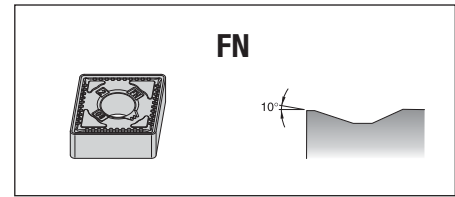


cutting conditions			
cutting speed (SFM) range	P0/P1	460 1300 1480	440 900 1180
	P2	590 870 1150	440 640 1150
	P3	555 625 820	440 510 755
	P4	295 475 655	230 345 590
carbide grade		KCP10B	KCP25B



ISO catalog number	ANSI catalog number	KCP10B	KCP25B	L10		R _e		ap min	starting value depth of cut (in)	ap max	f/rev min	starting value feed rate (in/rev)	f/rev max
				mm	in	mm	in						
CNMG090308FN	CNMG322FN	5523306	-	9,67	.381	0,8	1/32	.015	.039	.078	.003	.007	.011
CNMG120404FN	CNMG431FN	5531836	5531838	12,90	.508	0,4	1/64	.007	.019	.078	.003	.005	.009
CNMG120408FN	CNMG432FN	5531839	5531890	12,90	.508	0,8	1/32	.015	.039	.098	.003	.007	.011
CNMG120412FN	CNMG433FN	5531894	5531893	12,90	.508	1,2	3/64	.019	.047	.118	.004	.007	.011
DNMG110404FN	DNMG331FN	5531896	5698171	11,63	.458	0,4	1/64	.007	.019	.059	.003	.005	.009
DNMG110408FN	DNMG332FN	5697020	5531897	11,63	.458	0,8	1/32	.015	.039	.078	.003	.007	.011
DNMG110412FN	DNMG333FN	5544755	-	11,63	.458	1,2	3/64	.019	.047	.098	.004	.007	.011
DNMG150404FN	DNMG431FN	5697021	5531899	15,50	.610	0,4	1/64	.007	.019	.078	.003	.005	.009
DNMG150408FN	DNMG432FN	5531900	5698172	15,50	.610	0,8	1/32	.015	.039	.098	.003	.007	.011
DNMG150412FN	DNMG433FN	5697023	-	15,50	.610	1,2	3/64	.019	.047	.118	.004	.007	.011
DNMG150604FN	DNMG441FN	5531901	5531903	15,50	.610	0,4	1/64	.007	.019	.078	.003	.005	.009
DNMG150608FN	DNMG442FN	5388116	5531906	15,50	.610	0,8	1/32	.015	.039	.098	.003	.007	.011
DNMG150612FN	DNMG443FN	5531908	-	15,50	.610	1,2	3/64	.019	.047	.118	.004	.007	.011
SNMG120404FN	SNMG431FN	5531910	-	12,70	.500	0,4	1/64	.007	.019	.078	.003	.005	.009
SNMG120408FN	SNMG432FN	5697027	-	12,70	.500	0,8	1/32	.015	.039	.098	.003	.007	.011
TNMG160404FN	TNMG331FN	5697029	5698187	16,50	.650	0,4	1/64	.007	.019	.098	.003	.005	.009
TNMG160408FN	TNMG332FN	5413249	5698188	16,50	.650	0,8	1/32	.015	.039	.118	.003	.007	.011
TNMG160412FN	TNMG333FN	5413251	-	16,50	.650	1,2	3/64	.019	.047	.137	.004	.007	.011
TNMG220408FN	TNMG432FN	5507610	-	22,00	.866	0,8	1/32	.015	.039	.137	.003	.007	.011
VNMG160404FN	VNMG331FN	5697035	5698197	16,61	.654	0,4	1/64	.007	.015	.078	.003	.005	.009
VNMG160408FN	VNMG332FN	5615609	5615650	16,61	.654	0,8	1/32	.011	.023	.098	.003	.007	.011
WNMG080404FN	WNMG431FN	5697036	5698198	8,69	.342	0,4	1/64	.007	.019	.078	.003	.005	.009
WNMG080408FN	WNMG432FN	5697037	5698199	8,69	.342	0,8	1/32	.015	.039	.098	.003	.007	.011



