

# MILLING - Metric

Date compiled

May 4 2017

ADKT 1505..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.32	0.25	190	330	250	0.5	14.0	4.0
	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
M	Austenitic	190	0.14	0.24	0.18	190	250	220	0.5	14.0	3.0
	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
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	0.25	150	240	200	0.5	14.0	4.0
S	Heat resistant and super alloys	240	0.12	0.18	0.15	25	45	35	0.5	11.0	3.0
H	Hardened material	45Hrc	0.1	0.18	0.14	40	80	60	0.5	5.0	2.0
AOMT 1236..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.14	0.22	0.15	190	330	220	0.5	11.0	2.0
	Low Alloy	200	0.11	0.18	0.13	150	210	180	0.5	11.0	2.0
	High Alloy	220	0.08	0.15	0.12	90	150	120	0.5	8.0	1.5
M	Austenitic	190	0.14	0.24	0.18	190	250	220	0.5	11.0	2.0
	Ferritic	220	0.12	0.2	0.16	140	220	180	0.5	9.0	3.0
	Martensitic	40 Hc	0.12	0.18	0.14	80	150	120	0.5	6.0	2.0
K	Nodular Cast Iron	150	0.12	0.24	0.18	140	230	190	0.5	9.0	2.0
	Grey Cast Iron	150	0.13	0.22	0.15	150	240	190	0.5	11.0	2.0
S	Heat resistant and super alloys	240	0.08	0.13	0.10	25	45	30	0.5	8.0	1.5
H	Hardened material	45Hrc	0.07	0.13	0.08	40	80	55	0.5	2.4	0.8
APKT 1003..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.26	0.20	190	330	250	0.5	9.0	2.0
	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
M	Austenitic	190	0.11	0.21	0.16	190	250	220	0.5	9.0	2.0
	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
K	Nodular Cast Iron	150	0.12	0.24	0.18	140	230	190	0.5	9.0	2.0
	Grey Cast Iron	150	0.13	0.26	0.20	150	240	200	0.5	9.0	2.0
S	Heat resistant and super alloys	240	0.08	0.15	0.12	25	45	35	0.5	6.4	1.5
H	Hardened material	45Hrc	0.07	0.15	0.11	40	80	60	0.5	3.2	1.0
APKT 1604..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.32	0.25	190	330	250	0.5	15.0	4.0
	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
M	Austenitic	190	0.14	0.24	0.18	190	250	220	0.5	15.0	3.0
	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
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
S	Heat resistant and super alloys	240	0.12	0.18	0.15	25	45	35	0.5	10.7	3.0
H	Hardened material	45Hrc	0.10	0.18	0.14	40	80	60	0.5	5.4	2.0
APMT 1135..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.22	0.18	190	330	250	0.5	10.0	2.0
	Low Alloy	200	0.11	0.18	0.15	150	240	200	0.5	10.0	2.0
	High Alloy	220	0.08	0.15	0.12	90	150	120	0.5	7.2	1.5
M	Austenitic	190	0.14	0.24	0.18	190	250	220	0.5	10.0	2.0
	Ferritic	220	0.12	0.2	0.16	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
K	Nodular Cast Iron	150	0.12	0.22	0.18	140	230	190	0.5	10.0	2.0
	Grey Cast Iron	150	0.13	0.22	0.18	150	240	200	0.5	10.0	2.0
S	Heat resistant and super alloys	240	0.08	0.13	0.11	25	45	35	0.5	7.2	1.5
H	Hardened material	45Hrc	0.07	0.13	0.07	40	80	60	0.5	3.6	1.0

