

Swiss.Blue



MILLING

TURNING

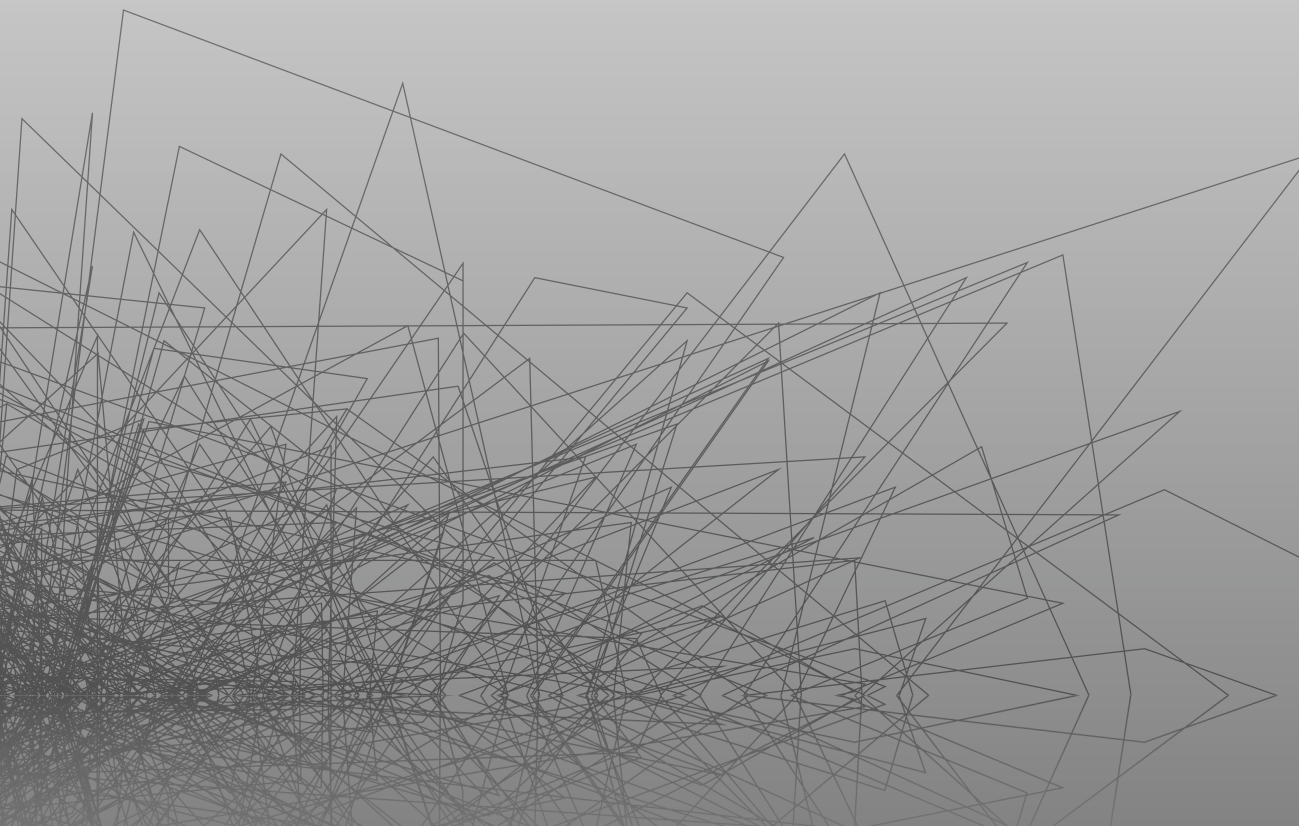
DRILLING

PARTING

THREADING

INFO

2020 CATALOG





MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

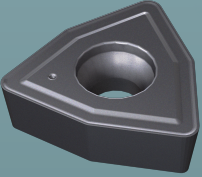
MILLING

A 3D illustration of a square-shaped metal part with a central circular hole, representing a milled component.

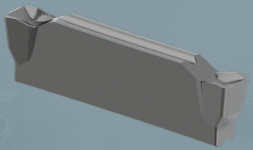
TURNING

A 3D illustration of a triangular metal part with a central circular hole, representing a turned component.

DRILLING

A 3D illustration of a square-shaped metal part with a central circular hole, representing a drilled component.

PARTING

A 3D illustration of a rectangular metal part with a central circular hole, representing a parted component.

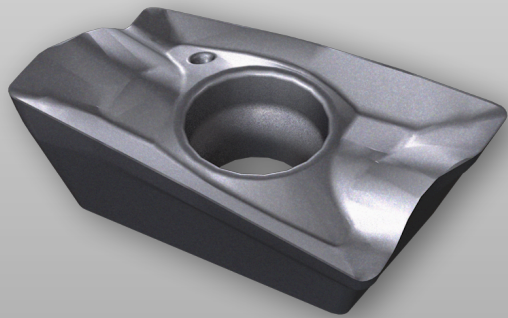
THREADING

A 3D illustration of a triangular metal part with a central circular hole and a threaded section, representing a threaded component.

INFORMATION

An information icon consisting of a lowercase 'i' inside a circle.

MILLING



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

01



MILLING

TURNING

DRILLING

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THREADING

INFO

MILLING

AOMT

OFMT

SEKT

APKT

RDMT

SPKN

APMT

RPMT

TPKN

JDMT

SDMT

AOMT

ITEMS

2100000108 **AOMT 123608 PDTR PM UN330**

INFORMATION

2100000108 **Stock Item** **Modern**

AOMT 123608 PDTR CUTTING CONDITIONS

D.O.C. 0.8 Fz 0.15 Vc 210	D.O.C. 0.75 Fz 0.15 Vc 170	D.O.C. 0.8 Fz 0.15 Vc 250	
D.O.C. 2.0 Fz 0.12 Vc 150	D.O.C. 1.5 Fz 0.1 Vc 100	D.O.C. 2.0 Fz 0.15 Vc 180	
D.O.C. 3.0 Fz 0.10 Vc 90	D.O.C. 2.3 Fz 0.08 Vc 80	D.O.C. 3.0 Fz 0.12 Vc 140	

CUTTERS

10	12	16	20	25	32	
						
40	50	63	82	100	120	
						



MILLING

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DRILLING

PARTING

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INFO

APKT




ITEMS

2100000100	APKT 1003 PDTR PM UN330
2100000102	APKT 1604 PDTR PM UN330

INFORMATION

2100000100	Stock Item	Modern
2100000102	Stock Item	Modern

APKT 1003 PDTR CUTTING CONDITIONS

D.O.C. 0.8 Fz 0.16 Vc 210	D.O.C. 0.75 Fz 0.14 Vc 160	D.O.C. 0.8 Fz 0.20 Vc 250	
D.O.C. 2.0 Fz 0.13 Vc 150	D.O.C. 1.5 Fz 0.12 Vc 100	D.O.C. 2.0 Fz 0.17 Vc 180	
D.O.C. 3.0 Fz 0.10 Vc 90	D.O.C. 2.3 Fz 0.10 Vc 80	D.O.C. 3.0 Fz 0.14 Vc 140	

