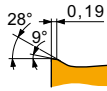


CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



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]



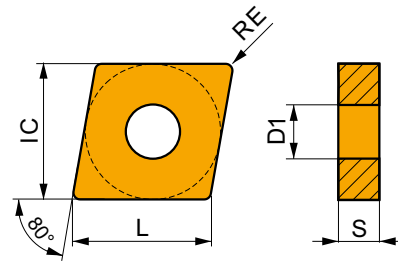
W-NM wiper geometry for finish to rough machining with increased feed rates and improved surface finish.

CNMG 120408W-NM	T7325	0.8	215	0.25	2.1	165	0.23	2.1	—	—	—	—	—	—	65	0.20	1.7	—	—	—
	T7335	0.8	210	0.25	2.1	160	0.23	2.1	—	—	—	—	—	—	65	0.20	1.7	—	—	—
	T9315	0.8	290	0.25	2.1	—	—	—	275	0.25	2.1	—	—	—	—	—	—	—	—	—
	T9325	0.8	260	0.25	2.1	155	0.23	2.1	245	0.25	2.1	—	—	—	55	0.20	1.7	—	—	—
CNMG 120412W-NM	T7325	1.2	215	0.30	2.1	165	0.27	2.1	—	—	—	—	—	—	65	0.24	1.7	—	—	—
	T7335	1.2	210	0.30	2.1	160	0.27	2.1	—	—	—	—	—	—	65	0.24	1.7	—	—	—
	T9315	1.2	285	0.30	2.1	—	—	—	270	0.30	2.1	—	—	—	—	—	—	—	—	—
	T9325	1.2	255	0.30	2.1	150	0.27	2.1	240	0.30	2.1	—	—	—	55	0.24	1.7	—	—	—

CNMM

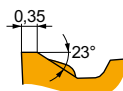


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



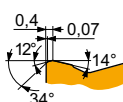
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



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

CNMM 160612E-DR	T9315	1.2	225	0.45	6.0	—	—	—	210	0.45	6.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	200	0.45	6.0	120	0.41	6.0	190	0.45	6.0	—	—	—	—	—	—	—	—	—
	T9335	1.2	170	0.45	6.0	100	0.41	6.0	—	—	—	—	—	—	—	—	—	—	—	—
CNMM 190608E-DR	T9315	0.8	215	0.40	8.0	—	—	—	200	0.40	8.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	190	0.40	8.0	110	0.36	8.0	180	0.40	8.0	—	—	—	—	—	—	—	—	—
CNMM 190612E-DR	T9315	1.2	220	0.45	8.0	—	—	—	205	0.45	8.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	195	0.45	8.0	115	0.41	8.0	185	0.45	8.0	—	—	—	—	—	—	—	—	—
	T9335	1.2	170	0.45	8.0	100	0.41	8.0	—	—	—	—	—	—	—	—	—	—	—	—
CNMM 190616E-DR	T9325	1.6	195	0.50	9.0	115	0.45	9.0	185	0.50	9.0	—	—	—	—	—	—	—	—	—
	T9335	1.6	170	0.50	9.0	100	0.45	9.0	—	—	—	—	—	—	—	—	—	—	—	—



HR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

CNMM 190616E-HR	6640	1.6	75	0.60	10.0	45	0.54	10.0	70	0.60	10.0	—	—	—	—	—	—	—	—	—
	T8345	1.6	55	0.60	10.0	30	0.54	10.0	50	0.60	10.0	—	—	—	—	—	—	—	—	—
	T9325	1.6	105	0.60	10.0	60	0.54	10.0	95	0.60	10.0	—	—	—	—	—	—	—	—	—
	T9335	1.6	80	0.60	10.0	45	0.54	10.0	—	—	—	—	—	—	—	—	—	—	—	—
CNMM 190624E-HR	T8345	2.4	60	0.65	10.0	35	0.59	10.0	55	0.65	10.0	—	—	—	—	—	—	—	—	—
	T9315	2.4	115	0.65	10.0	—	—	—	105	0.65	10.0	—	—	—	—	—	—	—	—	—
	T9325	2.4	100	0.65	10.0	60	0.59	10.0	95	0.65	10.0	—	—	—	—	—	—	—	—	—
	T9335	2.4	85	0.65	10.0	50	0.59	10.0	—	—	—	—	—	—	—	—	—	—	—	—



