ◪				PVD		submicron H	+ + +	Undoubtedly the most versatile grade it is suitable for machining all types of materials and can be applied in almost all turning operations. It's main benefits are high operational reliability and excellent frictional properties; it is therefore suited to applications at medium to low cutting speeds.

OTHER TURNING GRADES

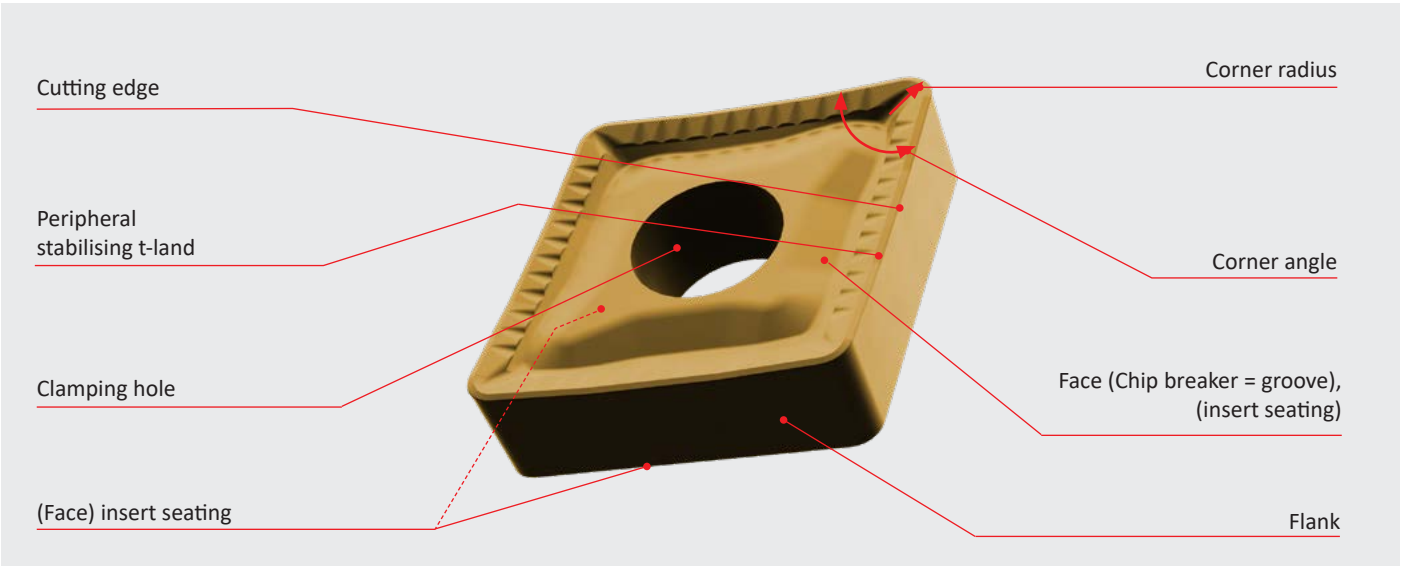
Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
HF7	M10 - M20 K10 - K25 N10 - N25	◪ ■ ■				×		submicron H	+ +	Uncoated grade which is primarily designed for machining non-ferrous metals; but can also be used for other machined materials (except steel). This material can be used in turning, milling, and even boring.
H07	M05 - M15 K10 - K25 N10 - N30 S01 - S20	◪ ■ ■ ■				×		submicron H	+ +	Uncoated turning grade suitable for machining applications where oxidation resistance is not dominating criterion of tool life. Designed for machining of Ti-based alloys. Grade exhibits high strength of cutting edge together with good wear resistance.
TT310	P10 - P25 M15 - M25	■ ◪				PVD		cermet	+ / -	Coated cermet used for fine and finish turning of carbon and alloy steels (including stainless). Its excellent friction properties are further improved by the coating applied using the PVD technique.
TT010	P01 - P10 M01 - M10	■ ◪				×		cermet	+ / -	Uncoated cermet, which is suitable for fine machining of all types of steel (including stainless) at very low feed rates. Its main advantage is the minimal radius of the cutting edge and its high resistance to physical and chemical wear mechanisms.
TC100	K01 - K15	■				×		ceramics	- -	Ceramic grade for cast iron machining. Suitable for machining with high cutting speed at stable conditions.
TB310	K01 - K10 S05 - S10 H01 - H10	■ ◪ ◪				×		CBN	- -	CBN grade for machining of hardened materials. Suitable for machining with high cutting speed and small feeds at stable conditions.
PD1	N05 - N25	■				×		PCD	-	PKD grade for turning non-ferrous materials. Ideal choice for working with high cutting speed and small feeds at stable conditions.
333TN	P45 - P50 M35 - M40 K35 - K40	■ ◪ ◪				PVD		HSS	+ + +	Special grade composed of HSS substrate and thin hard PVD coating. The most tough cutting grade in the portfolio. Inserts with this grade are one and only used for slotting of key groove.

Substrat	
H	WC-Co based substrate
submicron H	WC-Co based substrate fine grained (< 1 µm)
ultra submicron H	WC-Co based substrate very fine grained (< 0,5 µm)
FGM	Functionally graded substrate
Cermet	Cemented carbide without WC
ceramics	Cutting ceramics
PCD	Polycrystalline Diamond
CBN	Cubic Boron Nitride
HSS	High speed steel

Coating	
MT-CVD	Medium-temperature chemical method of coating
PVD	Low-temperature physical method of coating
×	Uncoated grade

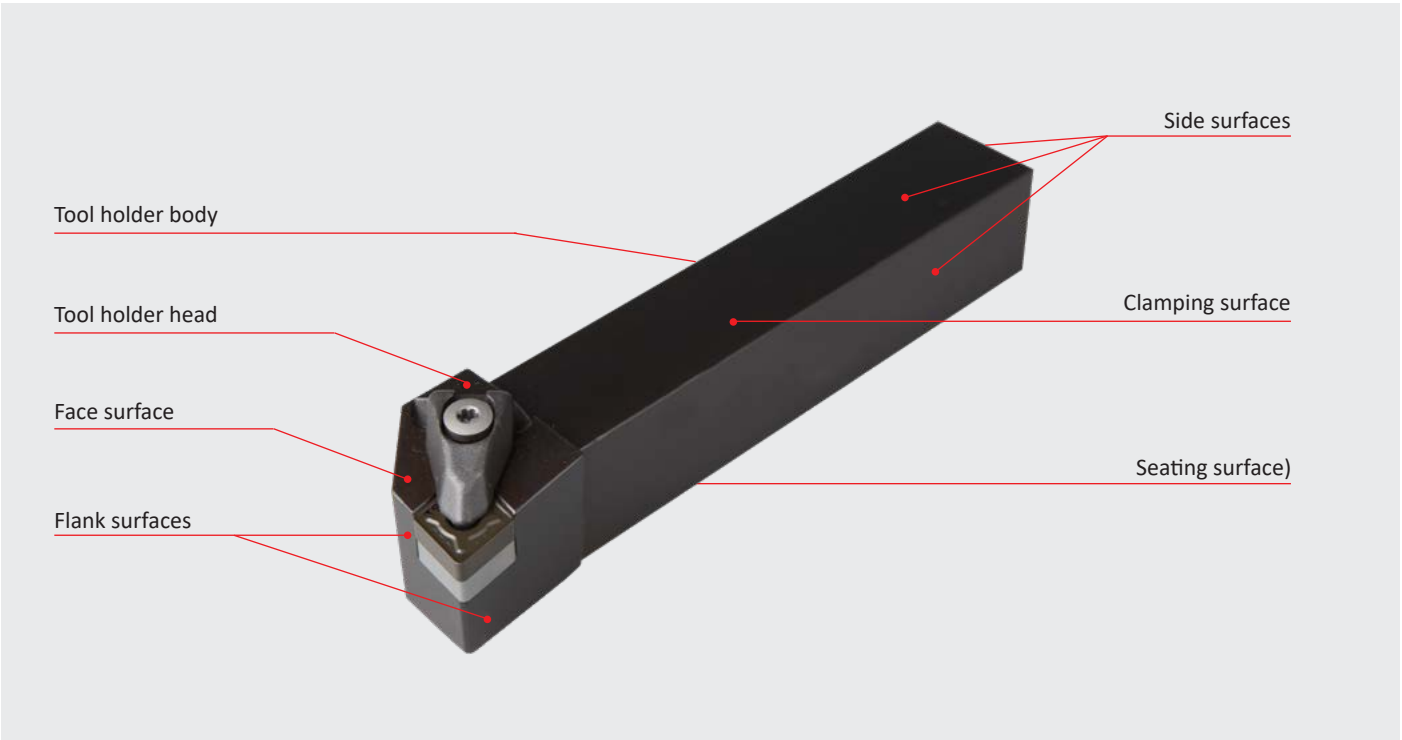
Benefits of cutting fluid	
+ + +	Use of coolant is essential
+ +	Highly recommended
+	Recommended
+ / –	Optional
– -	Do not use coolant
–	Coolant not recommended

Insert parts



Corner radius – determines in most cases the recommended minimum depth of cut and, together with the feed, also determines the achieved roughness.
The **Cutting edge** is the intersection of face and flank surfaces. Its longitudinal roughness is one of the first evaluation criteria when assessing an insert.
The **insert corner angle** is very important with regard to the usable cutting edge length, resistance in the interrupted cut, heat dissipation from the cutting point, etc.
The **peripheral stabilising t-land** is an area located after the cutting edge. Its width is very often variable and its angle also changes regularly. In most cases, the width of the t-land, together with the adjustment angle at which the insert works, is a limiting factor for specifying the minimum feed.
The **chip breaker** – together with the t-land determines the application area (narrow grooves – finishing and materials with short chip, wide grooves – mostly roughing operations and tough materials).
The **clamping hole** – if there is no hole, the insert will definitely be designed for the ISO C clamping system. If the hole is cylindrical, the insert is designed for the ISO P, M, D + clamping systems (in nearly all cases the flank angle is 0°. If the hole is trumpet-shaped and the flank angle is positive, the insert is single-sided and is designed for the ISO S clamping system. If the hole is conical and is the same on both sides of the insert, then it is most likely a tangential insert (double-sided).
The **insert seating** – if it is formed by the same relief as the face surface, the insert is double-sided, if it is different, the insert is single-sided. It must be assessed with regard to the planned load or the type of cut. (the size and distance of the radius and the cutting edges).