CUTTERS

10	12	16	20	25	32	
						
40	50	63	82	100	120	
						



MILLING

TURNING

DRILLING




PARTING

THREADING

INFO

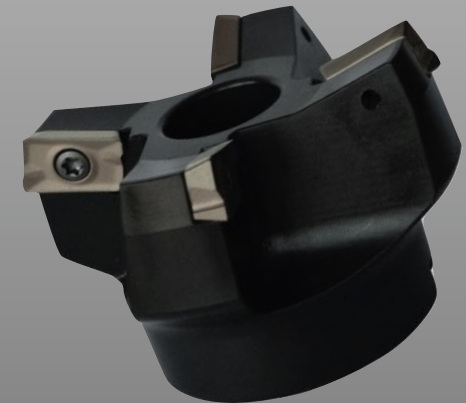
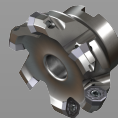
APKT 1604 PDTR

CUTTING CONDITIONS

D.O.C.	1.6	D.O.C.	1.5	D.O.C.	0.8	
Fz	0.23	Fz	0.21	Fz	0.15	
Vc	240	Vc	200	Vc	250	
D.O.C.	4.0	D.O.C.	3.0	D.O.C.	2.0	
Fz	0.18	Fz	0.16	Fz	0.17	
Vc	150	Vc	110	Vc	180	
D.O.C.	4.8	D.O.C.	4.8	D.O.C.	3.0	
Fz	0.14	Fz	0.13	Fz	0.14	
Vc	90	Vc	90	Vc	140	

CUTTERS

10	12	16	20	25	32
					
40	50	63	82	100	120
					



MILLING

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INFO

APMT

ITEMS

2100000104	APMT 1135 PDTR PM UN330
2100000106	APMT 1604 PDTR PM UN330

INFORMATION

2100000104	Stock Item	Utility
2100000106	Stock Item	Utility

APMT 1135 PDTR CUTTING CONDITIONS

D.O.C. 0.8 Fz 0.14 Vc 210	D.O.C 0.75 Fz 0.14 Vc 160	D.O.C. 0.8 Fz 0.18 Vc 250	
D.O.C. 2.0 Fz 0.12 Vc 150	D.O.C 1.5 Fz 0.12 Vc 100	D.O.C. 2.0 Fz 0.15 Vc 180	
D.O.C. 3.0 Fz 0.10 Vc 90	D.O.C 2.3 Fz 0.10 Vc 80	D.O.C. 3.0 Fz 0.12 Vc 140	

CUTTERS

10	12	16	20	25	32	
						
40	50	63	82	100	120	
						



MILLING

TURNING

DRILLING



PARTING

THREADING

INFO

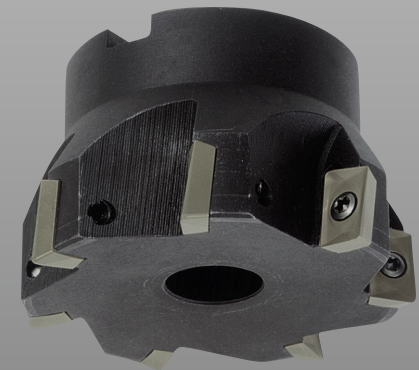
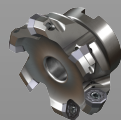
APMT 1604 PDTR

CUTTING CONDITIONS

D.O.C. 1.6 Fz 0.21 Vc 240	D.O.C. 1.5 Fz 0.18 Vc 200	D.O.C. 1.2 Fz 0.15 Vc 250	
D.O.C. 4.0 Fz 0.16 Vc 150	D.O.C. 3.0 Fz 0.14 Vc 110	D.O.C. 3.0 Fz 0.17 Vc 180	
D.O.C. 3.2 Fz 0.13 Vc 90	D.O.C. 4.8 Fz 0.11 Vc 90	D.O.C. 4.5 Fz 0.14 Vc 140	

CUTTERS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
40	50	63	82	100	120
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		



MILLING

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INFO

JDMT

ITEMS

2100000136	JDMT 09T320	UN330
2100000138	JDMW 09T320	UN330

INFORMATION

2100000136	Stock Item	High-Feed
2100000138	Stock Item	High-Feed

JDMT 09T320 CUTTING CONDITIONS

D.O.C 0.8 Fz 0.15 Vc 210	D.O.C 0.75 Fz 0.15 Vc 170	D.O.C. 0.8 Fz 0.15 Vc 250	
D.O.C 2.0 Fz 0.12 Vc 150	D.O.C 1.5 Fz 0.1 Vc 100	D.O.C. 2.0 Fz 0.15 Vc 180	
D.O.C 3.0 Fz 0.10 Vc 90	D.O.C 2.3 Fz 0.08 Vc 80	D.O.C. 3.0 Fz 0.12 Vc 140	

CUTTERS

10	12	16	20	25	32	
					<input type="checkbox"/>	
40	50	63	82	100	120	
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>			



MILLING

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INFO

JDMW 09T320

CUTTING CONDITIONS

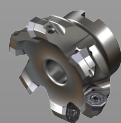
D.O.C. 1.6 Fz 0.23 Vc 240	D.O.C. 1.5 Fz 0.21 Vc 200	D.O.C. 0.8 Fz 0.15 Vc 250	
D.O.C. 4.0 Fz 0.18 Vc 150	D.O.C. 3.0 Fz 0.16 Vc 110	D.O.C. 2.0 Fz 0.17 Vc 180	
D.O.C. 4.8 Fz 0.14 Vc 90	D.O.C. 4.8 Fz 0.13 Vc 90	D.O.C. 3.0 Fz 0.14 Vc 140	

CUTTERS

10	12	16	20	25	32



40	50	63	82	100	120



OFMT




ITEMS

2100000130 **OFMT 05T305 TN** UN330

INFORMATION

2100000130 **Stock Item** **Modern**

OFMT 05T305 TN CUTTING CONDITIONS

D.O.C. 1.3 Fz 0.38 Vc 240	D.O.C. 1.2 Fz 0.34 Vc 200	D.O.C. 1.5 Fz 0.15 Vc 210	
D.O.C. 2.5 Fz 0.29 Vc 150	D.O.C. 2.0 Fz 0.26 Vc 100	D.O.C. 2.5 Fz 0.37 Vc 180	
D.O.C. 2.8 Fz 0.26 Vc 105	D.O.C. 3.2 Fz 0.21 Vc 90	D.O.C. 3.8 Fz 0.30 Vc 140	