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

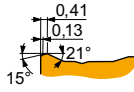
Product		RE [mm]	P			M			K			N			S			H			
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	
HR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																					
CNMM 250924E-HR	6640	2.4	■	75	0.65	14.0	■	45	0.59	14.0	■	70	0.65	14.0	—	—	—	—	—	—	
	T8345	2.4	■	55	0.65	14.0	■	30	0.59	14.0	■	50	0.65	14.0	—	—	—	—	—	—	
	T9315	2.4	■	110	0.65	14.0	—	—	—	■	100	0.65	14.0	—	—	—	—	—	—	—	
	T9325	2.4	■	100	0.65	14.0	■	60	0.59	14.0	■	95	0.65	14.0	—	—	—	—	—	—	
	T9335	2.4	■	80	0.65	14.0	■	45	0.59	14.0	—	—	—	—	—	—	—	—	—	—	
HR2 geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																					
CNMM 190616-HR2	T9226	1.6	■	85	0.65	10.0	■	50	0.59	10.0	■	80	0.65	10.0	—	—	—	—	—	—	
	T9315	1.6	■	110	0.65	10.0	—	—	—	■	100	0.65	10.0	—	—	—	—	—	—	—	
	T9335	1.6	■	80	0.65	10.0	■	45	0.59	10.0	—	—	—	—	—	—	—	—	—	—	
CNMM 190624-HR2	T9226	2.4	■	80	0.85	10.0	■	45	0.77	10.0	■	75	0.85	10.0	—	—	—	—	—	—	
	T9315	2.4	■	100	0.85	10.0	—	—	—	■	95	0.85	10.0	—	—	—	—	—	—	—	
	T9335	2.4	■	75	0.85	10.0	■	45	0.77	10.0	—	—	—	—	—	—	—	—	—	—	
CNMM 250924-HR2	T9315	2.4	■	100	0.85	12.0	—	—	—	■	95	0.85	12.0	—	—	—	—	—	—	—	
	T9335	2.4	■	75	0.85	12.0	■	45	0.77	12.0	—	—	—	—	—	—	—	—	—	—	
NR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																					
CNMM 120408E-NR	6640	0.8	■	155	0.40	3.0	■	90	0.36	3.0	■	145	0.40	3.0	—	—	—	—	—	—	
	T7325	0.8	■	175	0.40	3.0	■	135	0.36	3.0	—	—	—	—	■	55	0.28	2.4	—	—	
	T7335	0.8	■	165	0.40	3.0	■	125	0.36	3.0	—	—	—	—	■	50	0.28	2.4	—	—	
	T8330	0.8	■	155	0.40	3.0	■	90	0.36	3.0	■	145	0.40	3.0	—	—	—	■	35	0.28	2.4
	T8430	0.8	■	165	0.40	3.0	■	90	0.36	3.0	■	135	0.40	3.0	—	—	—	■	35	0.28	2.4
	T9315	0.8	■	215	0.40	3.0	—	—	—	■	200	0.40	3.0	—	—	—	—	—	—	—	
	T9325	0.8	■	195	0.40	3.0	■	115	0.36	3.0	■	185	0.40	3.0	—	—	—	■	40	0.28	2.4
	T9335	0.8	■	175	0.40	3.0	■	135	0.36	3.0	—	—	—	—	■	60	0.28	2.4	—	—	
CNMM 120412E-NR	T7325	1.2	■	185	0.40	3.0	■	140	0.36	3.0	—	—	—	—	■	60	0.28	2.4	—	—	
	T7335	1.2	■	175	0.40	3.0	■	135	0.36	3.0	—	—	—	—	■	55	0.28	2.4	—	—	
	T8330	1.2	■	165	0.40	3.0	■	95	0.36	3.0	■	155	0.40	3.0	—	—	—	■	40	0.28	2.4
	T8430	1.2	■	170	0.40	3.0	■	90	0.36	3.0	■	135	0.40	3.0	—	—	—	■	35	0.28	2.4
	T9325	1.2	■	205	0.40	3.0	■	120	0.36	3.0	■	190	0.40	3.0	—	—	—	■	45	0.28	2.4
NR2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.																					
CNMM 120408E-NR2	T7325	0.8	■	165	0.40	5.0	■	125	0.36	5.0	—	—	—	—	■	50	0.28	4.0	—	—	
	T7335	0.8	■	155	0.40	5.0	■	120	0.36	5.0	—	—	—	—	■	50	0.28	4.0	—	—	
	T8330	0.8	■	150	0.40	5.0	■	90	0.36	5.0	■	140	0.40	5.0	—	—	—	■	35	0.28	4.0
	T8430	0.8	■	150	0.40	5.0	■	80	0.36	5.0	■	125	0.40	5.0	—	—	—	■	30	0.28	4.0
	T9315	0.8	■	205	0.40	5.0	—	—	—	■	190	0.40	5.0	—	—	—	—	—	—	—	
	T9325	0.8	■	185	0.40	5.0	■	110	0.36	5.0	■	175	0.40	5.0	—	—	—	■	40	0.28	4.0
CNMM 120412E-NR2	T7335	1.2	■	155	0.45	5.0	■	120	0.41	5.0	—	—	—	—	■	50	0.32	4.0	—	—	
	T8330	1.2	■	150	0.45	5.0	■	90	0.41	5.0	■	140	0.45	5.0	—	—	—	■	35	0.32	4.0
	T8430	1.2	■	150	0.45	5.0	■	80	0.41	5.0	■	125	0.45	5.0	—	—	—	■	30	0.32	4.0
	T9315	1.2	■	205	0.45	5.0	—	—	—	■	190	0.45	5.0	—	—	—	—	—	—	—	
	T9325	1.2	■	185	0.45	5.0	■	110	0.41	5.0	■	175	0.45	5.0	—	—	—	■	40	0.32	4.0
CNMM 160608E-NR2	T8330	0.8	■	145	0.40	6.0	■	85	0.36	6.0	■	135	0.40	6.0	—	—	—	■	35	0.32	4.8
	T8430	0.8	■	150	0.40	6.0	■	80	0.36	6.0	■	125	0.40	6.0	—	—	—	■	30	0.32	4.8
	T9325	0.8	■	180	0.40	6.0	■	105	0.36	6.0	■	170	0.40	6.0	—	—	—	■	40	0.32	4.8

