

DORMER PRAMET

ON TOP OF EFFICIENCY

T9415 | Our most advanced steel turning grade
verified by customers.



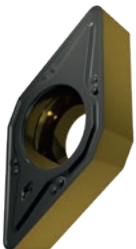
www.dormerpramet.com/T9415

PRAMET

INTRODUCTION

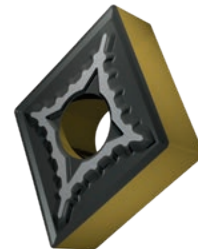


A new generation turning grade has been introduced offering one of the highest levels of productivity and versatility in the market today. The T9415 is our most advanced MT-CVD grade, bringing greater stability and performance in various cutting conditions. It covers a broad application range, replacing our previous T9310 and T9315 grades. In addition, it also partly overlaps with grade T9325, making T9415 the first choice for steel turning.



T9415

- Positive inserts
- Steels, cast irons, hard steels



T9415

- Negative inserts
- Steels, cast irons, hard steels

FEATURES & BENEFITS

- Greatly improved application range.

FIRST CHOICE GRADE
for various steel (ISO-P) turning.
- New MT-CVD coating is 30 % thicker resulting in greater resistance to flank wear, crater wear and plastic deformation.

TOOL LIFE AND PRODUCTIVITY
significantly increased compared to previous grades.
- Newly developed post-treatment process reinforces stability of cutting edge.

IMPROVED RELIABILITY,
especially in unstable conditions.
- Inserts produced on state-of-the-art electronic presses.

HIGH PRECISION
improves indexing accuracy and reduces idle time.
- Optimized cutting-edge geometry.

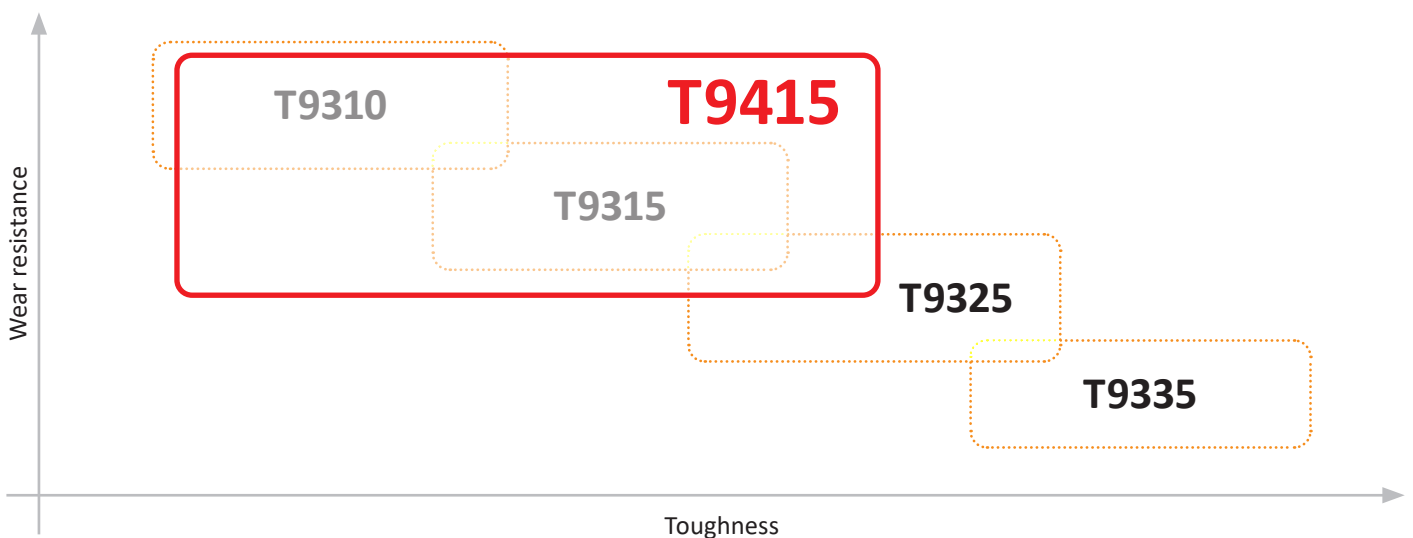
REDUCED CUTTING FORCES
and enhanced performance.
- Insert seating face ground after coating provides larger contact area and enhances heat transfer away from the cutting zone.

BETTER SEATING STABILITY
and improved overall tool life.
- Manufactured using the latest technologies.

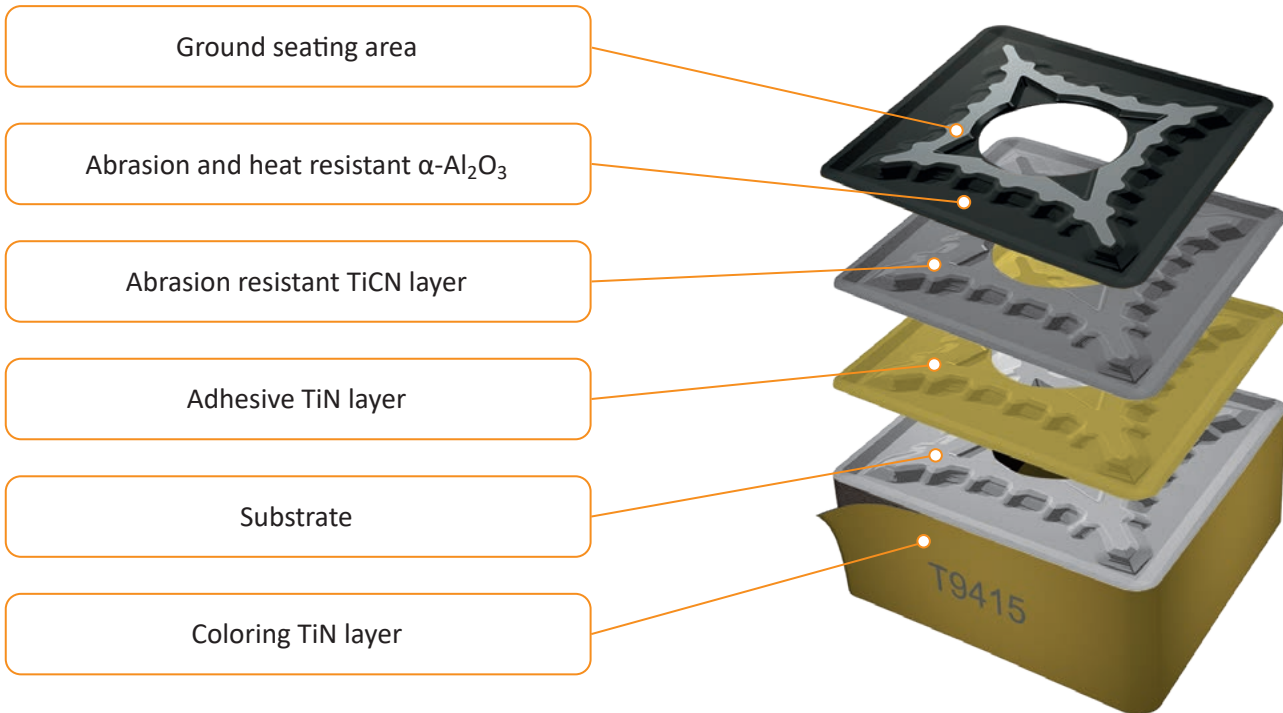
SUSTAINABLE
and environmentally friendly offer.
- TiN coated gold colored insert flanks.

EASIER WEAR DETECTION.

