MILLING - Metric

				MILLI	NG - Me	etric			Date compil	iod	May 4 2017
					ADKT 15	05			Date compil	ieu	Way 4 2017
	Material				ABINI 13		Cutting condition	ons			
_		Hardness	Fe	ed Fz (mm/Too	oth)		Speed Vc (m/mi			Depth Of Cut (r	nm)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.32	0.25	190	330	250	0.5	14.0	4.0
P	Low Alloy	200	0.15	0.25	0.20	150	240	200	0.5	14.0	4.0
	High Alloy	220	0.12	0.22	0.17	90	150	120	0.5	10.0	4.0
	Austenitic	190	0.14	0.24	0.18	190	250	220	0.5	14.0	3.0
M	Ferritic	220	0.12	0.2	0.16	140	220	180	0.5	14.0	3.0
	Martensitic	40 Hc	0.12	0.18	0.14	80	160	120	0.5	14.0	3.0
К	Nodular Cast Iron	150	0.18	0.32	0.24	150	230	190	0.5	15.0	4.0
	Grey Cast Iron	150	0.18	0.32	0.25	150	240	200	0.5	14.0	4.0
	Heat resistant	240	0.12	0.18	0.15	25	45	35	0.5	11.0	3.0
	and super alloys										
Н	Hardened material	45HRc	0.1	0.18	0.14	40	80	60	0.5	5.0	2.0
					4 ON AT 12	12.0					
	Material		T		AOMT 12		Cutting condition				
	Material	Hardness	En	ed Fz (mm/Too	n+h)		Cutting condition Speed Vc (m/mi			Depth Of Cut (r	mm1
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy		0.14			190				_	
P	Non Alloy Low Alloy	120 200	0.14	0.22 0.18	0.15 0.13	150	330 210	220 180	0.5 0.5	11.0 11.0	2.0
	High Alloy	220	0.11	0.18	0.13	90	150	120	0.5	8.0	1.5
	Austenitic	190	0.08	0.15	0.12	190	250	220	0.5	11.0	2.0
М	Ferritic	220	0.14	0.24	0.18	140	250	180	0.5	9.0	3.0
IVI	Martensitic	40 Hc	0.12	0.2	0.16	80	150	120	0.5	6.0	2.0
	Nodular Cast Iron	40 HC 150	0.12	0.18	0.14	140	230	190	0.5	9.0	2.0
K	Grey Cast Iron	150	0.12	0.24	0.18	150	240	190	0.5	11.0	2.0
	Heat resistant										
	and super alloys	240	0.08	0.13	0.10	25	45	30	0.5	8.0	1.5
н	Hardened material	45HRc	0.07	0.13	0.08	40	80	55	0.5	2.4	0.8
	That delited indecitor		0.07	0.20	0.00		1 30		0.0		
					APKT 100	03					
	Material						Cutting condition	ons			
_		Hardness	Fe	ed Fz (mm/Too	oth)		Speed Vc (m/mi			Depth Of Cut (r	nm)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.13	0.26	0.20	190	330	250	0.5	9.0	2.0
P	Low Alloy	200	0.11	0.21	0.16	150	240	200	0.5	9.0	2.0
	High Alloy	220	0.08	0.18	0.13	90	150	120	0.5	6.4	1.5
	Austenitic	190	0.11	0.21	0.16	190	250	220	0.5	9.0	2.0
М	Ferritic	220	0.12	0.18	0.15	130	220	170	0.5	9.0	3.0
	Martensitic	40 Hc	0.12	0.18	0.14	70	140	110	0.5	6.0	2.0
	Nodular Cast Iron	150	0.12	0.24	0.18	140	230	190	0.5	9.0	2.0
K	Grey Cast Iron	150	0.13	0.26	0.20	150	240	200	0.5	9.0	2.0
	Heat resistant	240	0.00	0.15	0.13	25	45	25	0.5	6.4	4.5
S	and super alloys	240	0.08	0.15	0.12	25	45	35	0.5	6.4	1.5
Н	Hardened material	45HRc	0.07	0.15	0.11	40	80	60	0.5	3.2	1.0
					APKT 160						
	Material	1					Cutting condition				
Group	Sub Group	Hardness		ed Fz (mm/Too			Speed Vc (m/mi	1		Depth Of Cut (r	
•	· ·	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.32	0.25	190	330	250	0.5	15.0	4.0
P	Low Alloy	200	0.15	0.25	0.20	150	240	195	0.5	15.0	4.0
	High Alloy	220	0.12	0.22	0.17	90	150	120	0.5	10.7	4.0
	Austenitic	190	0.14	0.24	0.18	190	250	220	0.5	15.0	3.0
М	Ferritic Martansitis	220	0.12	0.2	0.16	140	220	180	0.5	14.0	3.0
	Martensitic	40 Hc	0.12	0.18	0.14	80	160	120	0.5	14.0	3.0
K	Nodular Cast Iron	150	0.18	0.32	0.24	150	230	190	0.5	15.0	4.0
	Grey Cast Iron	150	0.18	0.32	0.24	150	240	190	0.5	15.0	4.0
	Heat resistant	240	0.12	0.18	0.15	25	45	35	0.5	10.7	3.0
н	and super alloys Hardened material	45HRc	0.10	0.18	0.14	40	80	60	0.5	5.4	2.0
			5.10	5.10			30	"	3.3	1 3.4	2.0
					APMT 11	.35					
	Material						Cutting condition	ons			
		Hardness	Fe	ed Fz (mm/Too	oth)		Speed Vc (m/mi	n)		Depth Of Cut (r	mm)
Gra	Cub Cuarra	(110)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
Group	Sub Group	(HB)			0.10	190	330	250	0.5	10.0	2.0
Group	Sub Group Non Alloy	(HB) 120	0.13	0.22	0.18						2.0
Group	· ·		0.13 0.11	0.22	0.15	150	240	200	0.5	10.0	
	Non Alloy	120					+	200 120	0.5 0.5	7.2	1.5
	Non Alloy Low Alloy	120 200	0.11	0.18	0.15	150	240				
	Non Alloy Low Alloy High Alloy	120 200 220	0.11 0.08	0.18 0.15	0.15 0.12	150 90	240 150	120	0.5	7.2	1.5
P	Non Alloy Low Alloy High Alloy Austenitic	120 200 220 190	0.11 0.08 0.14	0.18 0.15 0.24	0.15 0.12 0.18	150 90 190	240 150 250	120 220	0.5 0.5	7.2 10.0	1.5 2.0
P	Non Alloy Low Alloy High Alloy Austenitic Ferritic	120 200 220 190 220	0.11 0.08 0.14 0.12	0.18 0.15 0.24 0.2	0.15 0.12 0.18 0.16	150 90 190 130	240 150 250 220	120 220 170	0.5 0.5 0.5	7.2 10.0 9.0	1.5 2.0 3.0
P	Non Alloy Low Alloy High Alloy Austenitic Ferritic Martensitic	120 200 220 190 220 40 Hc	0.11 0.08 0.14 0.12 0.12	0.18 0.15 0.24 0.2 0.18	0.15 0.12 0.18 0.16 0.14	150 90 190 130 70	240 150 250 220 140	120 220 170 110	0.5 0.5 0.5 0.5	7.2 10.0 9.0 6.0	1.5 2.0 3.0 2.0
P M K	Non Alloy Low Alloy High Alloy Austenitic Ferritic Martensitic Nodular Cast Iron	120 200 220 190 220 40 Hc 150	0.11 0.08 0.14 0.12 0.12 0.12 0.13	0.18 0.15 0.24 0.2 0.18 0.22 0.22	0.15 0.12 0.18 0.16 0.14 0.18 0.18	150 90 190 130 70 140 150	240 150 250 220 140 230 240	120 220 170 110 190 200	0.5 0.5 0.5 0.5 0.5 0.5	7.2 10.0 9.0 6.0 10.0	1.5 2.0 3.0 2.0 2.0 2.0
P	Non Alloy Low Alloy High Alloy Austenitic Ferritic Martensitic Nodular Cast Iron Grey Cast Iron	120 200 220 190 220 40 Hc 150	0.11 0.08 0.14 0.12 0.12 0.12	0.18 0.15 0.24 0.2 0.18 0.22	0.15 0.12 0.18 0.16 0.14 0.18	150 90 190 130 70 140	240 150 250 220 140 230	120 220 170 110 190	0.5 0.5 0.5 0.5 0.5	7.2 10.0 9.0 6.0 10.0	1.5 2.0 3.0 2.0 2.0

