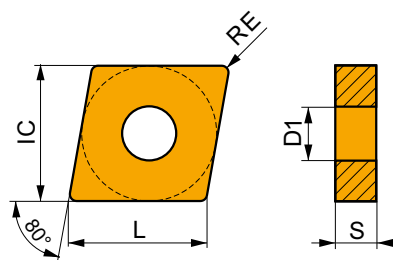




CNGG

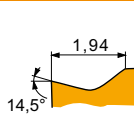


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76



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]



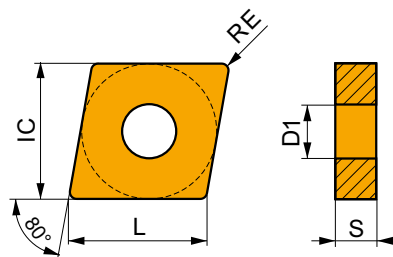
SF geometry with positive design for fine-finish machining of thin walls in continuous cuts.

CNGG 120402E-SF	H07	0.2	—	—	—	105	0.09	1.0	165	0.10	1.0	525	0.12	1.0	50	0.08	0.8	—	—	—
	T6310	0.2	195	0.10	1.0	140	0.09	1.0	155	0.10	1.0	585	0.12	1.0	55	0.08	0.8	35	0.15	1.0
	T8315	0.2	205	0.10	1.0	120	0.09	1.0	190	0.10	1.0	615	0.12	1.0	50	0.08	0.8	40	0.15	1.0
	T8330	0.2	195	0.10	1.0	115	0.09	1.0	185	0.10	1.0	585	0.12	1.0	45	0.08	0.8	35	0.15	1.0
	T8430	0.2	240	0.10	1.0	130	0.09	1.0	195	0.10	1.0	660	0.12	1.0	50	0.08	0.8	40	0.15	1.0

CNMA

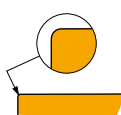
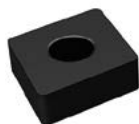


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



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]



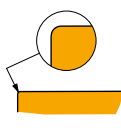
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMA 120404	T5305	0.4	—	—	—	—	—	—	235	0.10	4.0	—	—	—	—	—	—	50	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	200	0.10	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 120408	T5305	0.8	—	—	—	—	—	—	220	0.20	4.0	—	—	—	—	—	—	45	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	190	0.20	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 120412	T6310	0.8	—	—	—	—	—	—	100	0.20	4.0	—	—	—	—	—	—	25	0.15	1.0
	T5305	1.2	—	—	—	—	—	—	195	0.30	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 120416	T5315	1.2	—	—	—	—	—	—	180	0.30	4.0	—	—	—	—	—	—	35	0.15	1.0
	T6310	1.2	—	—	—	—	—	—	95	0.30	4.0	—	—	—	—	—	—	20	0.15	1.0
CNMA 120416	T5305	1.6	—	—	—	—	—	—	190	0.40	4.0	—	—	—	—	—	—	40	0.15	1.0
	T5315	1.6	—	—	—	—	—	—	170	0.40	4.0	—	—	—	—	—	—	35	0.15	1.0



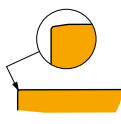
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[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 fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMA 160612	T5305	1.2	—	—	—	—	—	—	190	0.30	5.0	—	—	—	—	—	—	40	0.15	1.0
	T5315	1.2	—	—	—	—	—	—	175	0.30	5.0	—	—	—	—	—	—	35	0.15	1.0
	T6310	1.2	—	—	—	—	—	—	90	0.30	5.0	—	—	—	—	—	—	20	0.15	1.0
CNMA 160616	T5305	1.6	—	—	—	—	—	—	185	0.40	5.0	—	—	—	—	—	—	35	0.15	1.0
	T5315	1.6	—	—	—	—	—	—	165	0.40	5.0	—	—	—	—	—	—	35	0.15	1.0
CNMA 190612	T5305	1.2	—	—	—	—	—	—	190	0.30	6.0	—	—	—	—	—	—	40	0.15	1.0
	T5315	1.2	—	—	—	—	—	—	170	0.30	6.0	—	—	—	—	—	—	35	0.15	1.0
	T6310	1.2	—	—	—	—	—	—	85	0.30	6.0	—	—	—	—	—	—	20	0.15	1.0
CNMA 190616	T5305	1.6	—	—	—	—	—	—	180	0.40	6.0	—	—	—	—	—	—	35	0.15	1.0
	T5315	1.6	—	—	—	—	—	—	160	0.40	6.0	—	—	—	—	—	—	30	0.15	1.0



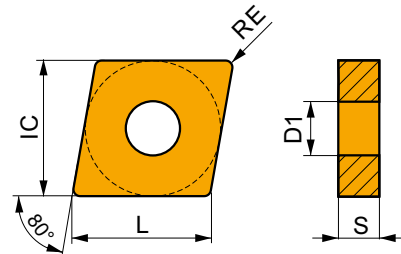
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMA 120408S	T5305	0.8	—	—	—	—	—	—	220	0.20	4.0	—	—	—	—	—	—	45	0.15	1.0
CNMA 120412S	T5305	1.2	—	—	—	—	—	—	190	0.40	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 160612S	T5305	1.2	—	—	—	—	—	—	190	0.30	5.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 190616S	T5305	1.6	—	—	—	—	—	—	180	0.40	6.0	—	—	—	—	—	—	35	0.15	1.0

CNMG

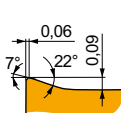
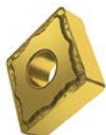


	IC [mm]	D1 [mm]	L [mm]	S [mm]
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.880	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



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

Product		RE [mm]	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[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]



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

CNMG 120404E-FF	T7325	0.4	235	0.12	1.0	180	0.11	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	—	—	—	—	—	—	—	—	—
CNMG 120408E-FF	T7325	0.8	265	0.15	1.0	205	0.14	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	245	0.15	1.0	145	0.14	1.0	230	0.15	1.0	—	—	—	—	—	—	—	—	—