



New products

2017.



MILLING CUTTERS AND INSERTS

4

- SOD05 / ODMT 05
Versatile tools for face, shoulder and copy milling

17

- SSO050 / SOMT 05
Economical tools for shoulder milling



MILLING INSERTS

22

- TNGX 10
Inserts for economical shoulder milling

24

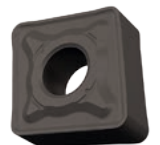
- RDMT 07-16
Direct-pressed copy milling inserts



TURNING INSERTS

29

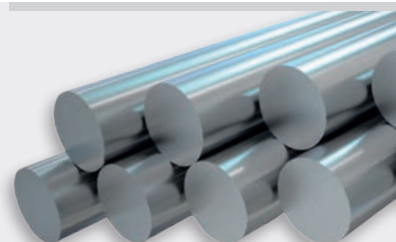
- NRM chipbreaker
Negative inserts for roughing of stainless steel



BAR PEELING INSERTS

35

- MM chipbreaker
Inserts for bar peeling of stainless steel



MILLING CUTTERS AND INSERTS



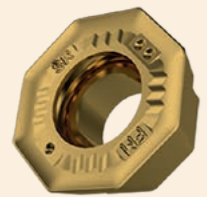
VERSATILE TOOLS FOR FACE, SHOULDER AND COPY MILLING

Popular line of face milling cutters with OEHT inserts has been expanded with a new range of versatile cutters capable of carrying octagonal (OD), round (RD) and square (SD) shaped inserts.

FEATURES & BENEFITS

- Range of cutters and insert shapes and geometries for wide variety of applications:
 - Roughing to finishing.
 - Face milling, shoulder milling, slotting, plunging, ramping
 - Wide range of workpiece materials
- All types of inserts have the same radial and axial positions of edges - useful for CNC programming or manual operations
- **Versatile tool** – One cutter for broad range of operations
- **Easy to use for operators** – Same cutter for mixed production
- **Economical** – 8 cutting edges of ODxT insert
- **Productive** – higher depths of cut with SDxT inserts

INSERT TYPES



OD

OCTAGONAL

Face and shoulder milling

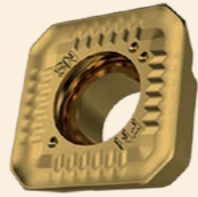
- 8 cutting edges



RD

ROUND

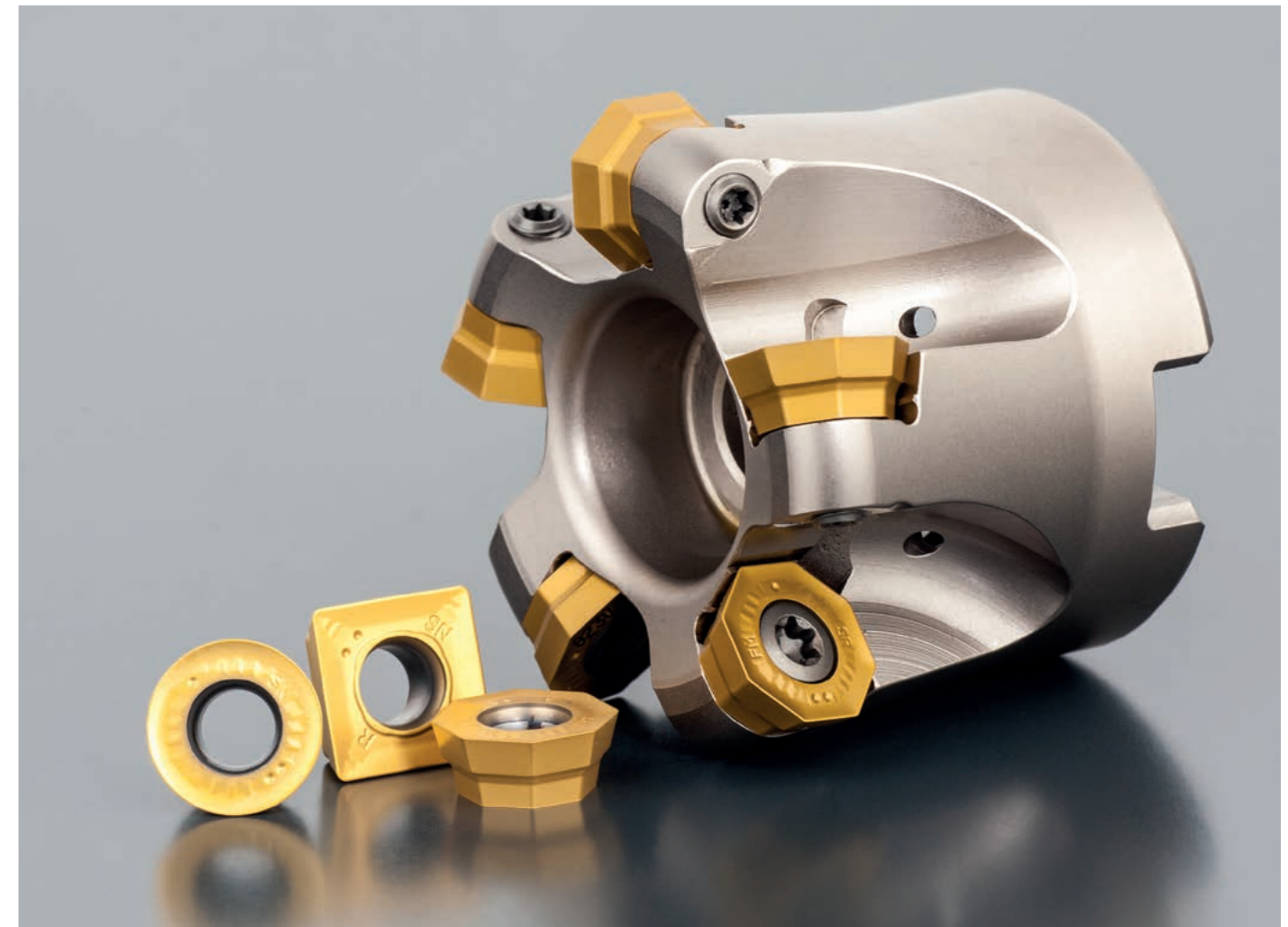
High feed roughing, shallow profiling, ramping



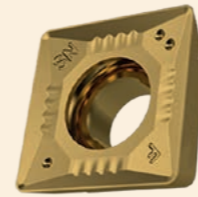
SD

SQUARE

Economical square shoulder milling with 4 cutting edges



INSERT GEOMETRIES

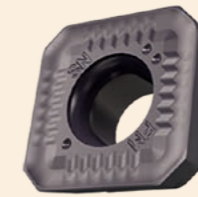


F

GEOMETRY F

Primary choice for low carbon steels, non-ferrous materials

- Positive geometry
- Finishing

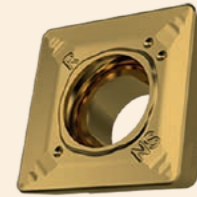


FM

GEOMETRY FM

Steels, stainless steels

- Positive geometry with protective chamfer
- Universal – semi-finishing to medium machining



R

GEOMETRY R

Steels, cast iron

- Suitable for unstable cutting conditions

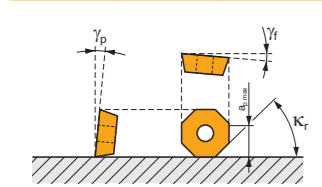
SOD05

P M K N S

S



κ_r	45°
a_{pmax}	3,0 (10,0) mm



ISO	D	D ₁	L	d	d ₁	l ₁	κ _r	b	t	γ _r °	γ _p °	ISO	max.	kg	ISO	ISO	ISO		
32N3R045A25-SOD05-C	24,7	32	130	25	-	45	45	-	-	-10	8	3	-	17700	#	0,41	GI326	FA049	-
40N3R045A32-SOD05-C	32,6	40	150	32	-	45	45	-	-	-7	8	3	-	15800	#	0,83	GI326	FA040	-
40A03R-S45OD05-C	32,7	40	40	16	14	-	45	8,4	5,6	-10	8	3	-	15800	#	0,16	GI326	FA042	-
50A04R-S45OD05-C	42,6	50	40	22	18	-	45	10,4	6,3	-7	8	4	-	14100	#	0,24	GI326	FA043	-
50A05R-S45OD05-C	42,6	50	40	22	18	-	45	10,4	6,3	-7	8	5	-	14100	#	0,25	GI326	FA043	-
63A05R-S45OD05-C	55,6	63	40	22	18	-	45	10,4	6,3	-7	8	5	#	12600	#	0,36	GI326	FA043	-
63A06R-S45OD05-C	55,6	63	40	22	18	-	45	10,4	6,3	-7	8	6	#	12600	#	0,36	GI326	FA043	-
80A06R-S45OD05-C	72,6	80	50	27	38	-	45	12,4	7	-7	8	6	#	11100	#	0,62	GI326	FA041	AC001
80A08R-S45OD05-C	72,6	80	50	27	38	-	45	12,4	7	-7	8	8	#	11100	#	0,65	GI326	FA041	AC001
100A07R-S45OD05-C	92,6	100	50	32	45	-	45	14,4	8	-7	8	7	#	10000	#	1,06	GI326	FA041	AC002
125A08R-S45OD05-C	117,6	125	63	40	56	-	45	16,4	9	-7	8	8	#	8900	#	2,19	GI326	FA041	AC003

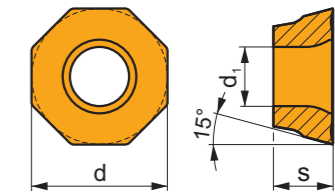
GI326	OD.. 0505..	RD.. 1205..	SDKT 1205..	SDMT 1205..SN

		Nm					
FA040	US 45014-T20P	5	M 5	13	Flag T20P	-	-
FA041	US 45014-T20P	5	M 5	13	-	SDR T20P-T	-
FA042	US 45014-T20P	5	M 5	13	-	SDR T20P-T	HS 90835
FA043	US 45014-T20P	5	M 5	13	-	SDR T20P-T	HS 1030C
FA049	US 45011-T20P	5	M 5	11	Flag T20P	-	-

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

ODKT 05IM

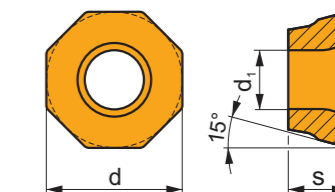
	d	d ₁	s
0505	12,700	5,5	5,56



i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
	ODKT 0505ADFR-F	M8310	■	■			□		●	-	0,8	0,05	0,25	0,2	2,7
	ODKT 0505ADSR-FM	M9340	■	■			□		●	---	0,8	0,17	0,26	0,3	2,7
		M8310	■	■	■		□		●	-	0,8	0,17	0,35	0,3	2,7
		M8345	■	■			□		●	+/-	0,8	0,17	0,35	0,3	2,7
		8230	■	■	■		□		●	-	0,8	0,17	0,35	0,3	2,7