Tool holder parts



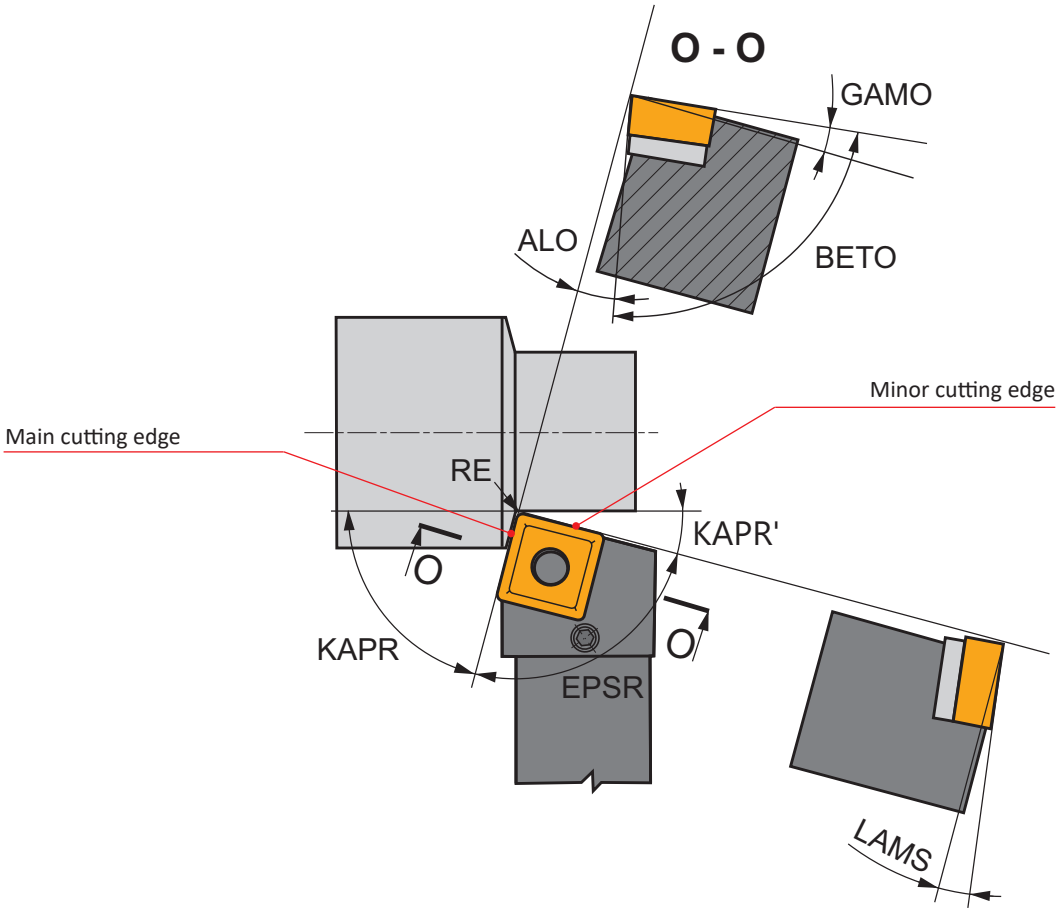
The turning tool consists of two basic parts:
1) the body consisting of:
seating surface
clamping surface
side surfaces (which can further be provided with adjusting screws)
Note: For external turning, the tool holder body is usually a square cross section (square or rectangle). For internal turning, the cross section of the holder body is circular and, for larger cross sections, it is provided with adjusting surfaces. But the holder body can also be formed by a special type of shank, such as CAPTO (PSC) or HSK

2) the head with:
face
flank surfaces
The tool holder head also includes a clamping system into which the inserts are inserted
From the face side (for radial inserts) or from the flank surface side (for tangential inserts)
Note: the types of heads are:
straight – allows turning in both directions
side – distinguish between right and left design
bent – distinguish between right and left design (allows better access when turning more complex surfaces)

Working and construction angles of turning tools

The position and orientation of the cutting edge in relation to the workpiece and its geometric shape determine the cutting angle characteristics.
The angles on the cutting edge are determined by a two coordinate system:
a) design
b) working

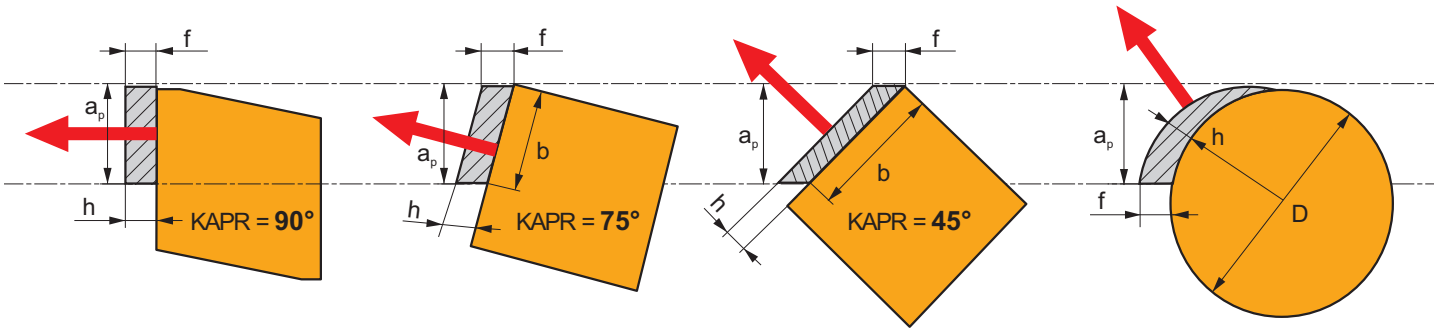
a) tool coordinate system (stationary), which is used to determine the cutting edge geometry during design, production and checking. All angles defined in this system are called tool cutting angles. All angles defined by ISO standards according to the insert shape belong in this group.



b) working coordinate system, used to determine the cutting edge geometry during the machining process. These angles are called working angles and they depend on the position of the insert clamped into the tool holder. For example, the cutting insert SNUN ..... has a tool clearance angle ***AN*** = 0° and a rake angle ***GAMP*** = 0°, however the insert is clamped in the tool holder to give a working clearance angle ***ALO*** = 6° and a working rake angle ***GAMO*** = -6°. The working angles affect the tool angles with pre-formed chip breakers. However the most important are the working angles for the cutting process.

The basic tool angles are indicated in the picture in the basic tool plane (interlaid by the bearing surface of the tool holder) and in the normal tool plane (interlaid across to cutting edge – cut O-O).
We are concerned with the following angles:
The rake angle ***GAMO*** – substantially affects the cutting process. Its size determines the progress and the intensity of plastic deformation during chip forming; it also determines the value of the cutting forces and the thermal stress on the cutting edge. The range of rake angles is wide, from ***GAMO*** = +25° to -15° for cutting tools with indexable cutting inserts for milling and turning. A positive rake angle improves the chip forming conditions, reduces the cutting forces and reduces the cutting temperature level. A negative rake angle improves the strength of the cutting edge, however it increases plastic deformation during chip forming and thereby also the cutting forces and temperatures.