APMT 1604..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.16	0.30	0.23	190	330	250	0.5	15.0	4.0
	Low Alloy	200	0.14	0.23	0.19	150	240	200	0.5	15.0	4.0
	High Alloy	220	0.11	0.2	0.16	90	150	120	0.5	10.7	4.0
M	Austenitic	190	0.14	0.23	0.19	190	250	220	0.5	15.0	4.0
	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
K	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
H	Hardened material	45HRc	0.09	0.17	0.13	40	80	60	0.5	5.4	2.0
APXT 11T3..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.26	0.20	190	330	250	0.5	9.0	2.0
	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
M	Austenitic	190	0.14	0.21	0.16	190	250	220	0.5	9.0	2.0
	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	150	0.13	0.26	0.20	150	240	200	0.5	9.0	2.0
S	Heat resistant and super alloys	240	0.08	0.15	0.12	25	45	35	0.5	6.4	1.5
H	Hardened material	45HRc	0.07	0.15	0.11	40	80	60	0.5	3.2	1.0
ODMT 0605..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.22	0.54	0.38	190	330	250	0.5	4.0	2.5
	Low Alloy	200	0.18	0.43	0.31	150	240	195	0.5	4.0	2.5
	High Alloy	220	0.14	0.37	0.26	90	150	120	0.5	2.9	1.9
M	Austenitic	190	0.18	0.37	0.28	190	250	220	0.5	4.0	2.5
	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
K	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
H	Hardened material	45HRc	0.12	0.31	0.22	40	80	60	0.4	1.4	1.3
ODMW 0605..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.22	0.58	0.40	190	330	250	0.5	4.0	3.0
	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
K	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
H	Hardened material	45HRc	0.12	0.32	0.22	40	80	60	0.4	1.4	1.3
OFER 0704..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.22	0.50	0.37	190	300	250	0.5	4.5	3.0
	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
M	Austenitic	190	0.18	0.35	0.28	190	240	220	0.5	4.5	3.0
	Ferritic	220	0.18	0.32	0.24	140	220	160	0.5	4.0	3.0
	Martensitic	40 Hc	0.16	0.30	0.22	80	160	120	0.5	4.0	3.0
K	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	0.50	0.34	150	240	195	0.5	4.5	3.0
S	Heat resistant and super alloys	240	0.14	0.28	0.25	25	45	35	0.5	3.0	2.2
H	Hardened material	45HRc	0.12	0.28	0.20	40	70	60	0.4	1.0	1.0
OFMT 05T3..											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.22	0.51	0.37	190	330	250	0.5	3.5	2.5
	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
M	Austenitic	190	0.18	0.35	0.27	190	250	220	0.5	3.5	2.5
	Ferritic	220	0.18	0.30	0.24	130	210	160	0.5	4.0	2.5

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

**RDMT 0602M0**

Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.48	0.29	190	330	220	0.5	3.0	0.8
	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
M	Austenitic	190	0.15	0.38	0.25	190	250	220	0.5	2.5	0.8
	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
K	Nodular Cast Iron	150	0.18	0.50	0.30	140	230	190	0.5	1.5	0.8
	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
H	Hardened material	45HRc	0.10	0.27	0.18	40	80	60	0.3	0.6	0.4

**RDMT 0802M0**

Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	4.0	0.8
	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
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	0.8
	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
K	Nodular Cast Iron	150	0.18	0.54	0.32	140	230	190	0.5	1.8	0.8
	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
H	Hardened material	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4

**RDMT 0803M0**

Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	4.0	0.8
	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
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	0.8
	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
K	Nodular Cast Iron	150	0.18	0.54	0.32	140	230	190	0.5	1.8	0.8
	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
H	Hardened material	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4

**RDMT 10T3M0**

Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	5.0	1.0
	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
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	3.0	1.0
	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
K	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.2	1.0
	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
H	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.8	0.5

**RDMT 1204M0**

Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	1.3
	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
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	3.5	1.3
	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
K	Nodular Cast Iron	150	0.18	0.62	0.34	140	230	190	0.5	2.5	1.3
	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
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RDMW 0602M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.41	190	330	260	0.5	4.0	0.8
	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
K	Nodular Cast Iron	150	0.18	0.52	0.32	140	220	180	0.5	1.5	0.8
	Grey Cast Iron	150	0.18	0.52	0.32	150	240	195	0.5	1.5	0.8
H	Hardened material	45HRC	0.10	0.32	0.23	40	80	60	0.3	0.6	0.4

RDMW 0802M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.41	190	330	260	0.5	4.0	0.8
	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
K	Nodular Cast Iron	150	0.18	0.56	0.34	140	220	180	0.5	2.5	0.8
	Grey Cast Iron	140	0.18	0.56	0.34	150	240	195	0.5	2.5	0.8
H	Hardened material	45HRC	0.10	0.32	0.23	40	80	60	0.3	0.8	0.4

RDMW 10T3M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	5.0	1.5
	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
K	Nodular Cast Iron	150	0.18	0.60	0.34	140	230	190	0.5	1.8	1.0
	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	1.8	1.0
H	Hardened material	45HRC	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

RDMW 1204M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	2.0
	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
K	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.8	1.3
	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	2.8	1.3
H	Hardened material	45HRC	0.14	0.41	0.28	40	80	60	0.3	1.2	0.8