APPLICATION AREA OF MT-CVD TURNING GRADES

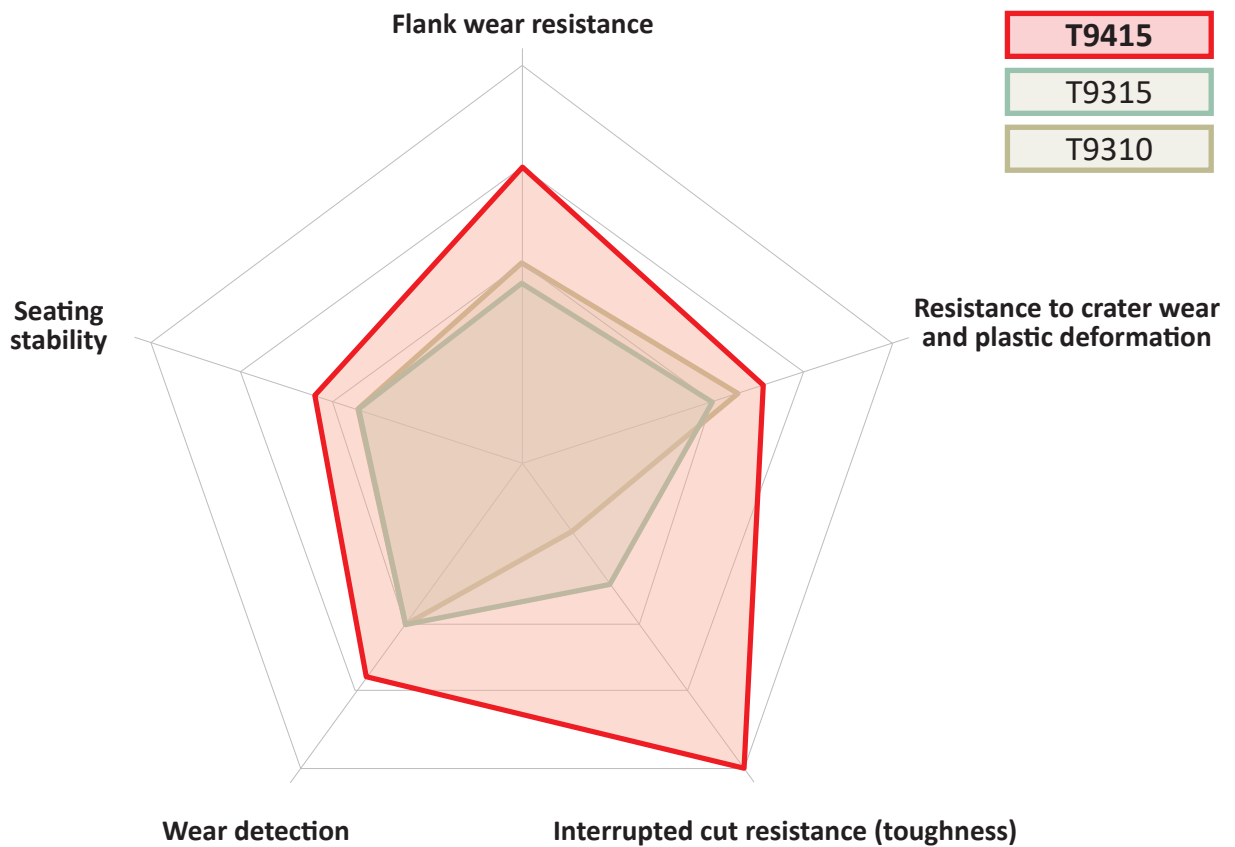


GRADE COMPOSITION



New CVD coating is 30 % thicker compared to previous grade.

FEATURES SPIDER DIAGRAM



MACHINING EXAMPLES

Material: C45 (Medium carbon steel)
 Machining: Continuous cut
 Application: Longitudinal turning
 Coolant: Yes

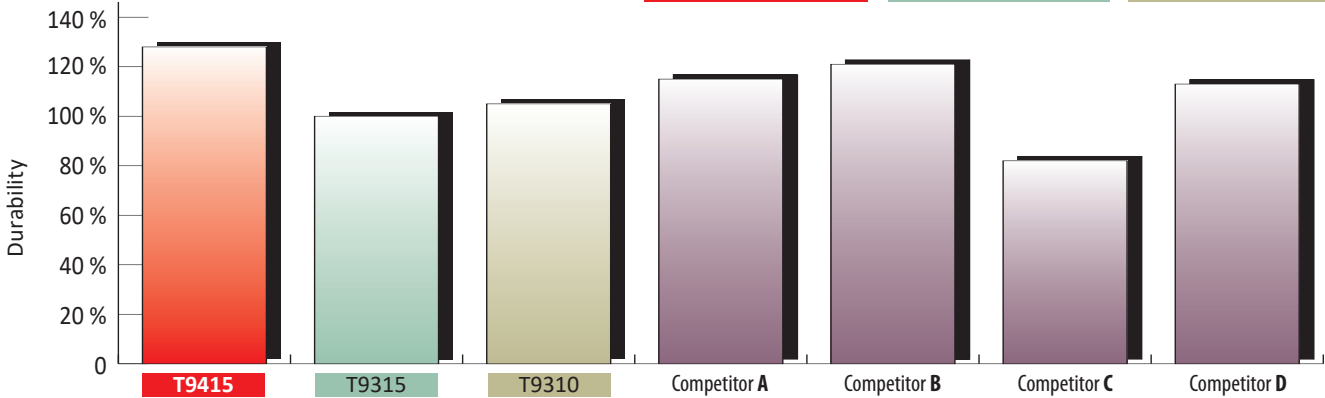
Cutting conditions

v_c (m/min)	f_n (mm/r)	a_p (mm)
300	0.25	2

Insert

CNMG 120408E-M

Photos from continuous cutting. All taken after 16 minutes.



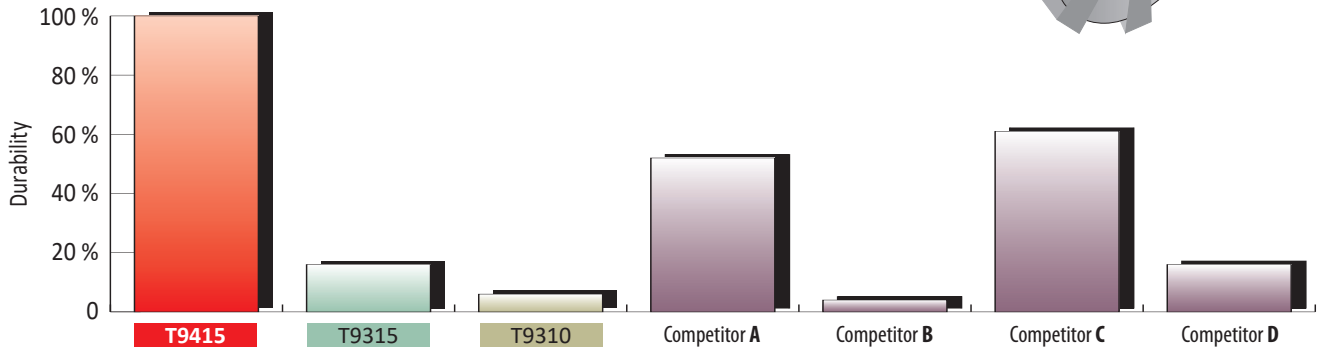
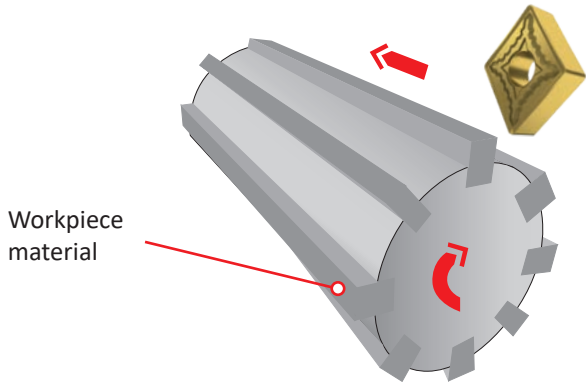
Material: 37Cr4 (Chromium steel)
 Machining: Interrupted cut
 Application: Longitudinal turning
 Coolant: No

Cutting conditions

v_c (m/min)	f_n (mm/r)	a_p (mm)
120	0.2	1

Insert

CNMG 120408E-M



v_c = cutting speed, f_n = feed per revolution, a_p = depth of cut

SUCCESS STORIES – T9415

Company:	Subcontractor for a leading Brazilian oil and gas company.
Component:	Separator ring
Material:	SAE 1045 (Carbon Steel)
Hardness:	250 HB
Application:	Internal continuous turning. Workpiece is clamped directly into lathe through hydraulic clamping system.
Previous results:	With previous competitor insert, five pieces were completed.