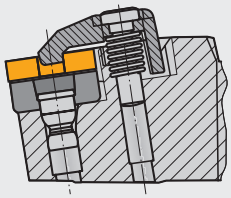
Clearance angle ***ALO*** affects the value of friction between the flank and the machined surface. Increasing the clearance angle ***ALO*** reduces this friction and thereby flank wear as well.
Wedge angle ***BETO*** is the angle of the cutting insert's wedge. Increasing angle ***BETO*** increases the strength of the cutting edge (resistance against shock), however it also increases the cutting resistance.
Inclination angle of main cutting edge ***LAMS*** – determines the point of first contact between the cutting edge and the workpiece, which is important for interrupted cut. If ***LAMS*** is positive, the point of contact is close to the nose of the cutting insert. The negative angle ***LAMS*** moves the point of first contact far from the nose and thereby affects the resistance of the cutting edge against mechanical stress. Furthermore, ***LAMS*** affects the direction of chip evacuation. If ***LAMS*** is negative, the direction of chip evacuation is towards the machined surface. Whereas if ***LAMS*** is positive, the direction of chip evacuation is away from the machined surface.
Setting angle of main cutting edge ***KAPR*** has main influence on the values of cutting forces and the cross section shape of the chip. Reducing angle ***KAPR*** makes the chip thinner at a given feed f and depth of cut a_p. Whereas if ***KAPR*** = 90° the chip thickness $h = f$ and the chip width $b = a_p$ becomes wider. Regarding the decreasing setting angle the function width of the T-land is increasing and the rake angle of insert is decreasing.
Setting angle of minor cutting edge ***KAPR´*** together with corner radius ***RE*** define the final surface quality.



$h = f$ | $h = 0{,}96\ f$ | $h = 0{,}71\ f$ | $h = 0 \div f$

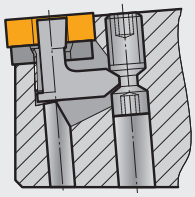
Tool holder choice with regard to the clamping technique

The PRAMET TOOLS offer includes tool holders, adjustable holders, turret heads and adjustable holders for external longitudinal, facing, copy turning, and naturally also for internal turning. Tool holders are classified according to the inserts clamping system into six groups that are schematically illustrated in the following passage.



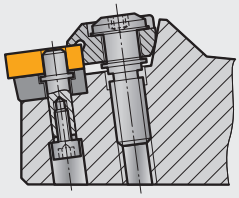
ISO D

This is the most rigid system for clamping of negative inserts with a cylindrical hole. The insert is fixed in the pocket only by a special clamp, which fits into the hole of the insert and it pushes the insert downwards and the same time against the rear faces of the pocket. The disadvantage of this system is again the clamp, which can cause problems with chip evacuation. Holders with this system are therefore particularly suitable for external machining operations characterised by high dynamic stresses on the tool.



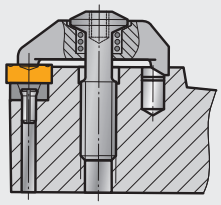
ISO P

This system serves for the clamping of negative inserts with cylindrical hole, both with chip formers and/or without them. The insert clamping is achieved as a result of an angle lever that after tightening the screw presses the insert down to the holder bed. Tool holders with this clamping system of inserts ensure a reliable and exact clamping of an insert. They perform the best and also the most frequent use at external turning operations, namely both finishing and roughing ones. Alternatively this type of clamping can be also used for holders intended for internal turning of holes with larger diameters.



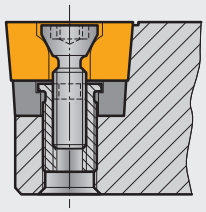
ISO M

This system is used for the clamping of cutting inserts of the same type as that of the system ISO P. In this case an insert is set onto a strong pin to which it is pressed by a clamp that is also fixing at the same time the top of insert. This clamping system is suitable mainly for holders with supposed enhanced dynamic load. These holders are used almost exclusively for the external turning.



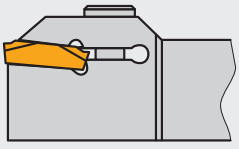
ISO C

This system serves for the clamping of both negative and positive inserts without holes, namely with both chip formers (pre-pressed, ground and side-pressed ones) and without them. The insert is fixed in the bed of a tool holder by a screw-held clamp, under which there is still embedded a side-pressed chip former at some insert types. Holders with this clamping system are used for both the external and internal surface machining. At present the clamping system C loses its importance. Especially at tools for internal turning it is replaced by the system S with benefit.



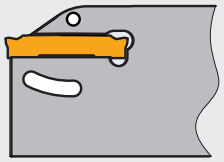
ISO S

This clamping system is mainly used for small cross-section tools, designed for both external and internal turning (drilling). In this case a special screw, going through an insert cone hole, achieves the clamping. By tightening this screw an insert is fixed in the tool bed. This solution is especially convenient because there is no obstacle for chip flow.



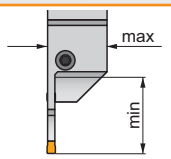
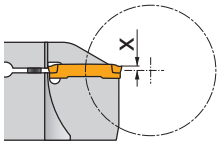
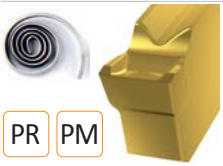
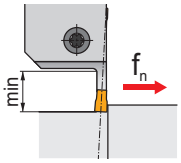
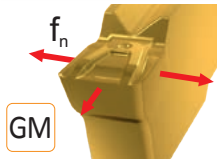
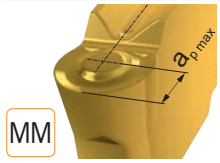
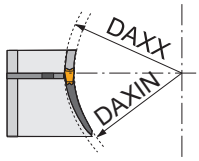
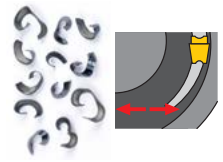
ISO G

This clamping system is used at tools for recess turning and at tools for copy turning (system CTP). The insert is pushed into the holder bed by a clamp from the top. The contact surface in the holder, in the clamp and also in the insert is shaped in such a way that it hinders the insert displacing by a feeding component of cutting speed.



ISO X

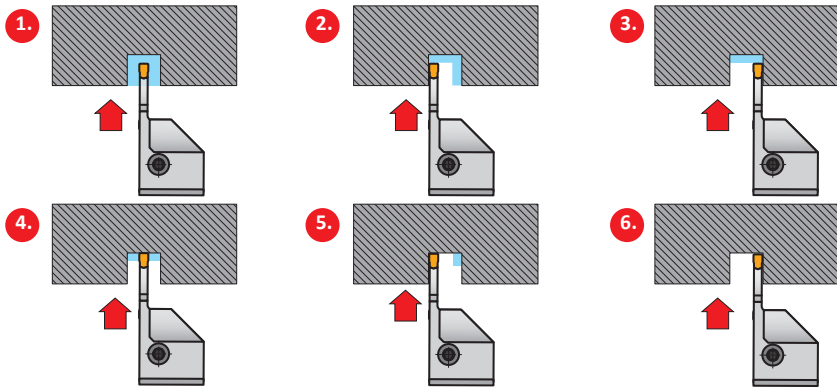
This marking identifies tools with so called special clamping system (i.e. it is different at individual tool manufacturers and suppliers). In our case we have identified under this marking tool holders that use the cutting resistance to clamp an insert into the self-locking bed. This clamping system is used for tools intended for parting and recessing.

Example	Recommendation
	Choose a tool holder with the maximum possible cross-section and the minimum possible tool overhang and CDX (maximum cutting depth) to reduce vibrations.
	Applying coolant directly to the cutting edge in sufficient quantities reduces the temperature of the cutting edge and seat, resulting in prolonged tool life.
	When parting off or deep grooving, it is advisable to set the cutting edge slightly higher than the workpiece axis to reduce vibrations.
	For parting off or deep grooving operations, use PM or PR chip breakers, which both form the desired spiral-shaped chips.
	When longitudinal turning, it is advisable to use tools with the minimum possible CDX (maximum cutting depth) to reduce vibrations and deflection of the tool.
	For longitudinal turning operations, use the GM chip breaker, which has the proper geometry on the front and both sides of the cutting edge.
	When copy turning with the MM chip breaker, the maximum depth of cut is 50% of the diameter of the geometry.
	For internal grooving operations, use only the GM and MM chip breakers, which both form the desired short chips.
	When face grooving, it is necessary to select a tool holder with the correct range of diameters.
	For deep face grooving operations, use only the GM chip breaker, which forms the desired long helical chips that don't get stuck in the face groove.
	For face turning and profiling operations, use only the GM and MM chip breakers, which both form the desired short chips.

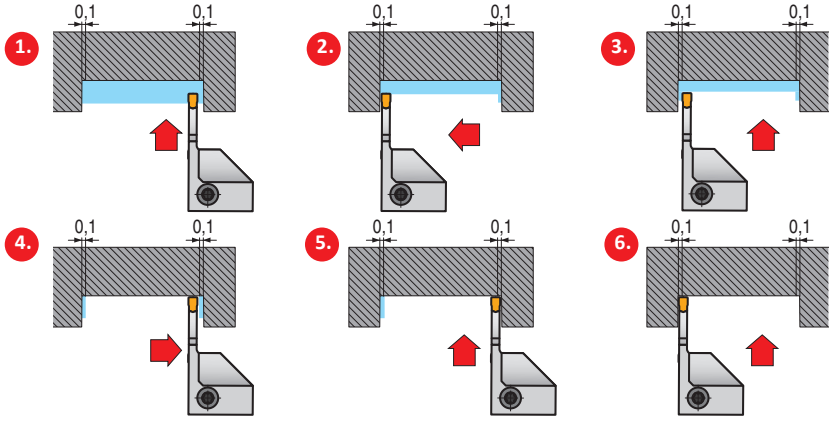
Recommendation for practical usage:

The procedure for turning a recess (deepening and widening) is shown in the following illustration.