ODMT 05IM

	d	d ₁	s
0505	12,700	5,5	5,56

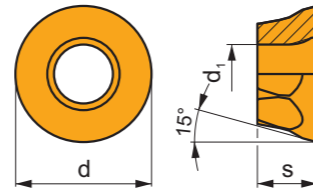


i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
	ODMT 0505ADSR-FM	M9340	■	■			□		●	---	0,8	0,17	0,26	0,3	3,0
		M8340	■	■	■		□		●	+/-	0,8	0,17	0,35	0,3	3,0

i	ISO		P	M	K	N	S	H	?		r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
 	ODMT 050508SN-R	M9340	■						✘	---	0,8	0,23	0,34	0,3	3,0
		8230	■	■					✘	-	0,8	0,23	0,45	0,3	3,0

RDGT 12IM

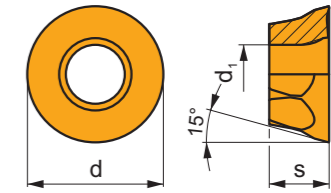
	d	d ₁	s
1205	12,700	5,5	5,56



i	ISO		P	M	K	N	S	H	?		r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
 	RDGT 120500FN-F	M8310	■	■			□		●	-	-	0,05	0,25	0,2	6,0
 	RDGT 120500SN-FM	M8345	■	■			□		●	+/-	-	0,12	0,35	0,2	6,0
		8230	■	■	■		□		●	-	-	0,12	0,35	0,2	6,0

RDMT 12IM

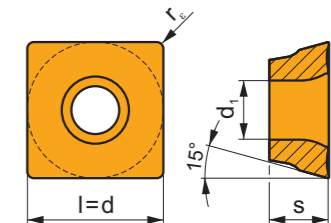
	d	d ₁	s
1205	12,700	5,5	5,56



i	ISO		P	M	K	N	S	H	?		r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
 	RDMT 120500SN-R	M9340	■						●	---	-	0,17	0,34	0,3	6,0
		M8340	■		■				●	+/-	-	0,17	0,45	0,3	6,0
		8230	■	■			□		●	---	-	0,17	0,45	0,3	6,0

SDKT 12IM

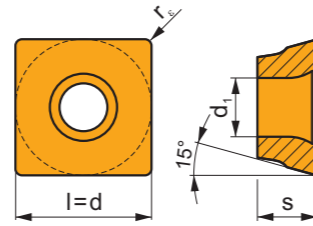
	d	d ₁	l	s
1205	12,700	5,5	12,700	5,56



i	ISO		P	M	K	N	S	H	?		r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
 	SDKT 1205PDR-F	8215	■	■		■	□		●	-	0,8	0,05	0,25	0,2	10,0
 	SDKT 1205PDSR-FM	M8345	■	■			□		●	+/-	0,8	0,15	0,35	0,2	10,0
		8230	■	■	■		□		●	-	0,8	0,15	0,35	0,2	10,0
 	SDKT 1205AESN-FM	M8345	■	■			□		●	+/-	-	0,15	0,35	0,2	10,0
		8230	■	■	■		□		●	-	-	0,15	0,35	0,2	10,0

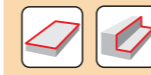
SDMT 12IM

	d	d ₁	l	s
1205	12,700	5,5	12,700	5,56



i	ISO		P	M	K	N	S	H			r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
	SDMT 120508SN-F	M8310	■	■			□		☉	-	0,8	0,15	0,30	0,3	10,0
		8230	■	■		□	□		☉	-	0,8	0,15	0,30	0,3	10,0
	SDMT 120508SN-FM	M8345	■	■			□		☉	+/-	0,8	0,15	0,35	0,3	10,0
	SDMT 120508SN-R	M9340	■						☉	---	0,8	0,17	0,34	0,3	10,0
		M8345	■						☉	+/-	0,8	0,17	0,45	0,3	10,0
	SDMT 1205AESN-R	M8340	■	■					☉	+/-	-	0,17	0,45	0,3	10,0
		8230	■	■					☉	-	-	0,17	0,45	0,3	10,0

ISO	f _{min}	f _{max}	M9340	M8310	M8340	M8345	8215	8230	
P	●	0,07	0,30	320	329	293	212	315	288
	☉	0,07	0,25	284	297	257	180	275	252
	☉	0,07	0,15	252	266	221	153	234	216
M	●	0,07	0,25	189	198	176	126	189	171
	☉	0,07	0,20	171	176	153	108	162	153
	☉	0,07	0,15	149	158	131	90	140	131
K	●	0,07	0,30	-	311	275	-	297	275
	☉	0,07	0,25	-	284	243	-	261	239
	☉	0,07	0,15	-	252	212	-	221	207
N	●	0,07	0,30	-	-	-	-	792	725
	☉	0,07	0,25	-	-	-	-	689	639
	☉	0,07	0,15	-	-	-	-	590	549
S	●	0,07	0,25	95	99	86	63	95	86
	☉	0,07	0,20	86	86	77	54	81	77
	☉	0,07	0,15	72	77	63	45	68	63

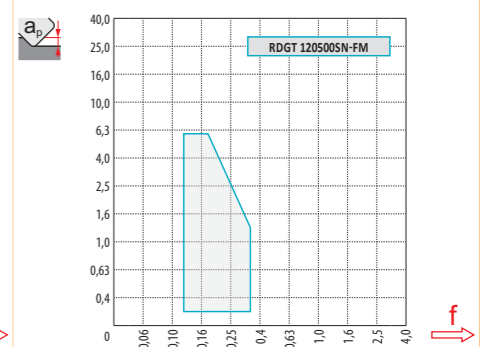
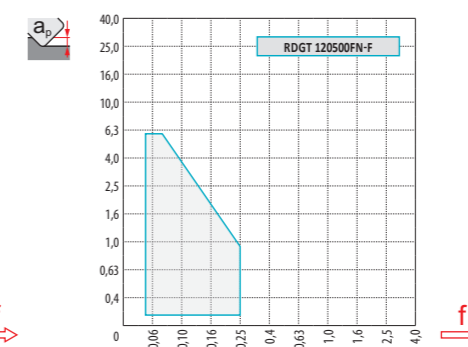
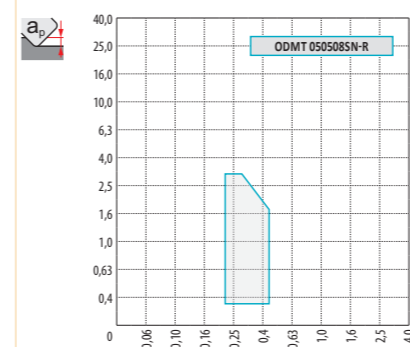
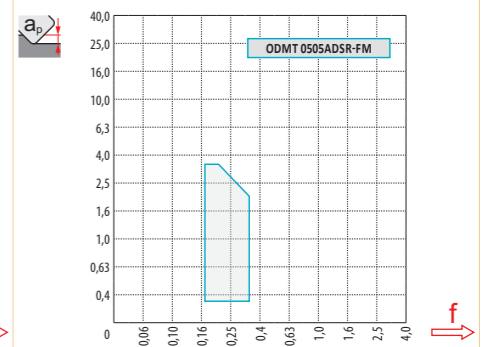
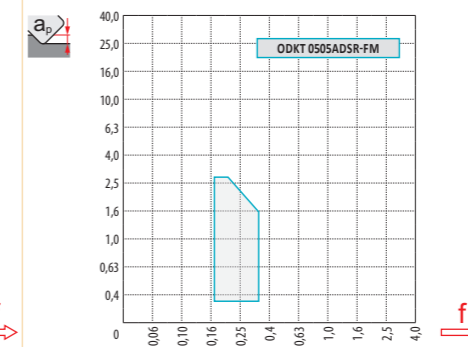
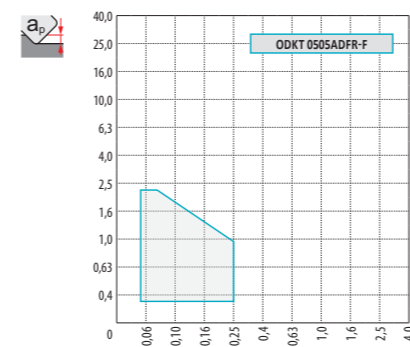


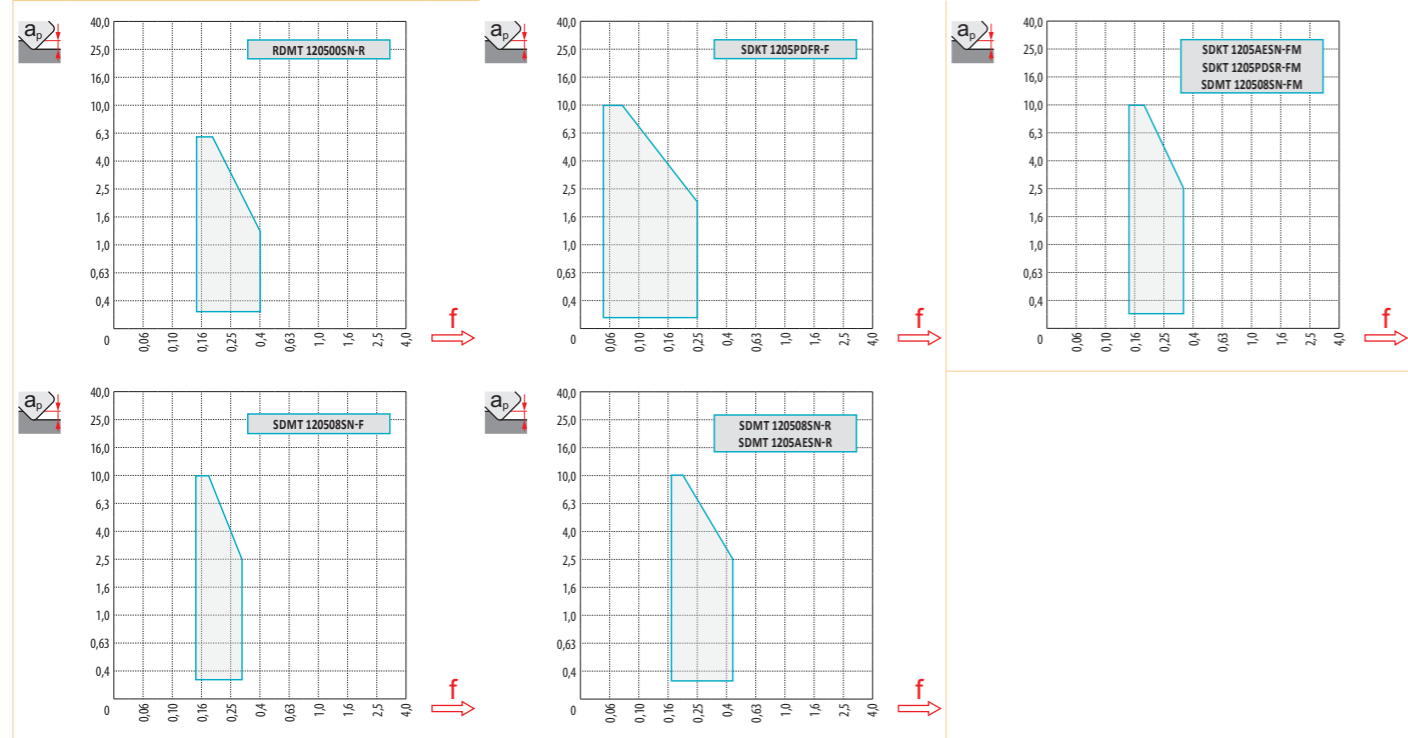
a _p /D	0,05	0,10	0,15	0,20	0,25	0,30	0,40	0,50	0,60	0,70	0,75	0,80	0,90	1,00
	1,48	1,35	1,27	1,22	1,19	1,16	1,11	1,08	1,05	1,03	1,00	1,00	1,00	1,00
	2,87	2,05	1,69	1,48	1,33	1,23	1,09	0,75	0,94	0,90	0,89	0,88	0,88	1,00
	0,64	0,64	0,64	0,64	0,64	0,65	0,65	0,67	0,68	0,71	0,72	0,74	0,79	1,00

