INDEXABLE CHAMFER & T-SLOTS MILLS

CHAMFER, T-SLOT MILLING

>>>

	SSD09	N-SSO09	2516	2636	J(T)-SXP16
	45°	45°	45°	10°– 80°	15°– 75°
	APMX [mm] 4.5	APMX [mm] 4.5	APMX [mm] 8.5	APMX [mm] 8.5	APMX [mm] 7.0– 28.0
	DC [mm] 10 – 25	DC [mm] 8 – 25	DC [mm] 11 – 19	DC [mm] 5 – 23	DC [mm] 35 – 45
Cylindrical shank	 DC = 16 – 25 [mm]				
Weldon	 DC = 10 – 25 [mm]				
Morse	 DC = 10 – 25 [mm]				
Shell mill					
Page	648	651	654	657	660
ISO	P M K S H	P M K S	P M K S	P M K S	P M K N
Insert shape					
Inserts	SDE. 0903	SOMT 09T3	TCMT 16T3	TCMT 16T3	XPHT 1604
No. of cutting edges	4	4	3	3	2
Chamfer milling	■	■	■	■	■
Rear face milling					
T-slot milling					
Shallow shoulder milling					
Shallow slot milling					

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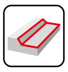
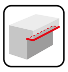
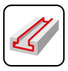
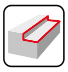
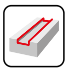
CHAMFER, T-SLOT MILLING

	F-SCC					
	90°					
	APMX [mm] 11.0 – 18.0					
	DC [mm] 25 – 40					
						
	664					
	P M K					
						
	CCMX					
	2					
						
	■					
	■					
	◩					
	◩					

SSD09

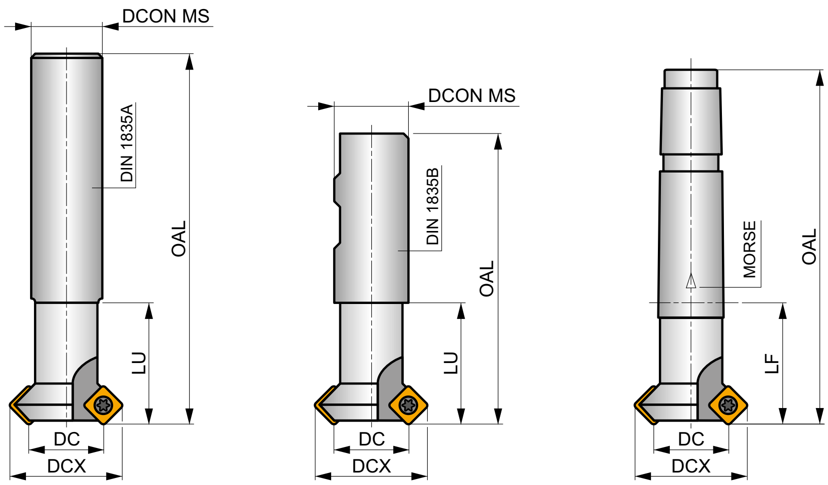
P M K S H

PRAMET

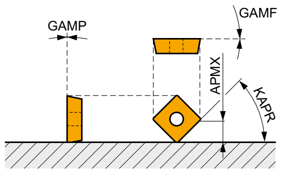
S

45° Chamfer Milling Cutter for Square Insert SD.. 09

A 45° chamfer milling cutter utilising single-sided SD.. 09 inserts with APMX of 4.5 mm. Suitable for top and bottom side chamfering. Available in cylindrical, Weldon and Morse taper style and outside Ø22, Ø28 and Ø37 mm . Body treated for longer tool life.



KAPR	45°
APMX	4.5 mm



h_m 0.095 - 0.15

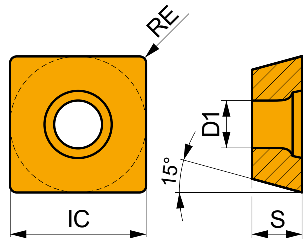
	Product	DC [mm]	DCX [mm]	OAL [mm]	DCON MS [mm]	LU [mm]	LF [mm]	CZC MS	GAMF [°]	GAMP [°]			max.		kg		
DIN 1835A	16N2R027A16-SSD09	16	28	200	16	27	–	–	0	0	2	–	32200	–	0.37	GI129	CO070
	25N3R042A25-SSD09	25	37	200	25	42	–	–	0	0	3	–	25800	–	0.78	GI129	CH011
DIN 1835B	10N1R027B16-SSD09-A	10	22	75	16	27	–	–	0	0	1	–	40700	–	0.14	GI129	CO070
	16N2R027B16-SSD09-A	16	28	75	16	27	–	–	0	0	2	–	32200	–	0.14	GI129	CO070
	25N3R042B25-SSD09-A	25	37	98	25	42	–	–	0	0	3	–	25800	–	0.37	GI129	CH011
DIN 228A	10N1R030E02-SSD09-A	10	22	94	–	–	30	2	0	0	1	–	40700	–	0.17	GI129	CO070
	16N2R030E02-SSD09-A	16	28	94	–	–	30	2	0	0	2	–	32200	–	0.25	GI129	CO070
	25N3R043E03-SSD09-A	25	37	124	–	–	43	3	0	0	3	–	25800	–	0.38	GI129	CH011

GI129	SDEW 0903..	SDEX 0903..

		Nm			
CO070	US 3507-T15	3.0	M 3.5	7	Flag T15
CH011	US 3509-T15	3.0	M 3.5	9	Flag T15

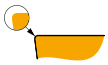
SDEW 09

	IC [mm]	D1 [mm]	S [mm]
0903	9.525	4.40	3.18

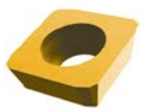
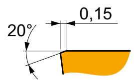


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SDEW 090308EN	M8330	0.8	◩ 235	0.10	4.5	–	–	–	■ 220	0.10	4.5	–	–	–	–	–	–	◩ 45	0.15	1.0
	M8340	0.8	◩ 210	0.10	4.5	–	–	–	◩ 195	0.10	4.5	–	–	–	–	–	–	–	–	–
SDEW 090308SN	8215	0.8	◩ 215	0.15	4.5	–	–	–	■ 200	0.15	4.5	–	–	–	–	–	–	◩ 40	0.15	1.0
	M8330	0.8	◩ 215	0.15	4.5	–	–	–	■ 200	0.15	4.5	–	–	–	–	–	–	◩ 40	0.15	1.0
	M8340	0.8	◩ 195	0.15	4.5	–	–	–	◩ 185	0.15	4.5	–	–	–	–	–	–	–	–	–

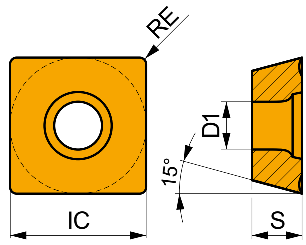
EN geometry with zero rake angle design for 45° chamfer milling.

SN geometry with zero rake angle design for 45° chamfer milling.

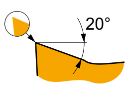
SDEX 09

	IC [mm]	D1 [mm]	S [mm]
0903	9.525	4.40	3.18



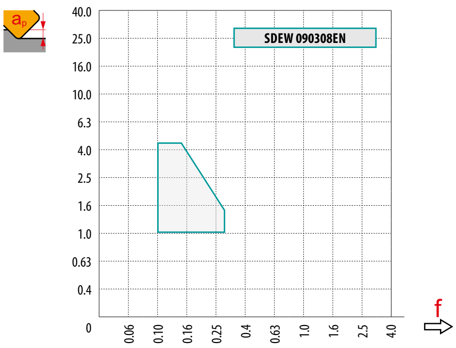
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

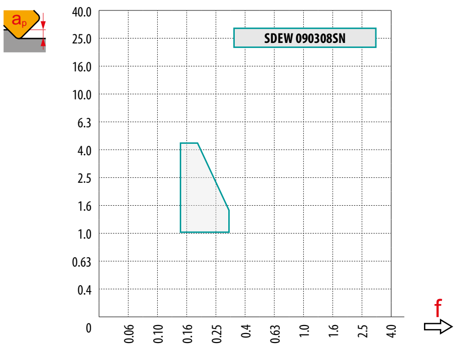
Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SDEX 090308FN-74	M8330	0.8	■ 305	0.12	4.5	◩ 180	0.11	4.5	◩ 285	0.12	4.5	–	–	–	◩ 75	0.11	3.6	–	–	–

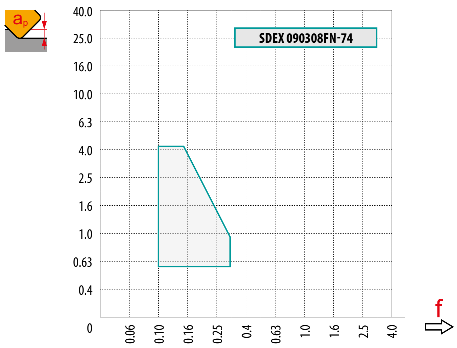



Geometry 74 with positive design for 45° chamfer milling.

	SDEW 09 EN	SDEW 09 SN	SDEX 09-74
RE	0.8	0.8	0.8
BS	–	–	–







DC	DCX	X.V	f_{min}	f_{max}
10	22	1.09	0.20	0.30
16	28	1.17	0.25	0.34
25	37	1.24	0.32	0.39

a_e/DC	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.50 – 1.00
	f							
45°	0.42 0.54 0.67	0.35 0.44 0.55	0.30 0.38 0.47	0.27 0.34 0.42	0.25 0.31 0.39	0.23 0.29 0.36	0.21 0.27 0.34	0.19 0.24 0.30
X.V	1.35	1.27	1.22	1.19	1.16	1.13	1.11	1.00

N-SSO09

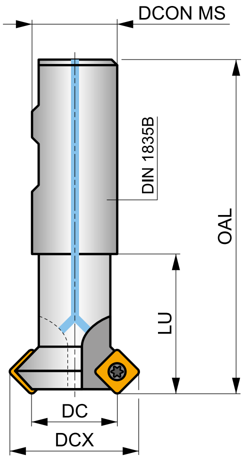
P M K S

PRAMET

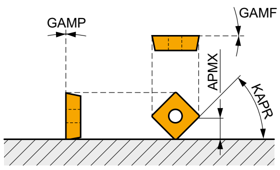
S

45° Chamfer Milling Cutter for Square Insert SOMT 09 with Internal Coolant

A 45° chamfer milling cutter utilising single-sided SOMT 09 inserts with APMX of 4.5 mm. Internal coolant. Suitable for top and bottom side chamfering. Available in cylindrical, Weldon and Morse taper style and outside Ø20.5, Ø28.8 and Ø37.8 mm. Body treated for longer tool life.



KAPR	45°
APMX	4.5 mm



h_m 0.095 - 0.18

	Product	DC [mm]	DCX [mm]	OAL [mm]	DCON MS [mm]	LU [mm]	GAMF [°]	GAMP [°]			max.		kg		
DIN 1835B	16N2R027B16-SSO09-C	16	28.8	110	16	27	0	0	2	–	26600	✓	0.23	GI146	SQ500
	25N3R042B25-SSO09-C	25	37.8	125	25	42	0	0	3	–	21300	✓	0.50	GI146	SQ500
	8N1R027B16-SSO09-C	8	20.5	90	16	27	0	0	1	–	37700	✓	0.12	GI146	SQ500

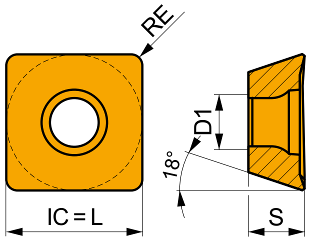
GI146	SOMT 09T3..

		Nm			
SQ500	US 3006-T09P	2.0	M 3	6	Flag T09P

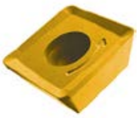
SOMT 09

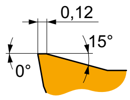
PRAMET

	IC [mm]	D1 [mm]	L [mm]	S [mm]
09T3	9.550	3.50	9.55	3.97



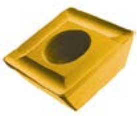
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Conditions are valid for setting angle 90°. Refer to our Machining Calculator app for further calculations.

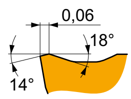




M geometry with positive design for medium machining.

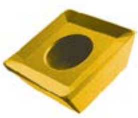
Product	Grade	RE [mm]	P	vc [m/min]	f [mm/tooth]	ap [mm]	M	vc [m/min]	f [mm/tooth]	ap [mm]	K	vc [m/min]	f [mm/tooth]	ap [mm]	N vc [m/min]	f [mm/tooth]	ap [mm]	S	vc [m/min]	f [mm/tooth]	ap [mm]	H vc [m/min]	f [mm/tooth]	ap [mm]
SOMT 09T308-M	8215	0.8	■	275	0.14	2.5	◩	165	0.13	2.5	◩	260	0.14	2.5	–	–	–	◩	65	0.13	2.0	–	–	–
	M5315	0.8	◩	390	0.14	2.5		–	–	–	◩	370	0.14	2.5	–	–	–		–	–	–	–	–	–
	M8330	0.8	■	270	0.14	2.5	■	160	0.13	2.5	◩	255	0.14	2.5	–	–	–	◩	65	0.13	2.0	–	–	–
	M8340	0.8	■	250	0.14	2.5	■	150	0.13	2.5	◩	235	0.14	2.5	–	–	–	◩	60	0.13	2.0	–	–	–
	M9315	0.8	■	380	0.14	2.5		–	–	–	◩	360	0.14	2.5	–	–	–		–	–	–	–	–	–

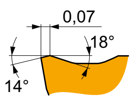




MI geometry with stable positive design for medium machining.

