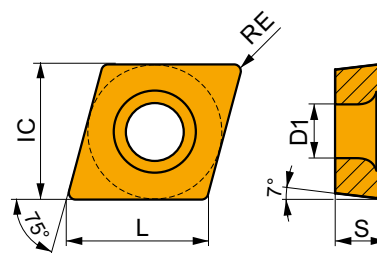




ECGT

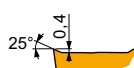


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
0602	6.350	2.80	6.50	2.38
0602-SF3	6.350	2.80	6.50	2.58
0803	7.940	3.40	8.20	3.18
0803-SF3	7.940	3.40	8.20	3.43



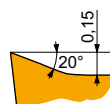
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



SF2 geometry with highly positive design for fine to finish machining, and continuous cuts.

ECGT 060202E-SF2	H07	0.2	—	—	—	105	0.05	1.0	—	—	—	525	0.06	1.0	50	0.04	0.8	—	—	—
	T6310	0.2	185	0.05	1.0	130	0.05	1.0	—	—	—	555	0.06	1.0	55	0.04	0.8	—	—	—
ECGT 060204E-SF2	H07	0.4	—	—	—	85	0.09	1.0	—	—	—	430	0.12	1.0	40	0.07	0.8	—	—	—
	T6310	0.4	160	0.10	1.0	115	0.09	1.0	—	—	—	480	0.12	1.0	45	0.07	0.8	—	—	—
ECGT 080302E-SF2	H07	0.2	—	—	—	105	0.05	1.0	—	—	—	525	0.06	1.0	50	0.04	0.8	—	—	—
	T6310	0.2	185	0.05	1.0	130	0.05	1.0	—	—	—	555	0.06	1.0	55	0.04	0.8	—	—	—
ECGT 080304E-SF2	H07	0.4	—	—	—	85	0.09	1.0	—	—	—	430	0.12	1.0	40	0.07	0.8	—	—	—
	T6310	0.4	160	0.10	1.0	115	0.09	1.0	—	—	—	480	0.12	1.0	45	0.07	0.8	—	—	—



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

ECGT 060202E-SF3	H07	0.2	—	—	—	105	0.05	0.8	170	0.05	0.8	540	0.06	0.8	55	0.04	0.6	—	—	—
	T6310	0.2	185	0.05	0.8	130	0.05	0.8	145	0.05	0.8	555	0.06	0.8	55	0.04	0.6	35	0.15	1.0
ECGT 080304E-SF3	H07	0.4	—	—	—	85	0.09	1.0	135	0.10	1.0	430	0.12	1.0	40	0.07	0.8	—	—	—
	T6310	0.4	160	0.10	1.0	115	0.09	1.0	125	0.10	1.0	480	0.12	1.0	45	0.07	0.8	30	0.15	1.0