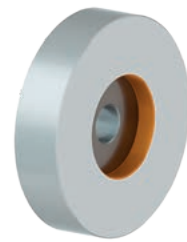
Result with T9415: A total of 10 pieces completed, doubling production.

Dormer Pramet solution

CNMG 120412E-RM:T9415

Machining data

v_c (m/min)	f_n (mm/r)	a_p (mm)
250	0.3	3



Company:	Italian manufacturer of shaft locking devices for the power generation and process industries.
Material:	C45N (Medium carbon steel)
Hardness:	172 – 242 HB
Coolant:	Yes
Application:	External continuous turning, short cuts
Previous result:	External turning of part diameter was carried out by a competitor solution. The customer wanted better tool life, while still achieving high quality surface finish.

Result with T9415: Using the new grade resulted in a 20 % increase in tool life, bringing considerable savings to the customer.

Dormer Pramet solution

CNMG 120412E-RM:T9415

Machining data

v_c (m/min)	f_n (mm/r)	a_p (mm)
200	0.35	3



Company:	Industrial valves producer in Italy
Component:	Die
Material:	DIN 1.2344 (Tool steel)
Hardness:	Variable due to faulty heat treatment
Coolant:	Yes
Application:	Vertical lathe face turning operation with variable hardness of workpiece material.
Previous results:	Durability of initial T9325 grade did not resist to the mix of hard and soft cutting conditions. This led to rapid extensive wear of insert and poor surface finish of workpiece.

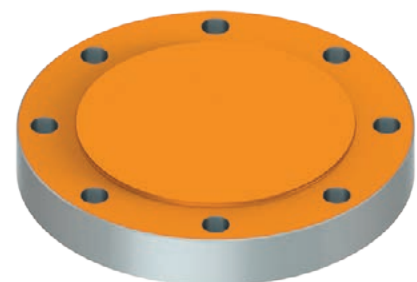
Result with T9415: The grade worked very well in low cutting speed and feed. It provided the best performance in roughing operations. With one cutting edge, a large component with a 2500 mm diameter was machined.

Dormer Pramet solution

SNMM 250924E-HR:T9415

Machining data

v_c (m/min)	f_n (mm/r)	a_p (mm)
40	0.5	8



TURNING INSERTS

Company:	Czech manufacturer of quality precision parts for energy, building and automotive industries.
Component:	Double end-stud
Material:	15142 (42CrMo4 alloy structural steel)
Coolant:	Yes
Application:	External continuous turning of slim workpiece
Previous result:	The customer used a previous generation turning grade which completed three pieces per cutting edge.

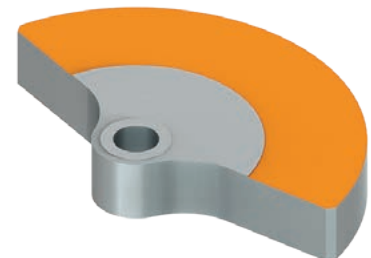
Dormer Pramet solution		
TNMG 160408E-SM:T9415		
Machining data		
v_c (m/min)	f_n (mm/r)	a_p (mm)
250	0.4	3



Result with T9415: Applying the new grade, the customer was able to machine at a higher speed and completed six pieces with one cutting edge. This not only significantly increased productivity, but also doubled the life of the cutting tool.

Company:	Chinese automotive engineering company
Component:	Diesel engine balance block
Material:	Q235 (plain carbon structural steel)
Hardness:	180 – 230 HB
Coolant:	No
Application:	Heavily interrupted cut
Previous result:	The customer used a competitor's grade that produced four pieces per cutting edge. The burrs on the workpiece were limiting the insert lifetime.

Dormer Pramet solution		
CNMG 190616E-RM:T9415		
Machining data		
v_c (m/min)	f_n (mm/r)	a_p (mm)
150	0.35	0.6










Result with T9415: New grade withstood existing cutting conditions, outperforming the previous option. It helped create six pieces with one cutting edge.



WHAT GRADE TO CHOOSE?

					
	T9415	T9310	T9315	T9325	T9335
High cutting speed, high system rigidity (stable working conditions)				-	-
High cutting speed, system rigidity slightly limited (depth of cut changing)		-			-
Medium cutting speed, system rigidity limited (slightly interrupted cut)		-	-		
Low cutting speed, low system rigidity (interrupted cut)	-	-	-	-	

TECHNICAL INFORMATION

Grade identification	Area of application	Application	Feed	Cutting speed	Resistance to adverse working conditions	Coating	Colour	Substrate	Coolant benefit
T9415	P05 – P30					MT-CVD		FGM	++
	K05 – K25								
	H10 – H20								

Grade description:

Highly wear-resistant material designed primarily for finish turning of common carbon and alloy steels. Despite its high abrasion resistance, it is also suitable for interrupted cutting operations. We recommend this material as the first choice for most turning operations, especially in high production applications.



ISO INSERTS POSITIVE – CHIPBREAKER NAVIGATOR

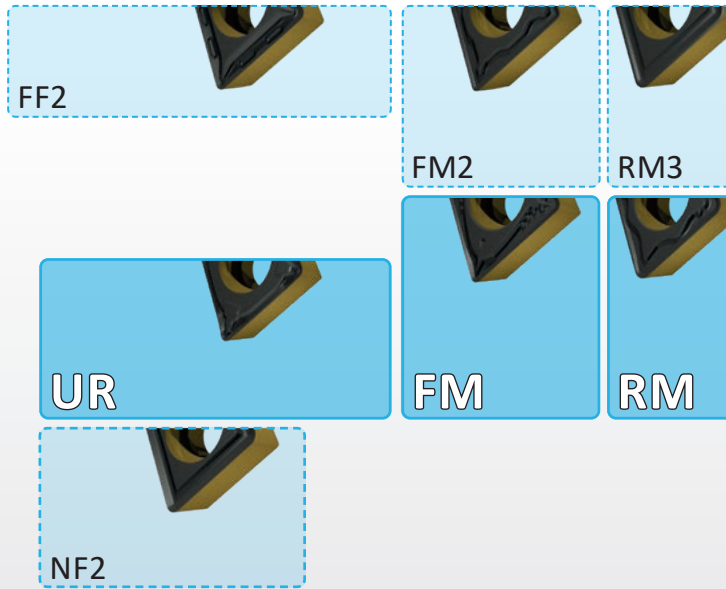
 Very unstable working conditions

 Unstable working conditions

 Stable working conditions

 Thin-walled and slim workpieces

 1st choice for stable working conditions
 Variants for different working conditions