CUTTERS

10	12	16	20	25	32	
40	50	63	82	100	120	



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INFO

RDMT




ITEMS

2100000114	RDMT 10T3 MO	UN330
2100000116	RDMT 1204 MO	UN330

INFORMATION

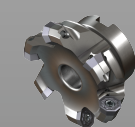
2100000114	Stock Item	Utility
2100000116	Stock Item	Utility

RDMT 10T3 MO CUTTING CONDITIONS

D.O.C. 0.8 Fz 0.35 Vc 240	D.O.C. 0.56 Fz 0.31 Vc 200	D.O.C. 0.6 Fz 0.41 Vc 190	
D.O.C. 1.0 Fz 0.27 Vc 150	D.O.C. 0.8 Fz 0.24 Vc 100	D.O.C. 1.0 Fz 0.34 Vc 160	
D.O.C. 1.2 Fz 0.24 Vc 105	D.O.C. 1.3 Fz 0.19 Vc 90	D.O.C. 1.5 Fz 0.31 Vc 140	

CUTTERS

10	12	16	20	25	32
					
40	50	63	82	100	120
					



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INFO

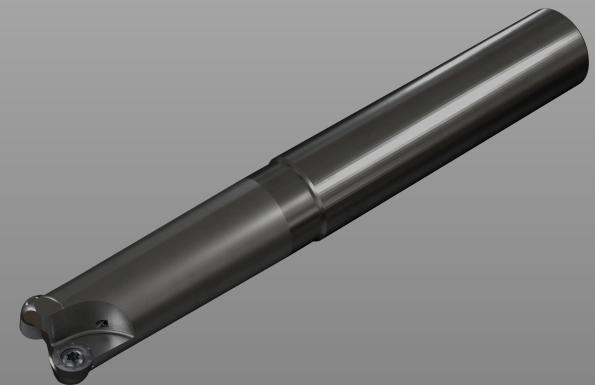
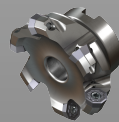
RDMT 1204 MO

CUTTING CONDITIONS

D.O.C. 1.0 Fz 0.36 Vc 240	D.O.C. 0.7 Fz 0.31 Vc 200	D.O.C. 0.6 Fz 0.39 Vc 190	
D.O.C. 1.3 Fz 0.3 Vc 150	D.O.C. 1.0 Fz 0.24 Vc 100	D.O.C. 1.0 Fz 0.35 Vc 160	
D.O.C. 1.6 Fz 0.27 Vc 120	D.O.C. 1.6 Fz 0.20 Vc 90	D.O.C. 1.5 Fz 0.32 Vc 140	

CUTTERS

10	12	16	20	25	32
					
40	50	63	82	100	120
					



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INFO

RPMT

ITEMS

2100000118	RPMT 10T3 MO	UN330
2100000120	RPMT 1204 MO	UN330

INFORMATION

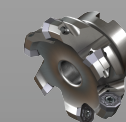
2100000118	Stock Item	Utility
2100000120	Stock Item	Utility

RPMT 10T3 MO CUTTING CONDITIONS

D.O.C. 0.8 Fz 0.35 Vc 240	D.O.C 0.56 Fz 0.31 Vc 200	D.O.C. 0.6 Fz 0.41 Vc 190	
D.O.C. 1.0 Fz 0.27 Vc 150	D.O.C 0.8 Fz 0.24 Vc 100	D.O.C. 1.0 Fz 0.34 Vc 160	
D.O.C. 1.2 Fz 0.24 Vc 105	D.O.C 1.3 Fz 0.19 Vc 90	D.O.C. 1.5 Fz 0.31 Vc 140	


CUTTERS

10	12	16	20	25	32
					
40	50	63	82	100	120
					



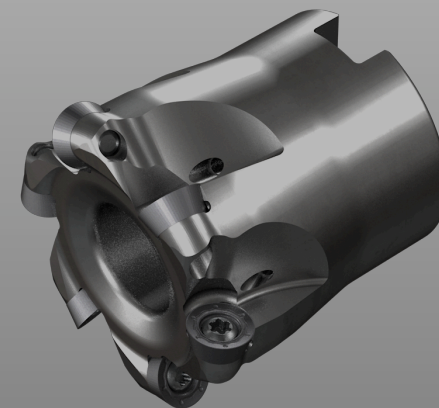
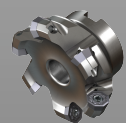
RPMT 1204 MO

CUTTING CONDITIONS

D.O.C. 1.0 Fz 0.36 Vc 240	D.O.C 0.7 Fz 0.31 Vc 200	D.O.C. 0.6 Fz 0.39 Vc 190	
D.O.C. 1.3 Fz 0.3 Vc 150	D.O.C 1.0 Fz 0.24 Vc 100	D.O.C. 1.0 Fz 0.35 Vc 160	
D.O.C. 1.6 Fz 0.27 Vc 120	D.O.C 1.6 Fz 0.20 Vc 90	D.O.C. 1.5 Fz 0.32 Vc 140	

CUTTERS

10	12	16	20	25	32
					
40	50	63	82	100	120
					



MILLING

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INFO

SDMT

ITEMS



2100000132	SDMT 09T312 PR	UN330
2100000134	SDMT 1205 PR	UN330

INFORMATION

2100000132	Stock Item	High-Feed
2100000134	Stock Item	High-Feed

SDMT 09T312

CUTTING CONDITIONS

<p>D.O.C. 0.6 Fz 1.22 Vc 240</p>	<p>D.O.C 0.5 Fz 0.45 Vc 200</p>	<p>D.O.C. 0.72 Fz 1.20 Vc 190</p>	
<p>D.O.C. 0.8 Fz 0.9 Vc 150</p>	<p>D.O.C 0.7 Fz 0.3 Vc 100</p>	<p>D.O.C. 1.2 Fz 1 Vc 160</p>	
<p>D.O.C. 1.0 Fz 0.72 Vc 105</p>	<p>D.O.C 1.0 Fz 0.24 Vc 90</p>	<p>D.O.C. 1.4 Fz 0.90 Vc 140</p>	

CUTTERS

10	12	16	20	25	32	
					<input type="checkbox"/>	
40	50	63	82	100	120	
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>			



MILLING

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INFO

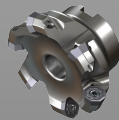
SDMT 1205

CUTTING CONDITIONS

D.O.C. 0.7 Fz 1.8 Vc 240	D.O.C. 0.6 Fz 0.75 Vc 210	D.O.C. 0.9 Fz 2.04 Vc 190	
D.O.C. 0.9 Fz 1.4 Vc 150	D.O.C. 0.8 Fz 0.5 Vc 100	D.O.C. 1.5 Fz 1.7 Vc 160	
D.O.C. 1.1 Fz 1.1 Vc 105	D.O.C. 1.1 Fz 0.43 Vc 90	D.O.C. 1.8 Fz 1.53 Vc 140	

