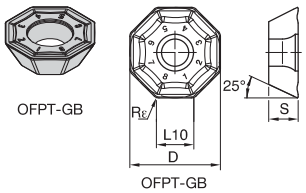
- First choice for general purpose.

beyond



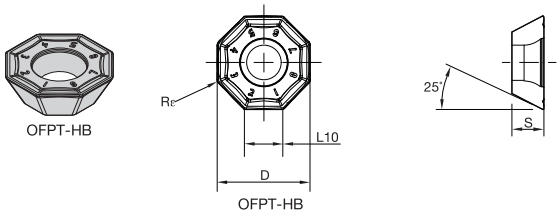
● first choice
○ alternate choice

P					○	●		●	●	○
M					●	●		○	○	●
K				●	○		●	○		
N	●	●								
S					●	●				●
H										

OFPT-GB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFPT06L5AFENGB	15	5,00	6,00	–	0,8	0,15	8	–	–	●	–	●	●	●	●	–

- First choice for heavy roughing.
- -HB geometry with the strongest cutting edge is the first choice for roughing operations on steel and cast iron.



OFPT-HB

catalogue number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC422M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40
OFPT06L5AFSNHB	15	5,00	6,00	–	0,8	0,21	8	–	–	●	–	●	●	●	–	●

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..LBJ	0,17	**0,61**	1,03	0,12	**0,44**	0,74	0,09	**0,33**	0,55	0,08	**0,29**	0,48	0,07	**0,26**	0,44	.F..LBJ
.F..LNJ	0,17	**0,61**	1,03	0,12	**0,44**	0,74	0,09	**0,33**	0,55	0,08	**0,29**	0,48	0,07	**0,26**	0,44	.F..LNJ
.E..LBJ	0,17	**0,61**	1,13	0,12	**0,44**	0,81	0,09	**0,33**	0,61	0,08	**0,29**	0,53	0,07	**0,26**	0,48	.E..LBJ
.E..LB	0,34	**0,75**	1,20	0,25	**0,54**	0,86	0,19	**0,40**	0,64	0,16	**0,35**	0,56	0,15	**0,32**	0,51	.E..LB
.S..LB	0,34	**0,73**	1,30	0,25	**0,53**	0,93	0,19	**0,39**	0,69	0,16	**0,34**	0,60	0,15	**0,32**	0,55	.S..LB
.E..GB	0,34	**0,87**	1,39	0,25	**0,62**	1,00	0,19	**0,47**	0,74	0,16	**0,41**	0,65	0,15	**0,37**	0,59	.E..GB
.S..HB	0,34	**0,87**	1,49	0,25	**0,62**	1,07	0,19	**0,47**	0,79	0,16	**0,41**	0,69	0,15	**0,37**	0,63	.S..HB

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22–X37 for recommended starting speeds.