					APMT 16	04						
	Material						Cutting condition	ns				
Group	Sub Group	Hardness		ed Fz (mm/Too	1 -		peed Vc (m/mi	1 -		Pepth Of Cut (m	1	
отопр	·	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend	
P	Non Alloy Low Alloy	120 200	0.16 0.14	0.30 0.23	0.23 0.19	190 150	330 240	250 200	0.5	15.0 15.0	4.0 4.0	
	High Alloy	220	0.14	0.23	0.16	90	150	120	0.5	10.7	4.0	
	Austenitic	190	0.14	0.23	0.19	190	250	220	0.5	15.0	4.0	
M	Ferritic	220	0.16	0.22	0.18	140	220	180	0.5	14.0	3.0	
	Martensitic	40 Hc	0.14	0.22	0.16	70	140	100	0.5	14.0	3.0	
К	Nodular Cast Iron	150	0.16	0.30	0.22	140	230	200	0.5	15.0	4.0	
	Grey Cast Iron	150	0.16	0.30	0.22	150	240	200	0.5	15.0	4.0	
S	Heat resistant and super alloys	240	0.11	0.17	0.14	25	45	35	0.5	10.7	3.0	
Н	Hardened material	45HRc	0.09	0.17	0.13	40	80	60	0.5	5.4	2.0	
					APXT 11	T3					•	
	Material	1					Cutting condition					
Group	Sub Group	Hardness		ed Fz (mm/Too	, *		peed Vc (m/mi	i e		Depth Of Cut (m		
·		(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend	
P	Non Alloy Low Alloy	120 200	0.13 0.11	0.26 0.21	0.20 0.16	190 150	330 240	250 200	0.5	9.0	2.0	
	High Alloy	220	0.08	0.21	0.13	90	150	120	0.5	6.4	1.5	
	Austenitic	190	0.14	0.21	0.16	190	250	220	0.5	9.0	2.0	
M	Ferritic	220	0.12	0.18	0.15	130	220	170	0.5	9.0	3.0	
	Martensitic	40 Hc	0.12	0.18	0.13	70	140	110	0.5	6.0	2.0	
K	Nodular Cast Iron	150	0.12	0.24	0.20	140	230	190	0.5	9.0	2.0	
	Grey Cast Iron Heat resistant	150	0.13	0.26	0.20	150	240	200	0.5	9.0	2.0	
S	and super alloys	240	0.08	0.15	0.12	25	45	35	0.5	6.4	1.5	
Н	Hardened material	45HRc	0.07	0.15	0.11	40	80	60	0.5	3.2	1.0	
					ODMT 06							
	Material	1					Cutting condition					
Group	Sub Group	Hardness		ed Fz (mm/Too			peed Vc (m/mi			Depth Of Cut (m		
	Non Allay	(HB) 120	Min 0.22	0.54	Recommend 0.38	Min 190	Max 330	Recommend 250	0.5	4.0	Recommend 2.5	
P	Non Alloy Low Alloy	200	0.22	0.54	0.38	150	240	195	0.5	4.0	2.5	
	High Alloy	220	0.14	0.43	0.26	90	150	120	0.5	2.9	1.9	
	Austenitic	190	0.18	0.37	0.28	190	250	220	0.5	4.0	2.5	
M	Ferritic	220	0.18	0.32	0.24	130	210	170	0.5	4.0	2.5	
	Martensitic	40 Hc	0.15	0.28	0.22	80	160	120	0.5	3.0	2.0	
К	Nodular Cast Iron	150	0.24	0.48	0.34	140	230	190	0.5	4.5	3.0	
	Grey Cast Iron	150	0.22	0.54	0.38	150	240	195	0.5	4.0	2.5	
S	Heat resistant and super alloys	240	0.14	0.31	0.23	25	45	35	0.5	2.9	1.9	
Н	Hardened material	45HRc	0.12	0.31	0.22	40	80	60	0.4	1.4	1.3	
					ODMW 0	605						
	Material		_				Cutting condition					
Group	Sub Group	Hardness (HB)		ed Fz (mm/Too	1		peed Vc (m/mi			Depth Of Cut (m	1	
	Non Alloy	120	0.22	0.58	Recommend 0.40	Min 190	330	Recommend 250	0.5	4.0	Recommend 3.0	
P	Low Alloy	200	0.18	0.45	0.32	150	240	195	0.5	4.0	3.0	
	High Alloy	220	0.14	0.40	0.27	90	150	120	0.5	2.9	2.3	
К	Nodular Cast Iron	150	0.24	0.48	0.34	140	230	190	0.5	4.5	3.0	
	Grey Cast Iron	150	0.22	0.58	0.40	150	240	195	0.5	4.0	3.0	
Н	Hardened material	45HRc	0.12	0.32	0.22	40	80	60	0.4	1.4	1.3	
					OFER 07	04						
	Material				OIER 07		Cutting condition	ins				
		Hardness	Fee	ed Fz (mm/Too	th)		peed Vc (m/mi			Depth Of Cut (m	ım)	
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend	
	Non Alloy	120	0.22	0.50	0.37	190	300	250	0.5	4.5	3.0	
P	Low Alloy	200	0.18	0.40	0.30	150	210	195	0.5	4.5	3.0	
	High Alloy	220	0.14	0.35	0.28	90	130	120	0.5	3.0	2.2	
М	Austenitic Ferritic	190 220	0.18 0.18	0.35 0.32	0.28	190 140	240 220	220 160	0.5	4.5 4.0	3.0	
IVI	Martensitic	40 Hc	0.18	0.32	0.24	80	160	120	0.5	4.0	3.0	
	Nodular Cast Iron	150	0.24	0.48	0.34	140	230	190	0.5	4.5	3.0	
К	Grey Cast Iron	150	0.22	0.50	0.34	150	240	195	0.5	4.5	3.0	
S	Heat resistant	240	0.14	0.28	0.25	25	45	35	0.5	3.0	2.2	
	and super alloys											
Н	Hardened material	45HRc	0.12	0.28	0.20	40	70	60	0.4	1.0	1.0	
					OFMT 05	T3						
	Material				— OFIVIT US		Cutting condition	ins				
C		Hardness	Fee	ed Fz (mm/Too	th)		peed Vc (m/mi		Depth Of Cut (mm)			
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend	
	Non Alloy	120	0.22	0.51	0.37	190	330	250	0.5	3.5	2.5	
Р	Low Alloy	200	0.18	0.40	0.29	150	240	195	0.5	3.5	2.5	
	High Alloy	220	0.14	0.35	0.25	90	150	120	0.5	2.5	1.9	
М	Austenitic Ferritic	190 220	0.18 0.18	0.35 0.30	0.27 0.24	190 130	250 210	220 160	0.5	3.5 4.0	2.5	
141	1611111	220	J.10	J.30	J.27	130		100	0.5	7.0	2.5	