	ODKT 05-F	ODKT 05-FM	ODMT 05-FM	ODMT 05-R
	0,4	0,8	0,8	0,8
	1,00	1,00	-	-

	RDGT 12-F	RDGT 12-FM	RDGT 12-R
	6,35	6,35	6,35
	-	-	-

	SDKT 12-F	SDKT 12-FM	SDMT 12-F	SDMT 12-R
	0,8	0,8	0,8	0,8
	2,30	2,30	-	-





D	R													
	ap	0,25	0,50	0,60	0,70	0,80	1,00	1,25	1,50	2,00	3,00	4,00	5,00	6,00
32		23,43	24,80	25,23	25,62	25,99	26,63	27,33	27,94	28,94	30,39	31,31	31,83	32,00
40		31,43	32,80	33,23	33,62	33,99	34,63	35,33	35,94	36,94	38,39	39,31	39,83	40,00
50		41,43	42,80	43,23	43,62	43,99	44,63	45,33	45,94	46,94	48,39	49,31	49,83	50,00
63		54,43	55,80	56,23	56,62	56,99	57,63	58,33	58,94	59,94	61,39	62,31	62,83	63,00
80		71,43	72,80	73,23	73,62	73,99	74,63	75,33	75,94	76,94	78,39	79,31	79,83	80,00
100		91,43	92,80	93,23	93,62	93,99	94,63	95,33	95,94	96,94	98,39	99,31	99,83	100,00
125		116,43	117,80	118,23	118,62	118,99	119,63	120,33	120,94	121,94	123,39	124,31	124,83	125,00

S

D	X.V	f _{max}
32	1,36	0,28
40	1,40	0,31
50	1,43	0,33
63	1,47	0,37
80	1,52	0,42
100	1,57	0,47
125	1,62	0,52

S

10,0

S

ap	1,0	5,0	10,0
f	0,35	0,21	0,15

D	O		R	
	α_{max}	ap/l	α_{max}	ap/l
50	4,1	7,05/100	3,8	6,2/95
63	2,7	4,6/100	2,5	4,25/100
80	1,8	3/100	1,7	2,85/100
100	1,7	2,85/100	1,6	2,65/100
125	0,7	1,1/100	0,3	0,4/100

D	O				R			
	d _{min}	d _{max}	$\frac{S_{max}}{D_{max}}$	$\frac{S_{max}}{d_{max}}$	d _{min}	d _{max}	$\frac{S_{max}}{D_{max}}$	$\frac{S_{max}}{d_{max}}$
50	78,0	100,0	4,5	4,5	78,0	100,0	4,5	4,5
50	78,0	100,0	4,5	4,5	78,0	100,0	4,5	4,5
63	105,0	126,0	4,5	4,5	105,0	126,0	4,5	4,5
63	105,0	126,0	4,5	4,5	105,0	126,0	4,5	4,5
80	138,0	160,0	4,5	4,5	138,0	160,0	4,5	4,5
80	138,0	160,0	4,5	4,5	138,0	160,0	4,5	4,5
100	178,0	200,0	4,5	4,5	178,0	200,0	4,5	4,5
125	229,0	250,0	4,0	4,5	230,0	250,0	4,0	4,5

ap	O	R
	2,4	2,3



R

R

\overline{D}	μm	3	5	10	15	20	30	40	50	60	80	100
32		0,620	0,800	1,131	1,386	1,600	1,960	2,263	2,530	2,771	3,200	3,578
40		0,693	0,894	1,265	1,549	1,789	2,191	2,530	2,828	3,098	3,578	4,000
50		0,775	1,000	1,414	1,732	2,000	2,449	2,828	3,162	3,464	4,000	4,472
63		0,869	1,122	1,587	1,944	2,245	2,750	3,175	3,550	3,888	4,490	5,020
80		0,980	1,265	1,789	2,191	2,530	3,098	3,578	4,000	4,382	5,060	5,657
100		1,095	1,414	2,000	2,449	2,828	3,464	4,000	4,472	4,899	5,657	6,325
125		1,225	1,581	2,236	2,739	3,162	3,873	4,472	5,000	5,477	6,325	7,071

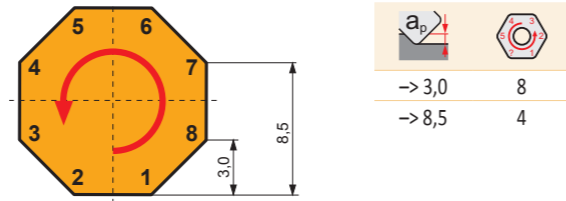
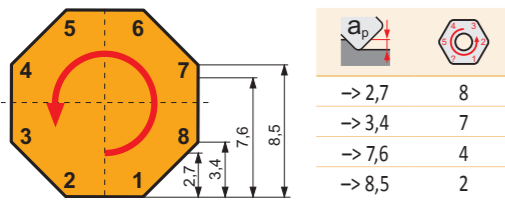
r_e

μm	3	5	10	15	20	30	40	50	60	80	100	
6,0		0,379	0,490	0,693	0,849	0,980	1,200	1,386	1,549	1,697	1,960	2,191

i

ODKT 05

ODMT 05

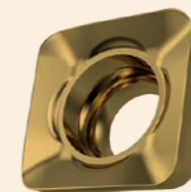


ECONOMICAL TOOLS FOR SHOULDER MILLING

Our range of tools for economical milling has been expanded with small diameter cutters for low depth of cut. New economical inserts SOMT 05 with 4 cutting edges for general machining.

FEATURES & BENEFITS

- Small diameter cutters – wide range 12-40 mm
- Single sided with 4 cutting edges
- Insert radii 0,4 and 0,8 mm
- Depth of cut up to 4,5 mm
- High performance grades for milling steels and stainless steels
- For shoulder milling, face milling, and shallow slot milling and plunging
- **Low costs** – price per cutting edge
- **Productivity** – high number of teeth
- Suitable for milling small parts on light duty machines
- Range of cutters ideally suited for turn-milling

INSERT GEOMETRIES

M
GEOMETRY M

Particularly suited to light and medium machining

- Suitable mainly for steels, stainless steels and cast iron
- Sharp geometry with narrow positive T-land



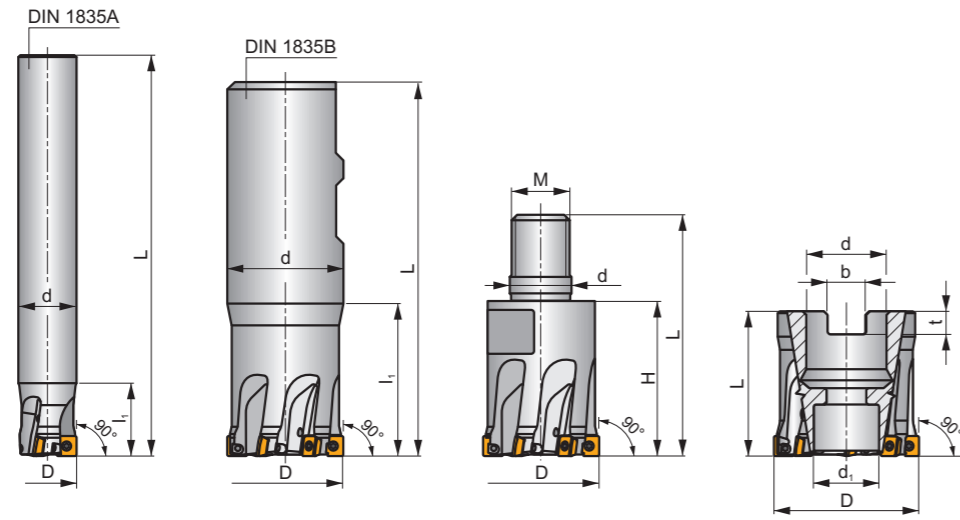
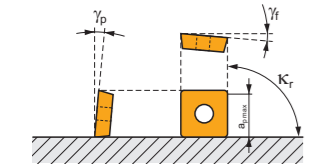
SSO050