A30 A35 A46

TURNING

FIRST CHOICE

MILLING

FIRST CHOICE

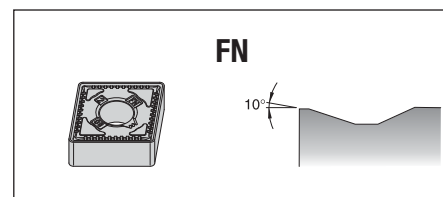
HOLEMAKING

FIRST CHOICE

TOOLING SYSTEMS

FIRST CHOICE

cutting conditions			
cutting speed (SFM) range	K1	920	1475 1970
	K2	755	1180 1800
	K3	490	790 1640
carbide grade		KCK05	



ISO catalog number	ANSI catalog number	KCK05	L10		Rε		ap min	starting value depth of cut (in)		f/rev min	starting value feed rate (in/rev)	
			mm	in	mm	in		ap max	f/rev max		f/rev max	
CNMG090308FN	CNMG322FN	3751944	9,67	.381	0,8	1/32	.015	.039	.078	.003	.007	.011
CNMG120404FN	CNMG431FN	3751945	12,90	.508	0,4	1/64	.007	.019	.078	.003	.005	.009
CNMG120408FN	CNMG432FN	3751946	12,90	.508	0,8	1/32	.015	.039	.098	.003	.007	.011
DNMG110404FN	DNMG331FN	3751950	11,63	.458	0,4	1/64	.007	.019	.059	.003	.005	.009
DNMG110408FN	DNMG332FN	3751952	11,63	.458	0,8	1/32	.015	.039	.078	.003	.007	.011
DNMG150404FN	DNMG431FN	3751955	15,50	.610	0,4	1/64	.007	.019	.078	.003	.005	.009
DNMG150408FN	DNMG432FN	3751956	15,50	.610	0,8	1/32	.015	.039	.098	.003	.007	.011
DNMG150412FN	DNMG433FN	3751958	15,50	.610	1,2	3/64	.019	.047	.118	.004	.007	.011
DNMG150604FN	DNMG441FN	3751959	15,50	.610	0,4	1/64	.007	.019	.078	.003	.005	.009
DNMG150608FN	DNMG442FN	3751960	15,50	.610	0,8	1/32	.015	.039	.098	.003	.007	.011
DNMG150612FN	DNMG443FN	3751961	15,50	.610	1,2	3/64	.019	.047	.118	.004	.007	.011
SNMG090308FN	SNMG322FN	3751963	9,53	.375	0,8	1/32	.015	.039	.078	.003	.007	.011
SNMG120404FN	SNMG431FN	3751964	12,70	.500	0,4	1/64	.007	.019	.078	.003	.005	.009
TNMG160404FN	TNMG331FN	3751970	16,50	.650	0,4	1/64	.007	.019	.098	.003	.005	.009
TNMG160408FN	TNMG332FN	3751971	16,50	.650	0,8	1/32	.015	.039	.118	.003	.007	.011
TNMG160412FN	TNMG333FN	3751972	16,50	.650	1,2	3/64	.019	.047	.137	.004	.007	.011
VNMG160404FN	VNMG331FN	3751974	16,61	.654	0,4	1/64	.007	.015	.078	.003	.005	.009
VNMG160408FN	VNMG332FN	3751975	16,61	.654	0,8	1/32	.011	.023	.098	.003	.007	.011
WNMG060404FN	WNMG331FN	3751976	6,52	.257	0,4	1/64	.007	.019	.059	.003	.005	.009
WNMG080404FN	WNMG431FN	3751978	8,69	.342	0,4	1/64	.007	.019	.078	.003	.005	.009
WNMG080408FN	WNMG432FN	3751979	8,69	.342	0,8	1/32	.015	.039	.098	.003	.007	.011

