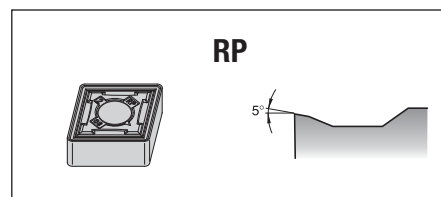
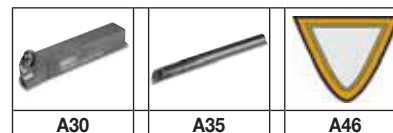


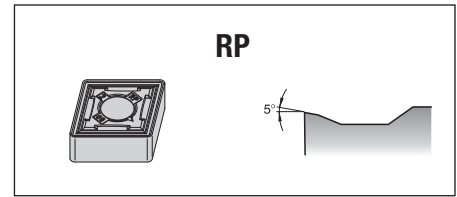
cutting conditions				
cutting speed (SFM) range	P0/P1	460 1300 1480	440 900 1180	425 690 790
	P2	590 870 1150	440 640 1150	425 490 755
	P3	555 625 820	440 510 755	330 395 560
	P4	295 475 655	230 345 590	165 310 460
	P5	490 705 985	395 640 885	360 440 490
	P6	360 590 885	345 490 720	260 345 460
carbide grade		KCP10B	KCP25B	KCP40B



ISO catalog number	ANSI catalog number	KCP10B	KCP25B	KCP40B	L10 mm in	R <sub>e</sub> mm in	ap min	starting value		starting value	
								depth of cut (in)	ap max	f/rev min	feed rate (in/rev) max
CNMG120404RP	CNMG431RP	-	5694083	-	12,90 .508	0,4 1/64	.023	.070	.137	.007	.011 .015
CNMG120408RP	CNMG432RP	5388039	5387665	-	12,90 .508	0,8 1/32	.039	.114	.177	.007	.017 .023
CNMG120412RP	CNMG433RP	5413174	5413175	5886541	12,90 .508	1,2 3/64	.047	.137	.197	.008	.019 .025
CNMG120416RP	CNMG434RP	5413176	5413177	-	12,90 .508	1,6 1/16	.055	.161	.197	.009	.019 .027
CNMG160608RP	CNMG542RP	-	5694088	-	16,12 .635	0,8 1/32	.039	.114	.275	.007	.017 .023
CNMG160612RP	CNMG543RP	5413180	5413181	5886542	16,12 .635	1,2 3/64	.047	.137	.275	.008	.019 .025
CNMG160616RP	CNMG544RP	5413182	5413183	-	16,12 .635	1,6 1/16	.055	.161	.315	.009	.019 .027
CNMG190612RP	CNMG643RP	5697939	5694092	5591971	19,34 .762	1,2 3/64	.047	.137	.354	.008	.019 .027
CNMG190616RP	CNMG644RP	-	5694093	-	19,34 .762	1,6 1/16	.055	.161	.354	.009	.023 .031
DNMG110408RP	DNMG332RP	-	5694108	-	11,63 .458	0,8 1/32	.039	.094	.157	.007	.015 .019
DNMG110412RP	DNMG333RP	-	5694109	-	11,63 .458	1,2 3/64	.047	.114	.157	.008	.015 .021
DNMG150408RP	DNMG432RP	5697968	5694121	-	15,50 .610	0,8 1/32	.039	.094	.197	.007	.017 .023
DNMG150412RP	DNMG433RP	5413195	5413196	-	15,50 .610	1,2 3/64	.047	.114	.197	.008	.019 .025
DNMG150608RP	DNMG442RP	5413197	5413198	-	15,50 .610	0,8 1/32	.039	.094	.197	.007	.017 .023
DNMG150612RP	DNMG443RP	5413202	5387543	-	15,50 .610	1,2 3/64	.047	.114	.197	.008	.019 .025
DNMG150616RP	DNMG444RP	5387851	5387545	-	15,50 .610	1,6 1/16	.055	.133	.197	.009	.019 .027
SNMG120408RP	SNMG432RP	-	5631151	-	12,70 .500	0,8 1/32	.039	.114	.236	.007	.017 .023
SNMG120412RP	SNMG433RP	5387874	5387563	-	12,70 .500	1,2 3/64	.047	.137	.236	.008	.019 .025
SNMG150612RP	SNMG543RP	5387882	5387567	-	15,88 .625	1,2 3/64	.047	.137	.275	.008	.021 .029
SNMG150616RP	SNMG544RP	5697163	-	-	15,88 .625	1,6 1/16	.055	.161	.275	.009	.023 .031
SNMG190612RP	SNMG643RP	-	5698113	5886544	19,05 .750	1,2 3/64	.047	.137	.354	.008	.023 .033
TNMG160408RP	TNMG332RP	5697030	5698189	-	16,50 .650	0,8 1/32	.039	.114	.236	.007	.017 .023
TNMG160412RP	TNMG333RP	5387896	5387575	-	16,50 .650	1,2 3/64	.047	.137	.236	.008	.019 .025
TNMG220408RP	TNMG432RP	5697178	5698131	5886545	22,00 .866	0,8 1/32	.039	.114	.295	.007	.017 .025
TNMG220412RP	TNMG433RP	-	5698135	-	22,00 .866	1,2 3/64	.047	.137	.295	.008	.019 .027
TNMG220416RP	TNMG434RP	-	5387577	-	22,00 .866	1,6 1/16	.055	.161	.295	.009	.021 .029
TNMG220432RP	TNMG438RP	5387901	5698136	-	22,00 .866	3,2 1/8	.094	.275	.295	.011	.025 .035
TNMG330924RP	TNMG666RP	-	-	5591974	33,00 1.299	2,4 3/32	.078	.228	.512	.011	.025 .035
WNMG060408RP	WNMG332RP	5697203	-	-	6,52 .257	0,8 1/32	.039	.114	.157	.007	.015 .019
WNMG080408RP	WNMG432RP	5387915	5413206	5591972	8,69 .342	0,8 1/32	.039	.114	.197	.007	.017 .023
WNMG080412RP	WNMG433RP	5387919	5413207	-	8,69 .342	1,2 3/64	.047	.137	.197	.008	.019 .025
WNMG080416RP	WNMG434RP	-	5413208	-	8,69 .342	1,6 1/16	.055	.161	.197	.009	.019 .027