P M K N S

S



K_r	90°
a_{pmax}	4,5 mm



h_m	0,04 - 0,08				
h_m	0,04 - 0,06				

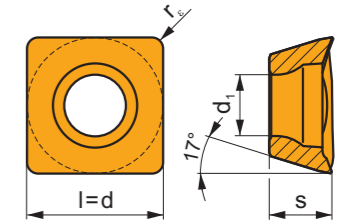
ISO	D	L	d	d ₁	l ₁	H	M	K_r	b	t	γ_i°	γ_p°								
12A2R018A10-SSO050-C	12	90	10	-	18	-	-	90	-	-	-8	8	2	-	58000	#	0,04	GI327	SQ330	-
12A2R018A12-SSO050-C	12	90	12	-	18	-	-	90	-	-	-8	8	2	-	58000	#	0,06	GI327	SQ330	-
16A3R020A14-SSO050-C	16	110	14	-	20	-	-	90	-	-	-5	8	3	-	50300	#	0,11	GI327	SQ330	-
16A3R020A16-SSO050-C	16	110	16	-	20	-	-	90	-	-	-5	8	3	-	50300	#	0,15	GI327	SQ330	-
20A4R020A18-SSO050-C	20	125	18	-	20	-	-	90	-	-	-5	8	4	#	45000	#	0,21	GI327	SQ330	-
20A4R020A20-SSO050-C	20	125	20	-	20	-	-	90	-	-	-5	8	4	#	45000	#	0,26	GI327	SQ330	-
25A5R024A25-SSO050-C	25	140	25	-	24	-	-	90	-	-	-5	8	5	#	40200	#	0,48	GI327	SQ330	-
20A4R032B20-SSO050-C	20	83	20	-	32	-	-	90	-	-	-5	8	4	#	45000	#	0,16	GI327	SQ330	-
25A5R042B25-SSO050-C	25	99	25	-	42	-	-	90	-	-	-5	8	5	#	40200	#	0,31	GI327	SQ330	-
32A6R042B32-SSO050-C	32	103	32	-	42	-	-	90	-	-	-4,5	8	6	#	35500	#	0,54	GI327	SQ330	-
40A8R050B32-SSO050-C	40	111	32	-	50	-	-	90	-	-	-4	8	8	#	31800	#	0,65	GI327	SQ330	-
12A2R020M06-SSO050-C	12	35	6,5	-	-	20	M6	90	-	-	-8	8	2	-	-	#	0,01	GI327	SQ330	-
16A3R023M08-SSO050-C	16	41	8,5	-	-	23	M8	90	-	-	-5	8	3	-	-	#	0,03	GI327	SQ330	-
20A4R030M10-SSO050-C	20	49	10,5	-	-	30	M10	90	-	-	-5	8	4	#	-	#	0,05	GI327	SQ330	-
25A5R035M12-SSO050-C	25	57	12,5	-	-	35	M12	90	-	-	-5	8	5	#	-	#	0,09	GI327	SQ330	-
32A6R043M16-SSO050-C	32	66	17	-	-	43	M16	90	-	-	-4,5	8	6	#	-	#	0,21	GI327	SQ330	-
32A06R-S90S0050-C	32	32	16	12,4	-	-	-	90	8,4	5,6	-4,5	8	6	#	35500	#	0,10	GI327	SQ332	-
40A08R-S90S0050-C	40	40	22	18,1	-	-	-	90	10,4	6,3	-4	8	8	#	31800	#	0,19	GI327	SQ333	-

	GI327		SOMT 0502..
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SQ330	US 62204-T07P	0,8	M 2,2	4,1	Flag T07P	-	-	-
SQ332	US 62204-T07P	0,8	M 2,2	4,1	-	D-T07P/T09P	FG-15	HS 90835
SQ333	US 62204-T07P	0,8	M 2,2	4,1	-	D-T07P/T09P	FG-15	HS 1030C

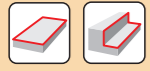
SOMT 05

	d	d ₁	l	s
0502	5,570	2,5	5,570	2,63



i	ISO		P	M	K	N	S	H			r_c	f_{min}	f_{max}	a_{pmin}	a_{pmax}	
	SOMT 050204SR-M	M9340	█	█	█	█	█	█	●	---	0,4	0,03	0,09	0,4	4,5	
		M6330	█	█	█	█	█	█	●	-	0,4	0,03	0,12	0,4	4,5	
		M8310	█	█	█	█	█	█	█	●	-	0,4	0,03	0,12	0,4	4,5
		M8340	█	█	█	█	█	█	█	●	+/-	0,4	0,03	0,12	0,4	4,5
	SOMT 050208SR-M	8215	█	█	█	█	█	█	●	-	0,4	0,03	0,12	0,4	4,5	
		M6330	█	█	█	█	█	█	●	-	0,8	0,03	0,12	0,4	4,5	
		M8340	█	█	█	█	█	█	█	●	+/-	0,8	0,03	0,12	0,4	4,5
		8215	█	█	█	█	█	█	█	●	-	0,8	0,03	0,12	0,4	4,5

ISO	f_{min}	f_{max}	M9340	M6330	M8310	M8340	8215	
P	●	0,03	0,12	280	255	290	260	280
P	●	0,03	0,08	250	225	260	225	240
P	✘	0,03	0,05	220	200	235	195	205
M	●	0,03	0,12	165	165	175	155	165
M	●	0,03	0,08	150	145	155	135	140
M	✘	0,03	0,05	130	125	140	115	120
K	●	0,03	0,12	-	-	275	240	260
K	●	0,03	0,08	-	-	250	215	230
K	✘	0,03	0,05	-	-	220	185	195
N	●	0,03	0,12	-	-	-	-	1010
N	●	0,03	0,08	-	-	-	-	880
N	✘	0,03	0,05	-	-	-	-	450
S	●	0,03	0,12	80	80	85	75	80
S	●	0,03	0,08	75	70	75	65	70
S	✘	0,03	0,05	60	60	65	55	60



a_p/D	0,05	0,10	0,15	0,20	0,25	0,30	0,40	0,50	0,60	0,70	0,75	0,80	0,90	1,00
$X.v$	1,48	1,35	1,27	1,22	1,19	1,16	1,11	1,08	1,05	1,03	1,00	1,00	1,00	1,00
$X.f$	2,87	2,05	1,69	1,48	1,33	1,23	1,09	0,75	0,94	0,90	0,89	0,88	0,88	1,00
$X.f$	0,64	0,64	0,64	0,64	0,64	0,65	0,65	0,67	0,68	0,71	0,72	0,74	0,79	1,00



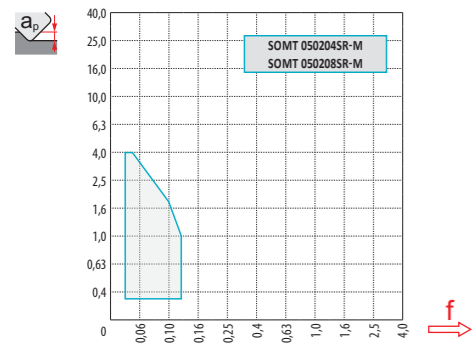
SOMT 05-M



0,4 0,8



- -



1,5



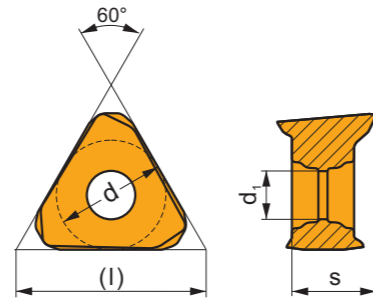
a_p	1,0	2,0	4,0
$X.f$	0,12	0,08	0,03

MILLING INSERTS



TNGX 10

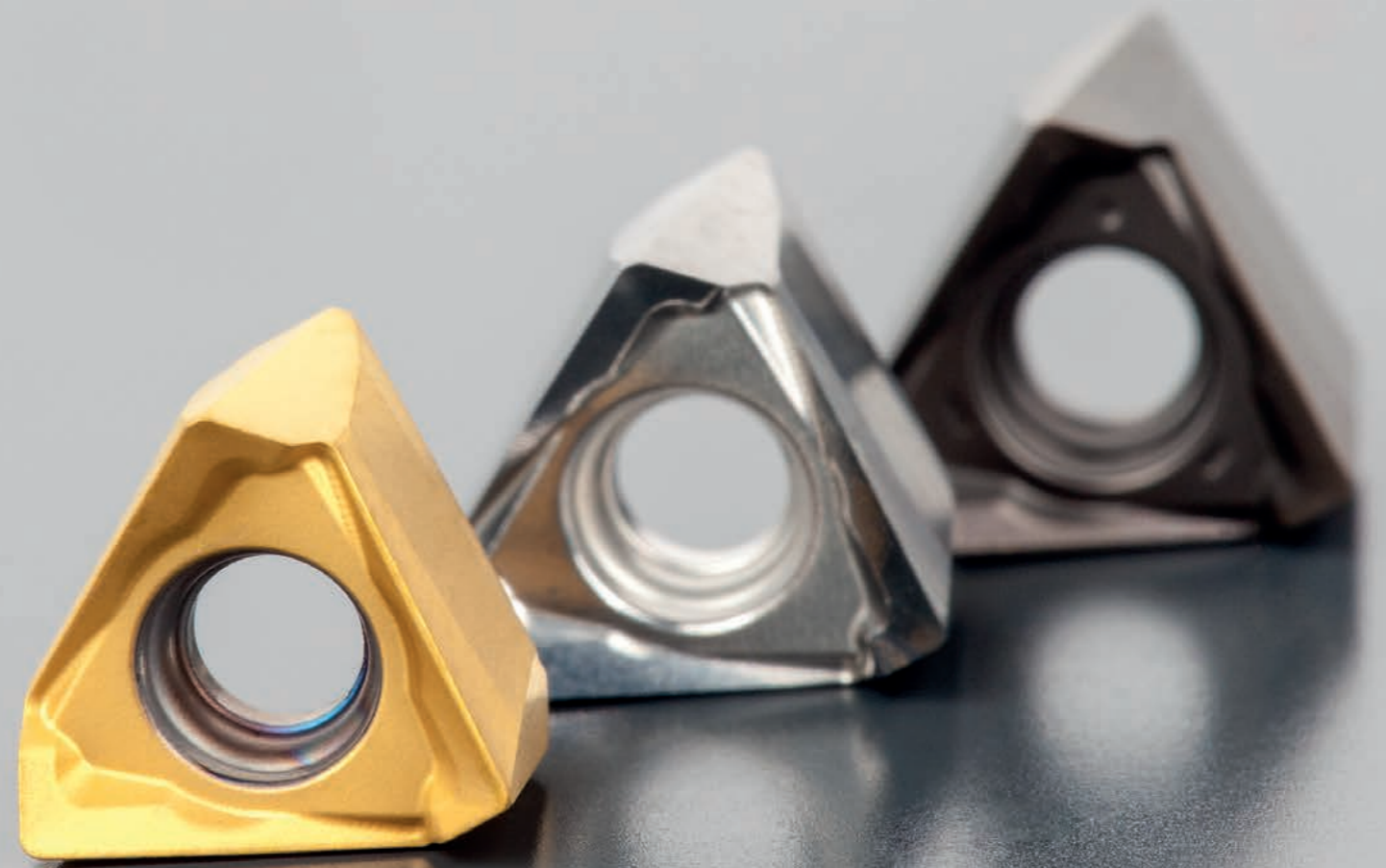
	d	d ₁	l	s
1004	6,000	2,8	10,39	4,69



2017
M127

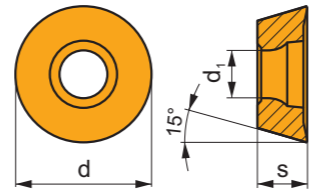
i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
	TNGX 100404SR-F	M6330	☑	☑			☑		●	-	0,4	0,03	0,11	0,1	5,0
	TNGX 100408SR-F	M6330	☑	☑			☑		●	-	0,8	0,03	0,11	0,1	5,0
	TNGX 100408SR-M	M6330	☑	☑			☑		●	-	0,8	0,05	0,15	0,3	5,0