Product	Grade	RE [mm]	P	vc [m/min]	f [mm/tooth]	ap [mm]	M	vc [m/min]	f [mm/tooth]	ap [mm]	K	vc [m/min]	f [mm/tooth]	ap [mm]	N vc [m/min]	f [mm/tooth]	ap [mm]	S	vc [m/min]	f [mm/tooth]	ap [mm]	H vc [m/min]	f [mm/tooth]	ap [mm]
SOMT 09T304-MI	8215	0.4	■	230	0.14	2.5	◩	135	0.13	2.5	◩	215	0.14	2.5	–	–	–	◩	55	0.10	2.0	–	–	–
	M8310	0.4	■	255	0.14	2.5	◩	130	0.13	2.5	◩	240	0.14	2.5	–	–	–		–	–	–	–	–	–
	M8330	0.4	■	230	0.14	2.5	■	135	0.13	2.5	◩	215	0.14	2.5	–	–	–	◩	55	0.10	2.0	–	–	–
	M8340	0.4	■	210	0.14	2.5	■	125	0.13	2.5	◩	195	0.14	2.5	–	–	–	◩	50	0.10	2.0	–	–	–
	M9315	0.4	■	320	0.14	2.5		–	–	–	◩	300	0.14	2.5	–	–	–		–	–	–	–	–	–
	M9340	0.4	■	265	0.14	2.5	■	155	0.13	2.5		–	–	–	–	–	–	◩	65	0.10	2.0	–	–	–

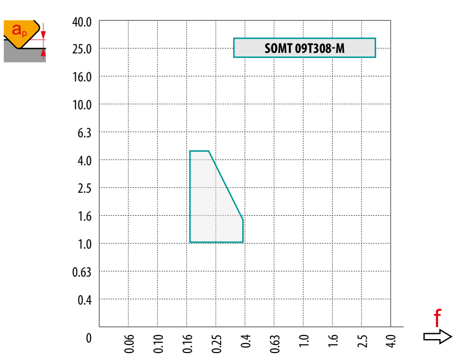


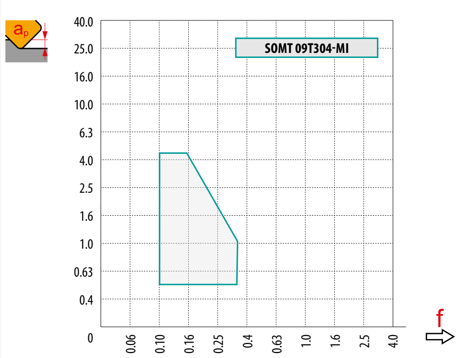


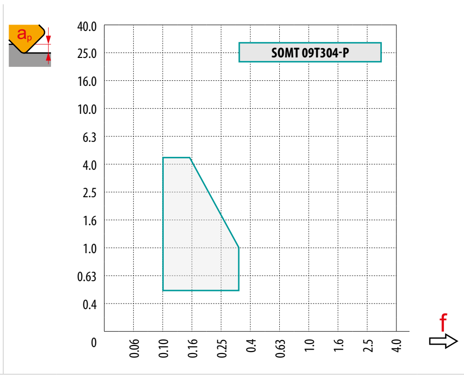
P geometry with highly positive design for medium machining.

Product	Grade	RE [mm]	P	vc [m/min]	f [mm/tooth]	ap [mm]	M	vc [m/min]	f [mm/tooth]	ap [mm]	K	vc [m/min]	f [mm/tooth]	ap [mm]	N vc [m/min]	f [mm/tooth]	ap [mm]	S	vc [m/min]	f [mm/tooth]	ap [mm]	H vc [m/min]	f [mm/tooth]	ap [mm]
SOMT 09T304-P	M8330	0.4	■	250	0.14	2.5	◩	150	0.13	2.5	◩	235	0.14	2.5	–	–	–	◩	60	0.10	2.0	–	–	–
	M8340	0.4	■	230	0.14	2.5	◩	135	0.13	2.5	◩	215	0.14	2.5	–	–	–	◩	55	0.10	2.0	–	–	–
	M9325	0.4	■	320	0.14	2.5		–	–	–	◩	300	0.14	2.5	–	–	–		–	–	–	–	–	–

	SOMT 09-M	SOMT 09-MI	SOMT 09-P
RE	0.8	0.4	0.4
BS	–	–	–







DC	DCX	X.V	f_{min}	f_{max}
8	20.5	1.06	0.18	0.29
16	28.8	1.17	0.25	0.34
25	37.8	1.24	0.32	0.39

a_e/DC	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.50 – 1.00
				f				
45°	0.42 0.63 0.80	0.35 0.51 0.66	0.30 0.44 0.57	0.27 0.40 0.51	0.25 0.36 0.46	0.23 0.33 0.43	0.21 0.31 0.40	0.19 0.28 0.36
X.V	1.35	1.27	1.22	1.19	1.16	1.13	1.11	1.00

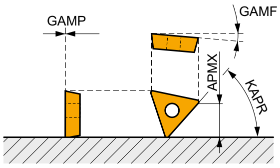
2516

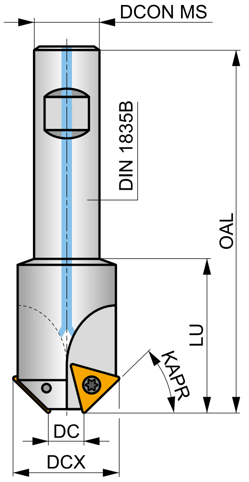
P M K N

PRAMET

S

KAPR	45°
APMX	8,5 mm





h_m 0.065 - 0.095

		DCX [mm]	DC [mm]	OAL [mm]	DCON MS [mm]	LU [mm]			max.		kg		
DIN 1835B	2516-45-11	31	11	100	16	30	2	–	18100	✓	0.24	GI155	SQ220
	2516-45-19	39	19	100	20	30	2	–	16200	✓	0.35	GI155	SQ220

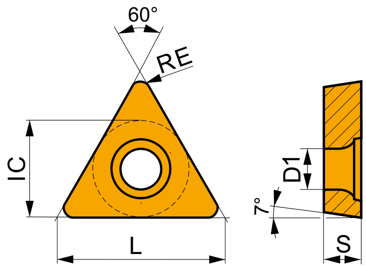
GI155	TCMT 16T308E-FM:T83..

		Nm			
SQ220	US 4011-T15P	3.5	M 4	10.6	Flag T15P

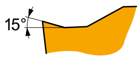
TCMT

PRAMET

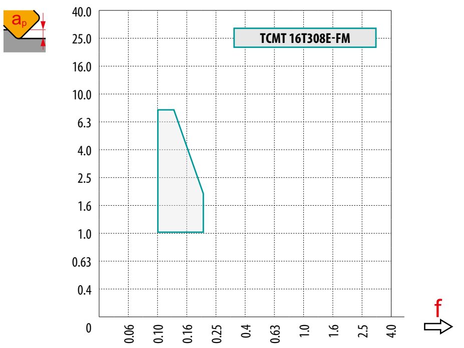
	IC [mm]	D1 [mm]	L [mm]	S [mm]
16T3	9.525	4.4	16.5	3.97



		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]
TCMT 16T308E-FM	T8315	0.80	170	0.17	1.7	100	0.15	1.7	160	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–
	T8330	0.80	160	0.17	1.7	95	0.15	1.7	150	0.17	1.7	480	0.20	1.7	–	–	–	–	–	–



	TCMT 16-FM
RE	0.8
BS	–



DC	DCX	X.V	f_{min}	f_{max}
11.0	31.0	1.02	0.10	0.18
19.0	39.0	1.10	0.14	0.20

a_e/DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
45°	0.29	0.34	0.42	0.24	0.27	0.35	0.21	0.24	0.30	0.18	0.21	0.27	0.17	0.19	0.25	0.16	0.18	0.23	0.15	0.17	0.21	0.13	0.15	0.19
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

2636

P M K N

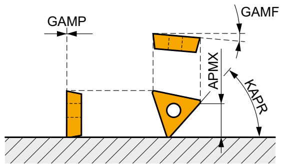
PRAMET

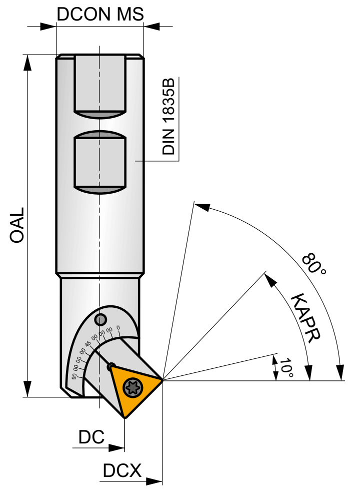
S

Adjustable Milling Cutter for TCMT 16 insert

Adjustable chamfering milling cutter utilising TCMT 16 inserts with APMX of 8.5 mm. Adjustable angle range from 10° up to 80°. Available in Weldon style Ø25 mm only. Body treated for longer tool life.

KAPR	10°- 80°
APMX	8,5 mm





h_m 0.03 - 0.08

	Product	DC [mm]	DCX [mm]	OAL [mm]	DCON MS [mm]	KAPR [°]	GAMF [°]	GAMP [°]			max.		kg		
DIN 1835B	2636-05-25	5.0	31.0	100	25	10	-8	0	1	–	18100	–	0.35	GI294	CH040
		5.5	31.0			15									
		7.0	29.5			30									
		11.0	29.5			45									
		16.0	28.5			60									
		21.0	26.5			75									
		23.0	26.0			80									

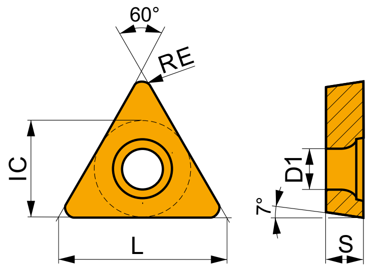
GI294	TCMT 16T304E-FM:T83..	TCMT 16T308E-FM:T83..

				Nm			
CH040	USI 0614	CA 2669	US 4011-T15P	3.5	M 4	10.6	Flag T15

TCMT

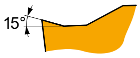
PRAMET

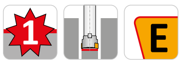
	IC [mm]	D1 [mm]	L [mm]	S [mm]
16T3	9.525	4.4	16.5	3.97



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

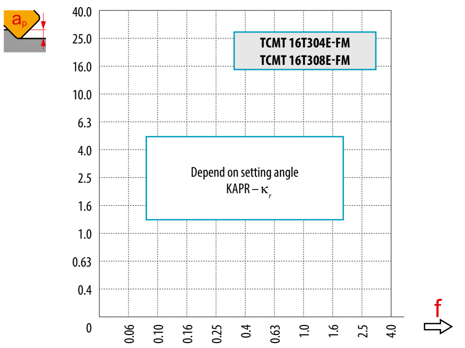
Product		RE [mm]	P	vc [m/min]	f [mm/rev]	ap [mm]	M	vc [m/min]	f [mm/rev]	ap [mm]	K	vc [m/min]	f [mm/rev]	ap [mm]	N	vc [m/min]	f [mm/rev]	ap [mm]	S	vc [m/min]	f [mm/rev]	ap [mm]	H	vc [m/min]	f [mm/rev]	ap [mm]
TCMT 16T304E-FM	**T8315**	0.40	◪	155	0.12	1.7	■	90	0.11	1.7	◪	145	0.12	1.7	◪	465	0.14	1.7		–	–	–		–	–	–
	T8330	0.40	■	150	0.12	1.7	■	90	0.11	1.7	◪	140	0.12	1.7	◪	450	0.14	1.7		–	–	–		–	–	–
TCMT 16T308E-FM	**T8315**	0.80	◪	170	0.17	1.7	■	100	0.15	1.7	◪	160	0.17	1.7	◪	510	0.20	1.7		–	–	–		–	–	–
	T8330	0.80	■	160	0.17	1.7	■	95	0.15	1.7	◪	150	0.17	1.7	◪	480	0.20	1.7		–	–	–		–	–	–