RPM T 08T2M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.41	190	330	250	0.5	4.0	0.8
	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
M	Austenitic	190	0.15	0.50	0.33	190	250	220	0.5	2.5	0.8
	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
K	Nodular Cast Iron	150	0.16	0.60	0.36	140	230	190	0.5	1.8	0.8
	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
H	Hardened material	45HRC	0.10	0.32	0.21	40	80	60	0.3	0.7	0.4

RPM T 10T3M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	5.0	1.0
	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
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	3.0	1.0
	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
K	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.2	1.0
	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
H	Hardened material	45HRC	0.10	0.36	0.23	40	80	60	0.3	0.8	0.5

RPM T 1204M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	1.3
	Low Alloy	200	0.15	0.50	0.30	150	240	195	0.5	5.0	1.3

M	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
	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
K	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.5	1.3
	Grey Cast Iron	150	0.18	0.64	0.35	150	240	190	0.5	2.5	1.3
S	Heat resistant and super alloys	240	0.13	0.30	0.29	25	50	38	0.5	1.5	1.0
H	Hardened material	45HRc	0.50	0.22	0.28	50	100	75	0.3	1.0	0.7

RPMW 1003M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	5.0	1.0
	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
K	Nodular Cast Iron	150	0.18	0.60	0.34	140	230	190	0.5	2.5	1.0
	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
H	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.8

RPMW 1204M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	1.3
	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
K	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	3.0	1.3
	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	3.0	1.3
H	Hardened material	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.5	1.0

RPMX 1204M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	6.0	1.3
	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
M	Austenitic	190	0.18	0.50	0.36	190	250	220	0.5	3.5	1.3
	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
K	Nodular Cast Iron	150	0.16	0.60	0.34	140	230	190	0.5	2.5	1.3
	Grey Cast Iron	150	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
S	Heat resistant and super alloys	240	0.13	0.30	0.29	25	50	38	0.5	1.5	1.0
H	Hardened material	45HRc	0.50	0.22	0.28	50	100	75	0.3	1.0	0.7

SEKN 1203 AFTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
	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
M	Austenitic	190	0.15	0.32	0.24	190	250	220	0.5	7.0	3.0
	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
K	Nodular Cast Iron	150	0.16	0.44	0.30	140	230	190	0.5	7.0	3.0
	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	0.10	0.26	0.18	30	60	35	0.5	5.0	2.3
H	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.0

SEKR 1203 AFTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
	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
M	Austenitic	190	0.15	0.32	0.24	190	250	220	0.5	7.0	3.0
	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
K	Nodular Cast Iron	150	0.16	0.44	0.30	140	230	190	0.5	7.0	3.0
	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
H	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

SEKT 12T3 AGTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			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
M	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
	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
K	Nodular Cast Iron	150	0.16	0.44	0.28	140	230	190	0.5	7.0	3.0
	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
H	Hardened material	45Hrc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

SEKT 1204 AFTN

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
	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
M	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
	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
K	Nodular Cast Iron	150	0.16	0.44	0.20	140	230	190	0.5	4.0	2.5
	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
H	Hardened material	45Hrc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

SEMT 1204 AFTN

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
	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
M	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
	Ferritic	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
K	Nodular Cast Iron	150	0.16	0.44	0.28	140	230	190	0.5	7.0	3.0
	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
H	Hardened material	45Hrc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

SEMT 13T3 AGSN

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
	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
M	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
	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
K	Nodular Cast Iron	150	0.16	0.44	0.30	140	130	190	0.5	7.0	3.0
	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
H	Hardened material	45Hrc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

SPKN 1203 EDTR

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.43	0.30	190	330	250	0.5	7.0	3.0
	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
K	Nodular Cast Iron	150	0.18	0.42	0.30	140	230	190	0.5	7.0	3.0
	Grey Cast Iron	150	0.18	0.43	0.30	150	240	200	0.5	7.0	3.0
H	Hardened material	45Hrc	0.10	0.24	0.17	40	80	60	0.5	2.5	1.5

SPKN 1504 EDTR

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.43	0.31	190	330	260	0.5	9.0	4.0
	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
K	Nodular Cast Iron	150	0.16	0.42	0.30	140	230	190	0.5	9.0	4.0
	Grey Cast Iron	150	0.18	0.43	0.31	150	240	190	0.5	9.0	4.0
H	Hardened material	45Hrc	0.10	0.24	0.17	40	80	60	0.5	3.2	2.0