ISO		f _{min}	f _{max}	M6330
P	●	0,05	0,15	224
	☑	0,05	0,11	200
	✘	0,05	0,08	175
M	●	0,05	0,12	147
	☑	0,05	0,05	130
	✘	0,05	0,06	112
K	●	0,05	0,15	-
	☑	0,05	0,10	-
	✘	0,05	0,08	-
N	●	0,05	0,20	-
	☑	0,05	0,15	-
	✘	0,05	0,10	-
S	●	0,05	0,12	74
	☑	0,05	0,08	63
	✘	0,05	0,06	56



RDMT 07

	d	d ₁	s
0702	7,000	2,8	2,38

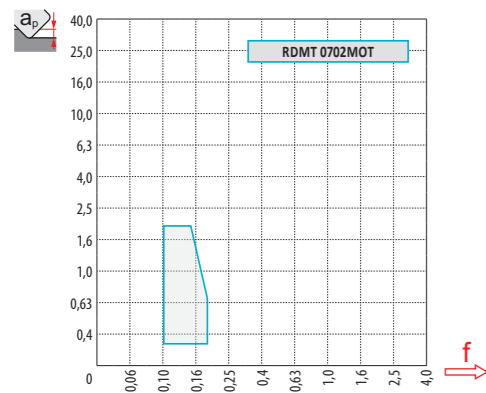


i ISO P M K N S H r_c f_{min} f_{max} a_{p min} a_{p max}

HFC RDMT 0702MOT M8325 - - 0,10 0,20 0,3 2,0

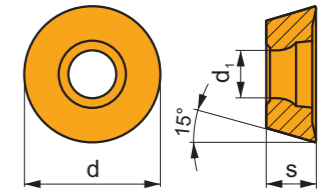
S 0,10 14° 20°

ISO	f _{min}	f _{max}	M8325
P		0,10 0,20	308
		0,10 0,17	275
		0,10 0,15	242
M		0,10 0,20	182
		0,10 0,17	165
		0,10 0,15	143
K		0,10 0,20	292
		0,10 0,17	259
		0,10 0,15	231
N		0,10 0,20	-
		0,10 0,17	-
		0,10 0,15	-
S		0,10 0,20	-
		0,10 0,15	-
		0,10 0,10	-
H		0,10 0,20	-
		0,10 0,15	-
		0,10 0,10	-



RDMT 10

	d	d ₁	s
1003	10,000	3,9	3,18

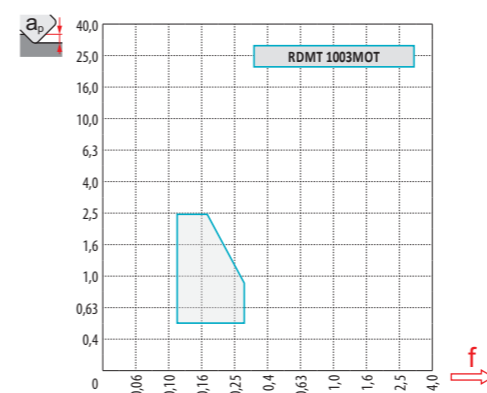


i ISO P M K N S H r_c f_{min} f_{max} a_{p min} a_{p max}

HFC RDMT 1003MOT M8325 M8345 - - 0,12 0,30 0,5 2,5

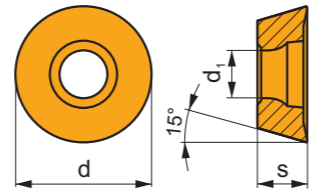
S 0,12 15° 20°

ISO	f _{min}	f _{max}	M8325	M8345
P		0,10 0,30	308	259
		0,10 0,25	275	220
		0,10 0,15	242	187
M		0,10 0,30	182	154
		0,10 0,25	165	132
		0,10 0,15	143	110
K		0,10 0,30	292	-
		0,10 0,25	259	-
		0,10 0,15	231	-
N		0,10 0,30	-	-
		0,10 0,25	-	-
		0,10 0,15	-	-
S		0,10 0,30	-	77
		0,10 0,25	-	66
		0,10 0,15	-	55
H		0,10 0,30	-	-
		0,10 0,20	-	-
		0,10 0,12	-	-



RDMT 12

	d	d ₁	s
12T3	12,000	3,9	3,97



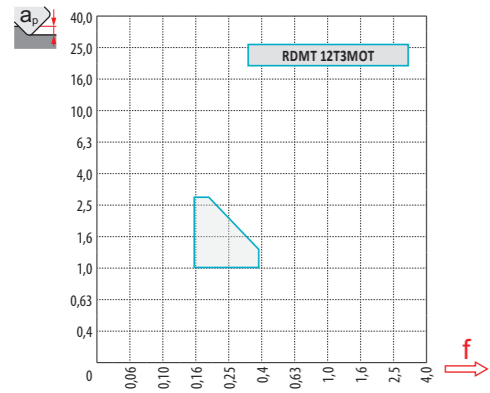
i ISO P M K N S H r_c f_{min} f_{max} a_{p min} a_{p max}

HFC RDMT 12T3MOT M8325 M8345

S

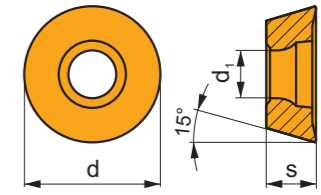
Material	Surface	r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
M8325	●	-	0,15	0,35	1,0	3,0
M8345	✱	+/-	0,15	0,35	1,0	3,0

ISO	f _{min}	f _{max}	M8325	M8345
P	●	0,10 0,35	308	259
	☉	0,10 0,30	275	220
	✱	0,10 0,20	242	187
M	●	0,10 0,35	182	154
	☉	0,10 0,30	165	132
	✱	0,10 0,20	143	110
K	●	0,10 0,35	292	-
	☉	0,10 0,30	259	-
	✱	0,10 0,20	231	-
N	●	0,10 0,35	-	-
	☉	0,10 0,30	-	-
	✱	0,10 0,20	-	-
S	●	0,10 0,30	-	77
	☉	0,10 0,25	-	66
	✱	0,10 0,15	-	55
H	●	0,10 0,30	-	-
	☉	0,10 0,20	-	-
	✱	0,10 0,15	-	-



RDMT 16

	d	d ₁	s
1604	16,000	5,2	4,76



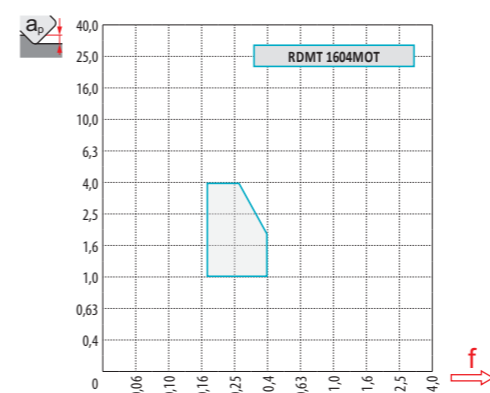
i ISO P M K N S H r_c f_{min} f_{max} a_{p min} a_{p max}

HFC RDMT 1604MOT M8325 M8345

S

Material	Surface	r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
M8325	●	-	0,18	0,40	1,0	4,0
M8345	✱	+/-	0,18	0,40	1,0	4,0

ISO	f _{min}	f _{max}	M8325	M8345
P	●	0,10 0,40	308	259
	☉	0,10 0,30	275	220
	✱	0,10 0,18	242	187
M	●	0,10 0,30	182	154
	☉	0,10 0,25	165	132
	✱	0,10 0,17	143	110
K	●	0,10 0,40	292	-
	☉	0,10 0,30	259	-
	✱	0,10 0,18	231	-
N	●	0,10 0,40	-	-
	☉	0,10 0,30	-	-
	✱	0,10 0,18	-	-
S	●	0,10 0,30	-	77
	☉	0,10 0,25	-	66
	✱	0,10 0,17	-	55
H	●	0,10 0,25	-	-
	☉	0,10 0,20	-	-
	✱	0,10 0,15	-	-



TURNING INSERTS

NRM

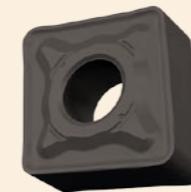
TURNING INSERTS

NEGATIVE INSERTS FOR ROUGHING OF STAINLESS STEEL

New negative inserts have been developed for roughing and semi-roughing of stainless steel and soft steel. The chipbreaker is available for both double-sided and large single-sided inserts.

FEATURES & BENEFITS

- Broad range of depth of cut
- Wide chip-groove
- Double-sided inserts can be used for roughing and semi-roughing operations
- Single-sided inserts can also be used for lower feeds and depths of cut
- Roughing of stainless steel without risk of work hardening
- Designed for **serial production** - high performance and higher feeds
- **Excellent chip-breaking** in stainless steel even at lower feeds
- **Good chip evacuation** in wide application area



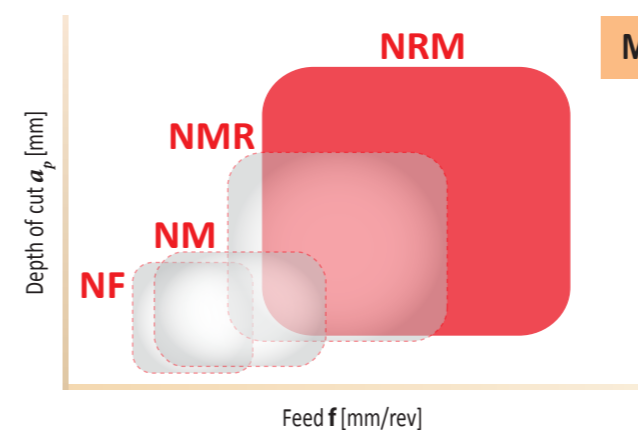
NRM

CHIP BREAKER NRM

Roughing and semi-roughing

- Positive geometry with wide T-land
- For stainless steel and soft steel
- Double-sided and single-sided inserts

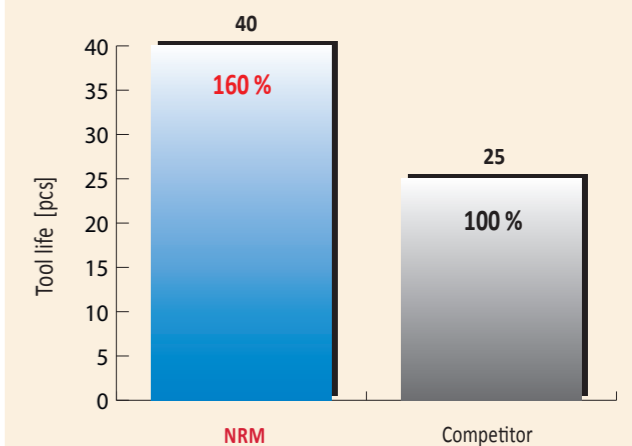
AREA OF APPLICATION



MACHINING EXAMPLE

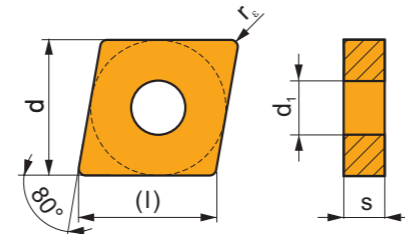
Material: DIN 1.4301
 Material group: M
 Insert: CNMG 120408-NRM: T7335