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

	TCMT 16-FM	
RE	0.8	0.4
BS	–	–



	ap	DC	DCX	X.V	fmin	fmax
10°	2.6	5.0	31.0	1.38	0.24	0.59
15°	3.9	5.5	31.0	1.30	0.17	0.40
30°	7.6	7.0	29.5	1.18	0.10	0.20
45°	10.7	11.0	29.5	1.13	0.09	0.14
60°	13.2	16.0	28.5	1.09	0.09	0.11
75°	14.7	21.0	26.5	1.06	0.09	0.10
80°	15.0	23.0	26.0	1.06	0.09	0.10

ae/DC	**0.10**			**0.15**			**0.20**			**0.25**			**0.30**			**0.35**			**0.40**			**0.50 – 1.00**		
	f																							
10°	0.55	0.91	1.46	0.45	0.74	1.19	0.39	0.64	1.03	0.35	0.58	0.92	0.32	0.53	0.84	0.29	0.49	0.78	0.27	0.46	0.73	0.24	0.41	0.65
15°	0.37	0.61	0.98	0.30	0.50	0.80	0.26	0.43	0.69	0.23	0.39	0.62	0.21	0.35	0.56	0.20	0.33	0.52	0.18	0.31	0.49	0.16	0.27	0.44
30°	0.19	0.32	0.51	0.15	0.26	0.41	0.13	0.22	0.36	0.12	0.20	0.32	0.11	0.18	0.29	0.10	0.17	0.27	0.09	0.16	0.25	0.08	0.14	0.23
45°	0.13	0.22	0.36	0.11	0.18	0.29	0.09	0.16	0.25	0.08	0.14	0.23	0.08	0.13	0.21	0.07	0.12	0.19	0.07	0.11	0.18	0.06	0.10	0.16
60°	0.11	0.18	0.29	0.09	0.15	0.24	0.08	0.13	0.21	0.07	0.12	0.18	0.06	0.11	0.17	0.06	0.10	0.16	0.05	0.09	0.15	0.05	0.08	0.13
75°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.12	0.19	0.06	0.10	0.17	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.12
80°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.11	0.18	0.06	0.10	0.16	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.11
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

J(T)-SXP16

P M K N

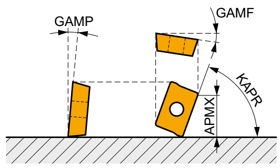
PRAMET

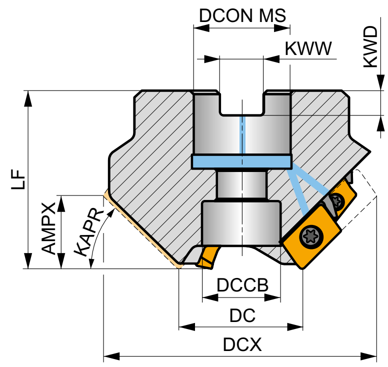
S

Long Edge Chamfer Milling Cutter for XPHT 16 insert with Internal Coolant

Chamfer milling cutter utilising single-sided XPHT 16 inserts with APMX from 7 up to 28 mm. Internal coolant. Suitable for top chamfering. Available in arbor style only. Minor Ø35 and Ø45 mm, in range of 15°, 25°, 30°, 35°, 40°, 45°, 50°, 55°, 60˚ and 75° chamfer angle. Body treated for longer tool life.

KAPR	15° - 75°
APMX	7.0 - 28.0 mm





h_m 0.05 - 0.11

Product	DC [mm]	DCX [mm]	LF [mm]	DCON MS [mm]	DCCB [mm]	KAPR [°]	KWW [mm]	KWD [mm]	APMX [mm]	GAMF [°]	GAMP [°]	NOF			max.		kg		
35T03R-S15XP1607-C	35	90.6	50	27	22	15	12.4	7	7.00	-6	-1	3	6	–	15200	✓	1.38	GI208	CH050
35T03R-S25XP1612-C	35	87.3	50	27	22	25	12.4	7	12.00	-6	0	3	6	–	15200	✓	1.24	GI208	CH050
35T03R-S30XP1614-C	35	85.1	50	27	22	30	12.4	7	14.00	-6	0	3	6	–	15200	✓	1.28	GI208	CH050
35T03R-S35XP1616-C	35	82.4	50	27	22	35	12.4	7	16.00	-6	0	3	6	–	15200	✓	1.15	GI208	CH050
35T03R-S40XP1618-C	35	79.4	50	27	22	40	12.4	7	18.00	-6	1	3	6	–	15200	✓	1.07	GI208	CH050
35T03R-S45XP1620-C	35	76.1	50	27	22	45	12.4	7	20.00	-6	2	3	6	–	15200	✓	0.97	GI208	CH050
35T03R-S50XP1622-C	35	72.4	50	27	22	50	12.4	7	22.00	-6	2	3	6	–	15200	✓	0.91	GI208	CH050
35T03R-S55XP1623-C	35	68.4	50	27	22	55	12.4	7	23.00	-6	2	3	6	–	15200	✓	0.83	GI208	CH050
35T03R-S60XP1625-C	35	64.2	50	27	22	60	12.4	7	25.00	-5	4	3	6	–	15200	✓	0.67	GI208	CH050
45T03R-S75XP1628-C	45	60.1	50	27	22	75	12.4	7	28.00	-5	5	3	6	–	13400	✓	0.73	GI208	CH050
45T04R-S25XP1612-C	45	97.3	50	27	22	25	12.4	7	12.00	-6	0	4	8	✓	13400	✓	1.63	GI208	CH050
45T04R-S30XP1614-C	45	95.1	50	27	22	30	12.4	7	14.00	-6	0	4	8	✓	13400	✓	1.22	GI208	CH050
45T04R-S35XP1616-C	45	92.4	50	27	22	35	12.4	7	16.00	-6	2	4	8	✓	13400	✓	1.30	GI208	CH050
45T04R-S40XP1618-C	45	89.5	50	27	22	40	12.4	7	18.00	-6	2	4	8	✓	13400	✓	1.18	GI208	CH050
45T04R-S45XP1620-C	45	86.1	50	27	22	45	12.4	7	20.00	-6	2	4	8	✓	13400	✓	1.11	GI208	CH050
45T04R-S50XP1622-C	45	82.4	50	27	22	50	12.4	7	22.00	-6	2	4	8	✓	13400	✓	1.04	GI208	CH050
45T04R-S55XP1623-C	45	78.4	50	27	22	55	12.4	7	23.00	-6	2	4	8	✓	13400	✓	0.96	GI208	CH050
45T04R-S60XP1625-C	45	74.2	50	27	22	60	12.4	7	25.00	-5	4	4	8	✓	13400	✓	0.82	GI208	CH050

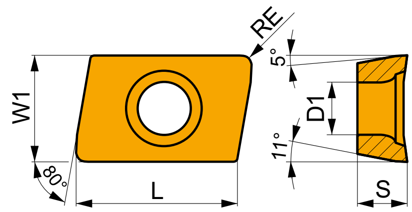
ISO 6462 DIN 8030

GI208	XPHT 1604..

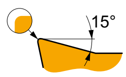
CH050	US 3509-T15	3.0	M 3.5	9	D-T07/T15	FG-15	HS 1230C

XPHT 16

	W1 [mm]	D1 [mm]	L [mm]	S [mm]
1604	9.525	4.40	15.88	4.76

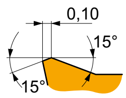


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.



E geometry with highly positive design for chamfer milling.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
XPHT 160412E	**8215**	1.2	■ 225	0.10	15.0	◪ 135	0.09	15.0	◪ 210	0.10	15.0	–	–	–	–	–	–	–	–	–
	M6330	1.2	■ 190	0.10	15.0	■ 135	0.09	15.0	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	1.2	■ 220	0.10	15.0	■ 130	0.09	15.0	◪ 205	0.10	15.0	–	–	–	–	–	–	–	–	–
	M8340	1.2	■ 195	0.10	15.0	■ 115	0.09	15.0	◪ 185	0.10	15.0	–	–	–	–	–	–	–	–	–



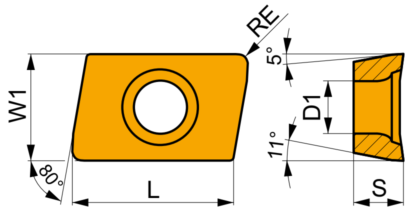
S geometry with highly positive design for chamfer milling.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
XPHT 160412S	**8215**	1.2	■ 210	0.12	15.0	◪ 125	0.11	15.0	◪ 195	0.12	15.0	–	–	–	–	–	–	–	–	–
	M8330	1.2	■ 210	0.12	15.0	■ 125	0.11	15.0	◪ 195	0.12	15.0	–	–	–	–	–	–	–	–	–
	M8340	1.2	■ 190	0.12	15.0	■ 110	0.11	15.0	◪ 180	0.12	15.0	–	–	–	–	–	–	–	–	–
	M9325	1.2	■ 270	0.12	15.0	–	–	–	◪ 255	0.12	15.0	–	–	–	–	–	–	–	–	–
	M9340	1.2	■ 245	0.12	15.0	■ 145	0.11	15.0	–	–	–	–	–	–	–	–	–	–	–	–

XPHT 16-FA

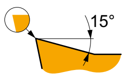
PRAMET

	W1 [mm]	D1 [mm]	L [mm]	S [mm]
1604	9.525	4.40	15.88	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.

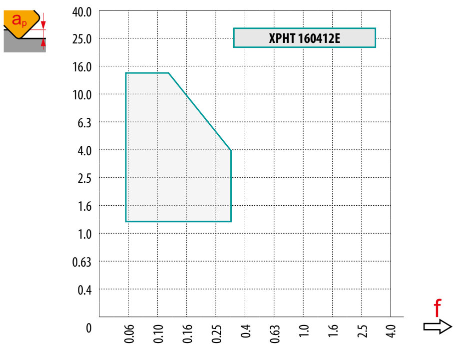
Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
XPHT 160408F-FA	HF7	0.8	–	–	–	–	–	–	–	–	–	■ 255	0.12	15.0	–	–	–	–	–	–

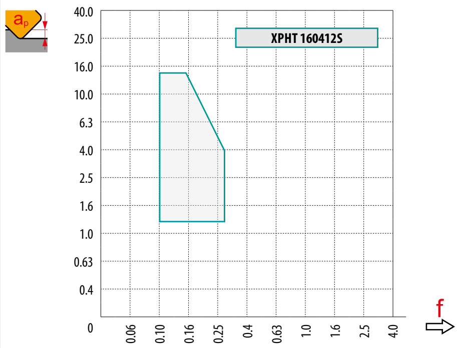


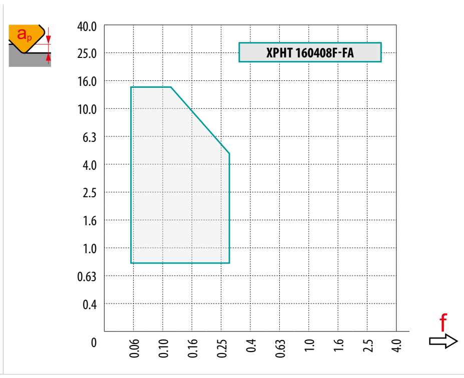
F

FA geometry with highly positive design for chamfer milling.

	XPHT 16 E	XPHT 16 S	XPHT 16-FA
RE	1.2	1.2	0.8
BS	–	–	–







a_e/DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
15°	0.61	0.98	1.34	0.50	0.80	1.10	0.43	0.69	0.95	0.39	0.62	0.85	0.35	0.56	0.78	0.33	0.52	0.72	0.31	0.49	0.67	0.27	0.44	0.60
25°	0.37	0.60	0.82	0.31	0.49	0.67	0.26	0.42	0.58	0.24	0.38	0.52	0.22	0.35	0.48	0.20	0.32	0.44	0.19	0.30	0.41	0.17	0.27	0.37
30°	0.32	0.51	0.70	0.26	0.41	0.57	0.22	0.36	0.49	0.20	0.32	0.44	0.18	0.29	0.40	0.17	0.27	0.37	0.16	0.25	0.35	0.14	0.23	0.31
35°	0.28	0.44	0.61	0.23	0.36	0.50	0.19	0.31	0.43	0.17	0.28	0.38	0.16	0.25	0.35	0.15	0.24	0.32	0.14	0.22	0.30	0.12	0.20	0.27
40°	0.25	0.39	0.54	0.20	0.32	0.44	0.17	0.28	0.38	0.16	0.25	0.34	0.14	0.23	0.31	0.13	0.21	0.29	0.12	0.20	0.27	0.11	0.18	0.24
45°	0.22	0.36	0.49	0.18	0.29	0.40	0.16	0.25	0.35	0.14	0.23	0.31	0.13	0.21	0.28	0.12	0.19	0.26	0.11	0.18	0.25	0.10	0.16	0.22
50°	0.21	0.33	0.45	0.17	0.27	0.37	0.15	0.23	0.32	0.13	0.21	0.29	0.12	0.19	0.26	0.11	0.18	0.24	0.10	0.17	0.23	0.09	0.15	0.20
55°	0.19	0.31	0.42	0.16	0.25	0.35	0.14	0.22	0.30	0.12	0.20	0.27	0.11	0.18	0.25	0.10	0.17	0.23	0.10	0.15	0.21	0.09	0.14	0.19
60°	0.18	0.29	0.40	0.15	0.24	0.33	0.13	0.21	0.28	0.12	0.18	0.25	0.11	0.17	0.23	0.10	0.16	0.21	0.09	0.15	0.20	0.08	0.13	0.18
75°	0.16	0.26	0.36	0.13	0.21	0.29	0.12	0.19	0.25	0.10	0.17	0.23	0.09	0.15	0.21	0.09	0.14	0.19	0.08	0.13	0.18	0.07	0.12	0.16
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

	a_p	DC	DCX	X.V	f_{min}	f_{max}
15°	7	35.0	90.6	1.16	0.43	0.70
25°	12	35.0	87.3	1.16	0.20	0.32
30°	14	35.0	85.1	1.17	0.16	0.25
35°	16	35.0	82.4	1.17	0.13	0.20
40°	18	35.0	79.4	1.17	0.11	0.16
45°	20	35.0	76.0	1.18	0.09	0.14
50°	22	35.0	72.4	1.18	0.08	0.12
55°	23	35.0	68.4	1.20	0.08	0.11
60°	25	35.0	64.1	1.20	0.07	0.09
25°	12	45.0	97.3	1.18	0.23	0.34
30°	14	45.0	95.0	1.18	0.18	0.26
35°	16	45.0	92.4	1.19	0.15	0.21
40°	18	45.0	89.5	1.19	0.12	0.17
45°	20	45.0	86.0	1.20	0.11	0.15
50°	22	45.0	82.4	1.21	0.09	0.13

	a_p	DC	DCX	X.V	f_{min}	f_{max}
55°	23	45.0	78.4	1.22	0.09	0.11
60°	25	45.0	74.1	1.23	0.08	0.10
75°	28	45.0	60.1	1.31	0.07	0.08

Cutters with setting angle 15°can be used as HFC. Use feeds from chamfers table.

