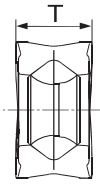
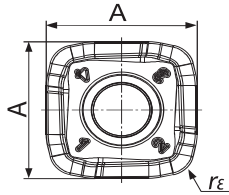


DOFEEDQUAD

Insert



Front

Back

Cat. No.	Accuracy	Honing	Grades PREMIUMTEC				Dimensions (in)		
			AH725	AH130	AH120	T3130	A	T	rε
SQMU1206ZSR-MJ	M	with	●	●	●	●	.461	.236	.079

Grade selection

Grades	P Steel	M Stainless	K Cast Iron	S Super alloys	H Hard Materials
AH725	⊙		○	⊙	⊙
AH130	○ For impact resistance	⊙			
AH120			⊙		
T3130	⊙ For wear resistance				

⊙ : First choice
○ : Applicable

Tool dia.: ϕD_c (in), Number of revolutions: n (rpm), Feed speed: V_f (ipm), Max. depth of cut: $a_p = .079''$

$\phi 2.000$		$\phi 2.500$		$\phi 3.000$		$\phi 4.000$		$\phi 5.000$	
n	V_f	n	V_f	n	V_f	n	V_f	n	V_f
1,260	227	1,010	242	790	237	630	227	500	210
$V_c = 660$ sfm, $f_z = .060$ ipt									
950	114	750	120	590	118	470	113	380	106
$V_c = 500$ sfm, $f_z = .040$ ipt									
950	86	750	90	590	89	470	85	380	80
$V_c = 500$ sfm, $f_z = .030$ ipt									
760	46	600	48	470	47	380	46	300	42
$V_c = 400$ sfm, $f_z = .020$ ipt									
1,260	227	1,010	242	790	237	630	227	500	210
$V_c = 660$ sfm, $f_z = .060$ ipt									
950	171	750	180	590	177	470	170	380	160
$V_c = 500$ sfm, $f_z = .060$ ipt									
250	15	200	16	150	15	120	14	100	14
$V_c = 130$ sfm, $f_z = .020$ ipt									
630	15	500	16	390	16	310	15	250	14
$V_c = 330$ sfm, $f_z = .008$ ipt									
380	2	300	2	240	2	190	2	150	2
$V_c = 200$ sfm, $f_z = .002$ ipt									

● : Stocked items.