		Martensitic	40 Hc	0.15	0.26	0.20	70	140	110	0.5	3.0	2.0
I	v	Nodular Cast Iron	150	0.22	0.50	0.36	140	230	190	0.5	3.5	2.5
	K	Grey Cast Iron	150	0.22	0.51	0.37	150	240	200	0.5	3.5	2.5
		Heat resistant and super alloys	240	0.14	0.29	0.22	25	45	35	0.5	2.5	1.9
ı	н	Hardened material	45HRc	0.12	0.29	0.21	40	80	60	0.4	1.3	1.3

					RDMT 060	2M0					
	Material					(Cutting condit	ions			
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	oth)	S	peed Vc (m/m	in)	D	epth Of Cut (n	nm)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.48	0.29	190	330	220	0.5	3.0	0.8
P	Low Alloy	200	0.15	0.38	0.25	150	210	180	0.5	2.5	0.8
	High Alloy	220	0.12	0.33	0.23	90	130	120	0.5	2.2	0.6
	Austenitic	190	0.15	0.38	0.25	190	250	220	0.5	2.5	0.8
M	Ferritic	220	0.14	0.32	0.24	120	190	140	0.5	2.2	0.8
	Martensitic	40 Hc	0.12	0.28	0.22	80	140	120	0.5	2.0	0.8
К	Nodular Cast Iron	150	0.18	0.50	0.30	140	230	190	0.5	1.5	0.8
K	Grey Cast Iron	150	0.18	0.50	0.30	150	240	190	0.5	1.5	0.8
S	Heat resistant and super alloys	240	0.12	0.27	0.20	25	45	32	0.5	0.8	0.6
н	Hardened material	45HRc	0.10	0.27	0.18	40	80	60	0.3	0.6	0.4

