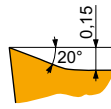


CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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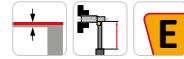
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [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]



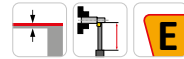
SF3 geometry with highly positive design for fine to finish machining, and continuous cuts.

DCGT 11T302E-SF3	H07	0.2	—	—	—	95	0.05	0.8	150	0.05	0.8	485	0.06	0.8	45	0.04	0.6	—	—	—
	T6310	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.15	1.0
DCGT 11T304E-SF3	H07	0.4	—	—	—	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	—	—	—
	T6310	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.15	1.0
DCGT 11T308E-SF3	T8315	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.15	1.0
	H07	0.8	—	—	—	90	0.09	0.8	145	0.10	0.8	455	0.12	0.8	45	0.08	0.6	—	—	—
	T6310	0.8	170	0.10	0.8	120	0.09	0.8	135	0.10	0.8	510	0.12	0.8	50	0.08	0.6	30	0.15	1.0
	T8315	0.8	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	540	0.12	0.8	45	0.08	0.6	35	0.15	1.0



ER-SI geometry with positive right-handed design for fine-finish machining, and continuous cuts.

DCGT 11T304ER-SI	T8330	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	—	—	—	40	0.10	0.6	—	—	—
	T8430	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
DCGT 11T308ER-SI	T8330	0.8	170	0.22	1.0	100	0.20	1.0	160	0.22	1.0	—	—	—	40	0.18	0.8	—	—	—
	T8430	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	—	—	—	40	0.18	0.8	—	—	—



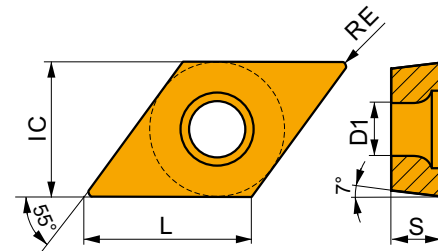
EL-SI geometry with positive left-handed design for fine-finish machining, and continuous cuts.

DCGT 11T304EL-SI	T8330	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	—	—	—	40	0.10	0.6	—	—	—
	T8430	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
DCGT 11T308EL-SI	T8330	0.8	170	0.22	1.0	100	0.20	1.0	160	0.22	1.0	—	—	—	40	0.18	0.8	—	—	—
	T8430	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	—	—	—	40	0.18	0.8	—	—	—

DCMT

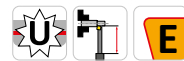
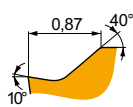


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



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 positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

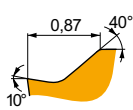
DCMT 11T302E-FF	T8315	0.2	160	0.10	0.8	95	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	150	0.10	0.8	90	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.2	185	0.10	0.8	100	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.2	255	0.10	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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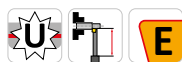
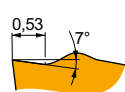
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (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)



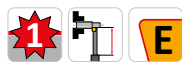
FF geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

DCMT 11T304E-FF	T8315	0.4	160	0.12	0.8	95	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	150	0.12	0.8	90	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	185	0.12	0.8	100	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.4	255	0.12	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
DCMT 11T308E-FF	T8315	0.8	180	0.15	0.8	105	0.14	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	170	0.15	0.8	100	0.14	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	200	0.15	0.8	110	0.14	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.8	270	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

DCMT 070202E-FF2	T7325	0.2	190	0.05	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	165	0.05	0.8	—	—	—	155	0.05	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.2	225	0.05	0.8	—	—	—	185	0.05	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.2	280	0.05	0.8	—	—	—	265	0.05	0.8	—	—	—	—	—	—	—	—	—
	TT010	0.2	275	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
DCMT 070204E-FF2	T7325	0.4	160	0.12	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	—	—	—	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	—	—	—	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	205	0.12	0.8	—	—	—	190	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 070208E-FF2	T7325	0.8	170	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	150	0.17	0.8	—	—	—	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.8	175	0.17	0.8	—	—	—	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	235	0.17	0.8	—	—	—	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	215	0.17	0.8	—	—	—	200	0.17	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T304E-FF2	T7325	0.4	160	0.12	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	—	—	—	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	—	—	—	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	205	0.12	0.8	—	—	—	190	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T308E-FF2	T7325	0.8	170	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	150	0.17	0.8	—	—	—	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.8	175	0.17	0.8	—	—	—	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	235	0.17	0.8	—	—	—	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	215	0.17	0.8	—	—	—	200	0.17	0.8	—	—	—	—	—	—	—	—	—



