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 m/min	Feed mm/tooth Cutting Diameter = D
			Ø16-Ø35
P	Low and Medium Carbon Steels <0.55%C	60 - 120	0.14 - 0.24
	High Carbon Steels ≥0.55%C	60 - 90	0.12 - 0.24
	Alloy Steels,Treated Steels	50 - 80	0.08 - 0.20
M	Stainless Steel-Free Cutting	70 - 100	0.08 - 0.19
	Stainless Steel-Austenitic	60 - 90	0.08 - 0.19
	Cast Steels	70 - 90	0.08 - 0.20
K	Cast Iron	40 - 80	0.14 - 0.24
N	Aluminum ≤12%Si, Copper	100 - 200	0.14 - 0.26
	Aluminum >12%Si	60 - 140	0.08 - 0.22
	Synthetics, Duroplastics, Thermoplastics	50 - 200	0.17 - 0.28
S	Nickel Alloys, Titanium Alloys.	20 - 40	0.05 - 0.14
H	Hardened Steel, 45-50HRc	60 - 70	0.07 - 0.17
	Hardened Steel, 51-55HRc	50 - 60	0.06 - 0.16