	RDMT 0802M0													
	Material					(Cutting conditi	ons						
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	oth)	S	peed Vc (m/m	in)	D	epth Of Cut (n	ım)			
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	4.0	0.8			
P	Low Alloy	200	0.15	0.50	0.30	150	240	195	0.5	3.0	0.8			
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	2.2	0.6			
	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	0.8			
M	Ferritic	220	0.16	0.34	0.24	120	190	140	0.5	2.2	0.8			
	Martensitic	40 Hc	0.14	0.28	0.23	80	140	120	0.5	1.8	0.8			
К	Nodular Cast Iron	150	0.18	0.54	0.32	140	230	190	0.5	1.8	0.8			
K	Grey Cast Iron	150	0.18	0.54	0.32	150	240	190	0.5	1.8	0.8			
s	Heat resistant	240	0.12	0.32	0.24	25	45	35	0.5	1.0	0.6			
	and super alloys	10	J.12	5.52	5.24		"		J.J	0	2.0			
	Hardened material	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4			

	RDMT 0803M0														
	Material					(Cutting condition	ons							
C	Sub Cusus	Hardness	Fee	ed Fz (mm/Too	th)	S	peed Vc (m/mi	n)	D	epth Of Cut (m	nm)				
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend				
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	4.0	0.8				
P	Low Alloy	200	0.15	0.50	0.30	150	240	195	0.5	3.0	0.8				
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	2.2	0.6				
	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	0.8				
M	Ferritic	220	0.18	0.32	0.24	120	190	140	0.5	2.2	0.8				
	Martensitic	40 Hc	0.16	0.28	0.23	80	140	120	0.5	1.8	0.8				
К	Nodular Cast Iron	150	0.18	0.54	0.32	140	230	190	0.5	1.8	0.8				
K	Grey Cast Iron	150	0.18	0.54	0.32	150	240	190	0.5	1.8	0.8				
S	Heat resistant and super alloys	240	0.12	0.32	0.24	25	45	35	0.5	1.0	0.6				
Н	Hardened material	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4				

	RDMT 10T3M0														
	Material					(Cutting condition	ons							
Crown	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	S	peed Vc (m/mi	n)	D	epth Of Cut (m	ım)				
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend				
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	5.0	1.0				
P	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	4.0	1.0				
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	2.5	0.8				
	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	3.0	1.0				
M	Ferritic	220	0.18	0.34	0.24	120	190	140	0.5	2.5	1.0				
	Martensitic	40 Hc	0.14	0.28	0.23	80	140	120	0.5	2.2	1.0				
К	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.2	1.0				
, K	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	2.2	1.0				
S	Heat resistant and super alloys	240	0.12	0.36	0.24	25	45	35	0.5	1.2	0.5				
Н	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.8	0.5				

	RDMT 1204M0													
	Material					(Cutting condit	ions						
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	S	peed Vc (m/m	nin)		epth Of Cut (n	nm)			
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	1.3			
P	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	5.0	1.3			
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	3.8	1.0			
	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	3.5	1.3			
M	Ferritic	220	0.20	0.38	0.26	120	180	140	0.5	3.2	1.2			
	Martensitic	40 Hc	0.16	0.30	0.24	80	150	120	0.5	2.5	1.2			
	Nodular Cast Iron	150	0.18	0.62	0.34	140	230	190	0.5	2.5	1.3			
K	Grey Cast Iron	150	0.18	0.64	0.34	150	240	200	0.5	2.5	1.3			
S	Heat resistant and super alloys	240	0.17	0.41	0.29	25	45	35	0.5	1.5	1.0			

H Hardened	material 45HRc	0.14	0.41	0.28	40	80	60	0.3	1.0	0.7

RDMW 0602M0													
	Material					(Cutting condition	ons					
C	Cub Cusum	Hardness	Feed Fz (mm/Tooth)			SI	peed Vc (m/mi	n)	Depth Of Cut (mm)				
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend		
	Non Alloy	120	0.18	0.64	0.41	190	330	260	0.5	4.0	0.8		
P	Low Alloy	200	0.15	0.50	0.33	150	240	195	0.5	3.0	0.8		
	High Alloy	220	0.12	0.44	0.28	90	150	120	0.5	2.2	0.6		
к	Nodular Cast Iron	150	0.18	0.52	0.32	140	220	180	0.5	1.5	0.8		
K	Grey Cast Iron	150	0.18	0.52	0.32	150	240	195	0.5	1.5	0.8		
н	Hardened material	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.6	0.4		

RDMW 0802M0													
	Material					(Cutting conditi	ons					
C	Cub Cusum	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/m	in)	Depth Of Cut (mm)				
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend		
	Non Alloy	120	0.18	0.64	0.41	190	330	260	0.5	4.0	0.8		
P	Low Alloy	200	0.15	0.50	0.33	150	240	195	0.5	3.5	0.8		
	High Alloy	220	0.12	0.44	0.28	90	150	120	0.5	2.8	0.6		
К	Nodular Cast Iron	150	0.18	0.56	0.34	140	220	180	0.5	2.5	0.8		
K	Grey Cast Iron	140	0.18	0.56	0.34	150	240	195	0.5	2.5	0.8		
Н	Hardened material	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.8	0.4		

RDMW 10T3M0														
	Material					C	Cutting condition	ons						
C	Cub Cusum	Hardness	Fee	ed Fz (mm/Too	oth)	Sį	peed Vc (m/mi	n)	Depth Of Cut (mm)					
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	5.0	1.5			
P	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	4.0	1.2			
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	2.5	0.8			
К	Nodular Cast Iron	150	0.18	0.60	0.34	140	230	190	0.5	1.8	1.0			
- K	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	1.8	1.0			
н	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5			