F-SCC

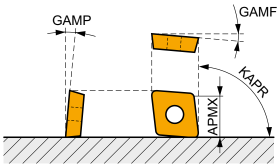
P M K

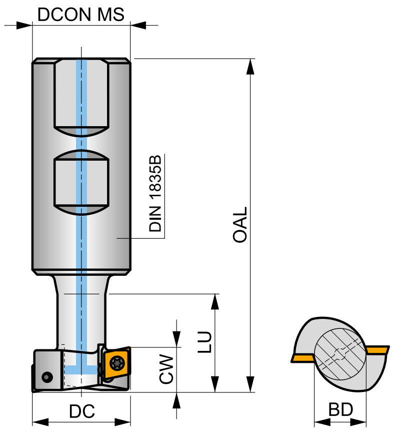
PRAMET S

T-Slot Milling Cutter for CCMX insert with Internal Coolant

T-slot milling cutter utilising single-sided CCMX inserts. Internal coolant. Suitable for T-slot, back-face, shallow shoulder and shallow slot milling. Available in Weldon style only in outside Ø25, Ø32 and Ø40 mm. Body treated for longer tool life.

KAPR	90°
APMX	11.0 - 18.0 mm





h_m 0.05 - 0.08

Product	DC [mm]	BD [mm]	OAL [mm]	DCON MS [mm]	LU [mm]	CW [mm]				max.		kg		
25F1R030B25-SCC06-C	25	12	86	25	25	11.00	1	2	–	28100	✓	0.26	GI148	SQ213
32F1R038B32-SCC08-C	32	16	98	32	33	14.00	1	2	–	19100	✓	0.50	GI149	SQ212
40F2R046B32-SCC09-C	40	20	105	32	41	18.00	2	4	–	14900	✓	0.56	GI150	SQ212

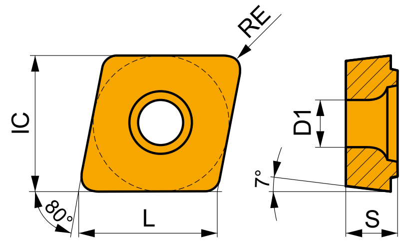
DIN 1835B

GI148	CCMX 060304
GI149	CCMX 08T308
GI150	CCMX 09T308

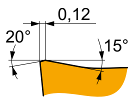
		Nm			
SQ212	US 3007-T09P	2.0	M 3	7.3	Flag T09P
SQ213	US 2506-T07P	1.2	M 2.5	6.3	Flag T07P

CCMX

	IC [mm]	D1 [mm]	L [mm]	S [mm]
0603	6.350	2.80	6.40	3.50
08T3	8.030	3.50	8.10	4.40
09T3	9.525	3.50	9.70	3.97



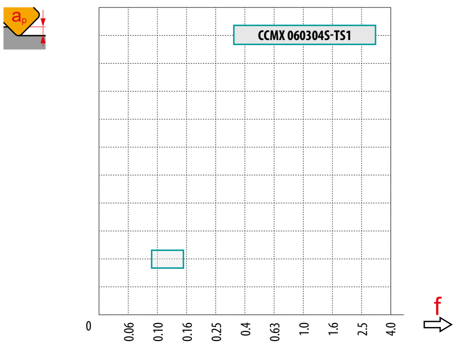
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

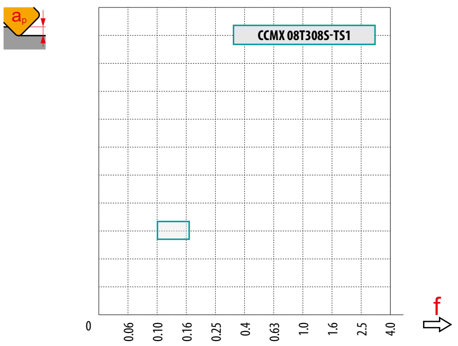


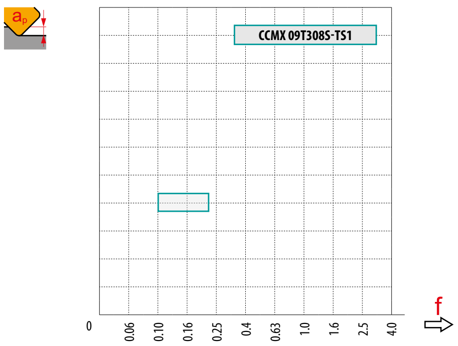
Special design for T-Slot milling fo+I250r light to medium cutting conditions.

Product	Grade	RE [mm]	P	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H	H vc [m/min]	H f [mm/tooth]	H ap [mm]
CCMX 060304S-TS1	**M8330**	0.4	■	240	0.10	–	◩	140	0.09	–	■	225	0.10	–		–	–	–		–	–	–		–	–	–
	M8340	0.4	■	215	0.10	–	◩	125	0.09	–	◩	200	0.10	–		–	–	–		–	–	–		–	–	–
CCMX 08T308S-TS1	**M8330**	0.8	■	275	0.10	–	◩	165	0.10	–	■	260	0.10	–		–	–	–		–	–	–		–	–	–
	M8340	0.8	■	245	0.10	–	◩	145	0.10	–	◩	230	0.10	–		–	–	–		–	–	–		–	–	–
CCMX 09T308S-TS1	**M8330**	0.8	■	270	0.10	–	◩	160	0.10	–	■	255	0.10	–		–	–	–		–	–	–		–	–	–
	M8340	0.8	■	240	0.10	–	◩	140	0.10	–	◩	225	0.10	–		–	–	–		–	–	–		–	–	–

	CCMX 06-TS1	CCMX 08-TS1	CCMX 09-TS1
RE	0.4	0.8	0.8
BS	–	–	–







a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

DC	a_e = 1		a_e = 2		a_e = 3		a_e = 4		a_e = 5		a_e = 8		a_e = 10	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.25	0.40	0.18	0.29	0.15	0.24	0.13	0.21	0.12	0.19	0.09	0.15	0.09	0.14
32	0.28	0.45	0.20	0.32	0.17	0.27	0.14	0.23	0.13	0.21	0.10	0.17	0.09	0.15
40	0.32	0.51	0.23	0.36	0.18	0.30	0.16	0.26	0.14	0.23	0.12	0.19	0.10	0.17

DC	a_e = 12		a_e = 16		a_e = 20		a_e = 25		a_e = 32		a_e = 40	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	–	–	–	–
32	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	–	–
40	0.10	0.15	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13

Valid for T-slot milling

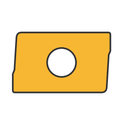
Valid for shoulder and inverse face milling

Valid for shoulder milling

DC		APMX	$a_{e\,max}$
25	1	11	6.4
32	1	14	8.0
40	2	18	9.7

OTHER MILLING INSERTS

OTHER MILLING INSERTS – NAVIGATOR

ADKT 15

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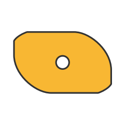
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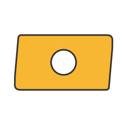
APMT 16

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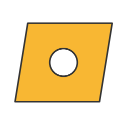
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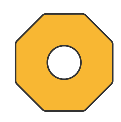
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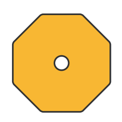
OFKR 07

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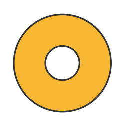
RDET

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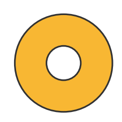
RDEX

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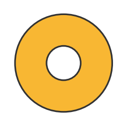
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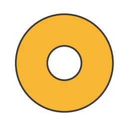
RPET 12

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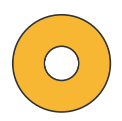
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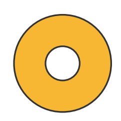
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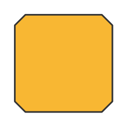
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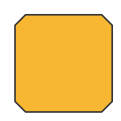
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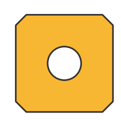
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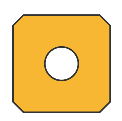
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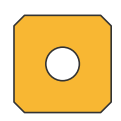
SEET 12-PM

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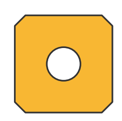
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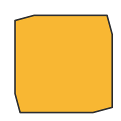
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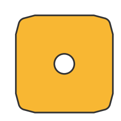
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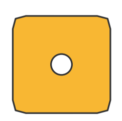
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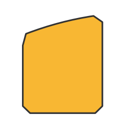
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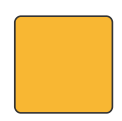
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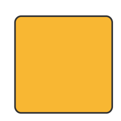
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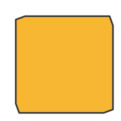
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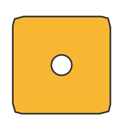
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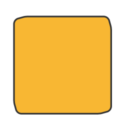
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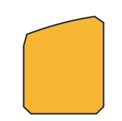
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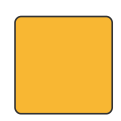
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TNJF

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TPCN 16

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TPKN

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TPKR

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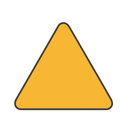
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VCGT 22-FA

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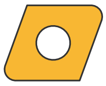
XDHW

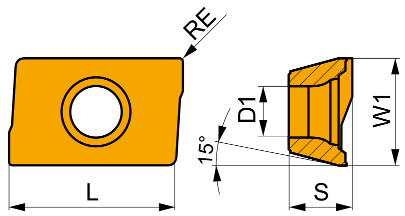


690

ADKT 15

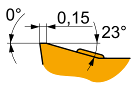
PRAMET

	W1 [mm]	D1 [mm]	L [mm]	S [mm]
1505	9.525	4.40	15.55	5.60



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

Product		RE [mm]	P				M				K				N				S				H			
				vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]
ADKT 1505PDER-M	M8330	0.8	■	235	0.20	5.0	■	140	0.18	5.0	■	220	0.20	5.0		–	–	–	◩	55	0.16	4.0		–	–	–
	M8340	0.8	■	210	0.20	5.0	■	125	0.18	5.0	◩	195	0.20	5.0		–	–	–	◩	50	0.16	4.0		–	–	–
	M9325	0.8	■	290	0.20	5.0		–	–	–	■	275	0.20	5.0		–	–	–		–	–	–		–	–	–

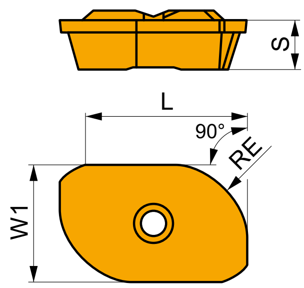


M geometry with highly positive design for medium machining.

ADKX 15

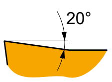
PRAMET

	W1 [mm]	L [mm]	S [mm]
15T3	9.525	12.60	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.