CUTTERS

10	12	16	20	25	32
					
40	50	63	82	100	120
					



MILLING

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INFO

SEKT




ITEMS

2100000126	SEKT 1204 AFTN PM	UN330
2100000128	SEKT 12T3 AGSN PM	UN330

INFORMATION

2100000126	Stock Item	Utility
2100000128	Stock Item	Utility

SEKT 1204 AFTN CUTTING CONDITIONS

D.O.C. 1.5 Fz 0.35 Vc 240	D.O.C. 1.38 Fz 0.31 Vc 200	D.O.C. 1.5 Fz 0.15 Vc 210	
D.O.C. 3.0 Fz 0.27 Vc 150	D.O.C. 2.3 Fz 0.24 Vc 100	D.O.C. 2.5 Fz 0.37 Vc 180	
D.O.C. 3.9 Fz 0.24 Vc 90	D.O.C. 3.7 Fz 0.19 Vc 90	D.O.C. 3.8 Fz 0.30 Vc 140	

CUTTERS

10	12	16	20	25	32	
					<input type="checkbox"/>	
40	50	63	82	100	120	
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>			



MILLING

TURNING

DRILLING

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INFO

SEKT 12T3 AGSN





CUTTING CONDITIONS

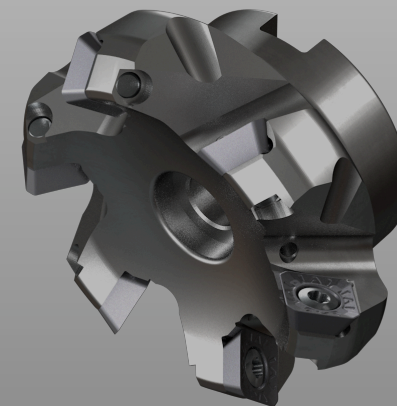
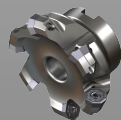
D.O.C. 1.5 Fz 0.35 Vc 240	D.O.C. 1.38 Fz 0.31 Vc 200	D.O.C. 1.5 Fz 0.15 Vc 210	
D.O.C. 3.0 Fz 0.27 Vc 150	D.O.C. 2.3 Fz 0.24 Vc 100	D.O.C. 2.5 Fz 0.37 Vc 180	
D.O.C. 3.9 Fz 0.24 Vc 90	D.O.C. 3.7 Fz 0.19 Vc 90	D.O.C. 3.8 Fz 0.30 Vc 140	

CUTTERS

10	12	16	20	25	32
					



40	50	63	82	100	120
					



MILLING

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INFO

SPKN




ITEMS

2100000122	SPKN 1203 PDTR	UN330
2100000124	SPKR 1203 PDTR	UN330

INFORMATION

2100000122	Stock Item	ISO
2100000124	Stock Item	ISO

SPKN 1203 PDTR CUTTING CONDITIONS

D.O.C. 1.2 Fz 0.30 Vc 220	D.O.C Fz Vc	D.O.C. 1.2 Fz 0.36 Vc 190	
D.O.C. 3.0 Fz 0.23 Vc 150	D.O.C Fz Vc	D.O.C. 3.0 Fz 0.3 Vc 160	
D.O.C. 4.5 Fz 0.18 Vc 90	D.O.C Fz Vc	D.O.C. 4.5 Fz 0.24 Vc 120	

CUTTERS

10	12	16	20	25	32	
40	50	63	82	100	120	
						



MILLING

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INFO

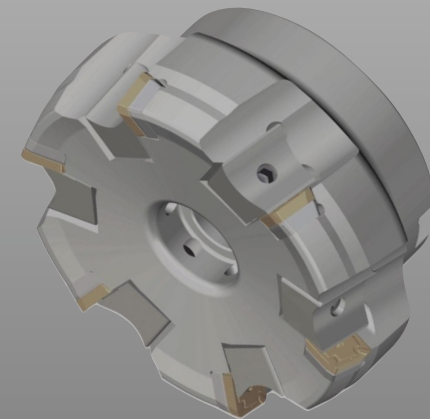
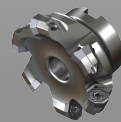
SPKR 1203 PDTR

CUTTING CONDITIONS

D.O.C. 1.2 Fz 0.28 Vc 220	D.O.C. 1.8 Fz 0.22 Vc 260	D.O.C. 1.2 Fz 0.28 Vc 200	
D.O.C. 3.0 Fz 0.23 Vc 150	D.O.C. 3.0 Fz 0.18 Vc 130	D.O.C. 3.0 Fz 0.23 Vc 170	
D.O.C. 4.5 Fz 0.21 Vc 90	D.O.C. 3.9 Fz 0.14 Vc 110	D.O.C. 4.5 Fz 0.18 Vc 130	

CUTTERS

10	12	16	20	25	32
40	50	63	82	100	120
					



MILLING

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INFO

TPKN

ITEMS

2100000110	TPKN 1603 PDTR	UN330
2100000112	TPKR 1603 PDTR	UN330

INFORMATION

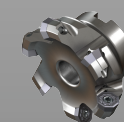
2100000110	Stock Item	ISO
2100000112	Stock Item	ISO

TPKN 1603 PDTR CUTTING CONDITIONS

D.O.C 1.2 Fz 0.20 Vc 220	D.O.C Fz Vc	D.O.C. 1.2 Fz 0.20 Vc 210	
D.O.C 3.0 Fz 0.15 Vc 150	D.O.C Fz Vc	D.O.C. 3.0 Fz 0.17 Vc 180	
D.O.C 4.5 Fz 0.12 Vc 90	D.O.C Fz Vc	D.O.C. 4.5 Fz 0.14 Vc 140	

CUTTERS

10	12	16	20	25	32
40	50	63	82	100	120
					



MILLING

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INFO

TPKR 1603 PDTR





CUTTING CONDITIONS

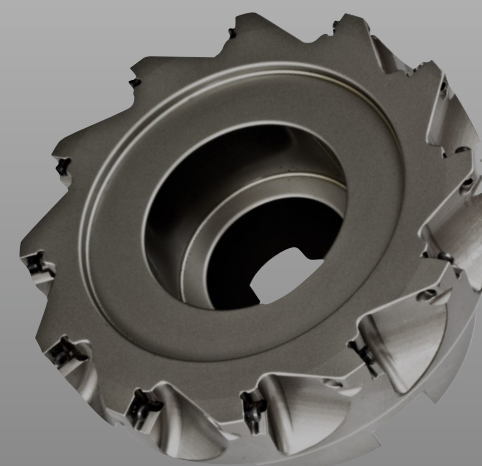
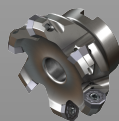
D.O.C. 1.2 Fz 0.19 Vc 220	D.O.C. 1.8 Fz 0.19 Vc 250	D.O.C. 1.2 Fz 0.22 Vc 210	
D.O.C. 3.0 Fz 0.16 Vc 150	D.O.C. 3.0 Fz 0.16 Vc 170	D.O.C. 3.0 Fz 0.18 Vc 180	
D.O.C. 4.5 Fz 0.14 Vc 90	D.O.C. 3.9 Fz 0.13 Vc 110	D.O.C. 4.5 Fz 0.14 Vc 140	