RDMW 1204M0													
	Material					(Cutting conditi	ons					
C	Cub Cusum	Hardness	Feed Fz (mm/Tooth)		SI	peed Vc (m/m	in)	D	epth Of Cut (m	nm)			
Group	Group Sub Group		Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend		
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	2.0		
P	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	4.5	1.5		
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	3.0	1.0		
v	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.8	1.3		
К	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	2.8	1.3		
Н	Hardened material	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.2	0.8		

					RPMT 08T	2M0					
	Material					(Cutting condit	ions			
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	oth)	SI	peed Vc (m/m	in)	D	epth Of Cut (n	nm)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.64	0.41	190	330	250	0.5	4.0	0.8
P	Low Alloy	200	0.15	0.50	0.33	150	240	195	0.5	3.0	0.8
	High Alloy	220	0.12	0.44	0.28	90	150	120	0.5	2.2	0.6
	Austenitic	190	0.15	0.50	0.33	190	250	220	0.5	2.5	0.8
M	Ferritic	220	0.18	0.32	0.24	120	190	140	0.5	2.2	0.8
	Martensitic	40 Hc	0.16	0.28	0.24	80	140	120	0.5	1.8	0.8
К	Nodular Cast Iron	150	0.16	0.60	0.36	140	230	190	0.5	1.8	0.8
K	Grey Cast Iron	150	0.18	0.64	0.40	150	240	195	0.5	1.8	0.8
S	Heat resistant and super alloys	240	0.12	0.32	0.22	25	45	35	0.5	1.0	0.6
Н	Hardened material	45HRc	0.10	0.32	0.21	40	80	60	0.3	0.7	0.4

					RPMT 10T	3M0					
	Material					(Cutting conditi	ons			
Croun	Sub Croup	Hardness	Fee	ed Fz (mm/Too	oth)	S	peed Vc (m/m	in)	D	epth Of Cut (m	nm)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	5.0	1.0
P	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	4.0	1.0
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	2.5	0.8
	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	3.0	1.0
M	Ferritic	220	0.18	0.34	0.24	120	190	140	0.5	2.5	1.0
	Martensitic	40 Hc	0.14	0.28	0.23	80	140	120	0.5	2.2	1.0
К	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.2	1.0
K	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	2.2	1.0
S	Heat resistant and super alloys	240	0.12	0.36	0.24	25	45	35	0.5	1.2	0.5
Н	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.8	0.5

	RPMT 1204M0												
	Material Cutting conditions												
Croun	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/mi	n)	D	epth Of Cut (m	m)		
Group		(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend		
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	1.3		
P	Low Alloy	200	0.15	0.50	0.30	150	240	195	0.5	5.0	1.3		

	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	3.8	1.0
	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	3.5	1.3
M	Ferritic	220	0.20	0.38	0.26	120	180	140	0.5	3.2	1.2
	Martensitic	40 Hc	0.16	0.30	0.24	80	150	120	0.5	2.5	1.2
К	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.5	1.3
N.	Grey Cast Iron	150	0.18	0.64	0.35	150	240	190	0.5	2.5	1.3
s	Heat resistant	240	0.13	0.30	0.29	25	50	38	0.5	1.5	1.0
	and super alloys										
	Hardened material	45HRc	0.50	0.22	0.28	50	100	75	0.3	1.0	0.7

					RPMW 100	03M0					
	Material					(Cutting condition	ons			
C	Sub Cusus	Hardness	Fee	ed Fz (mm/Tooth)		S	peed Vc (m/mi	n)	D	epth Of Cut (m	nm)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	5.0	1.0
P	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	4.0	1.0
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	3.5	0.8
к	<u> </u>	150	0.18	0.60	0.34	140	230	190	0.5	2.5	1.0
K	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
н	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.8

	RPMW 1204M0													
	Material					(Cutting conditi	ons						
C	Cub Cusum	Hardness	Fee	ed Fz (mm/Too	oth)	Sı	peed Vc (m/m	in)	D	epth Of Cut (m	nm)			
Group	Group Sub Group		Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	1.3			
P	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	5.0	1.3			
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	3.8	1.0			
К	Nodular Cast Iron 150	150	0.16	0.60	0.34	140	230	190	0.5	3.0	1.3			
K	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	3.0	1.3			
н	Hardened material	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.5	1.0			

					RPMX 120	4M0					
	Material					(Cutting conditi	ons			
C	Cub Cuaum	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/m	in)	D	epth Of Cut (m	ım)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	1.3
P	Low Alloy	200	0.15	0.50	0.30	150	240	195	0.5	5.0	1.3
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	3.8	1.0
	Austenitic	190	0.18	0.50	0.36	190	250	220	0.5	3.5	1.3
M	Ferritic	220	0.16	0.44	0.34	80	150	120	0.5	3.2	1.2
	Martensitic	40 Hc	0.14	0.38	0.28	150	240	195	0.5	2.5	1.2
К	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.5	1.3
K	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
s	Heat resistant	240	0.13	0.30	0.29	25	50	38	0.5	1.5	1.0
,	and super alloys	240	0.13	0.50	0.29	25	50	36	0.5	1.5	1.0
Н	Hardened material	45HRc	0.50	0.22	0.28	50	100	75	0.3	1.0	0.7