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

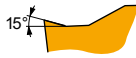
DCMT 070202E-FM	T7325	0.2	175	0.10	0.8	135	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	—	—	—	—	—	—
	T8330	0.2	150	0.10	0.8	90	0.09	0.8	140	0.10	0.8	450	0.12	0.8	—	—	—	—	—	—
	T8430	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	—	—	—	—	—	—
	T9315	0.2	255	0.10	0.8	—	—	—	240	0.10	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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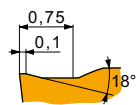
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (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]



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

DCMT 070204E-FM	T7325	0.4	155	0.17	0.8	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	155	0.17	0.8	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	—	—	—	—	—	—
	T8330	0.4	150	0.12	0.8	90	0.11	0.8	140	0.12	0.8	450	0.14	0.8	—	—	—	—	—	—
	T8430	0.4	185	0.12	0.8	100	0.11	0.8	150	0.12	0.8	510	0.14	0.8	—	—	—	—	—	—
	T9315	0.4	255	0.12	0.8	—	—	—	240	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T302E-FM	T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.2	175	0.10	0.8	135	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	—	—	—	—	—	—
	T8330	0.2	150	0.10	0.8	90	0.09	0.8	140	0.10	0.8	450	0.12	0.8	—	—	—	—	—	—
	T8430	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	—	—	—	—	—	—
	T9315	0.2	255	0.10	0.8	—	—	—	240	0.10	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T304E-FM	T9325	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.4	155	0.17	0.8	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	155	0.17	0.8	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	—	—	—	—	—	—
	T8330	0.4	135	0.17	0.8	80	0.15	0.8	125	0.17	0.8	405	0.20	0.8	—	—	—	—	—	—
	T8430	0.4	155	0.17	0.8	85	0.15	0.8	130	0.17	0.8	435	0.20	0.8	—	—	—	—	—	—
DCMT 11T308E-FM	T9310	0.4	285	0.12	0.8	—	—	—	270	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	255	0.12	0.8	—	—	—	240	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.8	185	0.17	0.8	140	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.8	180	0.17	0.8	140	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	170	0.17	0.8	100	0.15	0.8	160	0.17	0.8	510	0.20	0.8	—	—	—	—	—	—
DCMT 11T312E-FM	T8330	0.8	165	0.17	0.8	95	0.15	0.8	155	0.17	0.8	495	0.20	0.8	—	—	—	—	—	—
	T8430	0.8	190	0.17	0.8	105	0.15	0.8	155	0.17	0.8	525	0.20	0.8	—	—	—	—	—	—
	T9310	0.8	285	0.17	0.8	—	—	—	270	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	260	0.17	0.8	—	—	—	245	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	235	0.17	0.8	140	0.15	0.8	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8330	1.2	150	0.22	1.2	90	0.22	1.2	140	0.22	1.2	450	0.26	1.2	—	—	—	—	—	—
DCMT 11T312E-FM	T8430	1.2	175	0.22	1.2	95	0.22	1.2	140	0.22	1.2	480	0.26	1.2	—	—	—	—	—	—
	T9315	1.2	235	0.22	1.2	—	—	—	220	0.22	1.2	—	—	—	—	—	—	—	—	—
	T9325	1.2	210	0.22	1.2	125	0.22	1.2	195	0.22	1.2	—	—	—	—	—	—	—	—	—



FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

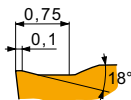
DCMT 070204E-FM2	T6310	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.4	160	0.12	0.8	120	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T304E-FM2	T9325	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	—	—	—	—	—	—	—	—	—
	T6310	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.4	160	0.12	0.8	120	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9335	0.4	175	0.12	0.8	105	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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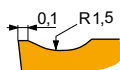
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (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]



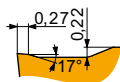
FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

DCMT 11T308E-FM2	T6310	0.8	150	0.17	0.8	105	0.15	0.8	120	0.17	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.8	170	0.17	0.8	130	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	150	0.17	0.8	90	0.15	0.8	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	235	0.17	0.8	—	—	—	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9335	0.8	180	0.17	0.8	105	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
DCMT 11T312E-FM2	T8430	1.2	155	0.22	1.2	85	0.20	1.2	130	0.22	1.2	—	—	—	—	—	—	—	—	—
	T9325	1.2	190	0.22	1.2	110	0.20	1.2	180	0.22	1.2	—	—	—	—	—	—	—	—	—
DCMT 150408E-FM2	T9315	0.8	205	0.20	1.5	—	—	—	190	0.20	1.5	—	—	—	—	—	—	—	—	—
	T9325	0.8	185	0.20	1.5	110	0.18	1.5	175	0.20	1.5	—	—	—	—	—	—	—	—	—
	T9335	0.8	160	0.20	1.5	95	0.18	1.5	—	—	—	—	—	—	—	—	—	—	—	—



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

DCMT 11T304E-RF	T5315	0.4	175	0.20	0.8	—	—	—	165	0.20	0.8	—	—	—	—	—	—	35	0.15	1.0
	T7335	0.4	115	0.20	0.8	85	0.18	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.4	150	0.20	0.8	90	0.18	0.8	140	0.20	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T308E-RF	T5315	0.8	205	0.20	0.8	—	—	—	190	0.20	0.8	—	—	—	—	—	—	40	0.15	1.0
	T7335	0.8	140	0.20	0.8	105	0.18	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.8	175	0.20	0.8	105	0.18	0.8	165	0.20	0.8	—	—	—	—	—	—	—	—	—



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

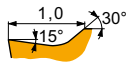
DCMT 11T304E-RM	T5305	0.4	225	0.27	0.8	—	—	—	210	0.27	0.8	—	—	—	—	—	—	45	0.15	1.0
	T5315	0.4	205	0.27	0.8	—	—	—	190	0.27	0.8	—	—	—	—	—	—	40	0.15	1.0
	T7335	0.4	135	0.27	0.8	105	0.24	0.8	—	—	—	40	0.19	0.6	—	—	—	—	—	—
	T8330	0.4	125	0.27	0.8	75	0.24	0.8	115	0.27	0.8	30	0.19	0.6	25	0.15	1.0	—	—	—
	T8430	0.4	135	0.27	0.8	75	0.24	0.8	110	0.27	0.8	25	0.19	0.6	20	0.15	1.0	—	—	—
	T9315	0.4	185	0.27	0.8	—	—	—	175	0.27	0.8	—	—	—	35	0.15	1.0	—	—	—
	T9325	0.4	165	0.27	0.8	95	0.24	0.8	155	0.27	0.8	35	0.19	0.6	—	—	—	—	—	—
DCMT 11T308E-RM	T5305	0.8	270	0.27	0.8	—	—	—	255	0.27	0.8	—	—	—	50	0.15	1.0	—	—	—
	T5315	0.8	240	0.27	0.8	—	—	—	225	0.27	0.8	—	—	—	45	0.15	1.0	—	—	—
	T7335	0.8	165	0.27	0.8	125	0.24	0.8	—	—	—	50	0.19	0.6	—	—	—	—	—	—
	T8330	0.8	150	0.27	0.8	90	0.24	0.8	140	0.27	0.8	35	0.19	0.6	30	0.15	1.0	—	—	—
	T8430	0.8	165	0.27	0.8	90	0.24	0.8	135	0.27	0.8	35	0.19	0.6	25	0.15	1.0	—	—	—
	T9315	0.8	220	0.27	0.8	—	—	—	205	0.27	0.8	—	—	—	40	0.15	1.0	—	—	—
	T9325	0.8	200	0.27	0.8	120	0.24	0.8	190	0.27	0.8	45	0.19	0.6	—	—	—	—	—	—
DCMT 11T312E-RM	T7335	1.2	165	0.27	1.2	125	0.24	1.2	—	—	—	50	0.19	1.2	—	—	—	—	—	—
	T8330	1.2	150	0.27	1.2	90	0.24	1.2	140	0.27	1.2	35	0.19	1.2	30	0.15	1.0	—	—	—
	T8430	1.2	170	0.27	1.2	90	0.24	1.2	135	0.27	1.2	35	0.19	1.2	25	0.15	1.0	—	—	—
	T9315	1.2	225	0.27	1.2	—	—	—	210	0.27	1.2	—	—	—	45	0.15	1.0	—	—	—
	T9325	1.2	200	0.27	1.2	120	0.24	1.2	190	0.27	1.2	45	0.19	1.2	—	—	—	—	—	—
DCMT 150408E-RM	T8330	0.8	135	0.27	1.9	80	0.24	1.9	125	0.27	1.9	30	0.22	1.5	25	0.15	1.0	—	—	—
	T8430	0.8	150	0.27	1.9	80	0.24	1.9	125	0.27	1.9	30	0.22	1.5	25	0.15	1.0	—	—	—
	T9315	0.8	200	0.27	1.9	—	—	—	190	0.27	1.9	—	—	—	40	0.15	1.0	—	—	—
	T9325	0.8	180	0.27	1.9	105	0.24	1.9	170	0.27	1.9	40	0.22	1.5	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----



