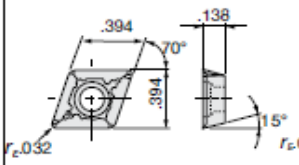
Inserts

GDMT10H3PDPR-MJ



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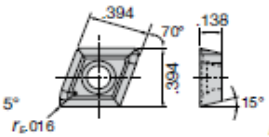

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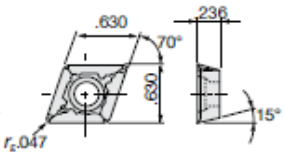

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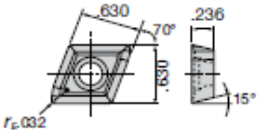

Cat. No.	Accuracy	Honing	Coated				DLC coated	Uncoated	
			AH120	AH140	AH330	T3130	DS1100	UX30	TH10
GDMT10H3PDPR-MJ	M	With	●	●	●	●		●	
GDMT17X6PDPR-MJ			●	●	●	●		●	
GDGT10H3PDFR-AJ	G	Without					●		●
GDGT17X6PDFR-AJ							●		●

Standard cutting conditions

Work material	Grades	ESD (ø1.0 – 1.25 in)			T/ESD (ø1.57 – 3.15 in)		
		Cutting speed *Vc* (SFM)	Feed per tooth *fz* (in/t)		Cutting speed *Vc* (SFM)	Feed per tooth *fz* (in/t)	
			Shouldering, grooving, Z-feed milling	Partial plunging		Shouldering, grooving, Z-feed milling	Partial plunging
Carbon steels (JIS S50C, etc.) < 300 HB	**AH120**	330 – 590	.002 – .008	.001 – .004	400 – 650	.003 – .010	.001 – .004
	AH330	400 – 750	.002 – .006	.001 – .003	500 – 820	.002 – .008	.001 – .003
	UX30	260 – 425			330 – 425		
	T3130	330 – 590	.002 – .008	.001 – .004	400 – 650	.003 – .010	.001 – .004
Alloy steels (JIS SCM440, etc.) < 300 HB	**AH120**	260 – 525	.002 – .006	.001 – .003	330 – 590	.003 – .008	.001 – .003
	AH330	330 – 650	.002 – .005	.001 – .002	400 – 750	.002 – .006	.001 – .002
	UX30	260 – 400			330 – 400		
	T3130	260 – 525	.002 – .006	.001 – .003	330 – 590	.003 – .008	.001 – .003
Die steels (H13,P20, etc.) < 300 HB	**AH120**	200 – 400	.002 – .005	.001 – .002	260 – 500	.003 – .006	.001 – .002
	AH330	260 – 525	.002 – .004	.001 – .002	330 – 650	.002 – .005	.001 – .002
	UX30	200 – 330			260 – 400		
	T3130	200 – 400	.002 – .005	.001 – .002	260 – 500	.003 – .006	.001 – .002
Stainless steels (JIS 304, 316)	**AH140**	260 – 525	.002 – .006	.001 – .003	330 – 590	.003 – .008	.001 – .003
Cast irons (Class 25-40, etc.)	**AH120**	330 – 590	.002 – .010	.001 – .004	400 – 650	.003 – .010	.001 – .004
	AH330	400 – 750	.002 – .008	.001 – .003	500 – 820	.002 – .008	.001 – .003
	UX30	260 – 425			330 – 425		
Aluminium alloys	**DS1100**	650 – 3300	.002 – .010	.002 – .006	650 – 3300	.002 – .010	.002 – .006
Copper alloys	**TH10**	650 – 1300	.002 – .010	.002 – .006	650 – 1300	.002 – .010	.002 – .006