					SEKN 1203	AFTN					
	Material					(Cutting condition	ons			
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	SI	eed Vc (m/mi	n)	D	epth Of Cut (m	im)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
P	Low Alloy	200	0.15	0.36	0.26	150	240	195	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.3
	Austenitic	190	0.15	0.32	0.24	190	250	220	0.5	7.0	3.0
M	Ferritic	220	0.18	0.30	0.23	130	210	160	0.5	4.0	2.5
	Martensitic	40 Hc	0.15	0.26	0.20	70	140	110	0.5	4.0	2.0
К	Nodular Cast Iron	150	0.16	0.44	0.30	140	230	190	0.5	7.0	3.0
N.	Grey Cast Iron	150	0.18	0.46	0.32	150	240	190	0.5	7.0	3.0
s	Heat resistant	240	0.10	0.26	0.18	30	60	35	0.5	5.0	2.3
	and super alloys	240	0.10	0.26	0.10	30	00	35	0.5	3.0	2.3
Н	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.0

					SEKR 1203	AFTN					
	Material					(Cutting condition	ons			
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/mi	n)	D	epth Of Cut (m	ım)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
P	Low Alloy	200	0.15	0.36	0.26	150	240	195	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.3
	Austenitic	190	0.15	0.32	0.24	190	250	220	0.5	7.0	3.0
M	Ferritic	220	0.16	0.28	0.22	140	210	160	0.5	4.0	2.5
	Martensitic	40 Hc	0.14	0.26	0.20	70	140	110	0.5	4.0	2.0
К	Nodular Cast Iron	150	0.16	0.44	0.30	140	230	190	0.5	7.0	3.0
N.	Grey Cast Iron	150	0.18	0.46	0.32	150	240	190	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
Н	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

	SEKT 12T3 AGTN												
	Material					(Cutting condition	ns					
Group	Sub Group	Sub Croup Hardness		ed Fz (mm/Too	th)	SI	oeed Vc (m/mi	1)	D	epth Of Cut (m	m)		
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend		
	Non Alloy	120	0.18	0.18 0.46 0.30 190 330 250 0.5 7.0 3.0									

					1						1
P	Low Alloy	200	0.15	0.36	0.25	150	240	200	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.0
	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
M	Ferritic	220	0.16	0.28	0.22	140	210	160	0.5	4.0	2.5
	Martensitic	40 Hc	0.14	0.30	0.20	80	140	110	0.5	4.0	2.5
К	Nodular Cast Iron	150	0.16	0.44	0.28	140	230	190	0.5	7.0	3.0
K	Grey Cast Iron	150	0.18	0.46	0.30	150	240	200	0.5	7.0	3.0
c	Heat resistant	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
3	and super alloys	240	0.12	0.20	0.19	25	43	33	0.5	3.0	2.3
Н	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

					SEKT 1204	AFTN					
	Material					(Cutting condit	ions			
Group	Sub Group	Hardness	Fe	ed Fz (mm/Too	oth)	S	peed Vc (m/m	nin)	D	epth Of Cut (n	nm)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
P	Low Alloy	200	0.15	0.36	0.25	150	240	200	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.0
	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
M	Ferritic	220	0.16	0.30	0.22	130	210	160	0.5	4.0	2.5
	Martensitic	40 Hc	0.14	0.30	0.20	80	140	110	0.5	4.0	2.5
	Nodular Cast Iron	150	0.16	0.44	0.20	140	230	190	0.5	4.0	2.5
K	Grey Cast Iron	150	0.18	0.46	0.30	150	240	200	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
н	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

					SEMT 1204	AFTN					
	Material					C	Cutting condition	ons			
C	Cub Curana	Hardness	Fee	ed Fz (mm/Too	th)	Sį	peed Vc (m/mi	n)	D	epth Of Cut (m	ım)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
P	Low Alloy	200	0.15	0.36	0.25	150	240	200	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.0
	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
M	Austenitic 190 Ferritic 220	220	0.16	0.30	0.22	130	210	160	0.5	4.0	2.5
	Martensitic	40 Hc	0.14	0.28	0.20	80	140	110	0.5	4.0	2.5
К	Nodular Cast Iron	150	0.16	0.44	0.28	140	230	190	0.5	7.0	3.0
K	Grey Cast Iron	150	0.18	0.46	0.30	150	240	200	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
н	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

	SEMT 13T3 AGSN													
	Material					(Cutting condition	ons						
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/mi	n)	D	epth Of Cut (m	nm)			
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0			
P	Low Alloy	200	0.15	0.36	0.25	150	240	200	0.5	7.0	3.0			
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.0			
	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0			
М	Ferritic	220	0.16	0.30	0.22	140	210	150	0.5	4.0	2.5			
	Martensitic	40 Hc	0.14	0.28	0.20	80	140	110	0.5	4.0	2.5			
к	Nodular Cast Iron	150	0.16	0.44	0.30	140	130	190	0.5	7.0	3.0			
K	Grey Cast Iron	150	0.18	0.46	0.30	150	240	200	0.5	7.0	3.0			
S	Heat resistant and super alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3			
Н	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5			

	SPKN 1203 EDTR														
	Material					(Cutting condition	ons							
C	Cub Cuaum	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/mi	n)	D	epth Of Cut (m	ım)				
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend				
	Non Alloy	120	0.18	0.43	0.30	190	330	250	0.5	7.0	3.0				
P	Low Alloy	200	0.15	0.34	0.25	150	240	200	0.5	7.0	3.0				
	High Alloy	220	0.12	0.30	0.20	90	150	120	0.5	5.0	2.5				
К	Nodular Cast Iron	150	0.18	0.42	0.30	140	230	190	0.5	7.0	3.0				
K	Grey Cast Iron	150	0.18	0.43	0.30	150	240	200	0.5	7.0	3.0				
Н	Hardened material	45HRc	0.10	0.24	0.17	40	80	60	0.5	2.5	1.5				