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



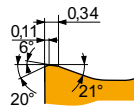
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



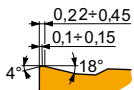
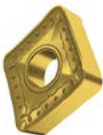
NR2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 160612E-NR2	T7325	1.2	165	0.45	6.0	125	0.41	6.0	—	—	—	—	—	—	50	0.36	4.8	—	—	—
	T7335	1.2	155	0.45	6.0	120	0.41	6.0	—	—	—	—	—	—	50	0.36	4.8	—	—	—
	T8330	1.2	145	0.45	6.0	85	0.41	6.0	135	0.45	6.0	—	—	—	35	0.36	4.8	—	—	—
	T8430	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	—	—	—	30	0.36	4.8	—	—	—
	T9315	1.2	205	0.45	6.0	—	—	—	190	0.45	6.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	—	—	—	40	0.36	4.8	—	—	—
CNMM 160616E-NR2	T7325	1.6	165	0.50	6.0	125	0.45	6.0	—	—	—	—	—	—	50	0.40	4.8	—	—	—
	T7335	1.6	160	0.50	6.0	120	0.45	6.0	—	—	—	—	—	—	50	0.40	4.8	—	—	—
	T9325	1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	—	—	—	40	0.40	4.8	—	—	—
CNMM 190612E-NR2	T7325	1.2	155	0.45	9.0	120	0.41	9.0	—	—	—	—	—	—	50	0.36	7.2	—	—	—
	T7335	1.2	145	0.45	9.0	110	0.41	9.0	—	—	—	—	—	—	45	0.36	7.2	—	—	—
	T8330	1.2	140	0.45	9.0	80	0.41	9.0	130	0.45	9.0	—	—	—	35	0.36	7.2	—	—	—
	T8430	1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	—	—	—	30	0.36	7.2	—	—	—
CNMM 190616E-NR2	T9325	1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	—	—	—	35	0.36	7.2	—	—	—
	T7325	1.6	160	0.50	9.0	120	0.45	9.0	—	—	—	—	—	—	50	0.40	7.2	—	—	—
	T7335	1.6	150	0.50	9.0	115	0.45	9.0	—	—	—	—	—	—	45	0.40	7.2	—	—	—
	T8330	1.6	140	0.50	9.0	80	0.45	9.0	130	0.50	9.0	—	—	—	35	0.40	7.2	—	—	—
	T8430	1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	—	—	—	30	0.40	7.2	—	—	—
	T9315	1.6	195	0.50	9.0	—	—	—	185	0.50	9.0	—	—	—	—	—	—	—	—	—
CNMM 190624E-NR2	T9325	1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	—	—	—	35	0.40	7.2	—	—	—
	T7335	2.4	130	0.80	9.0	100	0.72	9.0	—	—	—	—	—	—	40	0.56	7.2	—	—	—
	T9325	2.4	150	0.80	9.0	90	0.72	9.0	140	0.80	9.0	—	—	—	30	0.56	7.2	—	—	—
CNMM 250924E-NR2	T7325	2.4	100	0.80	12.0	75	0.72	12.0	—	—	—	—	—	—	30	0.56	9.6	—	—	—
	T7335	2.4	95	0.80	12.0	70	0.72	12.0	—	—	—	—	—	—	30	0.56	9.6	—	—	—
	T8430	2.4	80	0.80	12.0	45	0.72	12.0	65	0.80	12.0	—	—	—	15	0.56	9.6	—	—	—
	T9315	2.4	110	0.80	12.0	—	—	—	100	0.80	12.0	—	—	—	—	—	—	—	—	—
	T9325	2.4	100	0.80	12.0	60	0.72	12.0	95	0.80	12.0	—	—	—	20	0.56	9.6	—	—	—