ISO INSERTS NEGATIVE – CHIPBREAKER NAVIGATOR

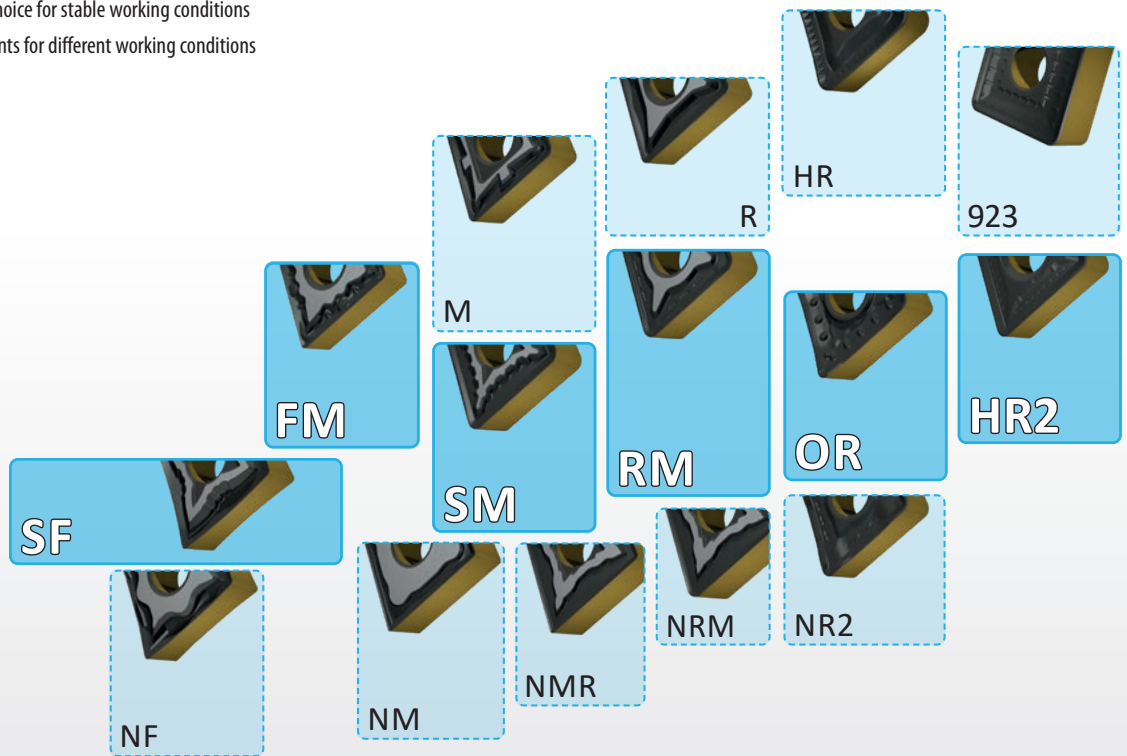
 Very unstable working conditions








 Unstable working conditions

 Stable working conditions

 Thin-walled and slim workpieces

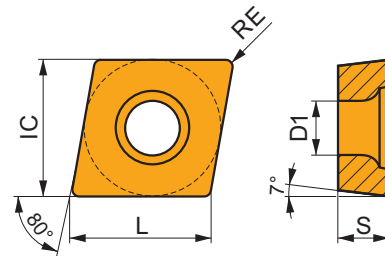
 1st choice for stable working conditions
 Variants for different working conditions



					
	0.05 – 0.2 mm/r		0.2 – 0.4 mm/r	0.4 – 1.0 mm/r	> 1.0 mm/r
	0.05 – 2 mm		2 – 4 mm	4 – 10 mm	> 10 mm

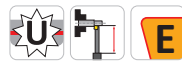
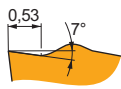
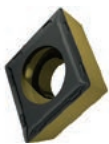
CCMT

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



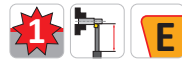
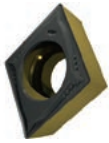
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



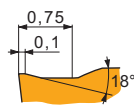
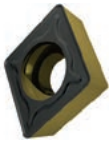
FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

CCMT 060202E-FF2	T9415	0.2	395	0.05	0.8	–	–	–	375	0.05	0.8	–	–	–	–	–	–	–
CCMT 060204E-FF2	T9415	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–
CCMT 09T304E-FF2	T9415	0.4	300	0.12	1.2	–	–	–	285	0.12	1.2	–	–	–	–	–	–	–
CCMT 09T308E-FF2	T9415	0.8	300	0.20	1.2	–	–	–	285	0.20	1.2	–	–	–	–	–	–	–



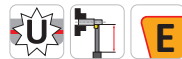
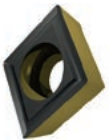
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

CCMT 060202E-FM	T9415	0.2	335	0.10	1.0	–	–	–	315	0.10	1.0	–	–	–	–	–	–	–
CCMT 060204E-FM	T9415	0.4	310	0.15	1.0	–	–	–	290	0.15	1.0	–	–	–	–	–	–	–
CCMT 060208E-FM	T9415	0.8	335	0.20	1.0	–	–	–	315	0.20	1.0	–	–	–	–	–	–	–
CCMT 09T302E-FM	T9415	0.2	330	0.10	1.2	–	–	–	310	0.10	1.2	–	–	–	–	–	–	–
CCMT 09T304E-FM	T9415	0.4	305	0.15	1.2	–	–	–	285	0.15	1.2	–	–	–	–	–	–	–
CCMT 09T308E-FM	T9415	0.8	330	0.20	1.2	–	–	–	310	0.20	1.2	–	–	–	–	–	–	–
CCMT 120404E-FM	T9415	0.4	295	0.15	1.7	–	–	–	280	0.15	1.7	–	–	–	–	–	–	–
CCMT 120408E-FM	T9415	0.8	315	0.20	1.7	–	–	–	295	0.20	1.7	–	–	–	–	–	–	–



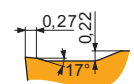
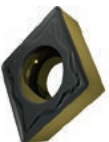
FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

CCMT 080304E-FM2	T9415	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–
CCMT 09T304E-FM2	T9415	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–
CCMT 09T308E-FM2	T9415	0.8	320	0.17	1.0	–	–	–	300	0.17	1.0	–	–	–	–	–	–	–



NF2 geometry with positive design for fine-finish to semi-rough machining, and continuous cuts.

CCMT 060204E-NF2	T9415	0.4	315	0.12	0.8	–	–	–	295	0.12	0.8	–	–	–	–	–	–	–
CCMT 080304E-NF2	T9415	0.4	305	0.12	1.0	–	–	–	285	0.12	1.0	–	–	–	–	–	–	–
CCMT 09T304E-NF2	T9415	0.4	300	0.12	1.2	–	–	–	285	0.12	1.2	–	–	–	–	–	–	–
CCMT 09T308E-NF2	T9415	0.8	340	0.14	1.2	–	–	–	320	0.14	1.2	–	–	–	–	–	–	–

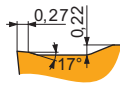
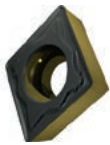


RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CCMT 09T304E-RM	T9415	0.4	255	0.25	2.2	–	–	–	240	0.25	2.2	–	–	–	–	–	50	0.18	0.3
CCMT 09T308E-RM	T9415	0.8	285	0.30	2.2	–	–	–	270	0.30	2.2	–	–	–	–	–	55	0.15	0.7

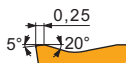
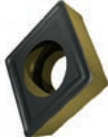
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



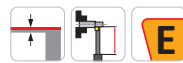
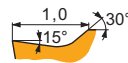
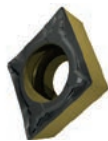
RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CCMT 120408E-RM	T9415	0.8	280	0.30	2.7	-	-	-	265	0.30	2.7	-	-	-	-	-	55	0.15	0.7
CCMT 120412E-RM	T9415	1.2	280	0.33	2.7	-	-	-	265	0.33	2.7	-	-	-	-	-	55	0.17	1.0



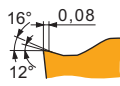
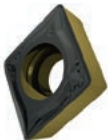
RM3 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CCMT 120404E-RM3	T9415	0.4	215	0.25	2.5	-	-	-	200	0.25	2.5	-	-	-	-	-	40	0.13	0.3
CCMT 120408E-RM3	T9415	0.8	250	0.27	2.5	-	-	-	235	0.27	2.5	-	-	-	-	-	50	0.14	0.7
CCMT 120412E-RM3	T9415	1.2	255	0.30	2.5	-	-	-	240	0.30	2.5	-	-	-	-	-	50	0.15	1.0



UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

CCMT 060202E-UR	T9415	0.2	295	0.10	0.8	-	-	-	280	0.10	0.8	-	-	-	-	-	-	-	-
CCMT 060204E-UR	T9415	0.4	270	0.15	1.0	-	-	-	255	0.15	1.0	-	-	-	-	-	-	-	-
CCMT 060208E-UR	T9415	0.8	290	0.20	1.0	-	-	-	275	0.20	1.0	-	-	-	-	-	-	-	-
CCMT 09T304E-UR	T9415	0.4	265	0.15	1.2	-	-	-	250	0.15	1.2	-	-	-	-	-	-	-	-
CCMT 09T308E-UR	T9415	0.8	285	0.20	1.2	-	-	-	270	0.20	1.2	-	-	-	-	-	-	-	-
CCMT 120404E-UR	T9415	0.4	255	0.15	1.7	-	-	-	240	0.15	1.7	-	-	-	-	-	-	-	-
CCMT 120408E-UR	T9415	0.8	275	0.20	1.7	-	-	-	260	0.20	1.7	-	-	-	-	-	-	-	-
CCMT 120412E-UR	T9415	1.2	265	0.27	1.7	-	-	-	250	0.27	1.7	-	-	-	-	-	-	-	-



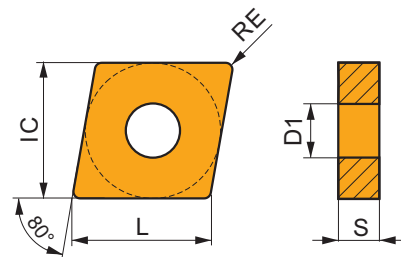
W-FM wiper geometry for fine to finish machining with increased feed rates and improved surface finish.

CCMT 060204W-FM	T9415	0.4	250	0.30	0.8	-	-	-	235	0.30	0.8	-	-	-	-	-	-	-	-
CCMT 09T304W-FM	T9415	0.4	305	0.15	1.2	-	-	-	285	0.15	1.2	-	-	-	-	-	-	-	-

CNMG

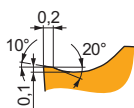
PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

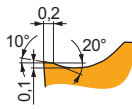
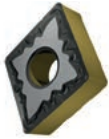


FM geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMG 090304E-FM	T9415	0.4	305	0.20	1.4	-	-	-	285	0.20	1.4	-	-	-	-	-	-	-	-
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

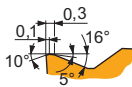
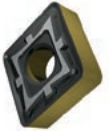
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



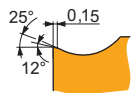
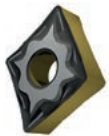
FM geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMG 090308E-FM	T9415	0.8	365	0.20	1.4	-	-	-	345	0.20	1.4	-	-	-	-	-	-	-	-
CNMG 120404E-FM	T9415	0.4	290	0.20	2.1	-	-	-	275	0.20	2.1	-	-	-	-	-	-	-	-
CNMG 120408E-FM	T9415	0.8	350	0.20	2.1	-	-	-	330	0.20	2.1	-	-	-	-	-	-	-	-
CNMG 120412E-FM	T9415	1.2	330	0.27	2.1	-	-	-	310	0.27	2.1	-	-	-	-	-	-	-	-



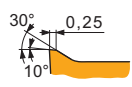
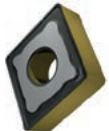
M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

CNMG 090308E-M	T9415	0.8	275	0.32	1.8	-	-	-	260	0.32	1.8	-	-	-	-	-	55	0.16	0.5
CNMG 120404E-M	T9415	0.4	265	0.20	2.1	-	-	-	250	0.20	2.1	-	-	-	-	-	50	0.13	0.3
CNMG 120408E-M	T9415	0.8	270	0.32	2.1	-	-	-	255	0.32	2.1	-	-	-	-	-	50	0.16	0.7
CNMG 120412E-M	T9415	1.2	265	0.40	2.1	-	-	-	250	0.40	2.1	-	-	-	-	-	50	0.20	1.0
CNMG 160608E-M	T9415	0.8	255	0.32	3.6	-	-	-	240	0.32	3.6	-	-	-	-	-	50	0.16	0.7
CNMG 160612E-M	T9415	1.2	250	0.40	3.6	-	-	-	235	0.40	3.6	-	-	-	-	-	50	0.20	1.0
CNMG 190608E-M	T9415	0.8	250	0.32	4.2	-	-	-	235	0.32	4.2	-	-	-	-	-	50	0.16	0.7
CNMG 190612E-M	T9415	1.2	245	0.40	4.2	-	-	-	230	0.40	4.2	-	-	-	-	-	45	0.20	1.0
CNMG 190616E-M	T9415	1.6	255	0.40	4.2	-	-	-	240	0.40	4.2	-	-	-	-	-	50	0.20	1.3



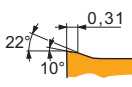
NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.

CNMG 120404E-NF	T9415	0.4	315	0.17	1.7	-	-	-	295	0.17	1.7	-	-	-	-	-	-	-	-
CNMG 120408E-NF	T9415	0.8	360	0.19	1.7	-	-	-	340	0.19	1.7	-	-	-	-	-	-	-	-
CNMG 120412E-NF	T9415	1.2	315	0.30	2.1	-	-	-	295	0.30	2.1	-	-	-	-	-	-	-	-



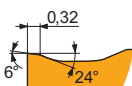
NM geometry with highly positive design for fine-finish, medium and rough machining, with continuous cuts.

CNMG 120404E-NM	T9415	0.4	305	0.20	2.1	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 120408E-NM	T9415	0.8	335	0.25	2.1	-	-	-	-	-	-	-	-	-	-	-	-	-	-



NMR geometry with positive design for medium to rough machining, and continuous cuts.

CNMG 120404E-NMR	T9415	0.4	245	0.25	2.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 120408E-NMR	T9415	0.8	255	0.35	2.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 120412E-NMR	T9415	1.2	255	0.40	2.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 120416E-NMR	T8430	1.6	155	0.45	2.7	85	0.41	2.7	-	-	-	30	0.32	2.2	-	-	-	-	-
CNMG 160608E-NMR	T9415	0.8	245	0.35	4.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 160612E-NMR	T9415	1.2	245	0.40	4.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 160616E-NMR	T9415	1.6	240	0.45	6.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 190608E-NMR	T9415	0.8	225	0.35	8.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 190616E-NMR	T8430	1.6	145	0.45	5.2	80	0.41	5.2	-	-	-	30	0.32	4.2	-	-	-	-	-
	T9415	1.6	240	0.45	5.2	-	-	-	-	-	-	-	-	-	-	-	-	-	-

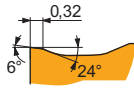


NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.

CNMG 120408-NRM	T8430	0.8	150	0.35	4.0	80	0.32	4.0	-	-	-	30	0.25	3.2	-	-	-	-	-
	T9415	0.8	245	0.35	4.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 120412-NRM	T8430	1.2	150	0.40	4.0	80	0.36	4.0	-	-	-	30	0.28	3.2	-	-	-	-	-
	T9415	1.2	245	0.40	4.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-

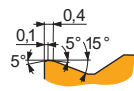
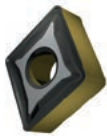
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



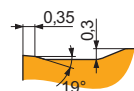
NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.