	SPKN 1504 EDTR													
	Material					(Cutting condition	ons						
C	Cub Cuaun	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/mi	n)	D	epth Of Cut (m	ım)			
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.18	0.43	0.31	190	330	260	0.5	9.0	4.0			
P	Low Alloy	200	0.15	0.34	0.25	150	240	195	0.5	9.0	4.0			
	High Alloy	220	0.12	0.30	0.21	90	150	120	0.5	6.5	3.0			
К	Nodular Cast Iron	150	0.16	0.42	0.30	140	230	190	0.5	9.0	4.0			
K	Grey Cast Iron	150	0.18	0.43	0.31	150	240	190	0.5	9.0	4.0			
Н	Hardened material	45HRc	0.10	0.24	0.17	40	80	60	0.5	3.2	2.0			

					SPKR 1203	EDTR					
Material Cutting conditions											
Croun	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	Sį	eed Vc (m/mii	1)	D	epth Of Cut (m	m)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend

	Non Alloy	120	0.18	0.38	0.25	190	330	250	0.5	7.0	3.0
P	Low Alloy	200	0.15	0.30	0.20	150	240	200	0.5	7.0	3.0
	High Alloy	220	0.12	0.26	0.17	90	150	120	0.5	5.0	2.5
	Austenitic	190	0.15	0.26	0.22	190	250	220	0.5	7.0	3.0
M	Ferritic	220	0.16	0.26	0.20	130	210	160	0.5	4.0	2.5
	Martensitic	40 Hc	0.14	0.26	0.19	80	140	110	0.5	4.0	2.5
К	Nodular Cast Iron	150	0.16	0.34	0.28	140	230	190	0.5	7.0	3.0
K	Grey Cast Iron	150	0.18	0.38	0.30	150	240	200	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.12	0.22	0.17	25	45	35	0.5	5.0	2.3
н	Hardened material	45HRc	0.10	0.22	0.16	40	80	60	0.5	2.5	1.5

					SPMT 09T	308					
	Material					(Cutting condition	ons			
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	S	peed Vc (m/mi	n)	D	epth Of Cut (m	nm)
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.07	0.17	0.15	190	330	250	0.5	9.0	2.4
P	Low Alloy	200	0.07	0.17	0.15	130	240	180	0.5	9.0	2.4
	High Alloy	220	0.07	0.15	0.13	60	150	130	0.5	6.5	1.8
	Austenitic	190	0.08	0.14	0.12	160	250	220	0.5	9.0	2.4
M	Ferritic	220	0.07	0.14	0.10	140	210	160	0.5	7.0	2.0
	Martensitic	40 Hc	0.06	0.12	0.09	80	160	120	0.5	7.0	1.5
К	Nodular Cast Iron	150	0.08	0.20	0.16	140	230	190	0.5	9.0	2.4
K	Grey Cast Iron	150	0.06	0.22	0.18	150	240	200	0.5	9.0	2.4
S	Heat resistant and super alloys	240	0.04	0.12	0.10	25	45	32	0.5	6.5	1.8
Н	Hardened material	45HRc	0.04	0.12	0.10	40	80	60	0.5	3.2	1.2

	SPMT 12T308													
	Material					C	Cutting conditi	ons						
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/m	in)	D	epth Of Cut (m	nm)			
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.13	0.29	0.18	190	330	250	0.5	11.0	3.0			
P	Low Alloy	200	0.11	0.23	0.16	130	240	180	0.5	10.0	3.0			
	High Alloy	220	0.08	0.20	0.14	60	150	130	0.5	8.0	2.3			
	Austenitic	190	0.12	0.23	0.16	160	250	220	0.5	9.0	3.0			
M	Ferritic	220	0.12	0.22	0.16	140	220	180	0.5	9.0	3.0			
	Martensitic	40 Hc	0.11	0.18	0.14	80	150	120	0.5	6.8	2.0			
К	Nodular Cast Iron	150	0.12	0.28	0.18	140	230	190	0.5	11.0	3.0			
K	Grey Cast Iron	150	0.13	0.29	0.18	150	240	200	0.5	11.0	3.0			
S	Heat resistant and super alloys	240	0.08	0.18	0.13	25	45	32	0.5	6.5	2.3			
Н	Hardened material	45HRc	0.07	0.16	0.11	40	80	60	0.5	3.2	1.5			

	SPMT 120408													
	Material					(Cutting conditi	ons						
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	S	peed Vc (m/m	in)	D	epth Of Cut (n	nm)			
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.13	0.29	0.18	190	330	250	0.5	11.0	3.0			
P	Low Alloy	200	0.11	0.23	0.16	130	240	180	0.5	10.0	3.0			
	High Alloy	220	0.08	0.20	0.14	60	150	130	0.5	8.0	2.3			
	Austenitic	190	0.12	0.23	0.17	160	250	220	0.5	9.0	3.0			
M	Ferritic	220	0.12	0.22	0.16	140	220	180	0.5	9.0	3.0			
	Martensitic	40 Hc	0.11	0.18	0.14	80	150	120	0.5	6.8	2.0			
К	Nodular Cast Iron	150	0.13	0.28	0.18	160	230	190	0.5	11.0	3.0			
K	Grey Cast Iron	150	0.13	0.29	0.18	150	240	200	0.5	11.0	3.0			
S	Heat resistant and super alloys	240	0.08	0.18	0.13	25	45	32	0.5	6.5	2.3			
Н	Hardened material	45HRc	0.07	0.16	0.11	40	80	60	0.5	3.2	1.5			

