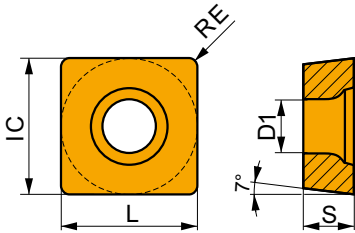




SCMW

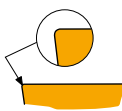


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



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]



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

SCMW 09T304	T5305	0.4	—	—	—	—	—	—	240	0.10	2.0	—	—	—	—	—	—	50	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	205	0.10	2.0	—	—	—	—	—	—	40	0.15	1.0
SCMW 09T308	T5305	0.8	—	—	—	—	—	—	220	0.20	2.0	—	—	—	—	—	—	45	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	190	0.20	2.0	—	—	—	—	—	—	40	0.15	1.0
SCMW 120408	T5305	0.8	—	—	—	—	—	—	205	0.20	4.0	—	—	—	—	—	—	40	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	185	0.20	4.0	—	—	—	—	—	—	35	0.15	1.0