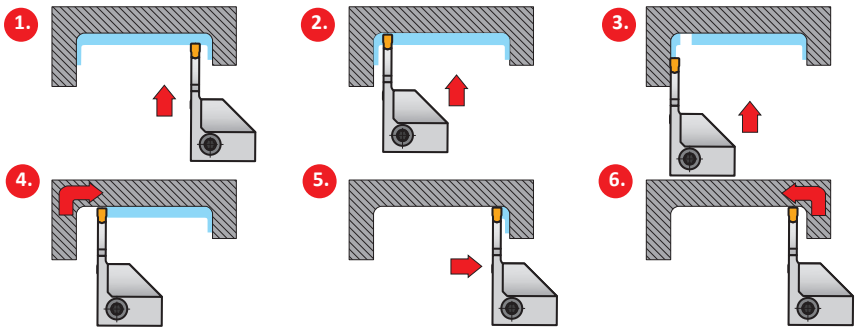
Note: To create a flat seating surface, use insert type **GL** with chip breaker **GM** or LCMF with chipbreaker F. The outboard radial grooving passes should overlap the central pass by two times the insert corner radius.



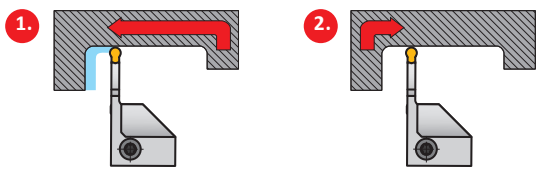
When machining a wide recess, follow the procedure shown in the following illustration.



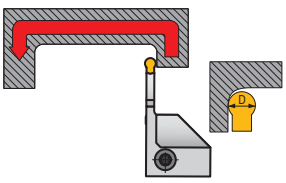
When opening up or deepening a contour using side turning, use the procedure shown in the following illustration.



Roughing of contour (insert with round cutting edge).

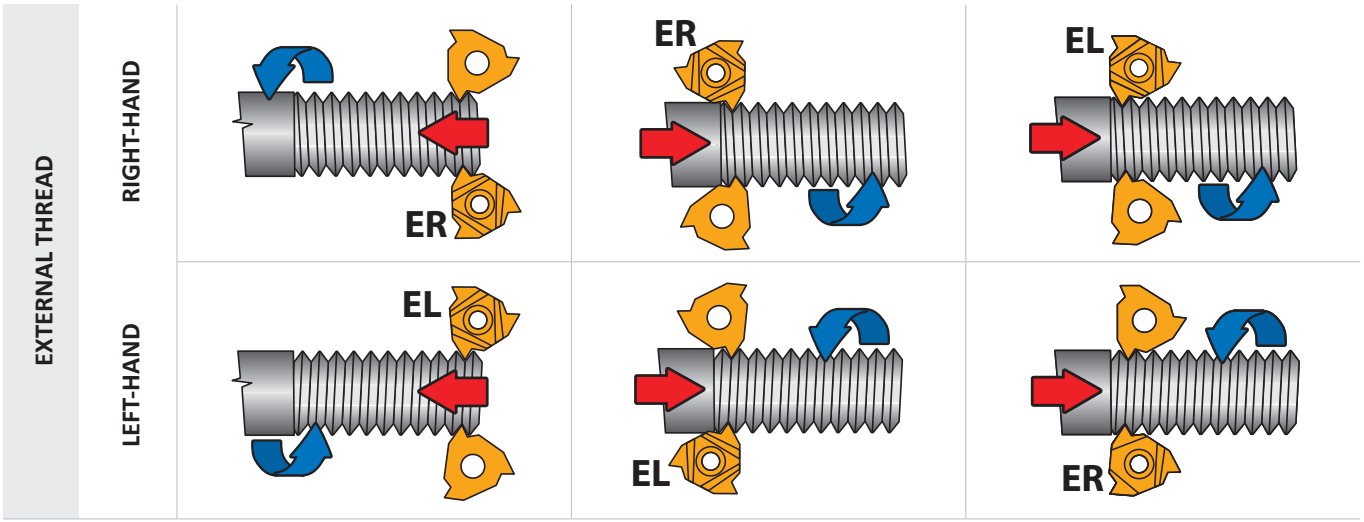


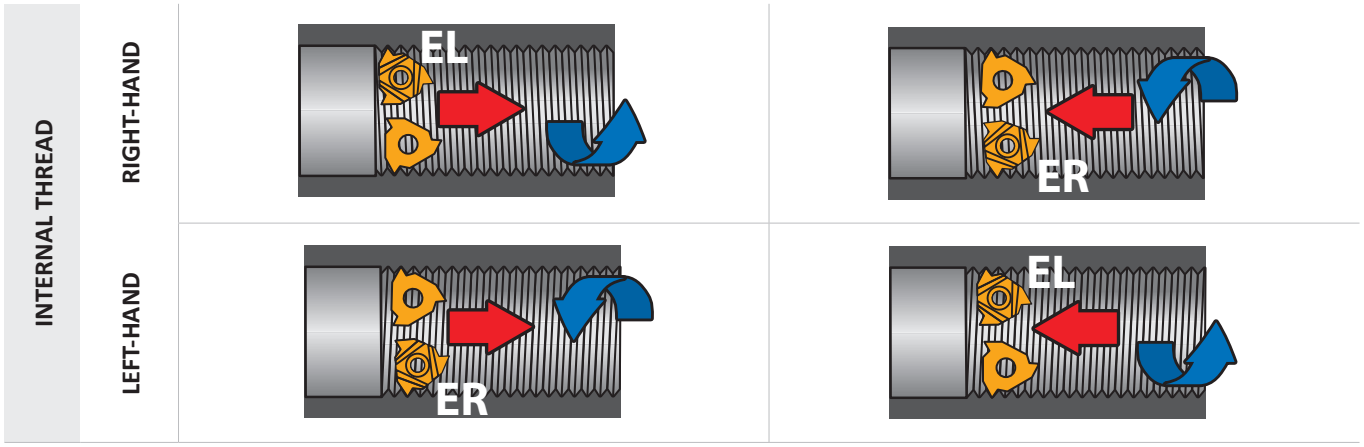
Finishing of contour (insert with round cutting edge).



THREADING

The choice of production method is influenced by the workpiece and the machine. Workpiece – external or internal thread, right – or left-hand thread. Machine – right – or left-hand tool. For guidance, you can use table below.



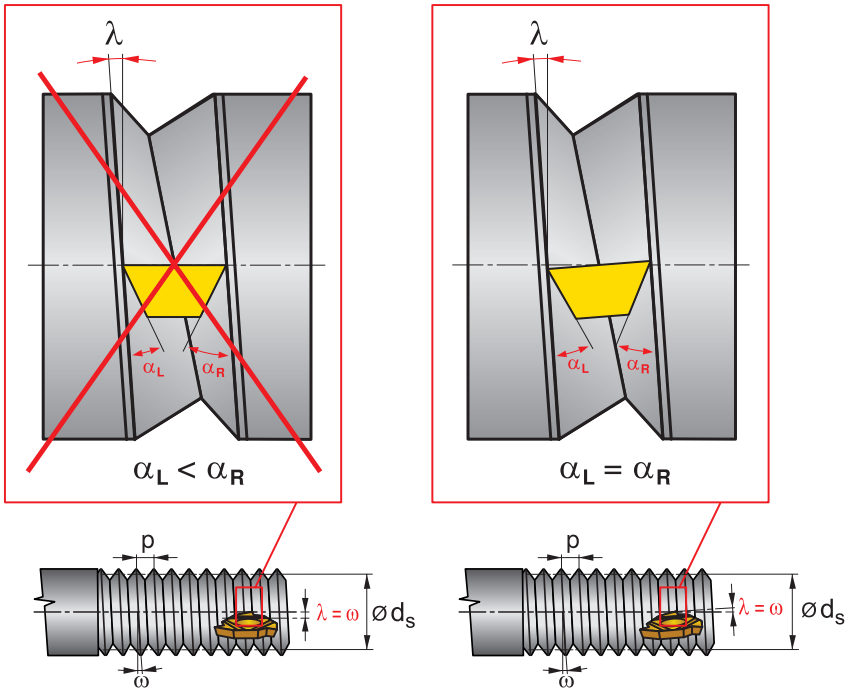


Movement of the workpiece

Tool movement

L / R Insert design

The following formula can be used to calculate the helix angle:



$$tg\ \omega = \frac{p}{d_s \cdot \pi}$$

ω helix angle [°]

p pitch [mm]

d_s pitch diameter [mm]

