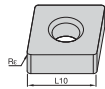
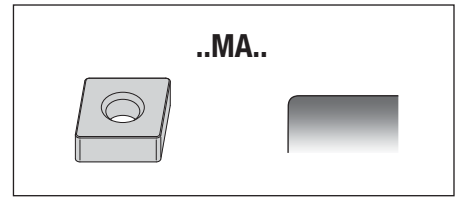
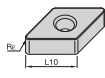


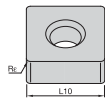
cutting conditions				
cutting speed (SFM) range	<b>K1</b>	790	1180	1800
	<b>K2</b>	490	885	1480
	<b>K3</b>	460	705	1345
carbide grade		<b>KCK15</b>		



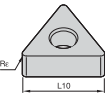
ISO catalog number	ANSI catalog number	KCK15	L10		R <sub>ε</sub>		ap min	starting value depth of cut		f/rev min	starting value feed rate	
			mm	in	mm	in		(in)	ap max		(in/rev)	f/rev max
CNMA120408	CNMA432	3752128	12,90	.508	0,8	1/32	.039	.114	.236	.011	.017	.023
CNMA120412	CNMA433	3752129	12,90	.508	1,2	3/64	.047	.137	.236	.012	.019	.025
CNMA120416	CNMA434	3752130	12,90	.508	1,6	1/16	.055	.161	.236	.013	.021	.027
CNMA160608	CNMA542	3752131	16,12	.635	0,8	1/32	.039	.114	.275	.011	.017	.023
CNMA160612	CNMA543	3752132	16,12	.635	1,2	3/64	.047	.137	.275	.012	.019	.025
CNMA160616	CNMA544	3752143	16,12	.635	1,6	1/16	.055	.161	.315	.013	.021	.027
CNMA190612	CNMA643	3752144	19,34	.762	1,2	3/64	.047	.137	.354	.012	.019	.027



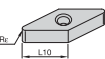
DNMA150408	DNMA432	3752145	15,50	.610	0,8	1/32	.039	.114	.236	.012	.017	.023
DNMA150412	DNMA433	3752146	15,50	.610	1,2	3/64	.047	.137	.236	.013	.019	.025
DNMA150608	DNMA442	3752147	15,50	.610	0,8	1/32	.039	.114	.236	.012	.017	.023



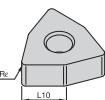
SNMA120412	SNMA433	3752152	12,70	.500	1,2	3/64	.047	.137	.236	.012	.019	.025
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TNMA160408	TNMA332	3752157	16,50	.650	0,8	1/32	.039	.094	.236	.011	.017	.023
TNMA160412	TNMA333	3752158	16,50	.650	1,2	3/64	.047	.114	.236	.012	.019	.025
TNMA160416	TNMA334	3752159	16,50	.650	1,6	1/16	.070	.173	.236	.012	.019	.025



VNMA160408	VNMA332	3752164	16,61	.654	0,8	1/32	.023	.055	.157	.009	.015	.019
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WNMA060408	WNMA332	3752165	6,52	.257	0,8	1/32	.039	.094	.157	.011	.015	.019
WNMA080408	WNMA432	3752167	8,69	.342	0,8	1/32	.039	.094	.197	.011	.017	.023
WNMA080412	WNMA433	3752168	8,69	.342	1,2	3/64	.047	.114	.197	.012	.019	.025

