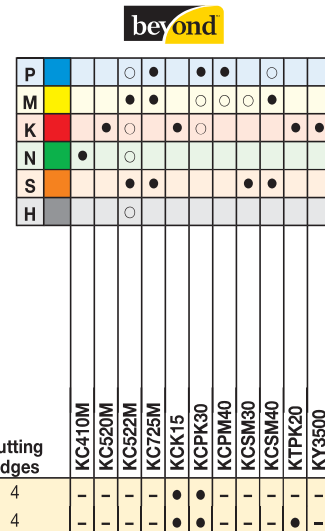


- first choice
- alternate choice



catalog number	D	S	L10	BS	R _e	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPM40	KCSM30	KCSM40	KTPM20	KY3500
SPPT3125PPSR8GB2	.394	.156	.394	.106	.031	.003	4	-	-	-	-	●	●	-	-	-	-
SPPT3125PPSR8GB2	.394	.156	.394	.106	.031	.005	4	-	-	-	-	●	●	-	-	●	-

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LE	.005	.017	.028	.003	.012	.020	.003	.009	.015	.002	.008	.013	.002	.007	.012	.F..LE
.F..LD	.005	.017	.028	.003	.012	.020	.003	.009	.015	.002	.008	.013	.002	.007	.012	.F..LD
.E..LD2	.005	.018	.032	.004	.013	.023	.003	.010	.017	.002	.009	.015	.002	.008	.014	.E..LD2
.E..LD	.007	.019	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.E..LD
.E..GB2	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.E..GB2
.S..GB	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB
.S..GB2	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB2
.S..GN	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GN

Shoulder Milling