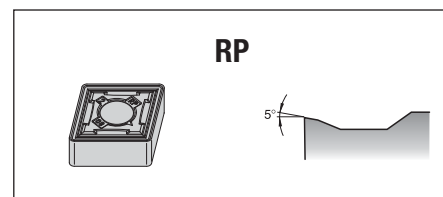
cutting conditions			
cutting speed (SFM) range	M1	330 590 820	295 490 590
	M2	330 540 855	295 460 590
	M3	330 490 820	295 395 590
carbide grade		KCM15B	KCM25B



ISO catalog number	ANSI catalog number	KCM15B	KCM25B	L10		R <sub>ε</sub>		starting value depth of cut		starting value feed rate			
				mm	in	mm	in	ap min	ap max	f/rev min	f/rev max		
CNMG120404RP	CNMG431RP	-	5591950	12,90	.508	0,4	1/64	.023	.070	.137	.007	.011	.015
CNMG120408RP	CNMG432RP	5640482	5596468	12,90	.508	0,8	1/32	.039	.114	.177	.007	.017	.023
CNMG120412RP	CNMG433RP	5640483	5596469	12,90	.508	1,2	3/64	.047	.137	.197	.008	.019	.025
CNMG120416RP	CNMG434RP	-	5591957	12,90	.508	1,6	1/16	.055	.161	.197	.009	.019	.027
CNMG160612RP	CNMG543RP	5640986	5591919	16,12	.635	1,2	3/64	.047	.137	.275	.008	.019	.025
CNMG160616RP	CNMG544RP	-	5591960	16,12	.635	1,6	1/16	.055	.161	.315	.009	.019	.027
CNMG190612RP	CNMG643RP	-	5591931	19,34	.762	1,2	3/64	.047	.137	.354	.008	.019	.027
CNMG190616RP	CNMG644RP	-	5591955	19,34	.762	1,6	1/16	.055	.161	.354	.009	.023	.031
DNMG150408RP	DNMG432RP	-	5591976	15,50	.610	0,8	1/32	.039	.094	.197	.007	.017	.023
DNMG150608RP	DNMG442RP	-	5591932	15,50	.610	0,8	1/32	.039	.094	.197	.007	.017	.023
SNMG120412RP	SNMG433RP	-	5591982	12,70	.500	1,2	3/64	.047	.137	.236	.008	.019	.025
SNMG150616RP	SNMG544RP	5641107	5591953	15,88	.625	1,6	1/16	.055	.161	.275	.009	.023	.031
SNMG190612RP	SNMG643RP	-	5591935	19,05	.750	1,2	3/64	.047	.137	.354	.008	.023	.033
SNMG190616RP	SNMG644RP	-	5591936	19,05	.750	1,6	1/16	.055	.161	.354	.009	.025	.035
TNMG220408RP	TNMG432RP	-	5591962	22,00	.866	0,8	1/32	.039	.114	.295	.007	.017	.025
TNMG220412RP	TNMG433RP	-	5591964	22,00	.866	1,2	3/64	.047	.137	.295	.008	.019	.027
TNMG270612RP	TNMG543RP	-	5591967	27,50	1.083	1,2	3/64	.047	.137	.354	.008	.019	.027
WNMG080408RP	WNMG432RP	5641122	5591959	8,69	.342	0,8	1/32	.039	.114	.197	.007	.017	.023
WNMG080412RP	WNMG433RP	-	5591938	8,69	.342	1,2	3/64	.047	.137	.197	.008	.019	.025