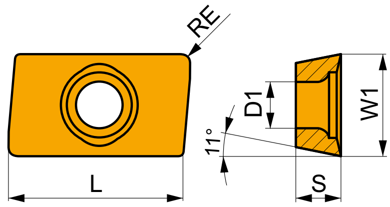
Product		RE [mm]	P				M				K				N				S				H			
				vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]
ADKX 15T308ER-F	M8330	0.8	◩	245	0.10	10.0	■	145	0.09	10.0		–	–	–		–	–	–	◩	60	0.07	8.0		–	–	–
	M8345	0.8	◩	170	0.10	10.0	■	100	0.09	10.0		–	–	–		–	–	–	◩	40	0.07	8.0		–	–	–
ADKX 15T330ER-F	M8330	3.0	■	280	0.10	10.0	■	165	0.09	10.0		–	–	–		–	–	–	◩	70	0.07	8.0		–	–	–
	M8345	3.0	■	200	0.10	10.0	■	120	0.09	10.0		–	–	–		–	–	–	■	50	0.07	8.0		–	–	–
ADKX 15T340ER-F	M8330	4.0	■	280	0.10	10.0	■	165	0.09	10.0		–	–	–		–	–	–	◩	70	0.07	8.0		–	–	–
	M8345	4.0	■	200	0.10	10.0	■	120	0.09	10.0		–	–	–		–	–	–	■	50	0.07	8.0		–	–	–
ADKX 15T360ER-F	M8330	6.0	■	280	0.10	10.0	■	165	0.09	10.0		–	–	–		–	–	–	◩	70	0.07	8.0		–	–	–



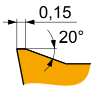
F geometry with very sharp positive design for light to medium machining.

APMT 16

	W1 [mm]	D1 [mm]	L [mm]	S [mm]
1604	9.600	4.50	17.00	4.76

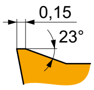


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

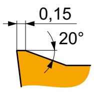
F geometry with positive design for light machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
APMT 1604PDER-F	M8330	–	■ 290	0.15	2.0	■ 170	0.14	2.0	◩ 275	0.15	2.0	–	–	–	◩ 70	0.11	1.6	–	–	–

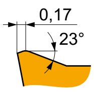
FM geometry with positive design for light to medium machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
APMT 1604PDER-FM	M8330	–	■ 285	0.16	2.0	■ 170	0.14	2.0	◩ 270	0.16	2.0	–	–	–	◩ 70	0.13	1.6	–	–	–
	M8345	–	■ 205	0.16	2.0	■ 120	0.14	2.0	–	–	–	–	–	–	◩ 50	0.13	1.6	–	–	–

ER-R geometry with positive design for rough machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
APMT 1604PDER-R	M8330	–	■ 255	0.16	5.0	–	–	–	■ 240	0.16	5.0	–	–	–	–	–	–	–	–	–
	M8345	–	■ 185	0.16	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

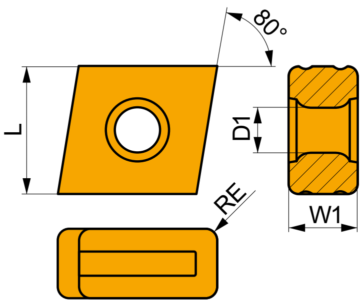
SR-R geometry with positive design for rough machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
APMT 1604PDSR-R	M8330	–	■ 255	0.18	5.0	–	–	–	■ 240	0.18	5.0	–	–	–	–	–	–	–	–	–
	M8345	–	■ 180	0.18	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

CNM

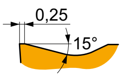
	D1 [mm]	L [mm]	S [mm]
63	5.50	15.00	8.00

PRAMET



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/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]		K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
CNM 563	M8330	1.2	■	185	0.30	10.0	–	–	–	■	175	0.30	10.0	–	–	–	–	–	–	–	–	–
	M8340	1.2	■	220	0.30	10.0	–	–	–	◩	205	0.30	10.0	–	–	–	–	–	–	–	–	–

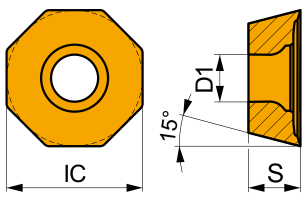


Universal geometry.

ODMT 05

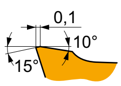
	IC [mm]	D1 [mm]	S [mm]
0504	12.700	4.40	4.76

PRAMET



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/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]		K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
ODMT 0504ZZN	M8340	–	■	195	0.25	1.5	–	–	–	◩	185	0.25	1.5	–	–	–	–	–	–	–	–	–

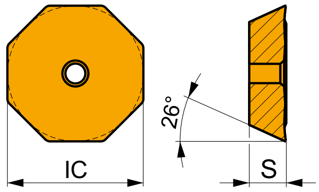


Slightly positive design for medium machining.

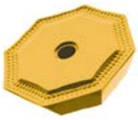
OFKR 07

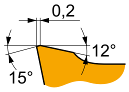
PRAMET

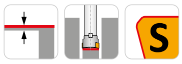
	IC [mm]	D1 [mm]	S [mm]
0704	17.845	2.65	4.56



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







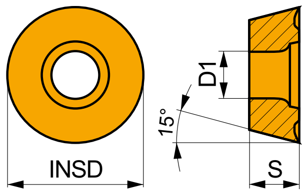
M geometry with positive design for light to medium machining.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
OFKR 0704SN-M	M8330	–	■ 235	0.25	1.5	■ 140	0.23	1.5	◪ 220	0.25	1.5	–	–	–	–	–	–	–	–	–
	M8340	–	■ 215	0.25	1.5	■ 125	0.23	1.5	◪ 200	0.25	1.5	–	–	–	–	–	–	–	–	–

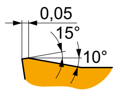
RDET

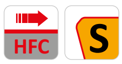
PRAMET

	INSD [mm]	D1 [mm]	S [mm]
0802	8.0	3.40	2.38
1003	10.0	4.40	3.18
12T3	12.0	4.40	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.





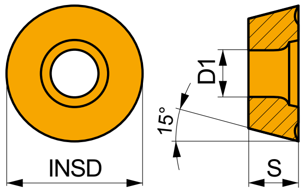
Positive design for finish machining.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
RDET 0802MOSN	M8340	–	■ 335	0.15	0.5	◪ 200	0.14	0.5	◪ 315	0.15	0.5	–	–	–	◪ 80	0.12	0.4	–	–	–
RDET 1003MOSN	M8340	–	■ 310	0.15	1.0	◪ 185	0.14	1.0	◪ 290	0.15	1.0	–	–	–	◪ 75	0.12	0.8	–	–	–
RDET 12T3MOSN	M8340	–	■ 280	0.20	1.5	◪ 165	0.18	1.5	◪ 265	0.20	1.5	–	–	–	◪ 70	0.14	1.2	–	–	–

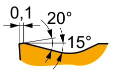
RDEX

PRAMET

	INSD [mm]	D1 [mm]	S [mm]
1204	12.0	4.40	4.76
1604	16.0	5.50	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.



HFC S

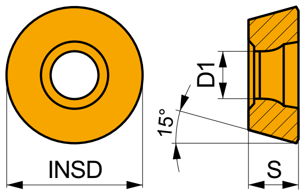
Positive design for finish machining.

Product	Grade	RE [mm]		P vc [m/min]	P f [mm/tooth]	P ap [mm]		M vc [m/min]	M f [mm/tooth]	M ap [mm]		K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]		S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
RDEX 1204MOSN-12	**M8340**	–	■	205	0.30	1.5	◩	120	0.27	1.5	◩	190	0.30	1.5	–	–	–	◩	50	0.21	1.2	–	–	–
RDEX 1604MOSN-12	**M8340**	–	■	195	0.30	2.0	◩	115	0.27	2.0	◩	185	0.30	2.0	–	–	–	◩	45	0.24	1.6	–	–	–

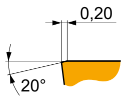
RDHX 20

PRAMET

	INSD [mm]	D1 [mm]	S [mm]
2006	20.0	5.20	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.



HFC T

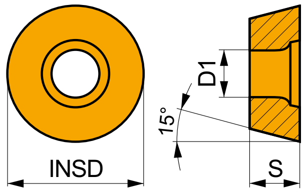
Zero rake angle design for finish machining.

Product	Grade	RE [mm]		P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]		K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]		H vc [m/min]	H f [mm/tooth]	H ap [mm]
RDHX 2006MOT	**M8310**	–	◩	240	0.35	3.0	–	–	–	■	225	0.35	3.0	–	–	–	–	–	–	■	45	0.15	1.0
	M8325	–	◩	180	0.35	3.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–

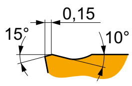
RPET 12

PRAMET

	INSD [mm]	D1 [mm]	S [mm]
1204	12.0	4.40	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.



HFC S

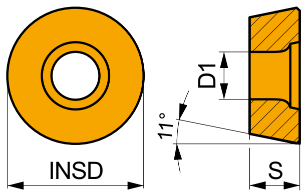
Positive design for finish machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
RPET 1204MOSN	**8215**	–	■ 325	0.20	1.5	◪ 195	0.18	1.5	◪ 305	0.20	1.5	–	–	–	◪ 80	0.14	1.2	–	–	–
	M8330	–	■ 320	0.20	1.5	◪ 190	0.18	1.5	◪ 300	0.20	1.5	–	–	–	◪ 80	0.14	1.2	–	–	–
	M8340	–	■ 295	0.20	1.5	◪ 175	0.18	1.5	◪ 280	0.20	1.5	–	–	–	◪ 70	0.14	1.2	–	–	–

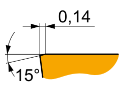
RPEW 12

PRAMET

	INSD [mm]	D1 [mm]	S [mm]
1204	12.0	4.40	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.



HFC S

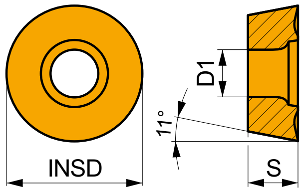
Zero rake angle design for finish machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
RPEW 1204MOSN	**M8330**	–	◪ 285	0.20	1.5	–	–	–	■ 270	0.20	1.5	–	–	–	–	–	–	◪ 55	0.15	1.0
	M8340	–	◪ 265	0.20	1.5	–	–	–	◪ 250	0.20	1.5	–	–	–	–	–	–	–	–	–

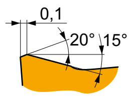
RPEX

PRAMET

	INSD [mm]	D1 [mm]	S [mm]
1204	12.0	4.40	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.



HFC S

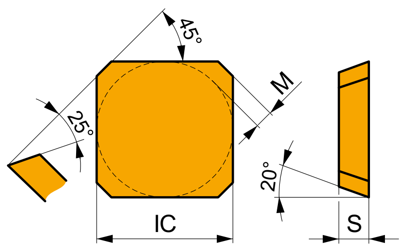
Positive design for finish machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
RPEX 1204MOSN-12	M8330	–	■ 235	0.30	1.5	◩ 140	0.27	1.5	■ 220	0.30	1.5	–	–	–	◩ 55	0.21	1.2	–	–	–
	M8340	–	■ 215	0.30	1.5	◩ 125	0.27	1.5	◩ 200	0.30	1.5	–	–	–	◩ 50	0.21	1.2	–	–	–

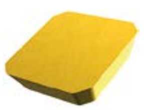
SEEN

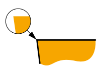
PRAMET

	IC [mm]	M [mm]	S [mm]
1203	12.700	2	3.18
1504	15.875	2	4.76



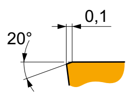
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.





U F

AFFN edge preperation, zero rake angle geometry for light to medium machining.



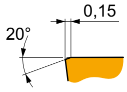
U S

AFSN edge preperation, zero rake angle geometry for medium to heavy machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEEN 1203AFFN	M8330	–	■ 270	0.15	2.0	◩ 160	0.14	2.0	◩ 255	0.15	2.0	–	–	–	–	–	–	–	–	–
	M8340	–	■ 245	0.15	2.0	◩ 145	0.14	2.0	◩ 230	0.15	2.0	–	–	–	–	–	–	–	–	–
SEEN 1203AFSN	8215	–	■ 255	0.20	2.0	–	–	–	■ 240	0.20	2.0	–	–	–	–	–	–	◩ 50	0.15	1.0
	M8330	–	■ 255	0.20	2.0	–	–	–	■ 240	0.20	2.0	–	–	–	–	–	–	◩ 50	0.15	1.0
	M8340	–	■ 230	0.20	2.0	–	–	–	◩ 215	0.20	2.0	–	–	–	–	–	–	–	–	–
	M9315	–	■ 340	0.20	2.0	–	–	–	■ 320	0.20	2.0	–	–	–	–	–	–	◩ 65	0.15	1.0
	M9325	–	■ 315	0.20	2.0	–	–	–	■ 295	0.20	2.0	–	–	–	–	–	–	◩ 60	0.15	1.0
	M9340	–	■ 285	0.20	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	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEEN 1504AFSN	**M8330**	–	■ 240	0.20	3.0	–	–	–	■ 225	0.20	3.0	–	–	–	–	–	–	◩ 45	0.15	1.0
	M8340	–	■ 225	0.20	3.0	–	–	–	◩ 210	0.20	3.0	–	–	–	–	–	–	–	–	–
	M9315	–	■ 320	0.20	3.0	–	–	–	■ 300	0.20	3.0	–	–	–	–	–	–	◩ 60	0.15	1.0
	M9325	–	■ 300	0.20	3.0	–	–	–	■ 285	0.20	3.0	–	–	–	–	–	–	◩ 60	0.15	1.0

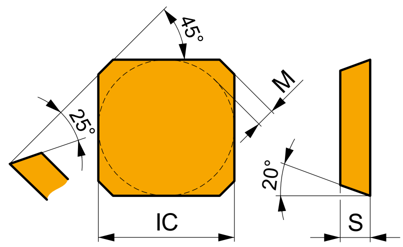


AFSN edge preperation, zero rake angle geometry for medium to heavy machining.

