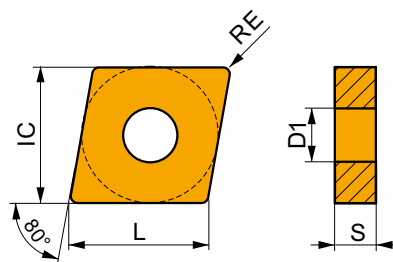




CNGA CER

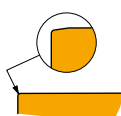
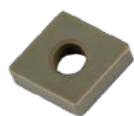


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76



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

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



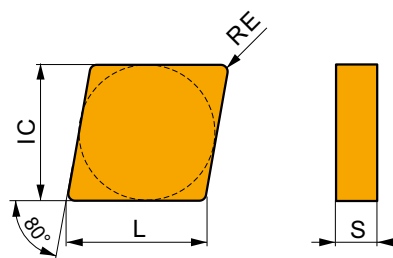
For machining with high speeds and continuous cuts.

CNGA 120404 T02020	TC100	0.4	—	—	—	—	—	—	590	0.10	2.0	—	—	—	—	—	—	—	—
CNGA 120408 T01020	TC100	0.8	—	—	—	—	—	—	550	0.20	2.0	—	—	—	—	—	—	—	—
CNGA 120412 T01020	TC100	1.2	—	—	—	—	—	—	540	0.25	2.0	—	—	—	—	—	—	—	—

CNGN CER

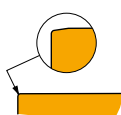


	IC	L	S
	[mm]	[mm]	[mm]
1204	12.700	12.90	4.76
1207	12.700	12.90	7.94



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

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



For machining with high speeds and continuous cuts.

CNGN 120408 T01020	TC100	0.8	—	—	—	—	—	—	550	0.20	2.0	—	—	—	—	—	—	—	—
CNGN 120708 T01020	TC100	0.8	—	—	—	—	—	—	550	0.20	2.0	—	—	—	—	—	—	—	—
CNGN 120712 T01020	TC100	1.2	—	—	—	—	—	—	540	0.25	2.0	—	—	—	—	—	—	—	—