

● Standard cutting conditions

LNMX12□□□-□□□

Work materials	Chipbreakers	Grades	Cutting speed V_c (SFM)	Depth of cut: a_p (in)		Feed: f (in/rev)	
				R.032	R.047	R.032	R.047
Steels S45C, SCM415 etc	TDR	T9115	400 - 820	.020 - .196	.031 - .196	.006 - .024	.008 - .031
		T9125	260 - 500				
	TWR	T9115	400 - 820				
		T9125	260 - 500				
Stainless steels SUS304, SUS316 etc	TDR	T9115	330 - 590				
		T9125	260 - 500				
	TWR	T9115	330 - 590				
		T9125	260 - 500				

LNMX16□□□-□□□

Work materials	Chipbreakers	Grade	Cutting speed V_c (SFM)	Depth of cut: a_p (in)			Feed: f (in/rev)		
				R.032	R.047	R.063	R.032	R.047	R.063
Steels S45C, SCM415 etc	TDR	T9115	400 - 820	.020 - .197	.032 - .236	.039 - .315	.005 - .024	.010 - .032	.012 - .039
		T9125	260 - 500						
	MDR	T9115	400 - 820	.059 - .236	.059 - .275	-	.004 - .020	.006 - .028	-
		AH725	260 - 500						
	TWR	T9115	400 - 820	.020 - .197	.032 - .236	-	.006 - .024	.010 - .032	-
		T9125	260 - 500						
Stainless steels SUS304, SUS316 etc	TDR	T9115	330 - 590	.020 - .197	.032 - .236	.039 - .315	.005 - .024	.010 - .032	.012 - .039
		T9125	260 - 500						
	MDR	T9115	330 - 500	.059 - .236	.059 - .275	-	.004 - .020	.006 - .028	-
		AH725	160 - 500						
	TWR	T9115	330 - 590	.020 - .197	.032 - .236	-	.006 - .024	.010 - .032	-
		T9125	260 - 500						

LNMX24□□□-□□□

Work materials	Chipbreakers	Grade	Cutting speed V_c (SFM)	Depth of cut: a_p (in)		Feed: f (in/rev)	
				R.032	R.047	R.032	R.047
Steels S45C, SCM415 etc	TDR	T9115	400 - 820	.157 - .590	.197 - .590	.012 - .039	.012 - .043
		T9125	260 - 500				
Stainless steels SUS304, SUS316 etc	TDR	T9115	330 - 590				
		T9125	260 - 500				

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TAC External Toolholders