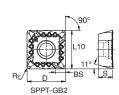
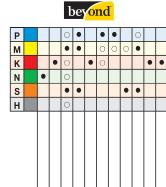


- · Medium machining.
- PSTS Precision Pressed and Sintered to Size.
- 5° rake face.
- Four cutting edges.



• first choice

o alternate choice



SPPT-GB2

SPPT-GB2

	catalog number	D	s	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KTPK20	81
Ī	SPPT3125PPER8GB2	.394	.156	.394	.106	.031	.003	4	-	_	_	-	•	•	-	_	-		-
	SPPT3125PPSR8GB2	.394	.156	.394	.106	.031	.005	4	[_[_	_	-	•	•	[_[_].	-1	• .	-

Recommended Starting Feeds

■ Recommended Starting Feeds [IPT]

Light	General	Heavy
Machining	Purpose	Machining

Insert	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)													Insert		
Geometry			10%			20%			30%			40–100%			Geometry	
.FLE	.005	.017	.028	.003	.012	.020	.003	.009	.015	.002	.008	.013	.002	.007	.012	.FLE
.FLD	.005	.017	.028	.003	.012	.020	.003	.009	.015	.002	.008	.013	.002	.007	.012	.FLD
.ELD2	.005	.018	.032	.004	.013	.023	.003	.010	.017	.002	.009	.015	.002	.008	.014	.ELD2
.ELD	.007	.019	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.ELD
.EGB2	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.EGB2
.SGB	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.SGB
.SGB2	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.SGB2
.SGN	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.SGN

NOTE: Use "Light Machining" values as starting feed rate.

Please see pages X22–X37 for recommended starting speeds.