CNMG 160608-NRM	T9415	0.8	235	0.35	6.0	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 160612-NRM	T9415	1.2	235	0.40	6.0	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 160616-NRM	T8430	1.6	145	0.45	6.0	80	0.41	6.0	-	-	-	30	0.32	4.8	-	-	-	-
	T9415	1.6	240	0.45	6.0	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 190612-NRM	T8430	1.2	140	0.40	8.0	75	0.36	8.0	-	-	-	30	0.28	6.4	-	-	-	-
	T9415	1.2	230	0.40	8.0	-	-	-	-	-	-	-	-	-	-	-	-	-
CNMG 190616-NRM	T8430	1.6	140	0.45	8.0	75	0.41	8.0	-	-	-	30	0.32	6.4	-	-	-	-
	T9415	1.6	230	0.45	8.0	-	-	-	-	-	-	-	-	-	-	-	-	-



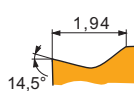
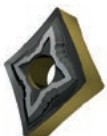
R geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMG 120408E-R	T9415	0.8	230	0.40	4.0	-	-	-	215	0.40	4.0	-	-	-	45	0.20	0.7
CNMG 120412E-R	T9415	1.2	235	0.45	4.0	-	-	-	220	0.45	4.0	-	-	-	45	0.23	1.0
CNMG 160612E-R	T9415	1.2	230	0.45	5.5	-	-	-	215	0.45	5.5	-	-	-	45	0.23	1.0
CNMG 190612E-R	T9415	1.2	225	0.45	7.0	-	-	-	210	0.45	7.0	-	-	-	45	0.23	1.0
CNMG 190616E-R	T9415	1.6	225	0.50	7.0	-	-	-	210	0.50	7.0	-	-	-	45	0.25	1.3



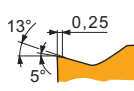
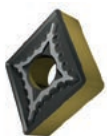
RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMG 120408E-RM	T9415	0.8	265	0.40	4.0	-	-	-	250	0.40	4.0	-	-	-	-	-	-
CNMG 120412E-RM	T9415	1.2	270	0.45	4.0	-	-	-	255	0.45	4.0	-	-	-	-	-	-
CNMG 120416E-RM	T9415	1.6	275	0.50	4.0	-	-	-	260	0.50	4.0	-	-	-	-	-	-
CNMG 160608E-RM	T9415	0.8	255	0.40	6.0	-	-	-	240	0.40	6.0	-	-	-	-	-	-
CNMG 160612E-RM	T9415	1.2	260	0.45	6.0	-	-	-	245	0.45	6.0	-	-	-	-	-	-
CNMG 160616E-RM	T9415	1.6	265	0.50	6.0	-	-	-	250	0.50	6.0	-	-	-	-	-	-
CNMG 190608E-RM	T9415	0.8	250	0.40	7.5	-	-	-	235	0.40	7.5	-	-	-	-	-	-
CNMG 190612E-RM	T9415	1.2	250	0.45	7.5	-	-	-	235	0.45	7.5	-	-	-	-	-	-
CNMG 190616E-RM	T8430	1.6	150	0.50	7.5	80	0.45	7.5	125	0.50	7.5	30	0.35	6.0	-	-	-
	T9415	1.6	255	0.50	7.5	-	-	-	240	0.50	7.5	-	-	-	-	-	-
CNMG 250924E-RM	T9415	2.4	125	0.80	12.0	-	-	-	115	0.80	12.0	-	-	-	-	-	-



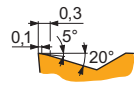
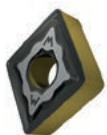
SF geometry with positive design for fine-finish machining of thin walls and continuous cuts.

CNMG 120404E-SF	T9415	0.4	315	0.17	1.0	-	-	-	295	0.17	1.0	-	-	-	60	0.13	0.3
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	----	------	-----



SM geometry with positive design for medium machining, and continuous to interrupted cuts.

CNMG 120404E-SM	T9415	0.4	280	0.20	2.0	-	-	-	265	0.20	2.0	-	-	-	55	0.13	0.3
CNMG 120408E-SM	T9415	0.8	305	0.25	2.0	-	-	-	285	0.25	2.0	-	-	-	60	0.13	0.7
CNMG 120412E-SM	T9415	1.2	300	0.30	2.0	-	-	-	285	0.30	2.0	-	-	-	60	0.15	1.0
CNMG 160612E-SM	T9415	1.2	290	0.30	3.0	-	-	-	275	0.30	3.0	-	-	-	55	0.15	1.0
CNMG 190612E-SM	T9415	1.2	280	0.30	4.0	-	-	-	265	0.30	4.0	-	-	-	55	0.15	1.0

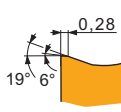
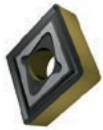


W-M wiper geometry for semi-rough to rough machining with increased feed rates and improved surface finish.

CNMG 120408W-M	T9415	0.8	245	0.45	1.5	-	-	-	230	0.45	1.5	-	-	-	-	-	-
----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



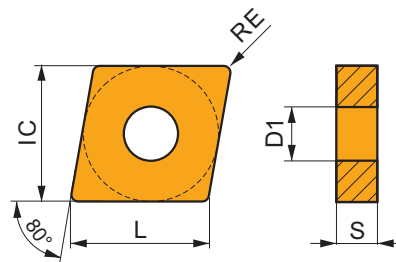
W-MR wiper geometry for finish to rough machining with increased feed rates and improved surface finish.

CNMG 120404W-MR	T9415	0.4	240	0.30	1.5	—	—	—	225	0.30	1.5	—	—	—	—	—	—	—
CNMG 120408W-MR	T9415	0.8	245	0.45	1.5	—	—	—	230	0.45	1.5	—	—	—	—	—	—	—
CNMG 120412W-MR	T9415	1.2	245	0.55	1.5	—	—	—	230	0.55	1.5	—	—	—	—	—	—	—

CNMM

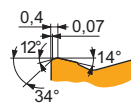


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



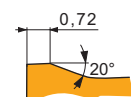
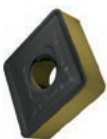
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



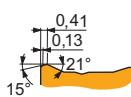
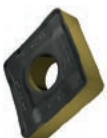
HR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

CNMM 190624E-HR	T9415	2.4	120	0.65	10.0	—	—	—	110	0.65	10.0	—	—	—	—	—	—	—
CNMM 250924E-HR	T9415	2.4	120	0.65	14.0	—	—	—	110	0.65	14.0	—	—	—	—	—	—	—



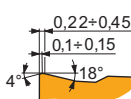
HR2 geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

CNMM 190616-HR2	T9415	1.6	115	0.65	10.0	—	—	—	105	0.65	10.0	—	—	—	—	—	—	—
CNMM 190624-HR2	T9415	2.4	110	0.85	10.0	—	—	—	100	0.85	10.0	—	—	—	—	—	—	—
CNMM 250924-HR2	T9415	2.4	110	0.85	12.0	—	—	—	100	0.85	12.0	—	—	—	—	—	—	—



NR2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 120408E-NR2	T9415	0.8	250	0.40	5.0	—	—	—	235	0.40	5.0	—	—	—	—	—	—	—
CNMM 190616E-NR2	T9415	1.6	240	0.50	9.0	—	—	—	225	0.50	9.0	—	—	—	—	—	—	—
CNMM 250924E-NR2	T9415	2.4	120	0.80	12.0	—	—	—	110	0.80	12.0	—	—	—	—	—	—	—

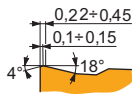
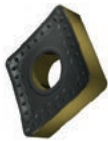


OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 120408E-OR	T9415	0.8	250	0.40	5.0	—	—	—	235	0.40	5.0	—	—	—	—	—	—	—
CNMM 120412E-OR	T9415	1.2	250	0.45	5.0	—	—	—	235	0.45	5.0	—	—	—	—	—	—	—
CNMM 160608E-OR	T9415	0.8	245	0.40	6.0	—	—	—	230	0.40	6.0	—	—	—	—	—	—	—
CNMM 160612E-OR	T9415	1.2	250	0.45	6.0	—	—	—	235	0.45	6.0	—	—	—	—	—	—	—
CNMM 160616E-OR	T9415	1.6	250	0.50	6.0	—	—	—	235	0.50	6.0	—	—	—	—	—	—	—