NRM geometry with positive design for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 250924-NRM	T7325	2.4	95	0.70	10.0	70	0.63	10.0	—	—	—	—	—	—	30	0.49	8.0	—	—	—
	T7335	2.4	90	0.70	10.0	70	0.63	10.0	—	—	—	—	—	—	25	0.49	8.0	—	—	—
	T9315	2.4	115	0.70	10.0	—	—	—	105	0.70	10.0	—	—	—	—	—	—	—	—	—



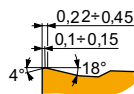
OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 120408E-OR	T8330	0.8	150	0.40	5.0	90	0.36	5.0	140	0.40	5.0	—	—	—	35	0.28	4.0	—	—	—
	T8430	0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	—	—	—	30	0.28	4.0	—	—	—
	T9315	0.8	205	0.40	5.0	—	—	—	190	0.40	5.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	—	—	—	40	0.28	4.0	—	—	—
CNMM 120412E-OR	T9335	0.8	160	0.40	5.0	95	0.36	5.0	—	—	—	—	—	—	35	0.28	4.0	—	—	—
	T9315	1.2	205	0.45	5.0	—	—	—	190	0.45	5.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	—	—	—	40	0.36	4.0	—	—	—
CNMM 120416E-OR	T9335	1.2	165	0.45	5.0	95	0.41	5.0	—	—	—	—	—	—	35	0.36	4.0	—	—	—
	T9325	1.6	190	0.50	5.0	110	0.45	5.0	180	0.50	5.0	—	—	—	40	0.40	4.0	—	—	—
CNMM 160608E-OR	T9335	1.6	165	0.50	5.0	95	0.45	5.0	—	—	—	—	—	—	35	0.40	4.0	—	—	—
	T9315	0.8	205	0.40	6.0	—	—	—	190	0.40	6.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	—	—	—	40	0.32	4.8	—	—	—
CNMM 160612E-OR	T9335	0.8	160	0.40	6.0	95	0.36	6.0	—	—	—	—	—	—	35	0.32	4.8	—	—	—
	T8430	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	—	—	—	30	0.36	4.8	—	—	—
	T9315	1.2	205	0.45	6.0	—	—	—	190	0.45	6.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	—	—	—	40	0.36	4.8	—	—	—



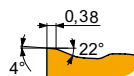
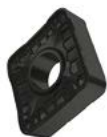
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	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]