SPKR 1203 EDTR

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend

P	Non Alloy	120	0.18	0.38	0.25	190	330	250	0.5	7.0	3.0
	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
M	Austenitic	190	0.15	0.26	0.22	190	250	220	0.5	7.0	3.0
	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
K	Nodular Cast Iron	150	0.16	0.34	0.28	140	230	190	0.5	7.0	3.0
	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
H	Hardened material	45Hrc	0.10	0.22	0.16	40	80	60	0.5	2.5	1.5

SPMT 09T308											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.07	0.17	0.15	190	330	250	0.5	9.0	2.4
	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
M	Austenitic	190	0.08	0.14	0.12	160	250	220	0.5	9.0	2.4
	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
K	Nodular Cast Iron	150	0.08	0.20	0.16	140	230	190	0.5	9.0	2.4
	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
H	Hardened material	45Hrc	0.04	0.12	0.10	40	80	60	0.5	3.2	1.2

SPMT 12T308											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.29	0.18	190	330	250	0.5	11.0	3.0
	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
M	Austenitic	190	0.12	0.23	0.16	160	250	220	0.5	9.0	3.0
	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
K	Nodular Cast Iron	150	0.12	0.28	0.18	140	230	190	0.5	11.0	3.0
	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
H	Hardened material	45Hrc	0.07	0.16	0.11	40	80	60	0.5	3.2	1.5

SPMT 120408											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.29	0.18	190	330	250	0.5	11.0	3.0
	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
M	Austenitic	190	0.12	0.23	0.17	160	250	220	0.5	9.0	3.0
	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
K	Nodular Cast Iron	150	0.13	0.28	0.18	160	230	190	0.5	11.0	3.0
	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
H	Hardened material	45Hrc	0.07	0.16	0.11	40	80	60	0.5	3.2	1.5

SPUN 120308											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.37	0.26	190	330	220	0.5	7.0	3.0
	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
K	Nodular Cast Iron	150	0.18	0.36	0.26	140	240	200	0.5	7.0	3.0
	Grey Cast Iron	150	0.18	0.36	0.26	140	240	200	0.5	7.0	3.0
H	Hardened material	45Hrc	0.10	0.21	0.16	40	80	60	0.5	2.5	1.5

TPKN 1603 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.14	0.27	0.21	190	330	260	0.5	12.0	3.0
	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
K	Nodular Cast Iron	150	0.14	0.26	0.20	140	240	190	0.5	12.0	3.0
	Grey Cast Iron	150	0.14	0.27	0.21	150	240	190	0.5	12.0	3.0
H	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	Hardness	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend

Group	Sub Group	(HB)	Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.16	0.27	0.22	190	330	260	0.5	18.0	4.0
	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
K	Nodular Cast Iron	150	0.16	0.26	0.20	150	240	190	0.5	18.0	4.0
	Grey Cast Iron	150	0.16	0.27	0.22	150	240	190	0.5	18.0	4.0
H	Hardened material	45Hrc	0.09	0.15	0.12	40	80	60	0.5	6.4	2.0

TPKR 1603 PDTR

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.16	0.22	0.19	190	330	260	0.5	12.0	3.0
	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
M	Austenitic	190	0.14	0.18	0.16	190	250	220	0.5	12.0	3.0
	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
K	Nodular Cast Iron	150	0.16	0.22	0.18	140	240	190	0.5	12.0	3.0
	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
H	Hardened material	45Hrc	0.09	0.13	0.11	40	80	60	0.5	3.4	1.5

TPKR 2204 PDTR

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.16	0.22	0.19	190	330	260	0.5	18.0	4.0
	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
M	Austenitic	190	0.14	0.24	0.18	190	250	220	0.5	18.0	4.0
	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
K	Nodular Cast Iron	150	0.16	0.22	0.18	150	240	195	0.5	18.0	4.0
	Grey Cast Iron	150	0.16	0.22	0.19	150	240	195	0.5	18.0	4.0
S	Heat resistant and super alloys	240	0.11	0.13	0.12	25	45	35	0.5	12.9	3.0
H	Hardened material	45Hrc	0.09	0.13	0.11	40	80	60	0.5	6.4	2.0

TPUN 160308

Material		Hardness (HB)	Cutting conditions								
Group	Sub Group		Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.14	0.27	0.20	190	330	220	0.5	12.0	3.0
	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
K	Nodular Cast Iron	150	0.14	0.26	0.20	240	240	200	0.5	12.0	3.0
	Grey Cast Iron	150	0.14	0.27	0.20	240	240	200	0.5	12.0	3.0
H	Hardened material	45Hrc	0.08	0.15	0.12	80	80	60	0.5	4.3	1.5