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



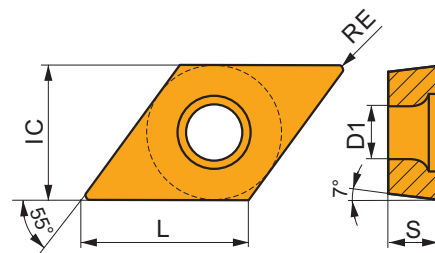
OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 190612E-OR	T9415	1.2	240	0.45	9.0	–	–	–	225	0.45	9.0	–	–	–	–	–	–	–
CNMM 190616E-OR	T9415	1.6	240	0.50	9.0	–	–	–	225	0.50	9.0	–	–	–	–	–	–	–
CNMM 190624E-OR	T9415	2.4	215	0.80	9.0	–	–	–	200	0.80	9.0	–	–	–	–	–	–	–
CNMM 250924E-OR	T9415	2.4	110	1.00	12.0	–	–	–	100	1.00	12.0	–	–	–	–	–	–	–

DCMT

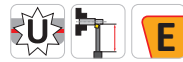
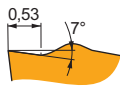


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



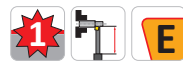
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



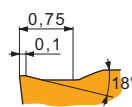
FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

DCMT 070204E-FF2	T9415	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–
DCMT 070208E-FF2	T9415	0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–
DCMT 11T304E-FF2	T9415	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–
DCMT 11T308E-FF2	T9415	0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–



FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

DCMT 070202E-FM	T9415	0.2	275	0.10	0.8	–	–	–	260	0.10	0.8	–	–	–	–	–	–	–
DCMT 070204E-FM	T9415	0.4	275	0.12	0.8	–	–	–	260	0.12	0.8	–	–	–	–	–	–	–
DCMT 11T302E-FM	T9415	0.2	275	0.10	0.8	–	–	–	260	0.10	0.8	–	–	–	–	–	–	–
DCMT 11T304E-FM	T9415	0.4	275	0.12	0.8	–	–	–	260	0.12	0.8	–	–	–	–	–	–	–
DCMT 11T308E-FM	T9415	0.8	290	0.17	0.8	–	–	–	275	0.17	0.8	–	–	–	–	–	–	–
DCMT 11T312E-FM	T9415	1.2	265	0.22	1.2	–	–	–	250	0.22	1.2	–	–	–	–	–	–	–

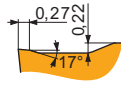


FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

DCMT 070204E-FM2	T9415	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–
DCMT 11T304E-FM2	T9415	0.4	250	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–
DCMT 11T308E-FM2	T9415	0.8	265	0.17	0.8	–	–	–	250	0.17	0.8	–	–	–	–	–	–	–

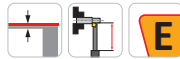
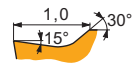
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



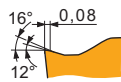
RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

DCMT 11T304E-RM	T9415	0.4	235	0.20	1.0	-	-	-	220	0.20	1.0	-	-	-	-	-	45	0.14	0.3
DCMT 11T308E-RM	T9415	0.8	255	0.27	1.0	-	-	-	240	0.27	1.0	-	-	-	-	-	50	0.14	0.7
DCMT 11T312E-RM	T9415	1.2	260	0.27	1.2	-	-	-	245	0.27	1.2	-	-	-	-	-	50	0.14	0.9
DCMT 150408E-RM	T9415	0.8	235	0.27	1.9	-	-	-	220	0.27	1.9	-	-	-	-	-	45	0.14	0.7



UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

DCMT 070202E-UR	T9415	0.2	235	0.10	0.8	-	-	-	220	0.10	0.8	-	-	-	-	-	-	-	-
DCMT 070204E-UR	T9415	0.4	240	0.12	0.8	-	-	-	225	0.12	0.8	-	-	-	-	-	-	-	-
DCMT 11T302E-UR	T9415	0.2	235	0.10	0.8	-	-	-	220	0.10	0.8	-	-	-	-	-	-	-	-
DCMT 11T304E-UR	T9415	0.4	240	0.12	0.8	-	-	-	225	0.12	0.8	-	-	-	-	-	-	-	-
DCMT 11T308E-UR	T9415	0.8	250	0.17	0.8	-	-	-	235	0.17	0.8	-	-	-	-	-	-	-	-
DCMT 11T312E-UR	T9415	1.2	230	0.22	1.2	-	-	-	215	0.22	1.2	-	-	-	-	-	-	-	-



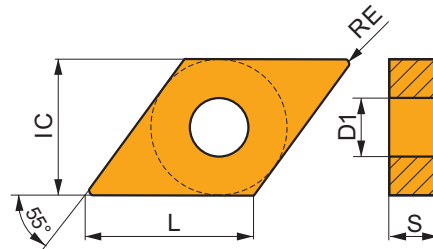
W-FM wiper geometry for fine to finish machining with increased feed rates and improved surface finish.

DCMX 11T304W-FM	T9415	0.4	200	0.30	0.8	-	-	-	190	0.30	0.8	-	-	-	-	-	-	-	-
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

DNMG

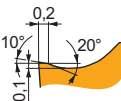
PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

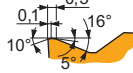


FM geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.

DNMG 110404E-FM	T9415	0.4	260	0.20	0.8	-	-	-	245	0.20	0.8	-	-	-	-	-	-	-	-
DNMG 110408E-FM	T9415	0.8	305	0.20	0.8	-	-	-	285	0.20	0.8	-	-	-	-	-	-	-	-
DNMG 150404E-FM	T9415	0.4	235	0.20	1.7	-	-	-	220	0.20	1.7	-	-	-	-	-	-	-	-
DNMG 150408E-FM	T9415	0.8	280	0.20	1.7	-	-	-	265	0.20	1.7	-	-	-	-	-	-	-	-
DNMG 150604E-FM	T9415	0.4	235	0.20	1.7	-	-	-	220	0.20	1.7	-	-	-	-	-	-	-	-
DNMG 150608E-FM	T9415	0.8	280	0.20	1.7	-	-	-	265	0.20	1.7	-	-	-	-	-	-	-	-
DNMG 150612E-FM	T9415	1.2	275	0.25	1.7	-	-	-	260	0.25	1.7	-	-	-	-	-	-	-	-
DNMG 150616E-FM	T9415	1.6	270	0.30	1.7	-	-	-	255	0.30	1.7	-	-	-	-	-	-	-	-

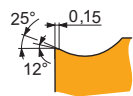
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



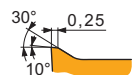
M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

DNMG 110404E-M	T9415	0.4	225	0.20	1.2	-	-	-	210	0.20	1.2	-	-	-	-	-	-	45	0.14	0.3
DNMG 110408E-M	T9415	0.8	235	0.30	1.2	-	-	-	220	0.30	1.2	-	-	-	-	-	-	45	0.15	0.7
DNMG 110412E-M	T9415	1.2	220	0.40	1.2	-	-	-	205	0.40	1.2	-	-	-	-	-	-	40	0.20	0.9
DNMG 150404E-M	T9415	0.4	210	0.20	1.9	-	-	-	195	0.20	1.9	-	-	-	-	-	-	40	0.14	0.3
DNMG 150408E-M	T9415	0.8	220	0.30	1.9	-	-	-	205	0.30	1.9	-	-	-	-	-	-	40	0.15	0.7
DNMG 150412E-M	T9415	1.2	210	0.40	1.9	-	-	-	195	0.40	1.9	-	-	-	-	-	-	40	0.20	0.9
DNMG 150604E-M	T9415	0.4	210	0.20	1.9	-	-	-	195	0.20	1.9	-	-	-	-	-	-	40	0.14	0.3
DNMG 150608E-M	T9415	0.8	220	0.30	1.9	-	-	-	205	0.30	1.9	-	-	-	-	-	-	40	0.15	0.7
DNMG 150612E-M	T9415	1.2	210	0.40	1.9	-	-	-	195	0.40	1.9	-	-	-	-	-	-	40	0.20	0.9



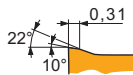
NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.