Cutting speed	v_c	150	m/min
Feed	f	0,27	mm/rev
Depth of cut	a_p	4	mm

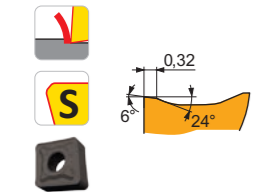


CNMG

	d	d ₁	l	s
1204	12,700	5,16	12,9	4,76
1606	15,875	6,35	16,1	6,35
1906	19,050	7,94	19,3	6,35
2509	25,400	9,12	25,8	9,525

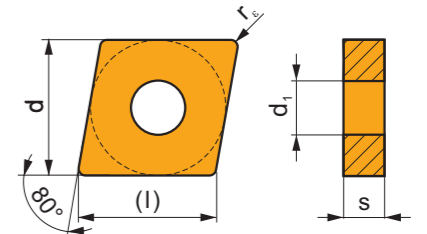


i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
✓	CNMG 120408-NRM	T7325	■	■					☉	++	0,8	0,23	0,55	0,8	7,0
		T7335	■	■					☉	++	0,8	0,23	0,55	0,8	7,0
		T9315	■	■					☉	++	0,8	0,23	0,55	0,8	7,0
✓	CNMG 120412-NRM	T7325	■	■					☉	++	1,2	0,25	0,70	1,2	7,0
		T7335	■	■					☉	+++	1,2	0,25	0,70	1,2	7,0
		T9315	■	■					☉	++	1,2	0,25	0,70	1,2	7,0
✓	CNMG 120416-NRM	T7325	■	■					☉	++	1,6	0,30	0,75	1,6	7,0
		T7335	■	■					☉	+++	1,6	0,30	0,75	1,6	7,0
		T9315	■	■					☉	++	1,6	0,30	0,75	1,6	7,0
✓	CNMG 160608-NRM	T7325	■	■					☉	++	0,8	0,27	0,60	0,8	8,0
		T7335	■	■					☉	+++	0,8	0,27	0,60	0,8	8,0
		T9315	■	■					☉	++	0,8	0,27	0,60	0,8	8,0
✓	CNMG 160612-NRM	T7325	■	■					☉	++	1,2	0,28	0,70	1,2	8,0
		T7335	■	■					☉	+++	1,2	0,28	0,70	1,2	8,0
		T9315	■	■					☉	++	1,2	0,28	0,70	1,2	8,0
✓	CNMG 160616-NRM	T7325	■	■					☉	++	1,6	0,30	0,80	1,6	8,0
		T7335	■	■					☉	+++	1,6	0,30	0,80	1,6	8,0
		T9315	■	■					☉	++	1,6	0,30	0,80	1,6	8,0
✓	CNMG 190608-NRM	T7325	■	■					☉	++	0,8	0,28	0,60	0,8	10,0
		T7335	■	■					☉	+++	0,8	0,28	0,60	0,8	10,0
		T9315	■	■					☉	++	0,8	0,28	0,60	0,8	10,0
✓	CNMG 190612-NRM	T7325	■	■					☉	++	1,2	0,32	0,70	1,2	10,0
		T7335	■	■					☉	+++	1,2	0,32	0,70	1,2	10,0
		T9315	■	■					☉	++	1,2	0,32	0,70	1,2	10,0
✓	CNMG 190616-NRM	T7325	■	■					☉	+++	1,6	0,32	0,80	1,6	10,0
		T7335	■	■					☉	+++	1,6	0,32	0,80	1,6	10,0
		T9315	■	■					☉	++	1,6	0,32	0,80	1,6	10,0
✓	CNMG 250924-NRM	T7325	■	■					☉	+++	2,4	0,35	1,00	2,0	15,0
		T7335	■	■					☉	+++	2,4	0,35	1,00	2,0	15,0
		T9315	■	■					☉	+++	2,4	0,35	1,00	2,0	15,0

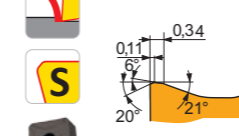


CNMM

	d	d ₁	l	s
2509	25,400	9,12	25,8	9,525

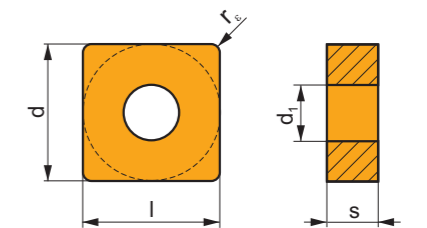


i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
✓	CNMM 250924-NRM	T7325	■	■					☉	+++	2,4	0,35	1,00	2,0	16,0
		T7335	■	■					☉	+++	2,4	0,35	1,00	2,0	16,0
		T9315	■	■					☉	+++	2,4	0,35	1,00	2,0	16,0

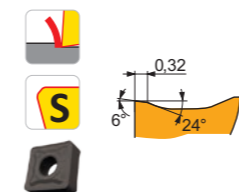





SNMG

	d	d ₁	l	s
1204	12,700	5,16	12,700	4,76
1506	15,875	6,35	15,875	6,35
1906	19,050	7,94	19,050	6,35
2507	25,400	9,12	25,400	7,94
2509	25,400	9,12	25,400	9,525



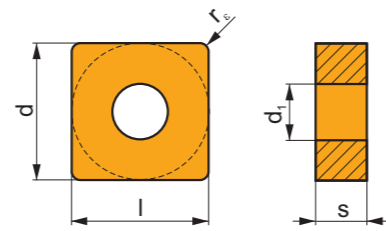
i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
✓	SNMG 120408-NRM	T7325	■	■					☉	++	0,8	0,23	0,55	0,8	7,0
		T7335	■	■					☉	++	0,8	0,23	0,55	0,8	7,0
		T9315	■	■					☉	++	0,8	0,23	0,55	0,8	7,0
✓	SNMG 120412-NRM	T7325	■	■					☉	++	1,2	0,25	0,70	1,2	7,0
		T7335	■	■					☉	++	1,2	0,25	0,70	1,2	7,0
		T9315	■	■					☉	++	1,2	0,25	0,70	1,2	7,0
✓	SNMG 150612-NRM	T7325	■	■					☉	++	1,2	0,28	0,70	1,2	8,0
		T7335	■	■					☉	+++	1,2	0,28	0,70	1,2	8,0
		T9315	■	■					☉	++	1,2	0,28	0,70	1,2	8,0
✓	SNMG 150616-NRM	T7325	■	■					☉	++	1,6	0,30	0,80	1,6	8,0
		T7335	■	■					☉	+++	1,6	0,30	0,80	1,6	8,0
		T9315	■	■					☉	++	1,6	0,30	0,80	1,6	8,0
✓	SNMG 190612-NRM	T7325	■	■					☉	++	1,2	0,32	0,70	1,2	10,0
		T7335	■	■					☉	+++	1,2	0,32	0,70	1,2	10,0
		T9315	■	■					☉	++	1,2	0,32	0,70	1,2	10,0
✓	SNMG 190616-NRM	T7325	■	■					☉	++	1,6	0,32	0,80	1,6	10,0
		T7335	■	■					☉	+++	1,6	0,32	0,80	1,6	10,0
		T9315	■	■					☉	++	1,6	0,32	0,80	1,6	10,0
✓	SNMG 250724-NRM	T7325	■	■					☉	++	2,4	0,35	1,00	2,0	14,0
		T7335	■	■					☉	+++	2,4	0,35	1,00	2,0	14,0
		T9315	■	■					☉	++	2,4	0,35	1,00	2,0	14,0
✓	SNMG 250924-NRM	T7325	■	■					☉	++	2,4	0,35	1,00	2,0	15,0











i	ISO		P	M	K	N	S	H	?		r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
  	SNMG 250924-NRM	T7335	█	█			□		✘	+++	2,4	0,35	1,00	2,0	15,0
		T9315	█						⊗	++	2,4	0,35	1,00	2,0	15,0

SNMM

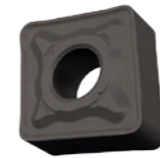
	d	d ₁	l	s
2507	25,400	9,12	25,400	7,94
2509	25,400	9,12	25,400	9,525



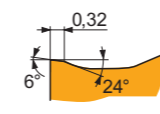
2017
T95

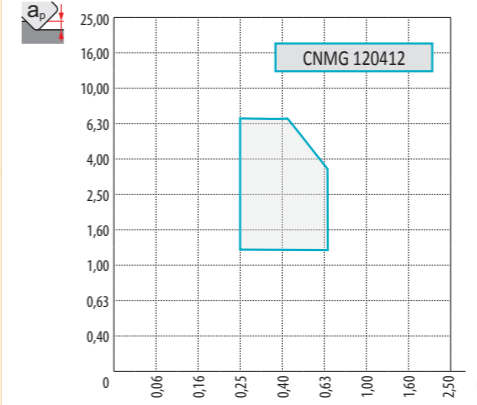
i	ISO		P	M	K	N	S	H	?		r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
  	SNMM 250716-NRM	T7325	█	█			□		✘	++	1,6	0,32	0,90	1,6	14,0
		T7335	█	█			□		✘	+++	1,6	0,32	0,90	1,6	14,0
		T9315	█						⊗	++	1,6	0,32	0,90	1,6	14,0
 	SNMM 250724-NRM	T7325	█	█			□		✘	++	2,4	0,35	1,00	2,0	14,0
		T7335	█	█			□		✘	+++	2,4	0,35	1,00	2,0	14,0
  	SNMM 250924-NRM	T7325	█	█			□		✘	++	2,4	0,35	1,00	2,0	16,0
		T7335	█	█			□		✘	+++	2,4	0,35	1,00	2,0	16,0
		T9315	█						⊗	++	2,4	0,35	1,00	2,0	16,0




