

Cutting Data

CMT Spiral Multi Flute Inserts



Carbide grade - MT8:

Sub-Micron Grade with Aluminum Titanium Nitride (AlTiN) multi-layer coating (ISO K10-K20). Extremely high heat resistant and smooth cutting operation, for high performance, and normal machining conditions. General purpose for all materials.

| ISO Standard | Material | Cutting Speed ft/min | Feed inch/tooth Cutting Diameter = D |
|--------------|--|----------------------|---|
| | | | Ø.63-Ø1.38 |
| P | Low and Medium Carbon Steels <0.55%C | 197 - 394 | .0055 - .0094 |
| | High Carbon Steels ≥0.55%C | 197 - 295 | .0047 - .0094 |
| | Alloy Steels, Treated Steels | 164 - 262 | .0031 - .0079 |
| M | Stainless Steel-Free Cutting | 230 - 328 | .0031 - .0075 |
| | Stainless Steel-Austenitic | 197 - 295 | .0031 - .0075 |
| | Cast Steels | 230 - 295 | .0031 - .0079 |
| K | Cast Iron | 131 - 262 | .0055 - .0094 |
| N | Aluminum ≤12%Si, Copper | 328 - 656 | .0055 - .0102 |
| | Aluminum >12%Si | 197 - 459 | .0031 - .0087 |
| | Synthetics, Duroplastics, Thermoplastics | 164 - 656 | .0067 - .0110 |
| S | Nickel Alloys, Titanium Alloys. | 66 - 131 | .0020 - .0055 |
| H | Hardened Steel, 45-50HRc | 197 - 230 | .0028 - .0067 |
| | Hardened Steel, 51-55HRc | 164 - 197 | .0024 - .0063 |