

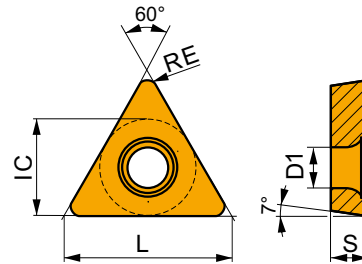
CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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TCGT

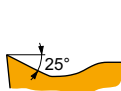
PRAMET

	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
1102-SF3	6.350	2.80	11.00	2.58
16T3	9.525	4.40	16.50	3.97
16T3-SF3	9.525	4.40	16.50	4.22



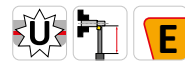
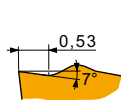
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



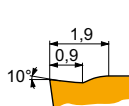
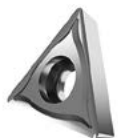
AL geometry with highly positive design for fine-finish to rough machining, and continuous to slightly interrupted cuts.

TCGT 090202F-AL	HF7	0.2	—	—	—	—	—	—	—	—	375	0.12	1.0	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	555	0.12	1.0	—	—	—	—	—	—
TCGT 090204F-AL	HF7	0.4	—	—	—	—	—	—	—	—	300	0.24	1.0	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	450	0.24	1.0	—	—	—	—	—	—
TCGT 110202F-AL	HF7	0.2	—	—	—	—	—	—	—	—	360	0.12	1.5	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	525	0.12	1.5	—	—	—	—	—	—
TCGT 110204F-AL	HF7	0.4	—	—	—	—	—	—	—	—	285	0.24	1.5	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	420	0.24	1.5	—	—	—	—	—	—
TCGT 110208F-AL	HF7	0.8	—	—	—	—	—	—	—	—	270	0.48	1.5	—	—	—	—	—	—
TCGT 16T304F-AL	HF7	0.4	—	—	—	—	—	—	—	—	285	0.24	2.4	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	405	0.24	2.4	—	—	—	—	—	—
TCGT 16T308F-AL	HF7	0.8	—	—	—	—	—	—	—	—	255	0.48	2.4	—	—	—	—	—	—
	T0315	0.8	—	—	—	—	—	—	—	—	360	0.48	2.4	—	—	—	—	—	—



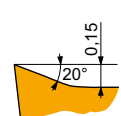
FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

TCGT 06T102E-FF2	T8330	0.2	175	0.05	0.8	—	—	—	165	0.05	0.8	—	—	—	—	—	—	—	—
	T8430	0.2	235	0.05	0.8	—	—	—	190	0.05	0.8	—	—	—	—	—	—	—	—
TCGT 090202E-FF2	TT010	0.2	295	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	TT010	0.2	295	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—



NF1 geometry with positive design for fine-finish to medium machining, and continuous cuts.

TCGT 110204E-NF1	H07	0.4	—	—	—	80	0.09	0.8	—	—	415	0.12	0.8	40	0.08	0.6	—	—	—
	T6310	0.4	155	0.10	0.8	110	0.09	0.8	—	—	465	0.12	0.8	45	0.08	0.6	30	0.15	1.0
	T7325	0.4	180	0.10	0.8	140	0.09	0.8	—	—	—	—	—	55	0.08	0.6	—	—	—



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

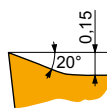
TCGT 110202E-SF3	T6310	0.2	175	0.05	0.8	125	0.05	0.8	140	0.05	0.8	525	0.06	0.8	50	0.04	0.6	35	0.15	1.0
	T8315	0.2	185	0.05	0.8	110	0.05	0.8	175	0.05	0.8	555	0.06	0.8	45	0.04	0.6	35	0.15	1.0
TCGT 110204E-SF3	H07	0.4	—	—	—	80	0.09	0.8	130	0.10	0.8	415	0.12	0.8	40	0.07	0.6	—	—	—
	T6310	0.4	155	0.10	0.8	110	0.09	0.8	125	0.10	0.8	465	0.12	0.8	45	0.07	0.6	30	0.15	1.0
	T8315	0.4	165	0.10	0.8	95	0.09	0.8	155	0.10	0.8	495	0.12	0.8	40	0.07	0.6	30	0.15	1.0

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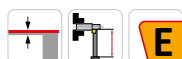
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



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

TCGT 16T304E-SF3	H07	0.4	—	—	—	80	0.09	1.0	125	0.10	1.0	405	0.12	1.0	40	0.07	0.8	—	—	—
	T6310	0.4	150	0.10	1.0	105	0.09	1.0	120	0.10	1.0	450	0.12	1.0	45	0.07	0.8	30	0.15	1.0
	T8315	0.4	160	0.10	1.0	95	0.09	1.0	150	0.10	1.0	480	0.12	1.0	40	0.07	0.8	30	0.15	1.0
TCGT 16T308E-SF3	H07	0.8	—	—	—	90	0.09	1.2	145	0.10	1.2	470	0.12	1.2	45	0.08	1.0	—	—	—
	T6310	0.8	175	0.10	1.2	125	0.09	1.2	140	0.10	1.2	525	0.12	1.2	50	0.08	1.0	35	0.15	1.0
	T8315	0.8	185	0.10	1.2	110	0.09	1.2	175	0.10	1.2	555	0.12	1.2	45	0.08	1.0	35	0.15	1.0
TCGT 16T312E-SF3	T6310	1.2	150	0.20	1.2	105	0.18	1.2	120	0.20	1.2	450	0.24	1.2	45	0.14	1.0	30	0.15	1.0



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

TCGT 110202ER-SI	T8315	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T8330	0.2	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T8430	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
TCGT 110204ER-SI	T8330	0.4	180	0.12	0.8	105	0.11	0.8	170	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
	T8430	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—



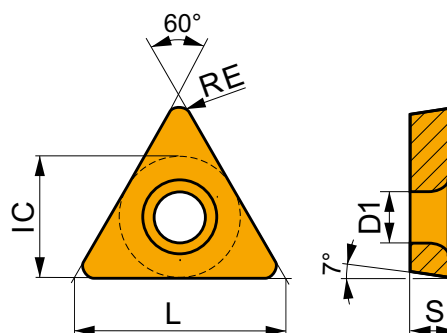
EL-SI geometry with positive left-handed design for fine-finish machining, and continuous cuts.

TCGT 110202EL-SI	T8315	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T8330	0.2	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T8430	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
TCGT 110204EL-SI	T8315	0.4	195	0.12	0.8	115	0.11	0.8	185	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
	T8330	0.4	180	0.12	0.8	105	0.11	0.8	170	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
	T8430	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—

TCMT

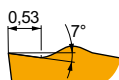
PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	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 (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



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

TCMT 06T102E-FF2	T8330	0.2	175	0.05	0.8	—	—	—	165	0.05	0.8	—	—	—	—	—	—	—	—
	T8430	0.2	235	0.05	0.8	—	—	—	190	0.05	0.8	—	—	—	—	—	—	—	—
	T9315	0.2	335	0.05	0.8	—	—	—	315	0.05	0.8	—	—	—	—	—	—	—	—