GEOMETRY OF CUTTING INSERTS



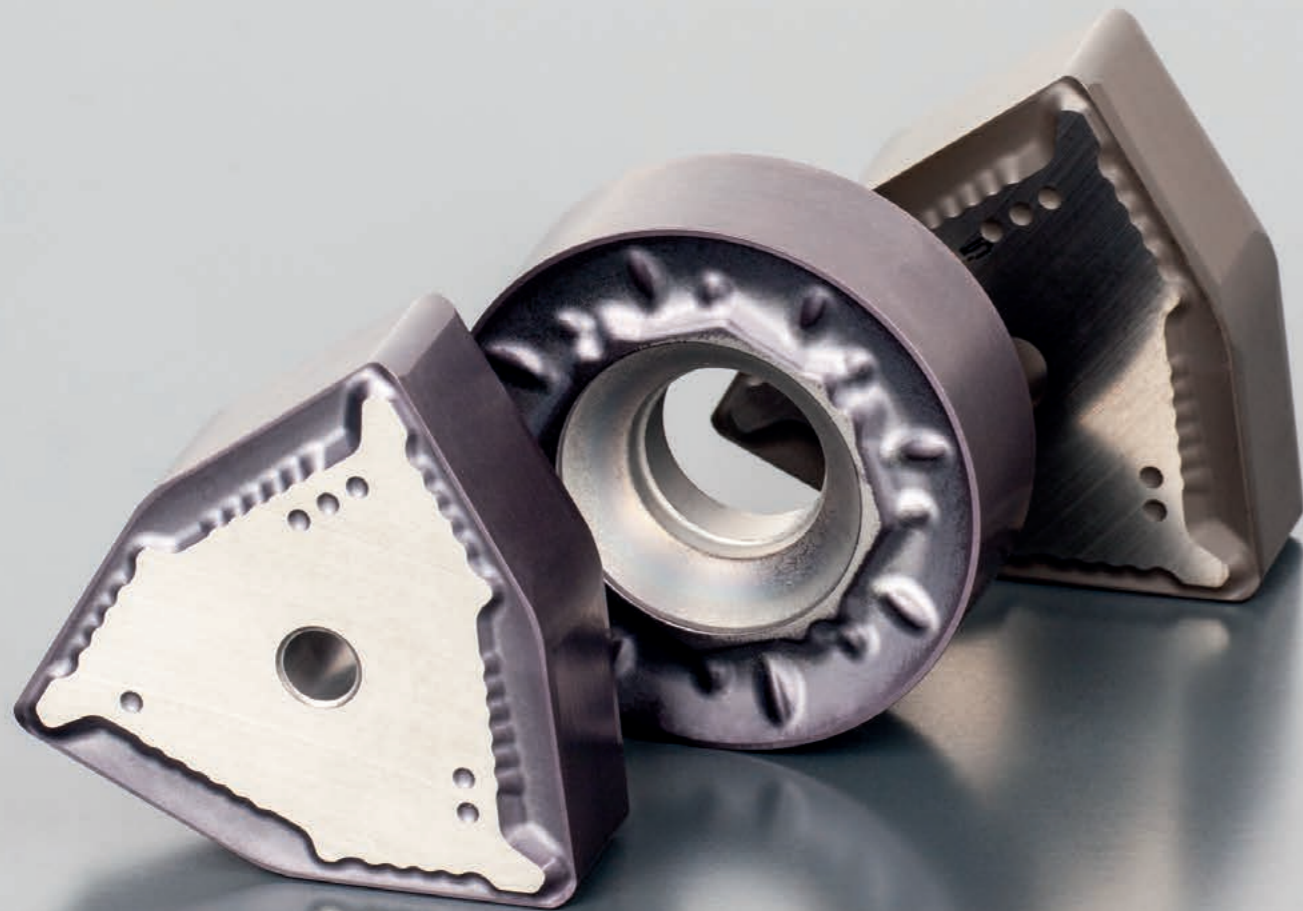
NRM





P	M	K	N	S	H
█	█			□	
f → 0,23 – 1,0					
a _p → 0,8 – 16,0					
					
					
 CNMG, CNMM, SNMG, SNMM					

BAR PEELING INSERTS



MM

BAR PEELING INSERTS

INSERTS FOR BAR PEELING OF STAINLESS STEEL

A new chip breaker developed especially for machining of stainless steel. Also suitable for steel and super alloys.

FEATURES & BENEFITS

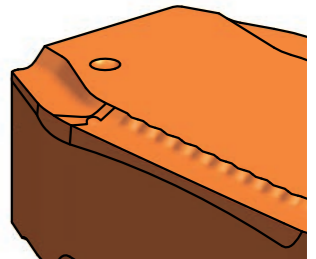
- New chipbreaker designed for stainless steel
- Strong geometry
- Increased stability of cutting edge
- Cutting edge identification marks



Options of cutting edge:

- S01 for hard material
- S02 for medium hardness
- S03 for soft materials or low rigidity

- **Reliable** tool thanks to improved chip control
- Designed for **high feeds**
- Suitable for heavy conditions
- **Even spread of cutting forces** thanks to high insert accuracy
- Longer tool life
- Reduced vibrations thanks to stabilization facet on main cutting edge (S03)



CHIP BREAKER MM

Roughing to finishing

- Wide, strong T-land
- For stainless steel and steel.
- Suitable for super alloys

MM

LNGF inserts

Roughing to finishing



RNGH inserts

Roughing



WNGF inserts

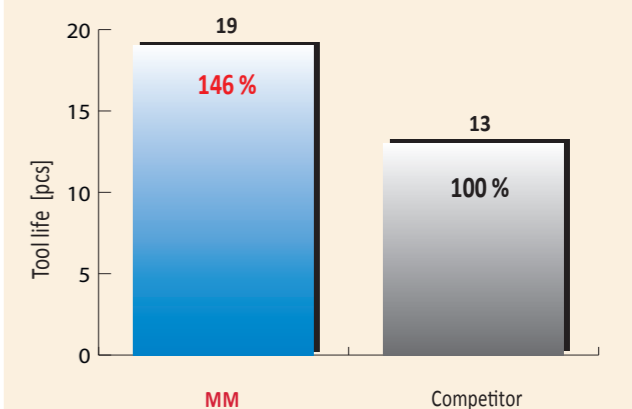
Roughing to finishing



MACHINING EXAMPLE

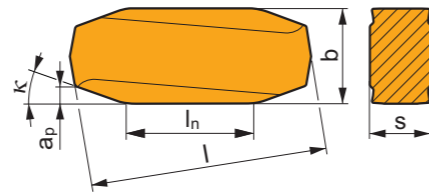
Material: 1.4028
 Material group: M
 Insert: RNGH 381200-MM: T9315

Cutting speed	v_c	70	m/min
Feed	f	5,5	mm/rev
Axial depth of cut	a_p	4	mm
Cutting length		5 000	mm

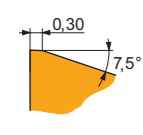
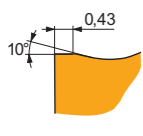


LNGF

300715	20	1,5	12	30,12	13	7,54
361220	20	2,0	18	36,50	16	12,00

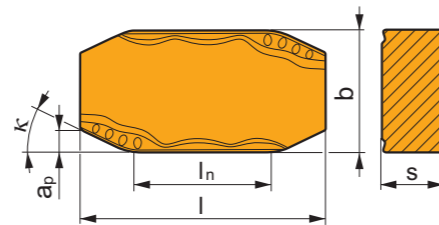


i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
U HFC W S	LNGF 300715-MM-S01	T7325	█	█				█	☹	+++	-	2,00	10,00	0,5	1,5
		T9315	█	█					☹	+++	-	2,00	10,00	0,5	1,5
		T6310	█	█				█	☹	+++	-	2,00	10,00	0,5	1,5
U HFC W S	LNGF 300715-MM-S02	T7325	█	█				█	☹	+++	-	2,00	10,00	0,5	1,5
	LNGF 300715-MM-S03	T7325	█	█				█	☹	+++	-	2,00	10,00	0,5	1,5
	LNGF 361220-MM-S01	T7325	█	█				█	☹	+++	-	2,50	13,00	0,6	2,0
U HFC W S	LNGF 361220-MM-S02	T7325	█	█				█	☹	+++	-	2,50	13,00	0,6	2,0
		T9315	█	█					☹	+++	-	2,50	13,00	0,6	2,0
		T6310	█	█				█	☹	+++	-	2,50	13,00	0,6	2,0
U HFC W S	LNGF 361220-MM-S03	T7325	█	█				█	☹	+++	-	2,50	13,00	0,6	2,0
		T9315	█	█					☹	+++	-	2,50	13,00	0,6	2,0
		H07		█				█	☹	+++	-	2,50	13,00	0,6	2,0
U HFC W S	LNGF 300715-PM	T7325	█	█				█	☹	+++	-	1,20	10,00	0,3	1,5
		T9315	█	█					☹	+++	-	1,20	10,00	0,3	1,5
		T9226	█	█					☹	+++	-	1,20	10,00	0,3	1,5
U HFC W S	LNGF 300715-PM-S02	T7325	█	█				█	☹	+++	-	1,20	10,00	0,3	1,5
	LNGF 300715-PM-S03	T7325	█	█				█	☹	+++	-	1,20	10,00	0,3	1,5
	LNGF 361220-PM-S01	T7325	█	█				█	☹	+++	-	1,60	13,00	0,4	2,0
U HFC W S	LNGF 361220-PM-S02	T7325	█	█				█	☹	+++	-	1,60	13,00	0,4	2,0
		T9315	█	█					☹	+++	-	1,60	13,00	0,4	2,0
	LNGF 361220-PM-S03	T7325	█	█				█	☹	+++	-	1,60	13,00	0,4	2,0

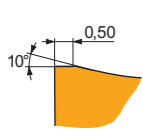


LNGF 40

401035	a _p	b	K°	l	l _n	s
401035	3,5	20	25	40	20	10

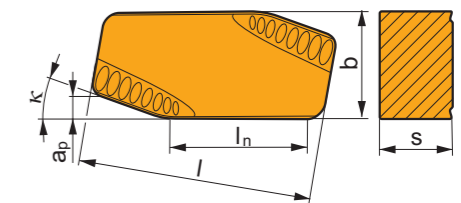


i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
U HFC W S	LNGF 401035-MM-S01	T7325	█	█				█	☹	+++	-	2,00	16,00	0,5	3,5
		T9315	█	█					☹	+++	-	2,00	16,00	0,5	3,5
		T6310	█	█				█	☹	+++	-	2,00	16,00	0,5	3,5
U HFC W S	LNGF 401035-MM-S02	T7325	█	█				█	☹	+++	-	2,00	16,00	0,5	3,5
	LNGF 401035-MM-S03	T7325	█	█				█	☹	+++	-	2,00	16,00	0,5	3,5

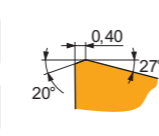
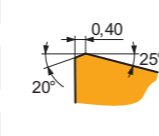


LNXR

381240	κ°	a _p	b	l	l _n	s
381240	20	4	17,5	38,25	21	12

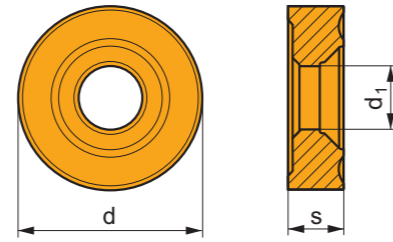


i	ISO		P	M	K	N	S	H	?		r _c	f _{min}	f _{max}	a _{p min}	a _{p max}
U HFC W S	LNXR 381240-PM	T9315	█	█					☹	+++	-	1,60	16,00	0,5	4,0
		T9226	█	█					☹	+++	-	1,60	16,00	0,5	4,0
		6610	█	█					☹	+++	-	1,60	16,00	0,5	4,0
U HFC W S	LNXR 381240-PR	T9226	█	█					☹	+++	-	1,60	16,00	0,5	4,0
		6630	█	█					☹	+++	-	1,60	16,00	0,5	4,0