CUTTERS

10	12	16	20	25	32



40	50	63	82	100	120
					



MILLING

TURNING

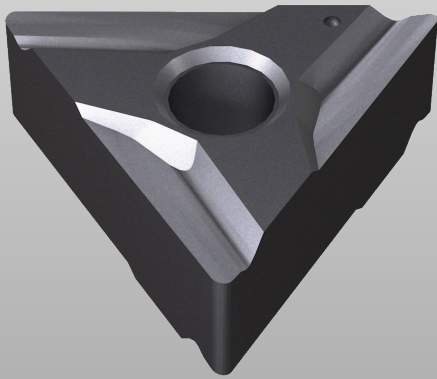
DRILLING

PARTING

THREADING

INFO

TURNING



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

02



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

TURNING

CNMG

CCMT

CNMA

DNMG

DCMT

TNMA

TNMG

KNUX

WNMA

VNMG

TCMT

WNMG

VBMT

CNMG

5100000002	CNMG 120404	PF	UN 7010
5100000004	CNMG 120404	PF	UN 6020
5100000006	CNMG 120408	PF	UN 7010
5100000008	CNMG 120408	PF	UN 6020
5100000010	CNMG 120408	PM	UN 7010
5100000012	CNMG 120408	PM	UN 6020
5100000014	CNMG 120408	PM	UN 5030
5100000016	CNMG 120408	PR	UN 7010
5100000018	CNMG 120408	PR	UN 6020
5100000020	CNMG 120408	PR	UN 5030
5100000158	CNMG 120408		UN 7010
5100000160	CNMG 120408		UN 6020
5100000162	CNMG 120408		UN 5030
5100000022	CNMG 120412	PM	UN 7010
5100000024	CNMG 120412	PM	UN 6020
5100000026	CNMG 120412	PM	UN 5030
5100000028	CNMG 120412	PR	UN 7010
5100000030	CNMG 120412	PR	UN 6020
5100000032	CNMG 120412	PR	UN 5030

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.2 D.O.C. 2.00	Fz 0.2 D.O.C. 1.00	Fz 0.25 D.O.C. 3.00	PF
Fz 0.3 D.O.C. 3.00	Fz 0.3 D.O.C. 3.00	Fz 0.35 D.O.C. 3.50	PM
Fz 0.5 D.O.C. 4.50	Fz 0.35 D.O.C. 3.50	Fz D.O.C.	PR

Cutting Speed (Range)

Vc Min 150 Vc Max 280	Vc Min 140 Vc Max 220	Vc Min 140 Vc Max 350	UN 7010
Vc Min 140 Vc Max 250	Vc Min 110 Vc Max 180	Vc Min 130 Vc Max 300	UN 6020
Vc Min 90 Vc Max 180	Vc Min Vc Max	Vc Min Vc Max	UN 5030



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

CNMG

TOOL HOLDERS

10	12	16	20	25	32
			<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>



MILLING

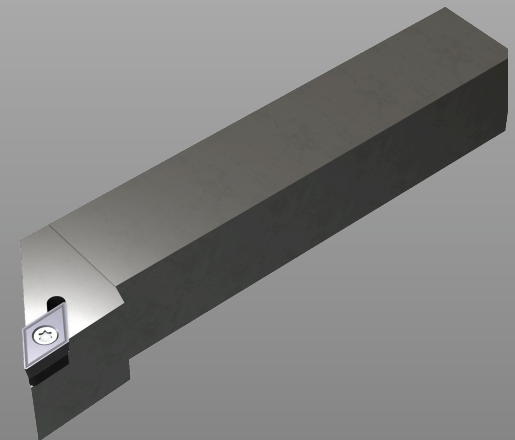
TURNING

DRILLING

PARTING

THREADING

INFO



DNMG

ITEMS

5100000034	DNMG 110404	PF	UN 7010
5100000036	DNMG 110404	PM	UN 6020
5100000038	DNMG 150408	PF	UN 7010
5100000040	DNMG 150408	PM	UN 6020

TOOL HOLDERS

10	12	16	20	25	32

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.2 D.O.C. 2.00	Fz 0.2 D.O.C. 0.80	Fz 0.25 D.O.C. 2.00	PF
Fz 0.3 D.O.C. 3.00	Fz 0.25 D.O.C. 2.50	Fz 0.35 D.O.C. 3.00	PM
			PR

Cutting Speed (Range)

Vc Min 130 Vc Max 230	Vc Min 120 Vc Max 180	Vc Min 120 Vc Max 290	UN 7010
Vc Min 120 Vc Max 210	Vc Min 95 Vc Max 150	Vc Min 110 Vc Max 250	UN 6020
			UN 5030



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

TNMG

ITEMS

5100000042	TNMG 160404	PF	UN 6020
5100000044	TNMG 160408	PF	UN 6020
5100000046	TNMG 160408	PM	UN 6020
5100000164	TNMG 160408		UN 6020
5100000048	TNMG 160408	PR	UN 6020
5100000050	TNMG 160412	PM	UN 6020
5100000166	TNMG 160412		UN 6020
5100000052	TNMX 160404	R	UN 110
5100000054	TNMX 160408	R	UN 110

TOOL HOLDERS

10	12	16	20	25	32
					

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.2 D.O.C. 2.00	Fz 0.2 D.O.C. 0.80	Fz 0.25 D.O.C. 2.00	PF & R
Fz 0.3 D.O.C. 3.00	Fz 0.25 D.O.C. 2.50	Fz 0.35 D.O.C. 3.00	PM
Fz 0.5 D.O.C. 4.50	Fz 0.4 D.O.C. 3.50	Fz 0.4 D.O.C. 3.50	PR

Cutting Speed (Range)

Vc Min 130 Vc Max 230	Vc Min 120 Vc Max 180	Vc Min 120 Vc Max 290	UN 7010
Vc Min 120 Vc Max 210	Vc Min 95 Vc Max 150	Vc Min 110 Vc Max 250	UN 6020
Vc Min 80 Vc Max 150	Vc Min Vc Max	Vc Min Vc Max	UN 5030