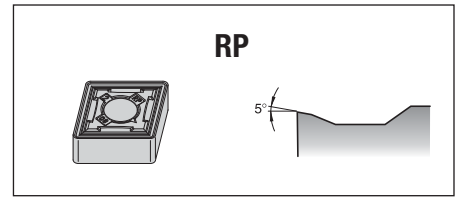
cutting conditions							
cutting speed (SFM) range	<b>K1</b>	920	1475	1970	790	1180	1800
	<b>K2</b>	755	1180	1800	490	885	1475
	<b>K3</b>	490	790	1640	460	705	1345
carbide grade		KCK05		KCK15			



ISO catalog number	ANSI catalog number	KCK05	KCK15	L10		Re		starting value depth of cut			starting value feed rate		
				mm	in	mm	in	ap min	(in)	ap max	f/rev min	(in/rev)	f/rev max
CNMG120408RP	CNMG432RP	3751862	3752176	12,90	.508	0,8	1/32	.039	.114	.177	.007	.017	.023
CNMG120412RP	CNMG433RP	3752114	3752050	12,90	.508	1,2	3/64	.047	.137	.197	.008	.019	.025
CNMG160612RP	CNMG543RP	-	3752052	16,12	.635	1,2	3/64	.047	.137	.275	.008	.019	.025
CNMG190612RP	CNMG643RP	-	3752053	19,34	.762	1,2	3/64	.047	.137	.354	.008	.019	.027
DNMG150612RP	DNMG443RP	-	3752057	15,50	.610	1,2	3/64	.047	.114	.197	.008	.019	.025
SNMG120412RP	SNMG433RP	-	3752061	12,70	.500	1,2	3/64	.047	.137	.236	.008	.019	.025
TNMG160408RP	TNMG332RP	3752122	-	16,50	.650	0,8	1/32	.039	.114	.236	.007	.017	.023
VNMG160408RP	VNMG332RP	-	3752067	16,61	.654	0,8	1/32	.039	.086	.137	.007	.015	.019
WNMG080408RP	WNMG432RP	3752124	-	8,69	.342	0,8	1/32	.039	.114	.197	.007	.017	.023
WNMG080412RP	WNMG433RP	3752125	3752070	8,69	.342	1,2	3/64	.047	.137	.197	.008	.019	.025



cutting conditions			
cutting speed (SFM) range	S1	50 180 460	30 130 200
	S2	50 200 460	30 100 250
	S3	50 230 460	50 130 250
	S4	50 230 560	50 180 345
carbide grade		KCU10	KCU25