RNGH

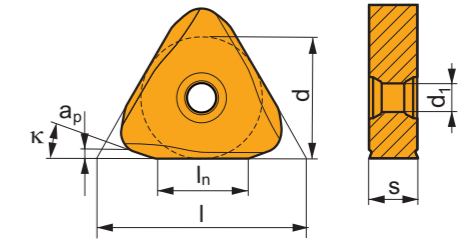
	a_p	d	d_1	s
381200	8	38,1	12,7	12,7
5018MO	12	50,0	12,7	18,0



i		ISO		P	M	K	N	S	H	?		r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$	
U	HFC	RNGH 381200-MM	T7325	█	█			█		●	+++	-	2,50	13,00	1,5	8,0	
				T9315	█	█			█		●	+++	-	2,50	13,00	1,5	8,0
				T6310	█	█			█		●	++	-	2,50	13,00	1,5	8,0
S	HFC	RNGH 5018MO-MM	M9340	█	█			█		●	++	-	3,00	16,00	1,5	12,0	
				T7325	█	█			█		●	+++	-	3,00	16,00	1,5	12,0
				T9315	█	█			█		●	+++	-	3,00	16,00	1,5	12,0
				T6310	█	█			█		●	++	-	3,00	16,00	1,5	12,0
P	HFC	RNGH 381200-MR	T7325	█	█			█		●	+++	-	2,20	13,00	1,5	8,0	
				T9315	█	█			█		●	+++	-	2,20	13,00	1,5	8,0
				T9226	█	█			□		●	+++	-	2,20	13,00	1,5	8,0
P	HFC	RNGH 5018MO-MR	M9340	█	█			█		●	++	-	3,00	16,00	1,5	12,0	
				T7325	█	█			█		●	+++	-	3,00	16,00	1,5	12,0
				T9335	█	█			█		●	+++	-	3,00	16,00	1,5	12,0
P	HFC	RNGH 381200-PR	T9226	█						●	+++	-	4,80	13,00	1,5	8,0	

TNGJ

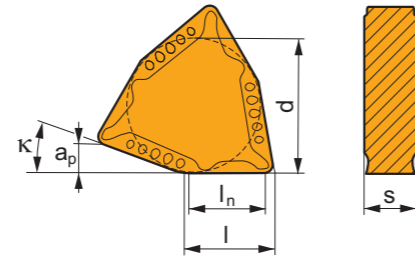
	κ°	a_p	d	d_1	l	l_n	s
220720	20	2,0	21,96	7	38,0	12	7,94
281025	20	2,5	28,60	7	49,5	18	10,00



i		ISO		P	M	K	N	S	H	?		r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
HFC	W	TNGJ 220720-PF-S01	T9315	█	█					●	+++	-	1,20	12,00	0,4	2,0
		TNGJ 220720-PF-S02	T7325	█	█			█		●	+++	-	1,20	12,00	0,4	2,0
E	W	TNGJ 281025-PF-S01	T9315	█	█					●	+++	-	1,20	16,00	0,5	2,5
		T9226	█	█			□		●	+++	-	1,20	16,00	0,5	2,5	
		6630	█	█			□		●	+++	-	1,20	16,00	0,5	2,5	
E	W	TNGJ 281025-PF-S02	T7325	█	█			█		●	+++	-	1,20	16,00	0,5	2,5
		TNGJ 281025-PF-S03	T7325	█	█			█		●	+++	-	1,20	16,00	0,5	2,5
U	HFC	TNGJ 220720-PM-S01	T9315	█	█					●	+++	-	1,20	12,00	0,4	2,0
		TNGJ 220720-PM-S02	T7325	█	█			█		●	+++	-	1,20	12,00	0,4	2,0
HFC	W		T9315	█	█					●	+++	-	1,20	12,00	0,4	2,0
			T9226	█	█					●	+++	-	1,20	12,00	0,4	2,0

WNGF

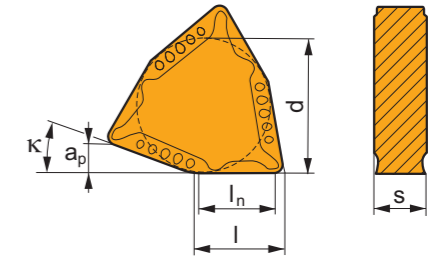
	κ°	a_p	d	l	l_n	s
201380	25	8	31,75	20	15	13



i	ISO	Material	P	M	K	N	S	H	Coating	Chip	r_c	f_{min}	f_{max}	$a_{p, min}$	$a_{p, max}$
	WNGF 201380-MM-S01	T7325	█	█			█		☹	+++	-	2,00	12,00	0,5	8,0
		T9315	█						☹	+++	-	2,00	12,00	0,5	8,0
		T6310	█	█			█		☹	+++	-	2,00	12,00	0,5	8,0
	WNGF 201380-MM-S02	T7325	█	█			█		☹	+++	-	2,00	12,00	0,5	8,0
	WNGF 201380-MM-S03	M9340	█	█			█		☹	+++	-	2,00	12,00	0,5	8,0

WNMF

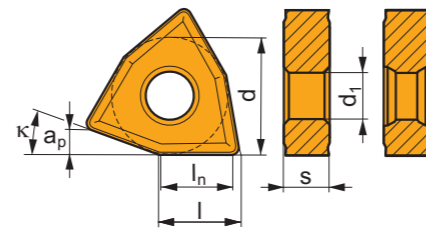
	κ°	a_p	d	l	l_n	s
201380	25	8	31,75	20	15	13



i	ISO	Material	P	M	K	N	S	H	Coating	Chip	r_c	f_{min}	f_{max}	$a_{p, min}$	$a_{p, max}$
	WNMF 201380-PM-S01	T9226	█						☹	+++	-	2,00	12,00	0,5	8,0
		6630	█						☹	+++	-	2,00	12,00	0,5	8,0

WNGU

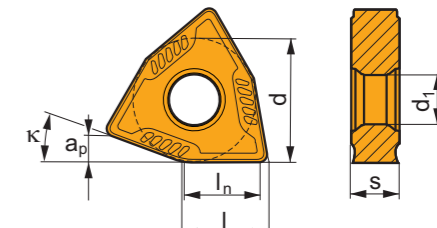
	κ°	a_p	d	d_1	l	l_n	s
150935	15	3,5	22,225	7,94	15	13	9,52



i	ISO	Material	P	M	K	N	S	H	Coating	Chip	r_c	f_{min}	f_{max}	$a_{p, min}$	$a_{p, max}$
	WNGU 150935-PM-S02	T9226	█						☹	+++	-	1,60	12,00	0,5	3,5
		6630	█						☹	+++	-	1,60	12,00	0,5	3,5

WNMJ

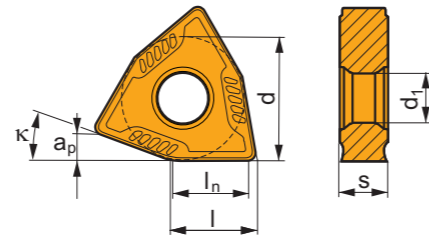
	κ°	a_p	d	d_1	l	l_n	s
201380	25	8	31,75	9,12	20	15	13
201480	25	8	31,75	9,12	20	15	14



i	ISO	Material	P	M	K	N	S	H	Coating	Chip	r_c	f_{min}	f_{max}	$a_{p, min}$	$a_{p, max}$
	WNMJ 201380-PR	T9226	█						☹	+++	-	1,60	12,00	0,5	8,0
	WNMJ 201480-PR	6630	█						☹	+++	-	1,60	12,00	0,5	8,0

WNXJ

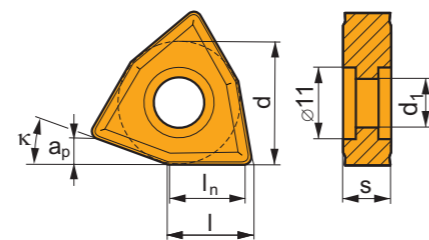
	κ°	a_p	d	d_1	l	l_n	s
150935	15	3,5	22,225	7,94	15	12	9,52
201380	25	8,0	31,750	9,12	20	15	13,00



i	ISO	6630	P	M	K	N	S	H	?	+	r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
WNXJ 150935-PM	6630	■	■	■	■	■	■	■	■	+++	-	1,60	12,00	0,5	3,5
WNXJ 201380-PR-S01	T9226 6630	■	■	■	■	■	■	■	■	+++	-	1,60	12,00	0,5	8,0
			■	■	■	■	■	■	■	+++	-	1,60	12,00	0,5	8,0

WNXX

	κ°	a_p	d	d_1	l	l_n	s
150935	15	3,5	22,225	7,94	15	12	9,52



i	ISO	6630	P	M	K	N	S	H	?	+	r_c	f_{min}	f_{max}	$a_{p min}$	$a_{p max}$
WNXX 150935-PM	6630	■	■	■	■	■	■	■	■	+++	-	1,60	12,00	0,5	3,5

GEOMETRY OF CUTTING INSERTS

MM

P	M	K	N	S	H
■	■	■	■	■	■
f	2,0 - 16,0				
a_p	0,5 - 12,0				
?	LNGF, RNGH, WNGF				

MR

P	M	K	N	S	H
■	■	■	■	■	■
f	2,2 - 16,0				
a_p	0,5 - 12,0				
?	RNGH				


PF

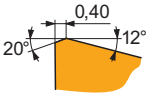
P	M	K	N	S	H
■	■	■	■	■	■
f	1,2 - 16,0				
a_p	0,4 - 2,5				
?	TNGJ				

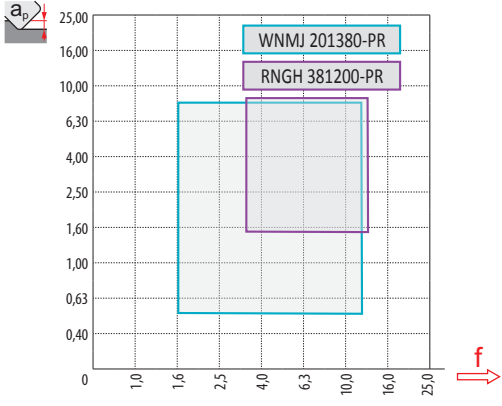
PM



P	M	K	N	S	H
■	■	■	■	■	■
f	1,2 - 16,0				
a_p	0,3 - 8,0				
?	LNGF, LN XR, TNGJ, WNGU, WNM F, WNXJ, WNXX				

PR







P	M	K	N	S	H
■					
f →	1,6 – 16,0				
a _p ↓	0,5 – 8,0				
					
					
?	LNXR, RNGH, WNMJ, WNXJ				

SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **simply reliable**.

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