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

VNMG

ITEMS

5100000056	VNMG 160404	PF	UN 6020
5100000058	VNMG 160408	PM	UN 6020

TOOL HOLDERS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.15 D.O.C. 1.20	Fz 0.15 D.O.C. 1.20	Fz 0.2 D.O.C. 1.70	PF
Fz 0.25 D.O.C. 2.00	Fz 0.3 D.O.C. 2.00	Fz 0.3 D.O.C. 2.50	PM
			PR

Cutting Speed (Range)

			UN 7010
Vc Min 110 Vc Max 190	Vc Min 85 Vc Max 135	Vc Min 100 Vc Max 225	UN 6020
			UN 5030



MILLING

TURNING

DRILLING

PARTING

THREADING

INDEXING

WNMG

5100000060	WNMG 060408	PM	UN 7010
5100000062	WNMG 060408	PM	UN 6020
5100000064	WNMG 080404	PF	UN 7010
5100000066	WNMG 080404	PF	UN 6020
5100000068	WNMG 080408	PF	UN 7010
5100000070	WNMG 080408	PF	UN 6020
5100000072	WNMG 080408	PM	UN 7010
5100000074	WNMG 080408	PM	UN 6020
5100000076	WNMG 080408	PM	UN 5030
5100000168	WNMG 080408		UN 7010
5100000170	WNMG 080408		UN 6020
5100000172	WNMG 080408		UN 5030
5100000078	WNMG 080408	PR	UN 7010
5100000080	WNMG 080408	PR	UN 6020
5100000082	WNMG 080408	PR	UN 5030
5100000084	WNMG 080412	PR	UN 7010
5100000086	WNMG 080412	PR	UN 6020
5100000088	WNMG 080412	PR	UN 5030

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.2 D.O.C. 2.00	Fz 0.2 D.O.C. 1.00	Fz 0.25 D.O.C. 3.00	PF	
Fz 0.3 D.O.C. 3.00	Fz 0.3 D.O.C. 3.00	Fz 0.35 D.O.C. 3.50		PM
Fz 0.5 D.O.C. 4.50	Fz 0.35 D.O.C. 3.50	Fz D.O.C.		PR

Cutting Speed (Range)

Vc Min 150 Vc Max 280	Vc Min 140 Vc Max 220	Vc Min 140 Vc Max 350	UN 7010
Vc Min 140 Vc Max 250	Vc Min 110 Vc Max 180	Vc Min 130 Vc Max 300	UN 6020
Vc Min 90 Vc Max 180	Vc Min Vc Max	Vc Min Vc Max	UN 5030



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

WNUMG

TOOL HOLDERS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

CCMT

ITEMS

5100000106	CCMT 060204	PM	UN 110
5100000108	CCMT 060204	PM	UN 6020
5100000110	CCMT 09T304	PM	UN 110
5100000112	CCMT 09T304	PM	UN 6020
5100000114	CCMT 09T308	PM	UN 110
5100000116	CCMT 09T308	PM	UN 6020
5100000118	CCMT 120408	PM	UN 110
5100000120	CCMT 120408	PM	UN 6020

BORING BARS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.2	Fz 0.18	Fz 0.22	PM
D.O.C. 2.50	D.O.C. 2.50	D.O.C. 2.50	

Cutting Speed (Range)

Vc Min 110	Vc Min 80	Vc Min 100	UN 110
Vc Max 160	Vc Max 130	Vc Max 160	
Vc Min 120	Vc Min 95	Vc Min 110	UN 6020
Vc Max 210	Vc Max 150	Vc Max 220	



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

DCMT

ITEMS

5100000122	DCMT 070204	PM	UN 110
5100000124	DCMT 070204	PM	UN 6020
5100000126	DCMT 11T304	PM	UN 110
5100000128	DCMT 11T304	PM	UN 6020
5100000130	DCMT 11T308	PM	UN 110
5100000132	DCMT 11T308	PM	UN 6020

BORING BARS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.2 D.O.C. 2.50	Fz 0.18 D.O.C. 2.50	Fz 0.22 D.O.C. 2.50	PM
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Cutting Speed (Range)

Vc Min 110 Vc Max 160	Vc Min 80 Vc Max 130	Vc Min 100 Vc Max 160	UN 110
Vc Min 120 Vc Max 210	Vc Min 95 Vc Max 150	Vc Min 110 Vc Max 220	UN 6020



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

KNUX

ITEMS

5100000134	KNUX 160405	L11	UN 110
5100000136	KNUX 160405	R11	UN 110

TOOL HOLDERS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.13 D.O.C. 3.00	Fz 0.08 D.O.C. 2.50	Fz 0.18 D.O.C. 3.00	R11 L11
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Cutting Speed (Range)

Vc Min 110 Vc Max 160	Vc Min 80 Vc Max 130	Vc Min 100 Vc Max 160	UN 110 UN 6020
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MILLING

TURNING

DRILLING

PARTING

THREADING

INF

TCMT

ITEMS

5100000138	TCMT 110204	PM	UN 110
5100000140	TCMT 110204	PM	UN 6020
5100000142	TCMT 16T304	PM	UN 110
5100000144	TCMT 16T304	PM	UN 6020
5100000146	TCMT 16T308	PM	UN 110
5100000148	TCMT 16T308	PM	UN 6020

BORING BARS

10	12	16	20	25	32
			■	■	■

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.2 D.O.C. 2.50	Fz 0.18 D.O.C. 2.50	Fz 0.22 D.O.C. 2.50	PM
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Cutting Speed (Range)

Vc Min 110 Vc Max 160	Vc Min 80 Vc Max 130	Vc Min 100 Vc Max 160	UN 110
Vc Min 120 Vc Max 210	Vc Min 95 Vc Max 150	Vc Min 110 Vc Max 220	UN 6020



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

VBMT

ITEMS

5100000150	VBMT 160404	PM	UN 110
5100000152	VBMT 160404	PM	UN 6020
5100000154	VBMT 160408	PM	UN 110
5100000156	VBMT 160408	PM	UN 6020

BORING BARS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.18 D.O.C. 2.50	Fz 0.2 D.O.C. 2.50	Fz 0.22 D.O.C. 2.50	PM
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Cutting Speed (Range)

Vc Min 110 Vc Max 160	Vc Min 80 Vc Max 130	Vc Min 100 Vc Max 160	UN 110
Vc Min 120 Vc Max 210	Vc Min 95 Vc Max 150	Vc Min 110 Vc Max 220	UN 6020



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

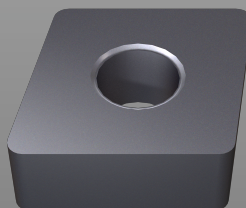
CNMA

ITEMS

5100000090	CNMA 120408		UN 7010
5100000092	CNMA 120412		UN 7010
5100000158	CNMG 120408	(STD)	UN 7010
5100000096	CNMG120412	(STD)	UN 7010