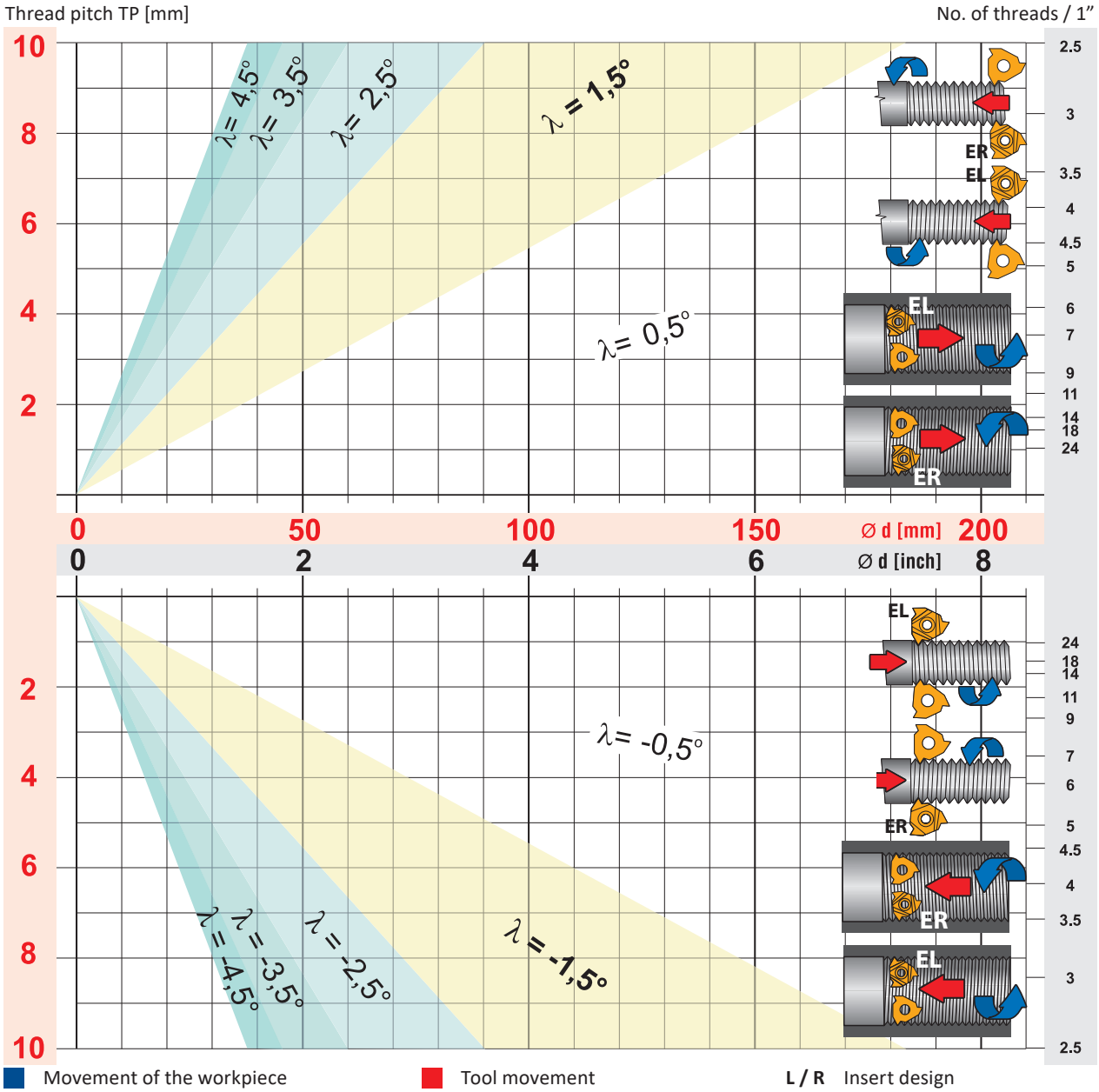
To generate the correct shape on the thread and uniform wear on the insert, the cutting edge helix angle should be equal to the thread lead angle.
Tool holders are usually supplied with a helix angle λ = 1.5°. A different helix angle can be selected by changing the anvil.
Use the following graph or table to choose the correct anvil.

Choice of shim

Helix angle λ	Positive					Negative	
	4.5°	3.5°	2.5°	1.5°	0.5°	-0.5°	-1.5°
Tool holder	**Anvil specification**						
SER .... .16; SIL .... .16	PE16+4.5	PE16+3.5	PE16+2.5	**PE16+1.5**	PE16+0.5	PE16-0.5	PE16-1.5
SEL .... .16; SIR .... .16	PI16+4.5	PI16+3.5	PI16+2.5	**PI16+1.5**	PI16+0.5	PI16-0.5	PI16-1.5
SER .... .22; SIL .... .22	PE22+4.5	PE22+3.5	PE22+2.5	**PE22+1.5**	PE22+0.5	PE22-0.5	PE22-1.5
SEL .... .22; SIR .... .22	PI22+4.5	PI22+3.5	PI22+2.5	**PI22+1.5**	PI22+0.5	PI22-0.5	PI22-1.5
SER-S .... .22; SIL-S .... .22	PE22S+4.5	PE22S+3.5	PE22S+2.5	**PE22S+1.5**	PE22S+0.5	PE22S-0.5	PE22S-1.5
SEL-S .... .22; SIR-S .... .22	PI22S+4.5	PI22S+3.5	PI22S+2.5	**PI22S+1.5**	PI22S+0.5	PI22S-0.5	PI22S-1.5

Tool holders are usually supplied with a helix angle λ = 1.5°. A different helix angle can be selected by changing the anvil.
Shims for holders SER-S ...., SIR-S .... are marked with „S“

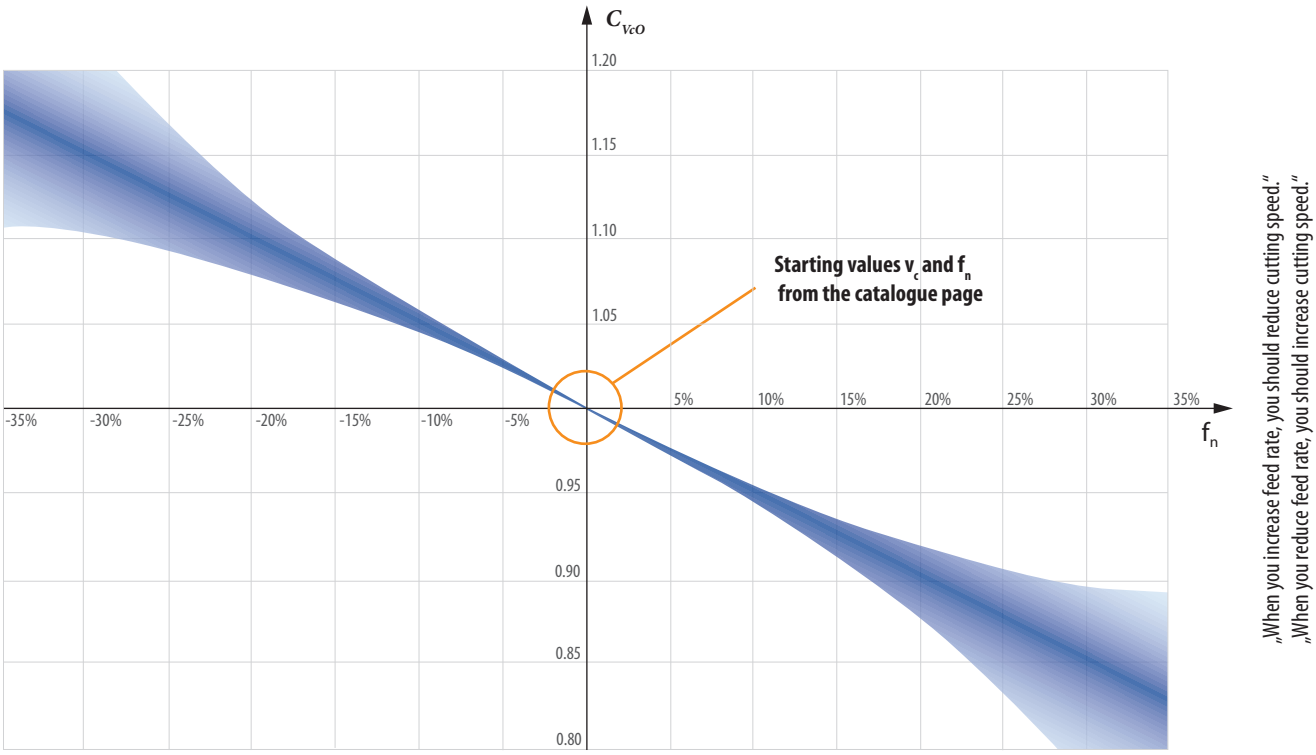
Graph for shim selection



Movement of the workpiece Tool movement **L / R** Insert design

CORRECTION FACTORS

Cutting speed correction factor C_{VcO} as a function of the feed rate change:



Correction factors for required durability C_{VcT}

minutes	10	15	20	30	45	60
General machining operations (fine finishing up to roughing)	1.13	1.00	0.93	0.84	0.76	0.71
Heavy machining operations (heavy roughing)	–	–	–	1.10	1.00	0.93