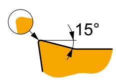
SEER

PRAMET

	IC [mm]	M [mm]	S [mm]
1203	12.700	2	3.18
1204	12.700	2	4.76
1504	15.875	2	4.76

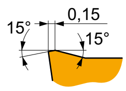


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.



AFEN edge preperation, chipbreaker geometry for medium to heavy machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEER 1203AFEN	**M8330**	–	■ 265	0.24	2.5	■ 155	0.22	2.5	◩ 250	0.24	2.5	–	–	–	◩ 65	0.22	2.0	–	–	–
	M8340	–	■ 245	0.24	2.5	■ 145	0.22	2.5	◩ 230	0.24	2.5	–	–	–	◩ 60	0.22	2.0	–	–	–
SEER 1504AFEN	**M8330**	–	■ 250	0.27	3.5	■ 150	0.24	3.5	◩ 235	0.27	3.5	–	–	–	◩ 60	0.24	2.8	–	–	–



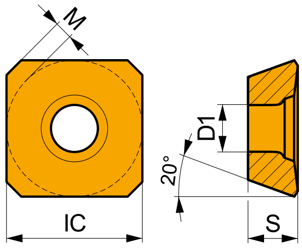
AFSN edge preperation, chipbreaker geometry for medium to heavy machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEER 1203AFSN	**M8330**	–	■ 265	0.25	2.5	◩ 155	0.23	2.5	■ 250	0.25	2.5	–	–	–	◩ 65	0.20	2.0	–	–	–
	M8340	–	■ 240	0.25	2.5	◩ 140	0.23	2.5	◩ 225	0.25	2.5	–	–	–	◩ 60	0.20	2.0	–	–	–
	M9325	–	■ 315	0.25	2.5	–	–	–	■ 295	0.25	2.5	–	–	–	–	–	–	–	–	–
	M9340	–	■ 285	0.25	2.5	◩ 170	0.23	2.5	–	–	–	–	–	–	◩ 70	0.20	2.0	–	–	–
SEER 1204AFSN	**M8330**	–	■ 265	0.25	2.5	◩ 155	0.23	2.5	■ 250	0.25	2.5	–	–	–	◩ 65	0.20	2.0	–	–	–
SEER 1504AFSN	**M8330**	–	■ 255	0.25	3.5	◩ 150	0.23	3.5	■ 240	0.25	3.5	–	–	–	◩ 60	0.20	2.8	–	–	–
	M8340	–	■ 230	0.25	3.5	◩ 135	0.23	3.5	◩ 215	0.25	3.5	–	–	–	◩ 55	0.20	2.8	–	–	–
	M9325	–	■ 305	0.25	3.5	–	–	–	■ 285	0.25	3.5	–	–	–	–	–	–	–	–	–

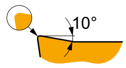
SEET 12

PRAMET

	IC [mm]	D1 [mm]	M [mm]	S [mm]
1204	12.700	5.50	2	4.76

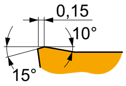


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

AFEN edge preperation, positive all purpose geometry.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEET 1204AFEN	**M8330**	–	■ 265	0.24	2.5	■ 155	0.22	2.5	◩ 250	0.24	2.5	–	–	–	◩ 65	0.22	2.0	–	–	–

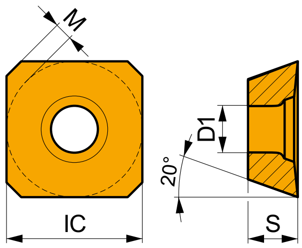
AFSN edge preperation, positive all purpose geometry.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEET 1204AFSN	**8215**	–	■ 265	0.23	2.5	◩ 155	0.21	2.5	■ 250	0.23	2.5	–	–	–	◩ 65	0.21	2.0	–	–	–
	M8330	–	■ 265	0.24	2.5	◩ 155	0.22	2.5	■ 250	0.24	2.5	–	–	–	◩ 65	0.22	2.0	–	–	–
	M8340	–	■ 240	0.25	2.5	◩ 140	0.23	2.5	◩ 225	0.25	2.5	–	–	–	◩ 60	0.23	2.0	–	–	–
	M9325	–	■ 340	0.20	2.5	–	–	–	■ 320	0.20	2.5	–	–	–	–	–	–	–	–	–
	M9340	–	■ 290	0.23	2.5	◩ 170	0.21	2.5	–	–	–	–	–	–	◩ 70	0.21	2.0	–	–	–

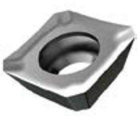
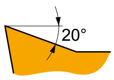
SEET 12-FA

PRAMET

	IC [mm]	D1 [mm]	M [mm]	S [mm]
1204	12.700	5.50	2	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.

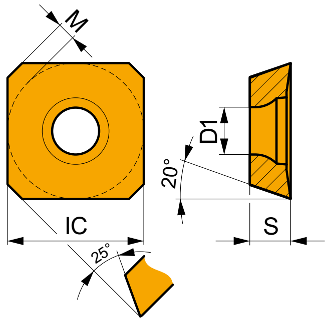
FA geometry with highly positive design for fine-finish to medium machining.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEET 1204AFFN-FA	**HF7**	–	–	–	–	–	–	–	–	–	–	■ 330	0.18	3.0	–	–	–	–	–	–
	M0315	–	–	–	–	–	–	–	–	–	–	■ 780	0.18	3.0	–	–	–	–	–	–

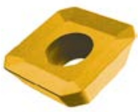
SEET 12-PM

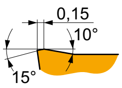
PRAMET

	IC [mm]	D1 [mm]	M [mm]	S [mm]
12T3	13.400	4.20	2	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.





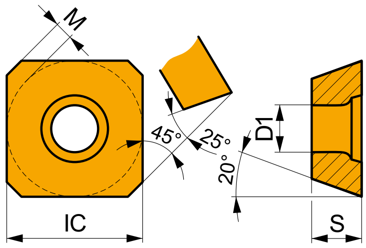
PM geometry with positive all purpose design.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEET 12T3M-PM	**M8330**	–	■ 265	0.25	2.0	◩ 155	0.23	2.0	■ 250	0.25	2.0	–	–	–	◩ 65	0.20	1.6	–	–	–
	M8340	–	■ 245	0.25	2.0	◩ 145	0.23	2.0	◩ 230	0.25	2.0	–	–	–	◩ 60	0.20	1.6	–	–	–
	M9325	–	■ 325	0.25	2.0	–	–	–	■ 305	0.25	2.0	–	–	–	–	–	–	–	–	–
	M9340	–	■ 290	0.25	2.0	◩ 170	0.23	2.0	–	–	–	–	–	–	◩ 70	0.20	1.6	–	–	–

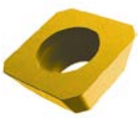
SEEW 12

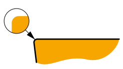
PRAMET

	IC [mm]	D1 [mm]	M [mm]	S [mm]
1204	12.700	5.50	2	4.76

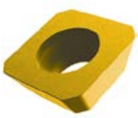


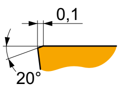
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.





AFEN edge preperation with zero rake angle geometry for light to medium machining.





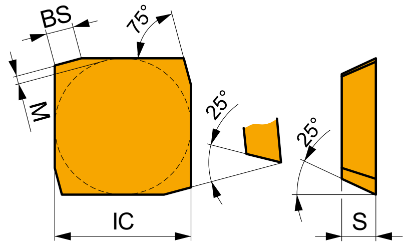
AFSN edge preperation with zero rake angle geometry for light to medium machining.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SEEW 1204AFEN	**M8330**	–	◩ 265	0.15	2.5	–	–	–	◩ 250	0.15	2.5	–	–	–	–	–	–	–	–	–
	M8340	–	◩ 240	0.15	2.5	–	–	–	◩ 225	0.15	2.5	–	–	–	–	–	–	–	–	–
SEEW 1204AFSN	**8215**	–	◩ 250	0.20	2.5	–	–	–	■ 235	0.20	2.5	–	–	–	–	–	–	◩ 50	0.15	1.0
	M8330	–	◩ 245	0.20	2.5	–	–	–	■ 230	0.20	2.5	–	–	–	–	–	–	◩ 45	0.15	1.0
	M8340	–	◩ 225	0.20	2.5	–	–	–	◩ 210	0.20	2.5	–	–	–	–	–	–	–	–	–
	M9325	–	◩ 305	0.20	2.5	–	–	–	■ 285	0.20	2.5	–	–	–	–	–	–	◩ 60	0.15	1.0

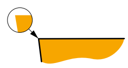
SFCN

PRAMET

	IC [mm]	M [mm]	S [mm]	BS [mm]
1203	12.700	1	3.18	2.00



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

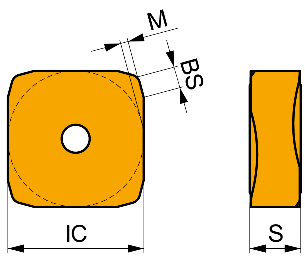

Positive design for light to medium machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SFCN 1203EFFR	**H10**	–	–	–	–	–	–	–	–	–	–	■ 405	0.12	3.0	–	–	–	–	–	–
	M0315	–	–	–	–	–	–	–	–	–	–	■ 765	0.12	3.0	–	–	–	–	–	–

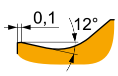
SNHF

PRAMET

	BS [mm]	IC [mm]	M [mm]	S [mm]
1204	2.00	12.700	1	4.76
1504	1.40	15.875	1	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.

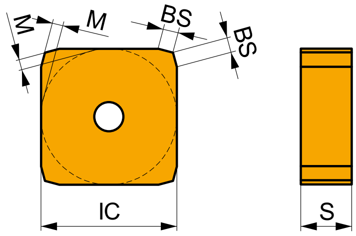
M geometry with positive design for light to medium machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SNHF 1204ENSR-M	**M8330**	–	■ 235	0.15	4.0	–	–	–	◪ 220	0.15	4.0	–	–	–	–	–	–	–	–	–
	M8340	–	■ 230	0.15	4.0	–	–	–	◪ 215	0.15	4.0	–	–	–	–	–	–	–	–	–
SNHF 1504ENSR-M	**M8330**	–	■ 225	0.15	6.0	–	–	–	◪ 210	0.15	6.0	–	–	–	–	–	–	–	–	–
	M8340	–	■ 220	0.15	6.0	–	–	–	◪ 205	0.15	6.0	–	–	–	–	–	–	–	–	–

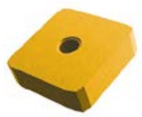
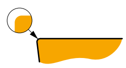
SNHN

PRAMET

	BS [mm]	IC [mm]	M [mm]	S [mm]
1204	1.40	12.700	1	4.76
1504	1.40	15.875	1	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.

U E

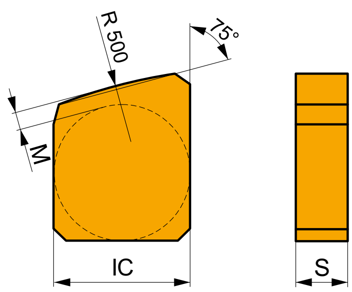
Standard negative milling geometry for 75° face milling.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SNHN 1204ENEN	**8215**	–	◩ 275	0.15	6.0	–	–	–	■ 260	0.15	6.0	–	–	–	–	–	–	◩ 55	0.15	1.0
	M8330	–	◩ 270	0.15	6.0	–	–	–	■ 255	0.15	6.0	–	–	–	–	–	–	◩ 50	0.15	1.0
	M8340	–	◩ 245	0.15	6.0	–	–	–	◩ 230	0.15	6.0	–	–	–	–	–	–	–	–	–
	M9325	–	◩ 340	0.15	6.0	–	–	–	■ 320	0.15	6.0	–	–	–	–	–	–	◩ 65	0.15	1.0
	S26	–	◩ 110	0.15	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNHN 1504ENEN	**8215**	–	◩ 260	0.15	9.0	–	–	–	■ 245	0.15	9.0	–	–	–	–	–	–	◩ 50	0.15	1.0
	M8330	–	◩ 260	0.15	9.0	–	–	–	■ 245	0.15	9.0	–	–	–	–	–	–	◩ 50	0.15	1.0
	M8340	–	◩ 235	0.15	9.0	–	–	–	◩ 220	0.15	9.0	–	–	–	–	–	–	–	–	–
	S26	–	◩ 105	0.15	9.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

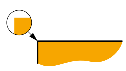
SNKX

PRAMET

	IC [mm]	M [mm]	S [mm]
1204	12.700	1	4.76
1504	15.875	1	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.