TOOL HOLDERS

10	12	16	20	25	32
			<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>



CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz D.O.C.	Fz D.O.C.	Fz 0.35 D.O.C. 3.50	STD
Fz D.O.C.	Fz D.O.C.	Fz 0.4 D.O.C. 3.50	(A)

Cutting Speed (Range)

Vc Min Vc Max	Vc Min Vc Max	Vc Min 140 Vc Max 350	UN 7010
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MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

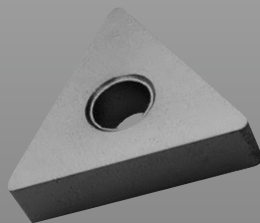
TNMA

ITEMS

5100000098	TNMA 160408		UN 7010
5100000100	TNMA 160412		UN 7010
5100000174	TNMG 160408	(STD)	UN 7010
5100000176	TNMG 160412	(STD)	UN 7010

TOOL HOLDERS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>



CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz D.O.C.	Fz D.O.C.	Fz 0.25 D.O.C. 2.50	STD
Fz D.O.C.	Fz D.O.C.	Fz 0.4 D.O.C. 3.00	(A)

Cutting Speed (Range)

Vc Min Vc Max	Vc Min Vc Max	Vc Min 120 Vc Max 310	UN 7010
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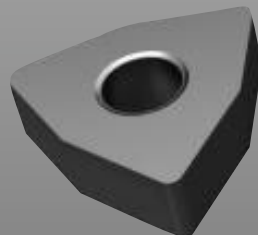
WNMA

ITEMS

5100000102	WNMA 080408		UN 7010
5100000104	WNMA 080412		UN 7010
5100000168	WNMG 080408	(STD)	UN 7010
5100000180	WNMG 080412	(STD)	UN 7010

TOOL HOLDERS

10	12	16	20	25	32
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>



CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz D.O.C.	Fz D.O.C.	Fz 0.35 D.O.C. 3.50	STD
Fz D.O.C.	Fz D.O.C.	Fz 0.4 D.O.C. 3.50	(A)

Cutting Speed (Range)

Vc Min Vc Max	Vc Min Vc Max	Vc Min 140 Vc Max 350	UN 7010
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MILLING

TURNING

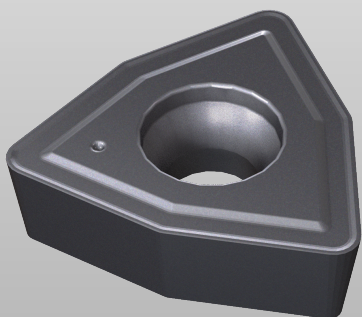
DRILLING

PARTING

THREADING

INFO

DRILLING



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

03



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

DRILLING

SPMG




WCMX

SPMG

ITEMS

3100000012	SPMG 050204	PM	UN 330
3100000014	SPMG 060204	PM	UN 330
3100000016	SPMG 07T308	PM	UN 330
3100000018	SPMG 090408	PM	UN 330
3100000020	SPMG 110408	PM	UN 330
3100000022	SPMG 140512	PM	UN 330

DRILLING BODIES

1D	2D	3D	4D	5D	7D
					

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.05 Vc 135	Fz 0.06 Vc 165	Fz 0.08 Vc 180	SPMG 05
Fz 0.06 Vc 135	Fz 0.07 Vc 165	Fz 0.09 Vc 180	SPMG 06
Fz 0.07 Vc 135	Fz 0.08 Vc 165	Fz 0.11 Vc 180	SPMG 07
Fz 0.09 Vc 135	Fz 0.1 Vc 165	Fz 0.11 Vc 180	SPMG 09
Fz 0.11 Vc 135	Fz 0.1 Vc 165	Fz 0.13 Vc 180	SPMG 11
Fz 0.12 Vc 135	Fz 0.11 Vc 165	Fz 0.14 Vc 180	SPMG 14



MILLING

TURNING

DRILLING

PARTING

THREADIN




INFO

WCMX

ITEMS

3100000002	WCMX 030208	PM	UN 330
3100000004	WCMX 040208	PM	UN 330
3100000006	WCMX 050308	PM	UN 330
3100000008	WCMX 06T308	PM	UN 330
3100000010	WCMX 080408	PM	UN 330

DRILLING BODIES

1D	2D	3D	4D	5D	7D
					

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.05 Vc 135	Fz 0.06 Vc 165	Fz 0.08 Vc 180	WCMX 03
Fz 0.06 Vc 135	Fz 0.07 Vc 165	Fz 0.09 Vc 180	WCMX 04
Fz 0.07 Vc 135	Fz 0.08 Vc 165	Fz 0.11 Vc 180	WCMX 05
Fz 0.09 Vc 135	Fz 0.1 Vc 165	Fz 0.11 Vc 180	WCMX 06
Fz 0.11 Vc 135	Fz 0.1 Vc 165	Fz 0.13 Vc 180	WCMX 08



MILLING

TURNING

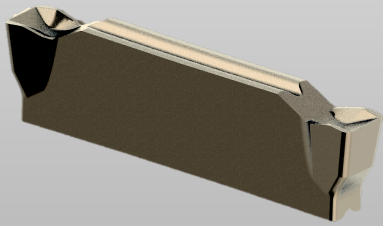
DRILLING

PARTING

THREADING

INFO

PARTING



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

04



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

PARTING

TDC

MGMN

TDC

ITEMS

4100000008	TDC 2002	PR	UN 330
4100000010	TDJ 2002	PF	UN 330
4100000012	TDC 3102	PR	UN 330
4100000014	TDJ 3102	PF	UN 330

TOOL HOLDERS

10	12	16	20	25	32
			■	■	

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.1 Vc 130	Fz 0.07 Vc 105	Fz 0.11 Vc 160	TDC 02 - PR
Fz 0.1 Vc 130	Fz 0.07 Vc 105	Fz 0.11 Vc 160	TDJ 02 - PF
Fz 0.1 Vc 130	Fz 0.07 Vc 105	Fz 0.11 Vc 160	TDC 03 - PR
Fz 0.1 Vc 130	Fz 0.07 Vc 105	Fz 0.11 Vc 160	TDJ 03 - PF



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

MGMN

ITEMS

4100000002	MGMN 2002	PR	UN 330
4100000004	MGMN 3003	PR	UN 330
4100000006	MGMN 4004	PR	UN 330

TOOL HOLDERS

10	12	16	20	25	32
			■	■	

CUTTING CONDITIONS

Feed & Depth Of Cut (Optimal)

Fz 0.1 Vc 130	Fz 0.07 Vc 105	Fz 0.11 Vc 160	MGMN 02 - PR
Fz 0.1 Vc 130	Fz 0.07 Vc 105	Fz 0.11 Vc 160	MGMN 03 - PR
Fz 0.1 Vc 130	Fz 0.07 Vc 105	Fz 0.11 Vc 160	MGMN 04 - PR