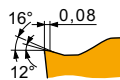
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

DCMT 070202E-UR	T7325	0.2	✓	150	0.10	0.8	✓	115	0.09	0.8	—	—	—	—	—	—	—	—	—	—
	T8315	0.2	✓	135	0.10	0.8	✓	80	0.09	0.8	■	125	0.10	0.8	—	—	—	—	—	—
	T8330	0.2	■	130	0.10	0.8	■	75	0.09	0.8	■	120	0.10	0.8	—	—	—	—	—	—
	T8430	0.2	■	155	0.10	0.8	✓	85	0.09	0.8	✓	130	0.10	0.8	—	—	—	—	—	—
	T9315	0.2	■	220	0.10	0.8	—	—	—	—	✓	205	0.10	0.8	—	—	—	—	—	—
	T9325	0.2	■	200	0.10	0.8	✓	120	0.09	0.8	✓	190	0.10	0.8	—	—	—	—	—	—
DCMT 070204E-UR	T7325	0.4	✓	135	0.17	0.8	✓	105	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	✓	135	0.12	0.8	✓	80	0.11	0.8	■	125	0.12	0.8	—	—	—	—	—	—
	T8330	0.4	■	130	0.12	0.8	✓	75	0.11	0.8	■	120	0.12	0.8	—	—	—	—	—	—
	T8430	0.4	■	155	0.12	0.8	✓	85	0.11	0.8	✓	130	0.12	0.8	—	—	—	—	—	—
	T9315	0.4	■	220	0.12	0.8	—	—	—	—	✓	205	0.12	0.8	—	—	—	—	—	—
	T9325	0.4	■	165	0.18	0.8	✓	95	0.16	0.8	✓	155	0.18	0.8	—	—	—	—	—	—
DCMT 11T302E-UR	TT310	0.4	■	210	0.12	0.8	✓	125	0.11	0.8	—	—	—	—	—	—	—	—	—	—
	T7325	0.2	✓	150	0.10	0.8	✓	115	0.09	0.8	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	■	130	0.10	0.8	✓	75	0.09	0.8	■	120	0.10	0.8	—	—	—	—	—	—
	T8430	0.2	■	155	0.10	0.8	✓	85	0.09	0.8	✓	130	0.10	0.8	—	—	—	—	—	—
	T9315	0.2	■	220	0.10	0.8	—	—	—	—	✓	205	0.10	0.8	—	—	—	—	—	—
	T9325	0.2	■	200	0.10	0.8	✓	120	0.09	0.8	✓	190	0.10	0.8	—	—	—	—	—	—
DCMT 11T304E-UR	TT310	0.2	■	210	0.10	0.8	✓	125	0.09	0.8	—	—	—	—	—	—	—	—	—	—
	T5315	0.4	✓	220	0.12	0.8	—	—	—	—	■	205	0.12	0.8	—	—	—	—	—	—
	T7325	0.4	✓	135	0.17	0.8	✓	105	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	✓	130	0.17	0.8	✓	100	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	✓	135	0.12	0.8	✓	80	0.11	0.8	■	125	0.12	0.8	—	—	—	—	—	—
	T8330	0.4	■	130	0.12	0.8	✓	75	0.11	0.8	■	120	0.12	0.8	—	—	—	—	—	—