Additional correction factors C_{VcA}

Machining environment	C_{VcA}	C_{VcB}
Condition of the work-material (hard skin due to forging or casting)	0.70	
Internal turning	0.75	
Parting and grooving (radial)	0.88	
Face grooving	0.80	
Interrupted cut		0.80
Unstable machining conditions		0.85
Common machining conditions		1.00
Stable machining conditions		1.20

Resulting corrected cutting speed v_{cC}

$$v_{cC} = v_c \cdot k_{vG} \cdot C_{VcO} \cdot C_{VcT} \cdot C_{VcA} \cdot C_{VcB}$$

k_{vG} – coefficient of used material
v_c – starting speed from catalogue page

FORMULA FOR CALCULATING CUTTING DATA

Value	Formula	Unit	Note
Number of revolutions	$n = \frac{v_c \cdot 1000}{D \cdot \pi}$	(1/min)	n Number of revolutions (1/min) D Diameter (of tool or workpiece) (mm) v_c Cutting speed (m/min) f_{rev} Feed per revolution (mm/rev) f_{min} Feed per minute (Linear Feedrate) (mm/min)
Cutting speed	$v_c = \frac{\pi \cdot D \cdot n}{1000}$	(m/min)	
Feed per revolution	$f_{rev} = \frac{f_{min}}{n}$	(mm/rev)	
Feed per minute (Linear Feedrate)	$f_{min} = v_f = f_{rev} \cdot n$	(mm/min)	
Max. height of profile R_{max}	$R_{max} = \frac{125 \cdot f_{rev}^{\ 2}}{RE}$	(µm)	R_{max} max. height of profile (mm) R_a surface finish (mm) f_{rev} feed per revolution (mm/rev) RE nose radius (mm)
Surface finish R_a	$R_a = \frac{43{,}9 \cdot f_{rev}^{\ 1{,}88}}{RE^{\ 0{,}97}}$	(µm)	
Chip cross section	$A = f_{rev} \cdot a_p$	(mm^2)	A Chip cross section (mm^2) f_{rev} Feed per revolution (mm/rev) a_p Axial depth of cut (mm) κ_r Primary edge setting angle (°) h Chip thickness (mm) v_c Cutting speed (m/min) f_{min} Feed per minute (Linear Feedrate) (mm/min) Q Material removal rate per minute (cm^3/min) $INSD$ Insert diameter (mm)
Chip thickness (For insert with straight edge)	$h = f_{rev} \cdot \sin \kappa_r$	(mm)	
Chip thickness (For round cutting insert)	$h = f_{rev} \cdot \sqrt{\frac{a_p}{INSD}}$	(mm)	
Metal removal rate	$Q = a_p \cdot f_{rev} \cdot v_c$	(cm^3/min)	
Power demand	$P_c = \frac{a_p \cdot f_{rev}^{\ 1-c} \cdot k_{c1} \cdot v_c \cdot k\kappa_r}{6 \cdot 10^4 \cdot \eta}$	(kW)	P_c Power demand (kW) a_p Depth of cut (mm) f_{rev} Feed (mm/rev) c Constant KTV (1) k_c Specific cutting force (MPa) $k_{\kappa r}$ κ_r angle constant (1) η Efficiency (usually $\eta = 0{,}75$) (1) x Machined material constant (1)
Approximate power demand	$P_c = \frac{a_p \cdot f_{rev} \cdot v_c}{x}$	(kW)	

Material	Steel	Cast iron	Al
Coefficient x	20	25	100

RECOMMENDED SCREW TORQUES

CLAMPING SCREW

Screw designation	Screwdriver	Torque (Nm)
28588	MA2-8304	0.8
28992	MA2-8304	0.8
416.1-832	PT-8002	3.6
5513 020-01	PT-8004	3.6
5513 020-03	PT-8001	0.8
5513 020-04	PT-8003	1.5
5513 020-05	PT-8001	0.8
5513 020-14	TX 225PLUS	8.5
5513 020-24	PT-8002	1.5
5513 020-27	PT-8000	0.6
5513 020-28	PT-8000	0.6
5513 021-03	DMN 3124	13
CS 8601-T09P	SDR T09P	1.7
CS 8601-T15P	SDR T15P	3.9
CS 8601-T20P	SDR T20P	6.4
CS 8601-T25P	SDR T25P	9.5
DVF 0573	PT-8002	1.5
DVF 2260	TX 215PLUS	3.6
DVF 3584	DMD 1650	0.6
DVF 3593	TX 207PLUS	0.8
HS 0408	HXK 3	5
HS 0412	HXK 3	5
HS 0516	HXK 4	5
HS 0520C	HXK 4	5
HS 0616C	HXK 5	8
HS 0620	HXK 5	6
HS 0620C	HXK 5	6
HS 0625	HXK 5	6
HS 0625C	HXK 5	6
HS 0630	HXK 5	6
HS 0825	HXK 6	10
HS 0830	HXK 6	10
HS 0835	HXK 6	10
HS 0840	HXK 8	11
HS 1030	HXK 8	8
HS 1060	HXK 6	10
HS 93	HXK 5	8
HS 94	HXK 5	8
HSI 1020	HXK 6	8
PS 0512	HXK 2	2
PS 0512-A	HXK 2	2
PS 0616	HXK 2,5	4
PS 12040	HXK 5	8

CLAMPING SCREW

Screw designation	Screwdriver	Torque (Nm)
PS 6026-709P	SRD T09P	2
PS 8290	HXK 2	2
SR 14	HXK 10	10
SR 85011-T15P	SDR T15P	5
SR 85017-T09P	SDR T09P	2
SR 85020-T15P	SDR T15P	3
SR 86025-T20P	SRD T20P	5
SR 88026-T30P	LKT30P	5
T20.037	DMD 1650	0.6
UP 0909-T09P	SRD T09P	2
UP 1515-T15P	SDR T15P	8
US 2505-T07P	SDR T07P	0.9
US 2506-T07P	SDR T07P	0.9
US 3007-T09P	SDR T09P	2
US 34	HXK 3	5
US 35	HXK 4	6
US 3508-T15P	SDR T15P	3
US 3510A-T15P	SDR T15P	3
US 3510-T15P	SDR T15P	3
US 3512A-T15P	SDR T15P	3
US 3512-T15P	SDR T15P	3
US 36	HXK 4	6
US 38	HXK 5	8
US 39	HXK 5	8
US 40	HXK 4	6
US 4008-T15P	SDR T15P	3.5
US 4011-T15P	SDR T15P	3.5
US 41	HXK 4	6
US 42	HXK 4	6
US 45013-T20P	SDR T20P	5
US 4512-T15P	SDR T15P	5
US 4514A-T20	SDR T20	5
US 46	HXK 3	5
US 46017-T20P	SDR T20P	5
US 47	HXK 5	8
US 5012-T15P	SDR T15P	5
US 5015-T20P	SDR T20P	5
US 5018-T20P	SDR T20P	5
US 6020-T25P	SDR T25P	6
US 64518-T15P	SDR T15P	5
US 8025-T30P	SDR T20P	13
US 83	HXK 4	6
US 95	HXK 4	10

TORQUE SCREWDRIVERS

Torque handle	Torque (Nm)	Clamping screw thread
MR-0.8-2.0 vario	0.5 – 2.0	M 2 – M 3
MR-1.0-5.0 vario	0.8 – 5.0	M 2.5 – M 5
MR-0.9 fix	0.9	M 2
MR-2.0 fix	2.0	M 3
MR-3.0 fix	3.0	M 3.5
MR-3.5 fix	3.5	M 4
MR-5.0 fix	5.0	M 5

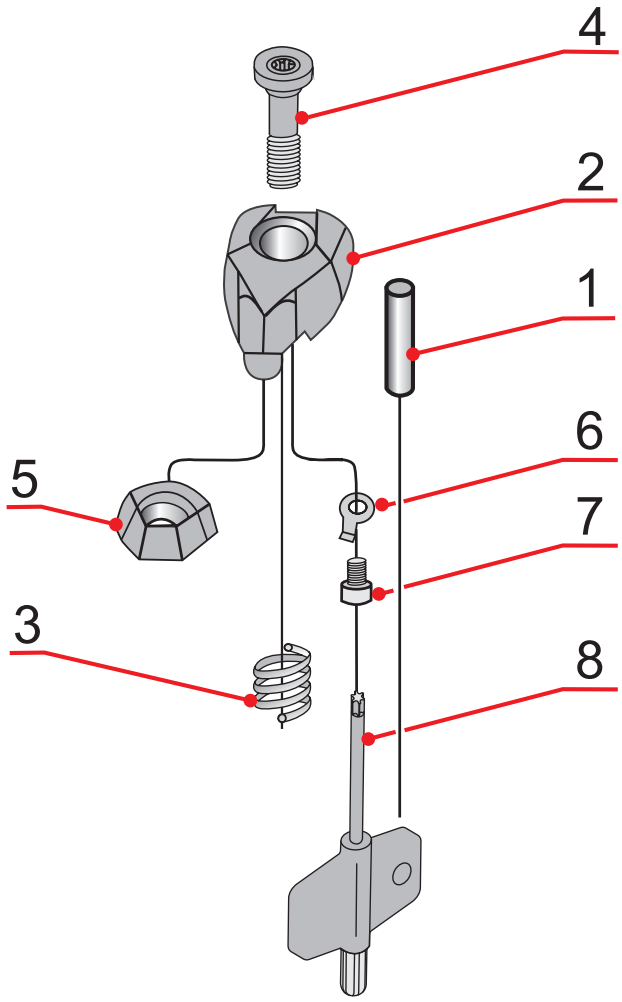
REPLACEABLE SHANKS

Replaceable shanks		
D-T6	**D-T8**	**D-T15**
D-T6P	**D-T8P**	**D-T15P**
D-T7	**D-T9**	**D-T20**
D-T7P	**D-T9P**	**D-T20P**