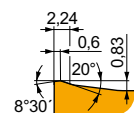
OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 160616E-OR	T9315	1.6	■	205	0.50	6.0	■	—	—	—	■	190	0.50	6.0	■	—	—	—	■	—	—	—
	T9325	1.6	■	180	0.50	6.0	■	105	0.45	6.0	■	170	0.50	6.0	■	—	—	—	■	40	0.40	4.8
CNMM 190612E-OR	T8330	1.2	■	140	0.45	9.0	■	80	0.41	9.0	■	130	0.45	9.0	■	—	—	—	■	35	0.36	7.2
	T8430	1.2	■	140	0.45	9.0	■	75	0.41	9.0	■	115	0.45	9.0	■	—	—	—	■	30	0.36	7.2
	T9315	1.2	■	195	0.45	9.0	■	—	—	—	■	185	0.45	9.0	■	—	—	—	■	—	—	—
	T9325	1.2	■	175	0.45	9.0	■	105	0.41	9.0	■	165	0.45	9.0	■	—	—	—	■	35	0.36	7.2
CNMM 190616E-OR	T9335	1.2	■	150	0.45	9.0	■	90	0.41	9.0	■	—	—	—	■	—	—	—	■	30	0.36	7.2
	T8330	1.6	■	140	0.50	9.0	■	80	0.45	9.0	■	130	0.50	9.0	■	—	—	—	■	35	0.40	7.2
	T8345	1.6	■	120	0.50	9.0	■	70	0.45	9.0	■	110	0.50	9.0	■	—	—	—	■	30	0.40	7.2
	T8430	1.6	■	140	0.50	9.0	■	75	0.45	9.0	■	115	0.50	9.0	■	—	—	—	■	30	0.40	7.2
	T9315	1.6	■	195	0.50	9.0	■	—	—	—	■	185	0.50	9.0	■	—	—	—	■	—	—	—
	T9325	1.6	■	175	0.50	9.0	■	105	0.45	9.0	■	165	0.50	9.0	■	—	—	—	■	35	0.40	7.2
CNMM 190624E-OR	T9335	1.6	■	155	0.50	9.0	■	90	0.45	9.0	■	—	—	—	■	—	—	—	■	30	0.40	7.2
	T9315	2.4	■	165	0.80	9.0	■	—	—	—	■	155	0.80	9.0	■	—	—	—	■	—	—	—
	T9325	2.4	■	150	0.80	9.0	■	90	0.72	9.0	■	140	0.80	9.0	■	—	—	—	■	30	0.56	7.2
CNMM 250924E-OR	T8330	2.4	■	75	1.00	12.0	■	45	0.90	12.0	■	70	1.00	12.0	■	—	—	—	■	15	0.70	9.6
	T8430	2.4	■	75	1.00	12.0	■	40	0.90	12.0	■	60	1.00	12.0	■	—	—	—	■	15	0.70	9.6
	T9315	2.4	■	100	1.00	12.0	■	—	—	—	■	95	1.00	12.0	■	—	—	—	■	—	—	—
	T9325	2.4	■	95	1.00	12.0	■	55	0.90	12.0	■	90	1.00	12.0	■	—	—	—	■	20	0.70	9.6
	T9335	2.4	■	75	1.00	12.0	■	45	0.90	12.0	■	—	—	—	■	—	—	—	■	15	0.70	9.6



OR1 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

CNMM 190616E-OR1	T9325	1.6	■	175	0.50	9.0	■	105	0.45	9.0	■	165	0.50	9.0	—	—	—	■	35	0.35	7.2
	T9335	1.6	■	155	0.50	9.0	■	90	0.45	9.0	■	150	0.50	9.0	—	—	—	■	30	0.35	7.2



Geometry 923 for semi-rough to heavy-rough machining, and continuous to heavy interrupted cuts.

CNMM 250924S-923	T8330	2.4	■	75	0.85	12.0	■	45	0.77	12.0	■	70	0.85	12.0	—	—	—	■	15	0.60	9.6
	T8430	2.4	■	75	0.85	12.0	■	40	0.77	12.0	■	60	0.85	12.0	—	—	—	■	15	0.60	9.6
	T9335	2.4	■	75	0.85	12.0	■	45	0.77	12.0	■	—	—	—	—	—	—	■	15	0.60	9.6