	SPUN 120308														
	Material					(Cutting condition	ons							
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	th)	SI	oeed Vc (m/mii	n)	C	epth Of Cut (m	nm)				
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend				
	Non Alloy	120	0.18	0.37	0.26	190	330	220	0.5	7.0	3.0				
P	Low Alloy	200	0.15	0.29	0.23	150	210	180	0.5	7.0	3.0				
	High Alloy	220	0.12	0.25	0.21	90	130	120	0.5	5.0	2.3				
к	Nodular Cast Iron	150	0.18	0.36	0.26	140	240	200	0.5	7.0	3.0				
K	Grey Cast Iron	150	0.18	0.36	0.26	140	240	200	0.5	7.0	3.0				
Н	Hardened material	45HRc	0.10	0.21	0.16	40	80	60	0.5	2.5	1.5				

	TPKN 1603 PDTR													
	Material					C	Cutting condition	ons						
Group	Sub Croun	Hardness	Fee	ed Fz (mm/Too	th)	SI	peed Vc (m/mi	n)	C	epth Of Cut (n	nm)			
Group	Sub Group	Sub Group (HB)		Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.14	0.27	0.21	190	330	260	0.5	12.0	3.0			
P	Low Alloy	200	0.12	0.21	0.17	150	240	195	0.5	12.0	3.0			
	High Alloy	220	0.10	0.19	0.15	90	150	120	0.5	8.6	2.5			
К	Nodular Cast Iron	150	0.14	0.26	0.20	140	240	190	0.5	12.0	3.0			
K	Grey Cast Iron	150	0.14	0.27	0.21	150	240	190	0.5	12.0	3.0			
Н	Hardened material	45HRc	0.08	0.15	0.12	40	80	60	0.5	4.3	1.5			

TPKN 2204 PDTR										
	Material			Cutting conditions						
Group Sub-Group Hard		Hardness	Feed Fz (mm/Tooth)	Speed Vc (m/min)	Depth Of Cut (mm)					

Group	Sup Group										
		(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
	Non Alloy	120	0.16	0.27	0.22	190	330	260	0.5	18.0	4.0
P	Low Alloy	200	0.14	0.21	0.18	150	240	195	0.5	18.0	4.0
	High Alloy	220	0.11	0.19	0.15	90	150	120	0.5	12.9	3.0
v	Nodular Cast Iron	150	0.16	0.26	0.20	150	240	190	0.5	18.0	4.0
K	Grey Cast Iron	150	0.16	0.27	0.22	150	240	190	0.5	18.0	4.0
Н	Hardened material	45HRc	0.09	0.15	0.12	40	80	60	0.5	6.4	2.0

					TPKR 1603	PDTR						
	Material	Cutting conditions										
C	Cub Cuaum	Hardness	Fee	ed Fz (mm/Too	th)	Sį	Speed Vc (m/min)			Depth Of Cut (mm)		
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend	
	Non Alloy	120	0.16	0.22	0.19	190	330	260	0.5	12.0	3.0	
P	Low Alloy	200	0.14	0.18	0.16	150	240	195	0.5	12.0	3.0	
	High Alloy	220	0.11	0.15	0.13	90	150	120	0.5	8.6	2.5	
	Austenitic	190	0.14	0.18	0.16	190	250	220	0.5	12.0	3.0	
M	Ferritic	220	0.12	0.17	0.13	130	210	180	0.5	9.0	3.0	
	Martensitic	40 Hc	0.10	0.16	0.11	80	150	120	0.5	9.0	3.0	
К	Nodular Cast Iron	150	0.16	0.22	0.18	140	240	190	0.5	12.0	3.0	
K	Grey Cast Iron	150	0.16	0.22	0.19	150	240	190	0.5	12.0	3.0	
S	Heat resistant and super alloys	240	0.11	0.13	0.12	25	45	35	0.5	8.6	2.3	
Н	Hardened material	45HRc	0.09	0.13	0.11	40	80	60	0.5	3.4	1.5	

TPKR 2204 PDTR												
	Material	Cutting conditions										
Group	Sub Group	Hardness	Fee	ed Fz (mm/Too	oth)	S	peed Vc (m/m	in)	D	epth Of Cut (n	nm)	
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend	
	Non Alloy	120	0.16	0.22	0.19	190	330	260	0.5	18.0	4.0	
P	Low Alloy	200	0.14	0.18	0.16	150	240	195	0.5	18.0	4.0	
	High Alloy	220	0.11	0.15	0.13	90	150	120	0.5	12.9	3.0	
	Austenitic	190	0.14	0.24	0.18	190	250	220	0.5	18.0	4.0	
M	Ferritic	220	0.12	0.22	0.17	130	210	180	0.5	12.0	3.5	
	Martensitic	40 Hc	0.12	0.2	0.14	80	150	110	0.5	12.0	3.5	
К	Nodular Cast Iron	150	0.16	0.22	0.18	150	240	195	0.5	18.0	4.0	
K	Grey Cast Iron	150	0.16	0.22	0.19	150	240	195	0.5	18.0	4.0	
s	Heat resistant	240	0.11	0.13	0.12	25	45	35	0.5	12.9	3.0	
	and super alloys	240	0.11	0.13	0.12	23	45	33	0.5	12.9	3.0	
	Hardened material	45HRc	0.09	0.13	0.11	40	80	60	0.5	6.4	2.0	

TPUN 160308														
Material				Cutting conditions										
C	Cub Curum	Hardness	Fee	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)				
Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend			
	Non Alloy	120	0.14	0.27	0.20	190	330	220	0.5	12.0	3.0			
P	Low Alloy	200	0.12	0.21	0.17	150	210	180	0.5	12.0	3.0			
	High Alloy	220	0.10	0.19	0.15	90	130	120	0.5	8.6	2.3			
V	Nodular Cast Iron	150	0.14	0.26	0.20	240	240	200	0.5	12.0	3.0			
К	Grey Cast Iron	150	0.14	0.27	0.20	240	240	200	0.5	12.0	3.0			
Н	Hardened material	45HRc	0.08	0.15	0.12	80	80	60	0.5	4.3	1.5			