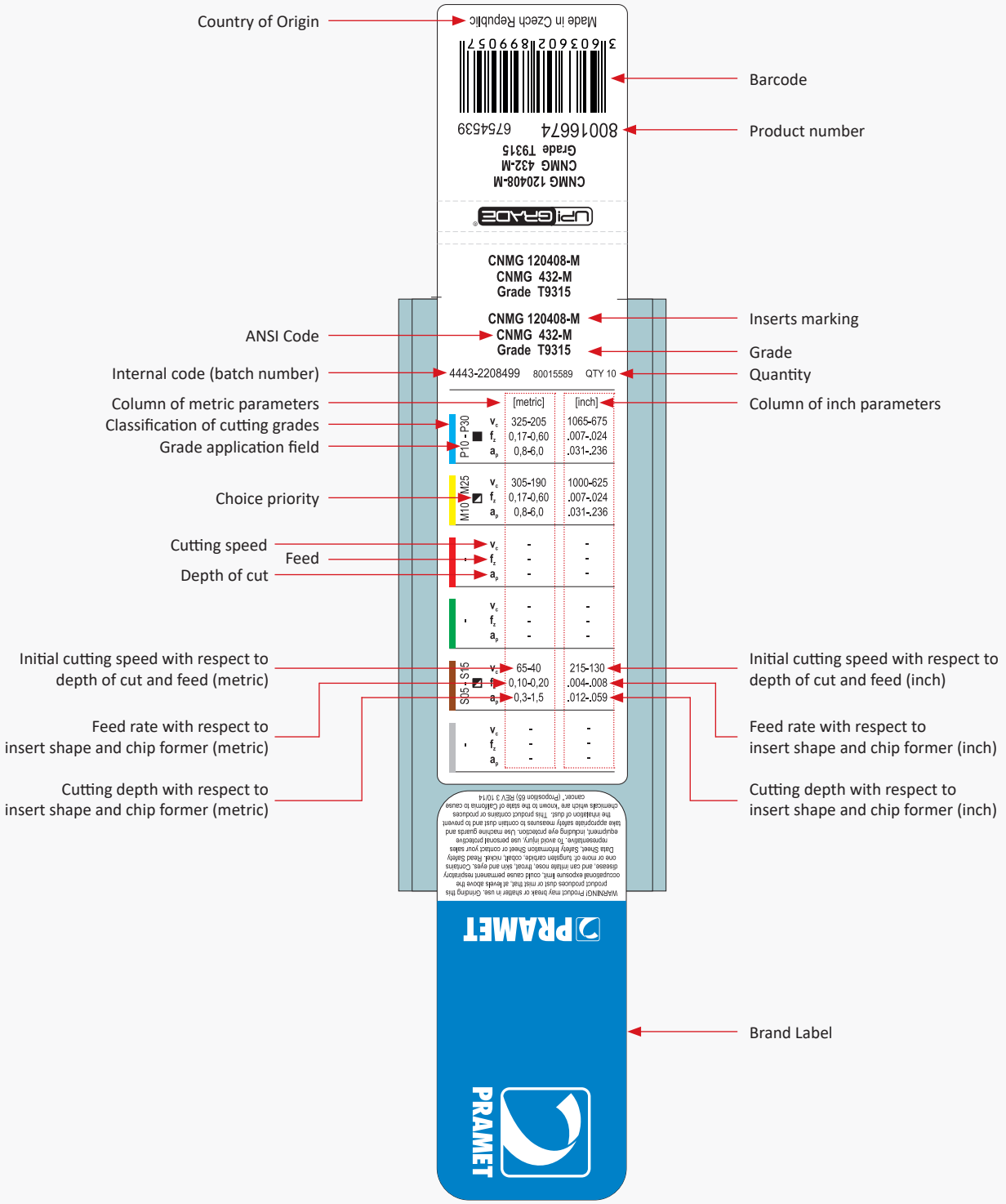
SCREW LUBRICATION

Insert clamping screws are subject to high thermal stresses. It is recommended that all screws be lubricated with a high quality paste such as MOLYKOTE 1000.

COMPLETE CLAMP SET



	1	2	3	4		5	6	7	8
					Nm				
DCS 09	CP 2655	CD 09	PR 0157	CS 8601-T09P	1.7	–	–	–	–
DCS 12	CP 2607	CD 12	PR 0158	CS 8602-T15P	3.9	–	–	–	–
DCS 16	CP 2607	CD 16	PR 0159	CS 8603-T20P	6.4	–	–	–	–
DCS 19	CP 2607	CD 19	PR 0159	CS 8603-T20P	6.4	–	–	–	–
DCS 25	CP 2607	CD 25	PR 0101	CS 8604-T25P	9.5	–	–	–	–
DCS 16V	CP 2607	CD 16V	PR 0158	CS 8602-T15P	3.9	–	–	–	–
DCS 12C2	CP 2607	CD 12C2	PR 0158	CS 8602-T15P	3.9	PP 3002	H 1201	CS 9701-T07P	FLAG T07P
DCS 16C2	CP 2607	CD 16C2	PR 0159	CS 8603-T20P	6.4	PP 3003	H 1201	CS 9701-T07P	FLAG T07P
DCS 12C4	CP 2607	CD 12C4	PR 0158	CS 8602-T15P	3.9	PP 3002	H 1201	CS 9701-T07P	FLAG T07P
DCS 16C4	CP 2607	CD 16C4	PR 0159	CS 8603-T20P	6.4	PP 3003	H 1201	CS 9701-T07P	FLAG T07P


Country of Origin
Made in Czech Republic
Barcode
Product number
8001667 4 6754539
Grade T9315
CNMG 432-M
CNMG 120408-M
CNMG 120408-M
CNMG 432-M
Grade T9315
ANSI Code
Internal code (batch number)
Column of metric parameters
Classification of cutting grades
Grade application field
Choice priority
Cutting speed
Feed
Depth of cut
Initial cutting speed with respect to depth of cut and feed (metric)
Feed rate with respect to insert shape and chip former (metric)
Cutting depth with respect to insert shape and chip former (metric)
Inserts marking
Grade
Quantity
Column of inch parameters
Initial cutting speed with respect to depth of cut and feed (inch)
Feed rate with respect to insert shape and chip former (inch)
Cutting depth with respect to insert shape and chip former (inch)
Brand Label
4443-2208499 80015589 QTY 10
[metric] [inch]
P10 - P30
M10 - M25
S05 - S45
325-205 1065-675
0,17-0,60 .007-.024
0,8-6,0 .031-.236
305-190 1000-625
0,17-0,60 .007-.024
0,8-6,0 .031-.236
65-40 215-130
0,10-0,20 .004-.008
0,3-1,5 .012-.059
PRAMET

