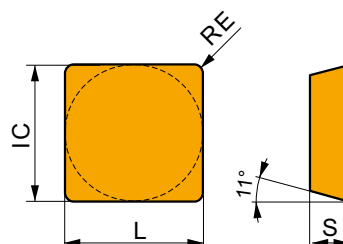




SPMR

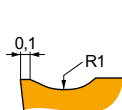


	IC	L	S
	[mm]	[mm]	[mm]
0903	9.525	9.53	3.18
1203	12.700	12.70	3.18



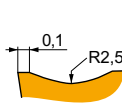
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



Geometry 46 for fine to finish machining, and continuous to interrupted cuts.

SPMR 090304E-46	T9325	0.4	215	0.15	1.0	125	0.15	1.0	200	0.15	1.0	—	—	—	—	—	—	—	—
SPMR 090308E-46	T9325	0.8	255	0.15	1.0	150	0.15	1.0	240	0.15	1.0	—	—	—	—	—	—	—	—



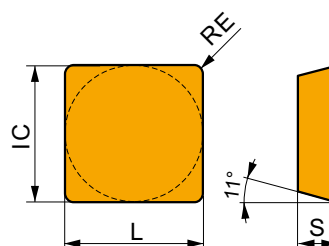
Geometry 48 for finish to semi-rough machining, and continuous to interrupted cuts.

SPMR 120304E-48	T9325	0.4	170	0.22	2.2	100	0.22	2.2	160	0.22	2.2	—	—	—	—	—	—	—	—
	T9335	0.4	145	0.22	2.2	85	0.22	2.2	—	—	—	—	—	—	—	—	—	—	—
SPMR 120308E-48	6640	0.8	160	0.22	2.2	95	0.22	2.2	150	0.22	2.2	—	—	—	—	—	—	—	—
	T9325	0.8	205	0.22	2.2	120	0.22	2.2	190	0.22	2.2	—	—	—	—	—	—	—	—
	T9335	0.8	175	0.22	2.2	105	0.22	2.2	—	—	—	—	—	—	—	—	—	—	—
SPMR 120312E-48	T9325	1.2	215	0.22	2.2	125	0.22	2.2	200	0.22	2.2	—	—	—	—	—	—	—	—

SPUN

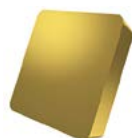


	IC	L	M	S
	[mm]	[mm]	[mm]	[mm]
1203	12.700	12.70	2	3.18
1504	15.875	15.88	3	4.76
1904	19.050	19.05	3	4.76
2506	25.400	25.40	4	6.35



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.

SPUN 120308	6640	0.8	180	0.15	4.0	—	—	—	170	0.15	4.0	—	—	—	—	—	—	—	—
SPUN 120312	6640	1.2	190	0.15	4.0	—	—	—	180	0.15	4.0	—	—	—	—	—	—	—	—
SPUN 150408	6640	0.8	155	0.20	5.0	—	—	—	145	0.20	5.0	—	—	—	—	—	—	—	—