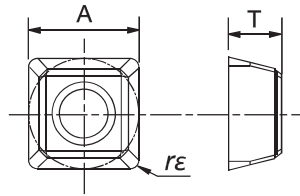


Inserts



Insert

Cat. No.	Accuracy	Honing	Stock			Dimensions (mm)			Cutter
			Coated grades		Carbide	A	T	r ϵ	
			AH725	AH140	TH10				
SDMT050204PN-MJ	M	with	●	●		.200	.094	.016	TPD05..., EPD05... ELD05...
SDHT050204FN-AJ	H	without			●	.200	.094	.016	

Standard cutting conditions

Shell, shank type

Work material	Brinell hardness HB	Grades	Cutting Speed Vc (sfm)	Feed per tooth fz (ipt)
Low carbon steels 1015 etc.	~ 200	AH725	750 - 1050	.0015 - .004
High carbon steels 1045 etc.	200 ~ 300		500 - 750	
Alloyed steels 4140 etc.	150 ~ 300		350 - 440	
Tool steels W1-8 etc.	~ 300			
Stainless steels 304 etc.	-	AH140	330 - 650	.001 - .0035
Gray cast irons No35B etc.	150 ~ 250	AH725	500 - 820	.002 - .005
Ductile cast irons 60-40-18 etc.			330 - 590	.002 - .005
Aluminum alloys (Si < 13%)	-	TH10	1150 - 1600	.002 - .006
Aluminum alloys (Si ≥ 13%)	-		330 - 650	

* For deep and wide cutting, set the Vc and fz to the lower recommended limits and check the vibration and spindle load of the machine.

Roughing type

Work material	Brinell hardness HB	Grades	Cutting Speed Vc (sfm)	Feed per tooth fz (ipt)
Low carbon steels 1015 etc.	~ 200	AH725	330 - 820	.0015 - .004
High carbon steels 1045 etc.	200 ~ 300		330 - 660	
Alloyed steels 4140 etc.	150 ~ 300		330 - 400	
Tool steels W1-8 etc.	~ 300			
Stainless steels 304 etc.	-	AH140	300 - 500	.0012 - .0035
Gray cast irons No35B etc.	150 ~ 250	AH725	330 - 820	.002 - .005
Ductile cast irons 60-40-18 etc.			260 - 660	.002 - .005
Aluminum alloys (Si < 13%)	-	TH10	660 - 1650	.002 - .006
Aluminum alloys (Si ≥ 13%)	-		330 - 650	