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

INFORMATION

06



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

INFORMATION

GRADE APPLICATIONS

GRADES CONVERSION-
CVD GRADES

CHIP BREAKER
APPLICATIONS

GRADES CONVERSION-
PVD GRADES

CHIP BREAKERS -
CONVERSION

GRADE APPLICATIONS

	P – ALLOY STEEL						M – STAINLESS STEEL						K – CAST IRON				
	P01	P10	P20	P30	P40	P50	M01	M10	M20	M30	M40	M50	K01	K10	K20	K30	K40
MILLING		UN 330						UN 330						UN 330			
PARTING		UN 330						UN 330						UN 330			
DRILLING		UN 330						UN 330						UN 330			
THREADING	UN 330						UN 330						UN 330				
TURNING		UN 110						UN 110						UN 110			
	UN 7010												UN 7010				
		UN 6020						UN 6020						UN 6020			
			UN 5030					UN 5030									



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

CHIP- BREAKER APPLICATIONS



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

CHIP BREAKERS - APPLICATION AREA																	
	P – ALLOY STEEL						M – STAINLESS STEEL						K – CAST IRON				
	P01	P10	P20	P30	P40	P50	M01	M10	M20	M30	M40	M50	K01	K10	K20	K30	K40
MILLING		PF						PF									
			PM						PM					PM			
PARTING		PF						PF									
			PR						PR					PR			
DRILLING		PM						PM					PM				
THREADING																	
TURNING		PF						PF									
			PM						PM								
			(STD)											(STD)			
				PR											(A) Type		

GRADES CONVERSION

CVD GRADES

		CVD - GRADES						
		SWISS.BLUE	Kennametal	Mitsubishi Carbide	TaeguTec	Sandvik	Tungaloy	ISCAR
P	Finish	UN 7010	KCP05 KC9105			GC4005 GC4205	T9005	IC428, IC9150 IC8150
	Medium	UN 6020	KCP10 KC9110 TN7005 TN7010	VP10MF	TT1300	GC4215 GC4015	T9005 T9015	IC9150, IC9015, IC8150
	Semi Rough	UN 6020	KCP25 KC9025 KC9125 TN7015	VP15TF VP20MF	TT1500	GC4015 GC4225 GC4025 GC4215 LC25	T9015 T9025	IC9025, IC9250 IC9054, IC8350
	Rough	UN 5030	KCP30 KCP40 KC8050 TN7025	VP15TF VP20MF	TT3500 TT5100	GC4225 GC4235 GC4025 GC4035 GC2135	T9025 T9035	IC9350, IC656, IC8350
M	Finish	UN 5030	KCM15, TN7010	VP10MF	TT2500	GC2015	T9015	IC9250
	Medium	UN 6020	KC9225 TN7015	VP15TF VP20MF	TT3500	GC2025	T6020 T9025	IC9250, IC9025 IC9054
K	Medium	UN 6020	KVK15, KCK20 KC9315, KC9110 TN5015	VP10RT VP15TF VP20RT	TT1300	GC3205 GC3210 GC3215	T5010	IC9150
	Rough	UN 7010	KCK20, KC9320 TN5020	VP15TF	TT1500	GC3215	T5020	IC9150, IC9015 IC418, IC428 IC4010
S	Light	UN 110		VP05RT VP10RT				
	Medium	UN 110	KC5410 KC5010	VP10RT VP15TF				
	Heavy		KC5025 KC5525	VP15TF				



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

GRADES CONVERSION

PVD GRADES

		PVD - GRADES							
		CONDITIONS	SWISS.BLUE	Kennametal	Mitsubishi Carbide	TaeguTec	Sandvik	Tungaloy	ISCAR
P	Finish	UN 110							IC 907
	Medium	UN 330	KC715M	VP15TF	TT8020 // TT9030	GC 1015//GC1025			IC 908
	Semi Rough	UN 330	KC522M	VP30RT	TT8020 // TT9030	GC 1015//GC1025	GH330//AH330		IC 908
	Rough								
M	Finish	UN 110	KC715M	VP15TF	TT8020 // TT9030	GC 1025//GC1030	GH330		IC 907
	Medium	UN 330	KC522M	VP20RT	TT8030	GC 1025//GC1030	AH120		IC 908
K	Medium	UN 110	KC510M	VP15TF		GC 1010//GC1020	AH110		IC 907
	Rough	UN 330	KC520M	VP20RT	TT6030	GC1020	AH120		IC 908
S	Light	UN 110	KC510M	VP15TF	TT6030	GC1025	AH120		IC 907
	Medium	UN 330	KC522M	VP15TF		GC1025			IC 908
	Heavy								



MILLING

TURNING

DRILLING

PARTING

THREADING

INFO

CHIP- BREAKERS CONVERSION



MILLING

TURNING

DRILLING

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THREADING

INFO

TURNING - CHIP BREAKERS

	SWISS.BLUE	Kennametal	Seco Tools	Mitsubishi Carbide	Walter	TaeguTec	Sandvik	Tungaloy	Kyocera	
P	Finish	PF	FF	FF1, FF2	PK* FH, FP FY	FP5	FA	QF LC	01* TF, 11 ZF	DP* GP, PP XP, XP-T, XF
	Medium	PM	P MN	MF3 MF5, M3 M5	MP MA MH	MP5	PC, MP MT SM	PM QM, XM	NM, ZM TM, AM DM, 33, 37, 38	PG, CJ, GS PS, HS PT
	Semi Rough	(STD)	RN, RP	MR6, MR7	RP GH Std.	RP5, RP7 NM6, NM9	RT	PR, HM XMR	TH Std.	PH GT Std.
	Rough	PR	MR RM RH	R4, R5, R6 57, RR6, R7 R8, RR9	HR, HZ, HL HM, HX HV	NR6, NRF NRR	RX, RH HD, HY, HT HZ, EH	QR, PR HR, MR	TRS TU TUS	PX
M	Finish	PF	FP LF*	MF1	SH, LM	NF4	SF	MF	SS	MQ, GU
	Medium	PM	MP	MF4	MS, GM MM, MA ES	RM5 NM4	ML EM VF	MM QM, XM K	SA, SF SM S	MS, MU SU, HU, TK ST
K	Medium	(STD)	RP, UN	M5	MK, GK Std.	RK5, NM5		KM	CM Std.	KG, Std., C
	Rough	(A) Flat			RK	RK7		KR		KH, GC
S	Light	PF	MS	MF4, MF5	LS, MJ, MJ*	NF4, NFT	EA	SGF*	HRF	
	Medium	PM	UP, P, NGP*	M1	MS	NMS, NMT		NGP*, SM	HRM SA, HMM	MS, MU, TK
	Heavy	PR	RP	M5, MR3, MR4	RS, GJ	NRS, NRT	ET	SR, SMR		