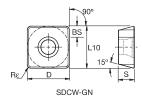


- · Heavy machining.
- Precision ground.
- 0° rake face flat top.
- Four cutting edges.





• first choice

o alternate choice

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## SDCW-GN

catalog number	D	s	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCSM30	KCSM40	KY3500
SDCW43EDSR8GN	.500	.188	.500	.132	.031	.006	4	-	-	-	-	-	-   -	-	-	•
SDCW43PDSR8GN	.500	.188	.500	.099	.031	.006	4	-	-	-	-	-	- -	-   -	-	•
SDCW433PDSR8GN	.500	.188	.500	.120	.047	.006	4	-	-	-	-	-	- -	-  -	-	•

## **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		5%			10%			20%			30%		'	40–100%	Geometry	
.FLE	.005	.017	.030	.003	.012	.021	.003	.009	.016	.002	.008	.014	.002	.007	.013	.FLE
.ELD	.007	.019	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.ELD
.ELD2	.005	.018	.032	.004	.013	.023	.003	.010	.017	.002	.009	.015	.002	.008	.014	.ELD2
.EGB	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.EGB
.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.

