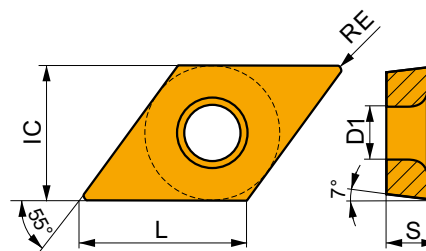




DCMW

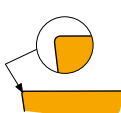


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



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]



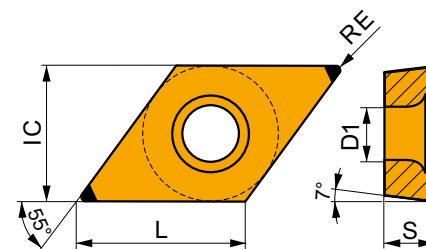
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

DCMW 070202	T5305	0.2	—	—	—	—	—	—	200	0.08	0.8	—	—	—	—	—	40	0.15	1.0
	T6310	0.2	—	—	—	—	—	—	80	0.08	0.8	—	—	—	—	—	20	0.15	1.0
DCMW 070204	T5305	0.4	—	—	—	—	—	—	195	0.10	0.8	—	—	—	—	—	40	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	175	0.10	0.8	—	—	—	—	—	35	0.15	1.0
	T6310	0.4	—	—	—	—	—	—	85	0.10	0.8	—	—	—	—	—	20	0.15	1.0
DCMW 11T304	T5305	0.4	—	—	—	—	—	—	190	0.10	1.2	—	—	—	—	—	40	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	165	0.10	1.2	—	—	—	—	—	35	0.15	1.0
	T6310	0.4	—	—	—	—	—	—	80	0.10	1.2	—	—	—	—	—	20	0.15	1.0
DCMW 11T308	T5305	0.8	—	—	—	—	—	—	185	0.18	1.2	—	—	—	—	—	35	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	160	0.18	1.2	—	—	—	—	—	30	0.15	1.0
	T6310	0.8	—	—	—	—	—	—	80	0.18	1.2	—	—	—	—	—	20	0.15	1.0

DCGW CBN

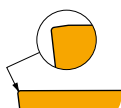
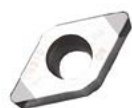


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
11T3	9.525	4.50	11.60	3.97



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	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 finish machining.

DCGW 11T304S01020B	TB310	0.4	—	—	—	—	—	—	370	0.10	0.4	—	—	—	95	0.07	0.3	75	0.15	1.0
DCGW 11T308S01020B	TB310	0.8	—	—	—	—	—	—	380	0.15	0.6	—	—	—	100	0.11	0.5	80	0.15	1.0