W F

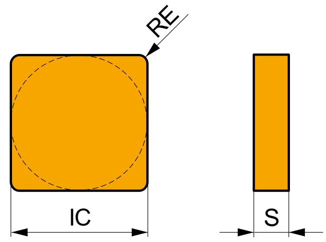
Standard negative wiper geometry for 75° face milling.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SNKX 1204ENFN	**H10**	–	–	–	–	–	–	–	■ 115	0.15	6.0	–	–	–	–	–	–	–	–	–
SNKX 1504ENFN	**H10**	–	–	–	–	–	–	–	■ 110	0.15	9.0	–	–	–	–	–	–	–	–	–

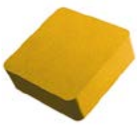
SNUN

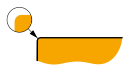
PRAMET

	IC [mm]	S [mm]
1204	12.700	4.76
1504	15.875	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.





E

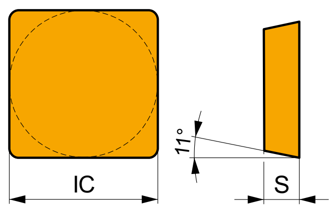
Negative geometry milling insert, can also be used for turning.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SNUN 120408	**M8330**	0.8	◩ 260	0.13	4.5	–	–	–	■ 245	0.13	4.5	–	–	–	–	–	–	◩ 50	0.15	1.0
SNUN 120412	**M8330**	1.2	◩ 275	0.13	4.5	–	–	–	■ 260	0.13	4.5	–	–	–	–	–	–	◩ 55	0.15	1.0
	S26	1.2	◩ 110	0.13	4.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNUN 150412	**M8330**	1.2	◩ 255	0.15	6.0	–	–	–	■ 240	0.15	6.0	–	–	–	–	–	–	◩ 50	0.15	1.0

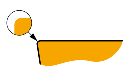
SPGN

PRAMET

	IC [mm]	S [mm]
0903	9.525	3.18
1203	12.700	3.18
1504	15.875	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.



E

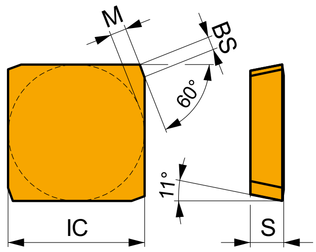
Zero rake angle design milling insert, can also be used for turning.

Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPGN 090308	**M8340**	0.8	■ 225	0.15	2.0	–	–	–	◩ 210	0.15	2.0	–	–	–	–	–	–	–	–	–
SPGN 120304	**M8330**	0.4	■ 195	0.15	4.0	–	–	–	■ 185	0.15	4.0	–	–	–	–	–	–	–	–	–
	M8340	0.4	■ 175	0.15	4.0	–	–	–	◩ 165	0.15	4.0	–	–	–	–	–	–	–	–	–
SPGN 120308	**M8330**	0.8	■ 230	0.15	4.0	–	–	–	■ 215	0.15	4.0	–	–	–	–	–	–	–	–	–
SPGN 150412	**M8330**	1.2	■ 225	0.20	5.0	–	–	–	◩ 210	0.20	5.0	–	–	–	–	–	–	–	–	–

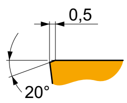
PRAMET

SPGN 25 DZ

	IC [mm]	M [mm]	S [mm]	BS [mm]
2506	25.000	3	6.35	2.40



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

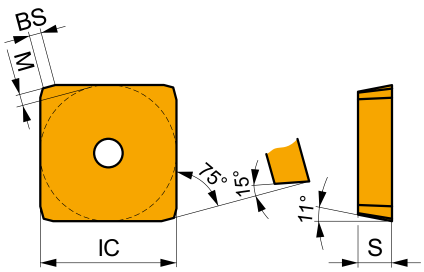
DZ geometry with zero rake angle design for heavy machining.

Product		RE [mm]		P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]		K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPGN 2506DZSR	M8326	–	◪	110	0.50	12.0	–	–	–	◪	100	0.50	12.0	–	–	–	–	–	–	–	–	–
	M8346	–	■	90	0.50	12.0	–	–	–		–	–	–	–	–	–	–	–	–	–	–	–

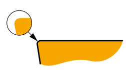
PRAMET

SPKN

	IC [mm]	M [mm]	S [mm]	BS [mm]
1203	12.700	1	3.18	1.60
1504	15.875	1	4.76	1.70

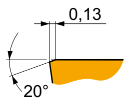


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

EDER edge preperation with zero rake angle geometry for light to medium machining.

Product		RE [mm]		P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]		K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]		H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPKN 1203EDER	H10	–		–	–	–	–	–	–	■	110	0.15	4.0	–	–	–	–	–	–		–	–	–
	M8330	–	■	255	0.15	4.0	–	–	–	■	240	0.15	4.0	–	–	–	–	–	–		–	–	–
	M8340	–	■	230	0.15	4.0	–	–	–	◪	215	0.15	4.0	–	–	–	–	–	–		–	–	–
SPKN 1504EDER	H10	–		–	–	–	–	–	–	◪	100	0.20	5.0	–	–	–	–	–	–		–	–	–
	M8330	–	■	235	0.20	5.0	–	–	–	◪	220	0.20	5.0	–	–	–	–	–	–		–	–	–
	M8340	–	■	210	0.20	5.0	–	–	–	◪	195	0.20	5.0	–	–	–	–	–	–		–	–	–

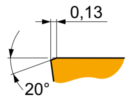



EDSR edge preperation with zero rake angle geometry for medium machining.

Product		RE [mm]		P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]		K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]		H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPKN 1203EDSL	M8330	–	◪	240	0.20	4.0	–	–	–	■	225	0.20	4.0	–	–	–	–	–	–	◪	45	0.15	1.0

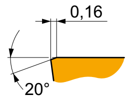
⏮

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



EDSR edge preperation with zero rake angle geometry for medium machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPKN 1203EDSR	8215	–	◩ 240	0.20	4.0	–	–	–	■ 225	0.20	4.0	–	–	–	–	–	–	◩ 45	0.15	1.0
	H10	–	–	–	–	–	–	–	■ 100	0.20	4.0	–	–	–	–	–	–	–	–	–
	M8330	–	◩ 240	0.20	4.0	–	–	–	■ 225	0.20	4.0	–	–	–	–	–	–	◩ 45	0.15	1.0
	M8340	–	◩ 215	0.20	4.0	–	–	–	◩ 200	0.20	4.0	–	–	–	–	–	–	–	–	–
	M9325	–	◩ 290	0.20	4.0	–	–	–	■ 275	0.20	4.0	–	–	–	–	–	–	◩ 55	0.15	1.0
	S26	–	◩ 95	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



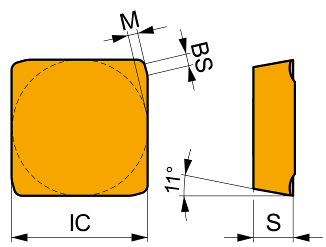
EDSR (right-hand cut) / EDSL (left-hand cut) edge preperation with zero rake angle geometry for medium machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPKN 1504EDSL	M8340	–	◩ 205	0.25	5.0	–	–	–	◩ 190	0.25	5.0	–	–	–	–	–	–	–	–	–
SPKN 1504EDSR	8215	–	◩ 220	0.25	5.0	–	–	–	◩ 205	0.25	5.0	–	–	–	–	–	–	◩ 40	0.15	1.0
	H10	–	–	–	–	–	–	–	◩ 95	0.25	5.0	–	–	–	–	–	–	–	–	–
	M8330	–	◩ 220	0.25	5.0	–	–	–	◩ 205	0.25	5.0	–	–	–	–	–	–	◩ 40	0.15	1.0
	M8340	–	◩ 205	0.25	5.0	–	–	–	◩ 190	0.25	5.0	–	–	–	–	–	–	–	–	–
	M9315	–	◩ 285	0.25	5.0	–	–	–	◩ 270	0.25	5.0	–	–	–	–	–	–	◩ 55	0.15	1.0
	M9325	–	◩ 270	0.25	5.0	–	–	–	◩ 255	0.25	5.0	–	–	–	–	–	–	◩ 50	0.15	1.0
	S26	–	◩ 90	0.25	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

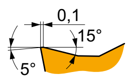
SPKR

PRAMET

	IC [mm]	L [mm]	M [mm]	S [mm]
1203	12.700	12.70	1	3.18
1504	15.875	15.88	1	4.76

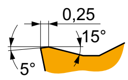


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.



EDSR edge preperation, chipbreaker geometry for medium to heavy machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPKR 1203EDSR	M8330	–	■ 265	0.20	4.0	◩ 155	0.18	4.0	■ 250	0.20	4.0	–	–	–	–	–	–	–	–	–
	M8340	–	■ 240	0.20	4.0	◩ 140	0.18	4.0	◩ 225	0.20	4.0	–	–	–	–	–	–	–	–	–
	M9340	–	■ 295	0.20	4.0	◩ 175	0.18	4.0	–	–	–	–	–	–	–	–	–	–	–	–



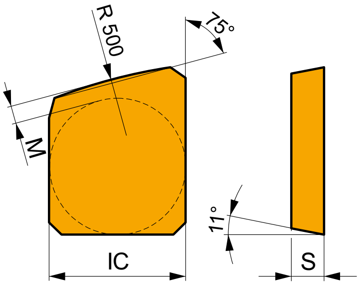
EDSR edge preperation, chipbreaker geometry for medium to heavy machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPKR 1504EDSR	M8330	–	■ 245	0.25	5.0	◩ 145	0.25	5.0	■ 230	0.25	5.0	–	–	–	–	–	–	–	–	–
	M8340	–	■ 225	0.25	5.0	◩ 135	0.25	5.0	◩ 210	0.25	5.0	–	–	–	–	–	–	–	–	–

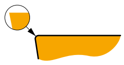
SPKX

PRAMET

	IC	M	S
	[mm]	[mm]	[mm]
1203	12.700	1	3.18
1504	15.875	1	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.

W F

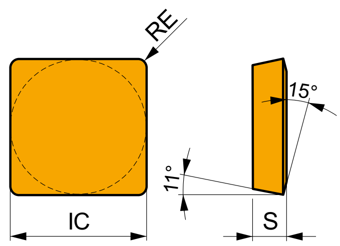
Zero rake wiper geomerty for improved surface finish

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPKX 1203EDFR	**H10**	–	–	–	–	–	–	–	■ 100	0.20	4.0	–	–	–	–	–	–	–	–	–
SPKX 1504EDFR	**H10**	–	–	–	–	–	–	–	■ 95	0.25	5.0	–	–	–	–	–	–	–	–	–

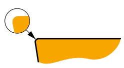
SPUN

PRAMET

	IC	S
	[mm]	[mm]
1203	12.700	3.18
1504	15.875	4.76
1904	19.050	4.76
2506	25.400	6.35



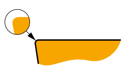
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

E

Zero rake geometry milling insert, can also be used for turning.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPUN 120304	**M8330**	0.4	■ 195	0.15	4.0	–	–	–	◩ 185	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 120308	**H10**	0.8	–	–	–	–	–	–	◩ 95	0.15	4.0	–	–	–	–	–	–	–	–	–
	M8330	0.8	■ 230	0.15	4.0	–	–	–	◩ 215	0.15	4.0	–	–	–	–	–	–	–	–	–
	S26	0.8	■ 95	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SPUN 120312	**M8330**	1.2	■ 245	0.15	4.0	–	–	–	◩ 230	0.15	4.0	–	–	–	–	–	–	–	–	–

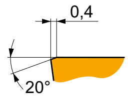
E

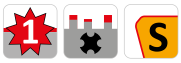
Zero rake geometry milling insert, can also be used for turning.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
SPUN 150412	**M8330**	1.2	■ 225	0.20	5.0	–	–	–	◩ 210	0.20	5.0	–	–	–	–	–	–	–	–	–
SPUN 190408	**M8330**	0.8	■ 210	0.20	6.0	–	–	–	◩ 195	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190412	**M8330**	1.2	■ 220	0.20	6.0	–	–	–	◩ 205	0.20	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/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]
SPUN 250616S	**M8326**	1.6	◩	115	0.40	12.0		–	–	–	◩	105	0.40	12.0		–	–	–		–	–	–		–	–	–
SPUN 250620S	**M5326**	2.0	◩	145	0.40	12.0		–	–	–	◩	135	0.40	12.0		–	–	–		–	–	–		–	–	–
	M8326	2.0	◩	120	0.40	12.0		–	–	–	◩	110	0.40	12.0		–	–	–		–	–	–		–	–	–
	M8346	2.0	■	100	0.40	12.0		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–
	S26	2.0	■	45	0.40	12.0		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–



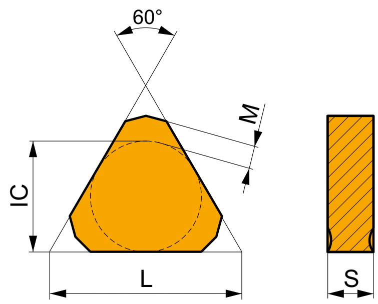


Zero rake geometry milling insert, can also be used for turning.