WMG (WORK MATERIAL GROUP)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Correction factor *kvG*
P	P1	P1.1	Free machining steel (carbon steels with increased machinability)	Sulfurized	< 240 HB	≤ 830	1.33
		P1.2		Sulfurized and phosphorized	< 180 HB	≤ 620	1.49
		P1.3		Sulfurized/phosphorized and leaded	< 180 HB	≤ 620	1.53
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620	1.14
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830	1.00
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030	0.89
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620	0.92
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900	0.74
		P3.3			260 – 360 HB	> 900 ≤ 1240	0.63
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900	0.55
		P4.2		Hardened and tempered	26 – 39 HRC	> 900 ≤ 1240	0.47
		P4.3			39 – 45 HRC	> 1240 ≤ 1450	0.38
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)		< 160 HB	≤ 520	1.22
		M1.2			160 – 220 HB	> 520 ≤ 700	1.03
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670	1.08
		M2.2		Quenched and tempered	200 – 280 HB	> 670 ≤ 950	0.89
		M2.3		Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300	0.75
	M3	M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)		< 200 HB	≤ 750	1.00
		M3.2			200 – 260 HB	> 750 ≤ 870	0.86
		M3.3			260 – 300 HB	> 870 ≤ 1040	0.77
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel		< 300 HB	≤ 990	0.75
		M4.2	Precipitation hardening austenitic stainless steel		300 – 380 HB	≤ 1320	0.64
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190	1.35
		K1.2		Ferritic-pearlictic or pearlitic	180 – 240 HB	> 190 ≤ 310	1.00
		K1.3		Pearlitic	240 – 280 HB	> 310 ≤ 390	0.75
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400	1.39
		K2.2		Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550	1.13
		K2.3		Pearlitic	200 – 240 HB	> 550 ≤ 660	0.90
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560	1.23
		K3.2		Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680	0.94
		K3.3		Pearlitic	220 – 260 HB	> 680 ≤ 800	0.76
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)		< 180 HB	≤ 190	1.14
		K4.2	Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure)		< 240 HB	≤ 740	0.86
		K4.3	Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)		< 280 HB	> 840 ≤ 980	0.63
		K4.4			280 – 320 HB	> 980 ≤ 1130	0.54
		K4.5			320 – 360 HB	> 1130 ≤ 1280	0.45
	K5	K5.1	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400	1.29
		K5.2		Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450	0.97
		K5.3		Pearlitic	220 – 260 HB	> 450 ≤ 500	0.75
N	N1	N1.1	Commercially pure wrought aluminium		< 60 HB	≤ 240	1.33
		N1.2	Wrought aluminium alloys	Half hard tempered	60 – 100 HB	> 240 ≤ 400	1.00
		N1.3		Full hard tempered	100 – 150 HB	> 400 ≤ 590	0.67
	N2	N2.1	Cast aluminium alloys		< 75 HB	≤ 240	0.67
		N2.2			75 – 90 HB	> 240 ≤ 270	0.60
		N2.3			90 – 140 HB	> 270 ≤ 440	0.43
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties		–	–	0.70
		N3.2	Short-chip copper-alloys with good to moderate machining properties		–	–	0.41
		N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties		–	–	0.21
	N4	N4.1	Thermoplastic polymers		–	–	0.70
		N4.2	Thermosetting polymers		–	–	0.27
		N4.3	Reinforced polymers or composites		–	–	0.29
	N5	N5.1	Graphite		–	–	1.00
S	S1	S1.1	Titanium or titanium alloys		< 200 HB	≤ 660	1.94
		S1.2			200 – 280 HB	> 660 ≤ 950	1.72
		S1.3			280 – 360 HB	> 950 ≤ 1200	1.44
	S2	S2.1	Fe-based high-temperature alloys		< 200 HB	≤ 690	1.33
		S2.2			200 – 280 HB	> 690 ≤ 970	1.17
	S3	S3.1	Ni-based high-temperature alloys		< 280 HB	≤ 940	1.00
		S3.2			280 – 360 HB	> 940 ≤ 1200	0.83
	S4	S4.1	Co-based high-temperature alloys		< 240 HB	≤ 800	0.78
		S4.2			240 – 320 HB	> 800 ≤ 1070	0.67
H	H1	H1.1	Chilled cast iron		< 440 HB	–	1.52
	H2	H2.1	Hardened cast iron		< 55 HRC	–	0.90
		H2.2			> 55 HRC	–	0.77
	H3	H3.1	Hardened steel < 55 HRC		< 51 HRC	–	1.00
		H3.2			51 – 55 HRC	–	0.82
	H4	H4.1	Hardened steel > 55 HRC		55 – 59 HRC	–	0.64
		H4.2			> 59 HRC	–	0.54

HARDNESS CONVERSION TABLE

Strength (MPa)	Hardness			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
285	86	**90**	1190	–
320	95	**100**	56.2	–
350	105	**110**	62.3	–
385	114	**120**	66.7	–
415	124	**130**	71.2	–
450	133	**140**	75.0	–
480	143	**150**	78.7	–
510	152	**160**	81.7	–
545	162	**170**	85.8	–
575	171	**180**	87.1	–
610	181	**190**	89.5	–
640	190	**200**	91.5	–
675	199	**210**	93.5	–
705	209	**220**	95	–
740	219	**230**	96.7	–
770	228	**240**	98.1	–
800	238	**250**	99.5	–
820	242	**255**	–	23.1
850	252	**265**	–	24.8
880	261	**275**	–	26.4
900	266	**280**	–	27.1
930	276	**290**	–	28.5
950	280	**295**	–	29.2
995	295	**310**	–	31.0
1030	304	**320**	–	32.2
1060	314	**330**	–	33.3
1095	323	**340**	–	34.4
1125	333	**350**	–	35.5
1155	342	**360**	–	36.6

Strength (MPa)	Hardness			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
1190	352	**370**	–	37.7
1220	361	**380**	–	38.8
1255	371	**390**	–	39.8
1290	380	**400**	–	40.8
1320	390	**410**	–	41.8
1350	399	**420**	–	42.7
1385	409	**430**	–	43.6
1420	418	**440**	–	44.5
1455	428	**450**	–	45.3
1485	437	**460**	–	46.1
1520	447	**470**	–	46.9
1555	456	**480**	–	47.7
1595	466	**490**	–	48.4
1630	475	**500**	–	49.1
1665	485	**510**	–	49.8
1700	494	**520**	–	50.5
1740	504	**530**	–	51.1
1775	513	**540**	–	51.7
1810	523	**550**	–	52.3
1845	532	**560**	–	53.0
1880	542	**570**	–	53.6
1920	551	**580**	–	54.1
1955	561	**590**	–	54.7
1995	570	**600**	–	55.2
2030	580	**610**	–	55.7
2070	589	**620**	–	56.3
2105	599	**630**	–	56.8
2145	608	**640**	–	57.3
2180	618	**650**	–	57.8

SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

DORMER PRAMET

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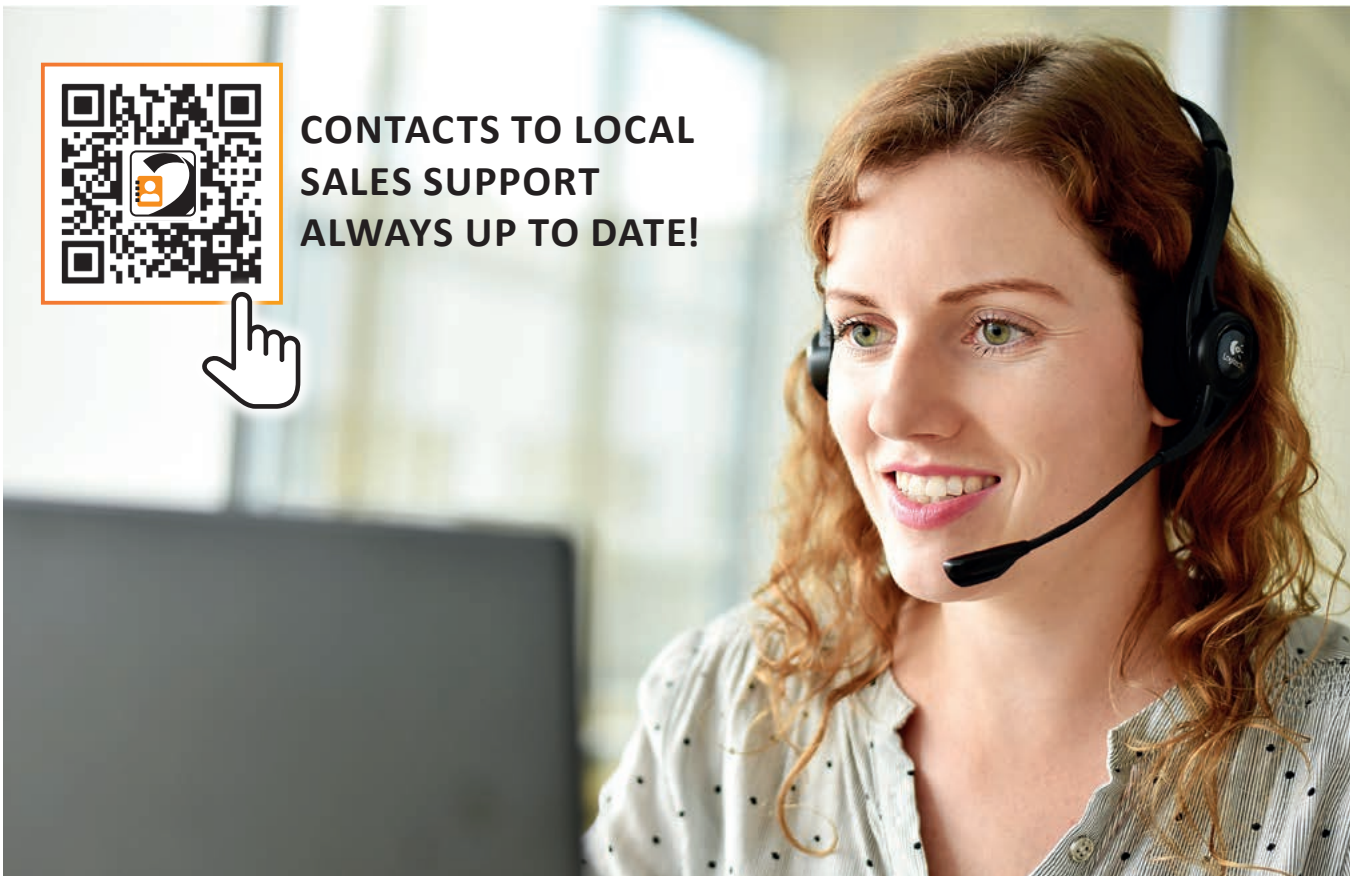

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