ISO catalog number	ANSI catalog number	KCU10	KCU25	L10		R <sub>e</sub>		ap min	starting value depth of cut		f/rev min	starting value feed rate	
				mm	in	mm	in		ap max	(in)		ap max	(in/rev)
CNMG120404RP	CNMG431RP	4050682	4050453	12,90	.508	0,4	1/64	.023	.070	.137	.007	.011	.015
CNMG120408RP	CNMG432RP	4050689	4050057	12,90	.508	0,8	1/32	.039	.114	.177	.007	.017	.023
CNMG120412RP	CNMG433RP	4050695	4050456	12,90	.508	1,2	3/64	.047	.137	.197	.008	.019	.025
CNMG120416RP	CNMG434RP	4050699	4050459	12,90	.508	1,6	1/16	.055	.161	.197	.009	.019	.027
CNMG160608RP	CNMG542RP	4050701	4050461	16,12	.635	0,8	1/32	.039	.114	.275	.007	.017	.023
CNMG160612RP	CNMG543RP	4050704	4050463	16,12	.635	1,2	3/64	.047	.137	.275	.008	.019	.025
CNMG160616RP	CNMG544RP	-	4050465	16,12	.635	1,6	1/16	.055	.161	.315	.009	.019	.027
CNMG190612RP	CNMG643RP	4050712	4050468	19,34	.762	1,2	3/64	.047	.137	.354	.008	.019	.027
CNMG190616RP	CNMG644RP	4050714	4050470	19,34	.762	1,6	1/16	.055	.161	.354	.009	.023	.031
DNMG110408RP	DNMG332RP	4053374	4050478	11,63	.458	0,8	1/32	.039	.094	.157	.007	.015	.019
DNMG150408RP	DNMG432RP	4053387	4050482	15,50	.610	0,8	1/32	.039	.094	.197	.007	.017	.023
DNMG150412RP	DNMG433RP	4053391	4050485	15,50	.610	1,2	3/64	.047	.114	.197	.008	.019	.025
DNMG150416RP	DNMG434RP	4053393	-	15,50	.610	1,6	1/16	.055	.133	.197	.009	.019	.027
DNMG150608RP	DNMG442RP	4053403	4050488	15,50	.610	0,8	1/32	.039	.094	.197	.007	.017	.023
DNMG150612RP	DNMG443RP	4053407	4050490	15,50	.610	1,2	3/64	.047	.114	.197	.008	.019	.025
DNMG150616RP	DNMG444RP	-	4050491	15,50	.610	1,6	1/16	.055	.133	.197	.009	.019	.027
SNMG120408RP	SNMG432RP	5062108	4121684	12,70	.500	0,8	1/32	.039	.114	.236	.007	.017	.023
SNMG120412RP	SNMG433RP	5062111	4050518	12,70	.500	1,2	3/64	.047	.137	.236	.008	.019	.025
SNMG120416RP	SNMG434RP	5090763	-	12,70	.500	1,6	1/16	.055	.161	.236	.009	.019	.027
SNMG150612RP	SNMG543RP	5062113	4050519	15,88	.625	1,2	3/64	.047	.137	.275	.008	.021	.029
SNMG150616RP	SNMG544RP	-	4121688	15,88	.625	1,6	1/16	.055	.161	.275	.009	.023	.031
SNMG190612RP	SNMG643RP	5062117	4050520	19,05	.750	1,2	3/64	.047	.137	.354	.008	.023	.033
SNMG190616RP	SNMG644RP	5062120	4121690	19,05	.750	1,6	1/16	.055	.161	.354	.009	.025	.035
TNMG160408RP	TNMG332RP	5062137	4121698	16,50	.650	0,8	1/32	.039	.114	.236	.007	.017	.023
TNMG160412RP	TNMG333RP	-	4121699	16,50	.650	1,2	3/64	.047	.137	.236	.008	.019	.025
TNMG220408RP	TNMG432RP	5062142	4121702	22,00	.866	0,8	1/32	.039	.114	.295	.007	.017	.025
TNMG220412RP	TNMG433RP	5062145	4121704	22,00	.866	1,2	3/64	.047	.137	.295	.008	.019	.027
TNMG220416RP	TNMG434RP	-	4121705	22,00	.866	1,6	1/16	.055	.161	.295	.009	.021	.029
TNMG270612RP	TNMG543RP	5062147	-	27,50	1.083	1,2	3/64	.047	.137	.354	.008	.019	.027
TNMG270616RP	TNMG544RP	6353749	-	27,50	1.083	1,6	1/16	.055	.161	.354	.009	.021	.029
TNMG330924RP	TNMG666RP	5062148	-	33,00	1.299	2,4	3/32	.078	.228	.512	.011	.025	.035
VNMG160408RP	VNMG332RP	4045167	4121716	16,61	.654	0,8	1/32	.039	.086	.137	.007	.015	.019
VNMG160412RP	VNMG333RP	5090857	4121717	16,61	.654	1,2	3/64	.047	.106	.137	.008	.015	.019
WNMG060408RP	WNMG332RP	4045178	4121721	6,52	.257	0,8	1/32	.039	.114	.157	.007	.015	.019
WNMG080408RP	WNMG432RP	4045185	4121725	8,69	.342	0,8	1/32	.039	.114	.197	.007	.017	.023
WNMG080412RP	WNMG433RP	4045188	4121726	8,69	.342	1,2	3/64	.047	.137	.197	.008	.019	.025
WNMG080416RP	WNMG434RP	-	4121727	8,69	.342	1,6	1/16	.055	.161	.197	.009	.019	.027