TNJF

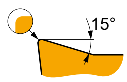
PRAMET

	IC [mm]	L [mm]	M [mm]	S [mm]
1204	12.700	22.00	2	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/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]		vc [m/min]	f [mm/tooth]	ap [mm]
TNJF 1204ANEN	**M8330**	–	■	270	0.15	4.0	◩	160	0.14	4.0	◩	255	0.15	4.0		–	–	–		–	–	–		–	–	–

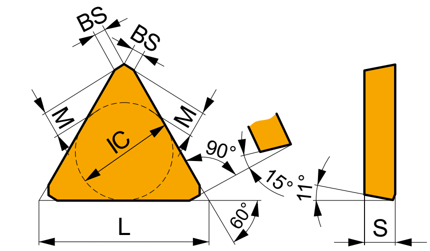


Positive rake angle with chip breaking geometry.

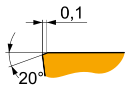
TPCN 16

PRAMET

	BS [mm]	IC [mm]	L [mm]	M [mm]	S [mm]
1603	1.20	9.530	16.10	2	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.



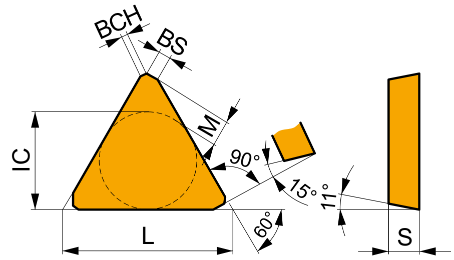
Special design for disc milling.

Product	Grade	RE [mm]	P	vc [m/min]	f [mm/tooth]	ap [mm]	M	vc [m/min]	f [mm/tooth]	ap [mm]	K	vc [m/min]	f [mm/tooth]	ap [mm]	N	vc [m/min]	f [mm/tooth]	ap [mm]	S	vc [m/min]	f [mm/tooth]	ap [mm]	H	vc [m/min]	f [mm/tooth]	ap [mm]
TPCN 1603PDSN	M8330	–	■	195	0.20	–		–	–	–	■	185	0.20	–		–	–	–		–	–	–		–	–	–
	M8340	–	■	175	0.20	–		–	–	–	◩	165	0.20	–		–	–	–		–	–	–		–	–	–

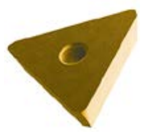
TPKN

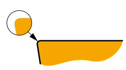
PRAMET

	IC [mm]	L [mm]	M [mm]	S [mm]	BCH [mm]	BS [mm]
1603	9.530	16.50	2	3.18	1.20	1.30
2204	12.700	22.00	4	4.76	1.20	1.50



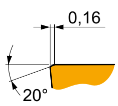
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.





PDER edge preperation, zero rake angle geometry for light to medium machining.

Product	Grade	RE [mm]	P	vc [m/min]	f [mm/tooth]	ap [mm]	M	vc [m/min]	f [mm/tooth]	ap [mm]	K	vc [m/min]	f [mm/tooth]	ap [mm]	N	vc [m/min]	f [mm/tooth]	ap [mm]	S	vc [m/min]	f [mm/tooth]	ap [mm]	H	vc [m/min]	f [mm/tooth]	ap [mm]
TPKN 1603PDER	M8330	–	◩	195	0.15	4.0		–	–	–	◩	185	0.15	4.0		–	–	–		–	–	–		–	–	–
	M8340	–	◩	175	0.15	4.0		–	–	–	◩	165	0.15	4.0		–	–	–		–	–	–		–	–	–
TPKN 2204PDER	8215	–	◩	190	0.15	5.5		–	–	–	◩	180	0.15	5.5		–	–	–		–	–	–		–	–	–
	M8330	–	◩	190	0.15	5.5		–	–	–	◩	180	0.15	5.5		–	–	–		–	–	–		–	–	–
	M8340	–	◩	170	0.15	5.5		–	–	–	◩	160	0.15	5.5		–	–	–		–	–	–		–	–	–

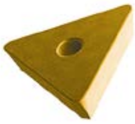


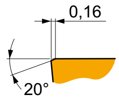
PDSR edge preperation, zero rake angle geometry for medium machining.

Product	Grade	RE [mm]	P	vc [m/min]	f [mm/tooth]	ap [mm]	M	vc [m/min]	f [mm/tooth]	ap [mm]	K	vc [m/min]	f [mm/tooth]	ap [mm]	N	vc [m/min]	f [mm/tooth]	ap [mm]	S	vc [m/min]	f [mm/tooth]	ap [mm]	H	vc [m/min]	f [mm/tooth]	ap [mm]
TPKN 1603PDSR	M8330	–	◩	185	0.20	4.0		–	–	–	◩	175	0.20	4.0		–	–	–		–	–	–	◩	35	0.15	1.0
	M8340	–	◩	165	0.20	4.0		–	–	–	◩	155	0.20	4.0		–	–	–		–	–	–		–	–	–
	S26	–	◩	75	0.20	4.0		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–

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/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
TPKN 2204PDSR	**H10**	–	–	–	–	–	–	–	◩ 80	0.20	5.5	–	–	–	–	–	–	–	–	–
	M5315	–	◩ 235	0.20	5.5	–	–	–	◩ 220	0.20	5.5	–	–	–	–	–	–	◩ 45	0.15	1.0
	M8310	–	◩ 195	0.20	5.5	–	–	–	◩ 185	0.20	5.5	–	–	–	–	–	–	◩ 35	0.15	1.0
	M8330	–	◩ 175	0.20	5.5	–	–	–	◩ 165	0.20	5.5	–	–	–	–	–	–	◩ 35	0.15	1.0
	M8340	–	◩ 160	0.20	5.5	–	–	–	◩ 150	0.20	5.5	–	–	–	–	–	–	–	–	–
	M9325	–	◩ 220	0.20	5.5	–	–	–	◩ 205	0.20	5.5	–	–	–	–	–	–	◩ 40	0.15	1.0
	S26	–	◩ 75	0.20	5.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



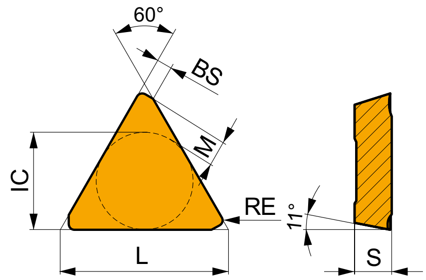


PDSR edge preperation, zero rake angle geometry for medium machining.

TPKR

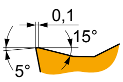
PRAMET

	IC [mm]	L [mm]	M [mm]	S [mm]	BS [mm]
1603	9.530	16.50	2	3.18	1.40
2204	12.700	22.00	4	4.76	1.40



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

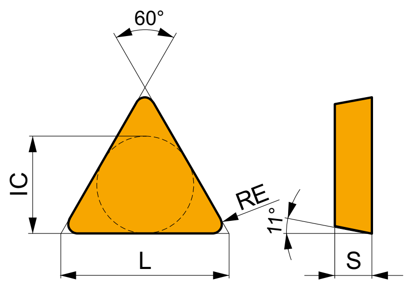
Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
TPKR 1603PDSR	**M8330**	–	■ 185	0.20	4.0	◩ 110	0.18	4.0	■ 175	0.20	4.0	–	–	–	–	–	–	–	–	–
	M8340	–	■ 165	0.20	4.0	◩ 95	0.18	4.0	◩ 155	0.20	4.0	–	–	–	–	–	–	–	–	–
TPKR 2204PDSR	**M8330**	–	■ 175	0.20	5.5	◩ 105	0.18	5.5	■ 165	0.20	5.5	–	–	–	–	–	–	–	–	–
	M8340	–	■ 160	0.20	5.5	◩ 95	0.18	5.5	◩ 150	0.20	5.5	–	–	–	–	–	–	–	–	–
	M9325	–	■ 220	0.20	5.5	–	–	–	■ 205	0.20	5.5	–	–	–	–	–	–	–	–	–
	M9340	–	■ 195	0.20	5.5	◩ 115	0.18	5.5	–	–	–	–	–	–	–	–	–	–	–	–



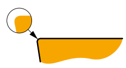
PDSR edge preperation, chipbreaker geometry for medium to heavy machining.

TPUN

	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



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



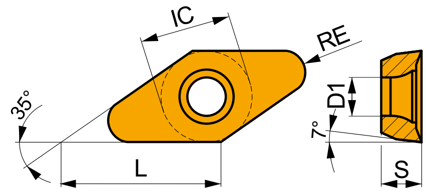
Zero rake geometry milling insert, can also be used for turning.

Product	Grade	RE [mm]	P	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H	H vc [m/min]	H f [mm/tooth]	H ap [mm]
TPUN 110304	H10	0.4		–	–	–	–	–	–	◩	90	0.10	0.8	–	–	–	–	–	–		–	–	–
	M8330	0.4		–	–	–	–	–	–	■	150	0.10	1.2	–	–	–	–	–	–	◩	30	0.15	1.0
TPUN 110308	M8330	0.8		–	–	–	–	–	–	■	155	0.18	1.2	–	–	–	–	–	–	◩	30	0.15	1.0
TPUN 160304	8215	0.4	◩	155	0.15	4.0	–	–	–	◩	145	0.15	4.0	–	–	–	–	–	–		–	–	–
	H10	0.4		–	–	–	–	–	–	◩	65	0.15	4.0	–	–	–	–	–	–		–	–	–
	M8330	0.4	◩	155	0.15	4.0	–	–	–	◩	145	0.15	4.0	–	–	–	–	–	–		–	–	–
	S26	0.4	◩	65	0.15	4.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
TPUN 160308	8215	0.8	◩	185	0.15	4.0	–	–	–	◩	175	0.15	4.0	–	–	–	–	–	–		–	–	–
	H10	0.8		–	–	–	–	–	–	◩	80	0.15	4.0	–	–	–	–	–	–		–	–	–
	M8330	0.8		–	–	–	–	–	–	■	155	0.18	1.5	–	–	–	–	–	–	◩	30	0.15	1.0
	S26	0.8	◩	75	0.15	4.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
TPUN 160312	M8330	1.2		–	–	–	–	–	–	■	155	0.20	1.5	–	–	–	–	–	–	◩	30	0.15	1.0
TPUN 220408	8215	0.8	◩	170	0.20	5.0	–	–	–	◩	160	0.20	5.0	–	–	–	–	–	–		–	–	–
	M8330	0.8	◩	170	0.20	5.0	–	–	–	◩	160	0.20	5.0	–	–	–	–	–	–		–	–	–
	S26	0.8	◩	70	0.20	5.0	–	–	–		–	–	–	–	–	–	–	–	–		–	–	–
TPUN 220412	M8330	1.2		–	–	–	–	–	–	■	155	0.20	2.0	–	–	–	–	–	–	◩	30	0.15	1.0

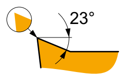
VCGT 22-FA

PRAMET

	IC [mm]	D1 [mm]	L [mm]	S [mm]
2205	12.700	5.20	22.00	5.50



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



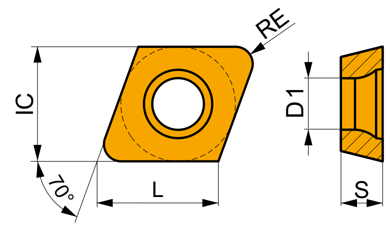
FA geometry with highly positive design for medium to rough machining.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
VCGT 220515F-FA	**HF7**	1.5	–	–	–	–	–	–	–	–	–	■ 255	0.24	0.4	–	–	–	–	–	–
VCGT 220520F-FA	**HF7**	2.0	–	–	–	–	–	–	–	–	–	■ 255	0.30	0.5	–	–	–	–	–	–
VCGT 220530F-FA	**HF7**	3.0	–	–	–	–	–	–	–	–	–	■ 210	0.48	1.0	–	–	–	–	–	–

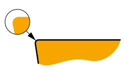
XDHW

PRAMET

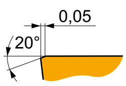
	IC [mm]	D1 [mm]	L [mm]	S [mm]
0702	6.500	2.95	6.90	2.38
10T3	10.000	3.95	10.60	3.97



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



EN geometry with zero rake angle design for slot milling.



SN geometry with zero rake angle design for slot milling.

Product	Grade	RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
XDHW 070210EN	**M8310**	1.0	◪ 310	0.10	1.0	–	–	–	■ 290	0.10	1.0	–	–	–	–	–	–	■ 60	0.15	1.0
XDHW 070210SN	**M8310**	1.0	◪ 310	0.10	1.0	–	–	–	■ 290	0.10	1.0	–	–	–	–	–	–	■ 60	0.15	1.0
	M8325	1.0	◪ 230	0.10	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
XDHW 10T310SN	**M8310**	1.0	◪ 275	0.15	1.0	–	–	–	■ 260	0.15	1.0	–	–	–	–	–	–	■ 55	0.15	1.0
	M8325	1.0	◪ 210	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–