DCMT 11T308E-UR	T8430	0.4	■	155	0.12	0.8	✓	85	0.11	0.8	✓	130	0.12	0.8	—	—	—	—	—	—
	T9315	0.4	■	220	0.12	0.8	—	—	—	—	✓	205	0.12	0.8	—	—	—	—	—	—
	T9325	0.4	■	165	0.18	0.8	✓	95	0.16	0.8	✓	155	0.18	0.8	—	—	—	—	—	—
	TT310	0.4	■	210	0.12	0.8	✓	125	0.11	0.8	—	—	—	—	—	—	—	—	—	—
	T5315	0.8	✓	230	0.17	0.8	—	—	—	—	■	215	0.17	0.8	—	—	—	—	—	—
	T7325	0.8	✓	160	0.17	0.8	✓	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—
DCMT 11T312E-UR	T7335	0.8	✓	155	0.17	0.8	✓	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	✓	145	0.17	0.8	✓	85	0.15	0.8	■	135	0.17	0.8	—	—	—	—	—	—
	T8330	0.8	■	140	0.17	0.8	✓	80	0.15	0.8	■	130	0.17	0.8	—	—	—	—	—	—
	T8430	0.8	■	165	0.17	0.8	✓	90	0.15	0.8	✓	135	0.17	0.8	—	—	—	—	—	—
	T9315	0.8	■	225	0.17	0.8	—	—	—	—	✓	210	0.17	0.8	—	—	—	—	—	—
	T9325	0.8	■	200	0.17	0.8	✓	120	0.15	0.8	✓	190	0.17	0.8	—	—	—	—	—	—
DCMT 11T312E-UR	TT310	0.8	■	225	0.17	0.8	✓	135	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T9315	1.2	■	205	0.22	1.2	—	—	—	—	✓	190	0.22	1.2	—	—	—	—	—	—
	T9325	1.2	■	180	0.22	1.2	✓	105	0.20	1.2	✓	170	0.22	1.2	—	—	—	—	—	—



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

DCMX 11T304W-FM	T7325	0.4	✓	130	0.30	0.8	■	100	0.27	0.8	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	■	115	0.30	0.8	■	65	0.27	0.8	■	105	0.30	0.8	—	—	—	—	—	—
	T8430	0.4	■	130	0.30	0.8	■	70	0.27	0.8	✓	105	0.30	0.8	—	—	—	—	—	—
	T9315	0.4	■	170	0.30	0.8	—	—	—	—	✓	160	0.30	0.8	—	—	—	—	—	—
	T9325	0.4	■	155	0.30	0.8	■	90	0.27	0.8	✓	145	0.30	0.8	—	—	—	—	—	—
DCMX 11T308W-FM	T7325	0.8	✓	140	0.40	1.0	■	105	0.36	1.0	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	■	130	0.40	1.0	■	70	0.36	1.0	✓	105	0.40	1.0	—	—	—	—	—	—
	T9315	0.8	■	175	0.40	1.0	—	—	—	—	✓	165	0.40	1.0	—	—	—	—	—	—
	T9325	0.8	■	160	0.40	1.0	■	95	0.36	1.0	✓	150	0.40	1.0	—	—	—	—	—	—