DNMG 110408E-NF	T9415	0.8	315	0.17	1.0	-	-	-	295	0.17	1.0	-	-	-	-	-	-	-	-	-
DNMG 150404E-NF	T9415	0.4	260	0.15	1.7	-	-	-	245	0.15	1.7	-	-	-	-	-	-	-	-	-
DNMG 150408E-NF	T9415	0.8	300	0.17	1.7	-	-	-	285	0.17	1.7	-	-	-	-	-	-	-	-	-
DNMG 150604E-NF	T9415	0.4	260	0.15	1.9	-	-	-	245	0.15	1.9	-	-	-	-	-	-	-	-	-
DNMG 150608E-NF	T9415	0.8	295	0.17	1.9	-	-	-	280	0.17	1.9	-	-	-	-	-	-	-	-	-



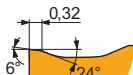
NM geometry with highly positive design for fine-finish, medium to rough machining, and continuous cuts.

DNMG 150608E-NM	T9415	0.8	275	0.25	1.9	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-----------------	-------	-----	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---



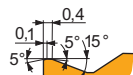
NMR geometry with positive design for medium to rough machining, and continuous cuts.

DNMG 110408E-NMR	T9415	0.8	240	0.30	0.8	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
DNMG 150408E-NMR	T9415	0.8	220	0.30	1.9	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
DNMG 150604E-NMR	T9415	0.4	210	0.20	1.9	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
DNMG 150608E-NMR	T9415	0.8	220	0.30	1.9	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
DNMG 150612E-NMR	T9415	1.2	235	0.30	1.9	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



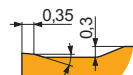
NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.

DNMG 150608-NRM	T9415	0.8	210	0.30	3.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-----------------	-------	-----	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---



R geometry for semi-rough to rough machining, and continuous to interrupted cuts.

DNMG 150608E-R	T9415	0.8	190	0.40	3.0	-	-	-	180	0.40	3.0	-	-	-	-	-	-	35	0.20	0.7
DNMG 150612E-R	T9415	1.2	200	0.40	3.0	-	-	-	190	0.40	3.0	-	-	-	-	-	-	40	0.20	0.9

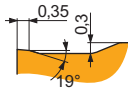


RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

DNMG 110408E-RM	T9415	0.8	230	0.40	2.0	-	-	-	215	0.40	2.0	-	-	-	-	-	-	-	-	-
DNMG 110412E-RM	T9415	1.2	265	0.30	2.0	-	-	-	250	0.30	2.0	-	-	-	-	-	-	-	-	-
DNMG 150408E-RM	T9415	0.8	220	0.40	3.0	-	-	-	205	0.40	3.0	-	-	-	-	-	-	-	-	-
DNMG 150412E-RM	T9415	1.2	230	0.40	3.0	-	-	-	215	0.40	3.0	-	-	-	-	-	-	-	-	-

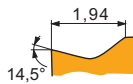
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



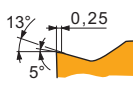
RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

DNMG 150608E-RM	T9415	0.8	220	0.40	3.0	—	—	—	205	0.40	3.0	—	—	—	—	—	—	—	—
DNMG 150612E-RM	T9415	1.2	230	0.40	3.0	—	—	—	215	0.40	3.0	—	—	—	—	—	—	—	—
DNMG 150616E-RM	T9415	1.6	245	0.40	3.0	—	—	—	230	0.40	3.0	—	—	—	—	—	—	—	—



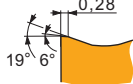
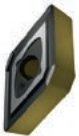
SF geometry with positive design for fine-finish machining of thin walls and continuous cuts.

DNMG 150608E-SF	T9415	0.8	290	0.17	1.5	—	—	—	275	0.17	1.5	—	—	—	—	—	55	0.12	0.7
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	----	------	-----



SM geometry with positive design for medium machining, and continuous to interrupted cuts.

DNMG 150604E-SM	T9415	0.4	225	0.20	1.7	—	—	—	210	0.20	1.7	—	—	—	—	—	45	0.14	0.3
DNMG 150608E-SM	T9415	0.8	250	0.25	1.7	—	—	—	235	0.25	1.7	—	—	—	—	—	50	0.13	0.7
DNMG 150612E-SM	T9415	1.2	245	0.30	1.7	—	—	—	230	0.30	1.7	—	—	—	—	—	45	0.15	0.9



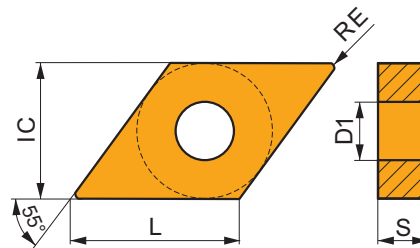
W-MR wiper geometry for finish to rough machining with increased feed rates and improved surface finish.

DNMG 150608W-MR	T9415	0.8	205	0.40	1.5	—	—	—	190	0.40	1.5	—	—	—	—	—	—	—	—
DNMG 150612W-MR	T9415	1.2	200	0.50	1.5	—	—	—	190	0.50	1.5	—	—	—	—	—	—	—	—

DNMM

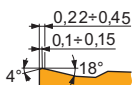


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

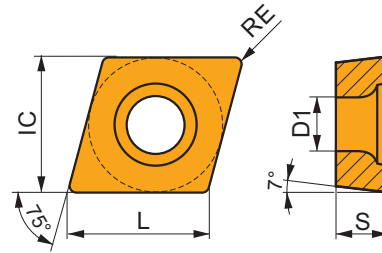


OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

DNMM 150612E-OR	T9415	1.2	220	0.40	3.0	—	—	—	205	0.40	3.0	—	—	—	—	—	—	—	—
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

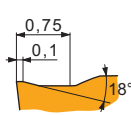
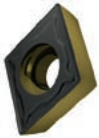
ECMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

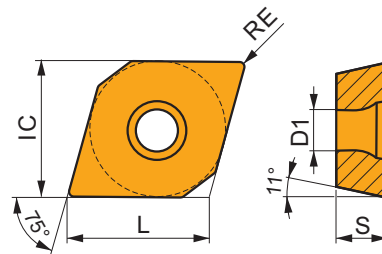


FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

ECMT 060204E-FM2	T9415	0.4	285	0.12	0.8	—	—	—	270	0.12	0.8	—	—	—	—	—	—	—	—
ECMT 080304E-FM2	T9415	0.4	275	0.12	1.0	—	—	—	260	0.12	1.0	—	—	—	—	—	—	—	—
ECMT 080308E-FM2	T9415	0.8	290	0.17	1.0	—	—	—	275	0.17	1.0	—	—	—	—	—	—	—	—

EPMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.560	2.50	5.70	2.38



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

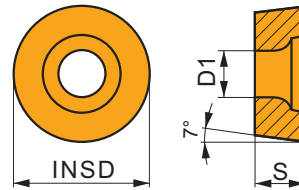


NF2 geometry with positive design for fine-finish to semi-rough machining, and continuous cuts.

EPMT 050202E-NF2	T9415	0.2	355	0.05	0.8	—	—	—	335	0.05	0.8	—	—	—	—	—	—	—	—
------------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

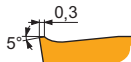
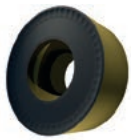
RCMT

	INSD (mm)	D1 (mm)	S (mm)
0602	6.000	2.80	2.38
0803	8.000	3.40	3.18
10T3	10.000	4.40	3.97
1204	12.000	4.40	4.76
1606	16.000	5.50	6.35
2006	20.000	6.50	6.35
3009	30.000	10.00	9.53



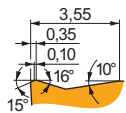
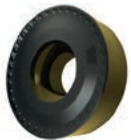
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



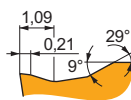
Geometry 37 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMT 1606MOS-37	T9415	-	200	0.60	3.0	-	-	-	190	0.60	3.0	-	-	-	-	-	-	-	-
-----------------	-------	---	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---



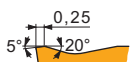
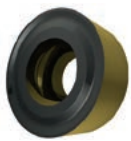
Geometry 371 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMT 2006MOS-371	T9415	-	185	0.80	3.0	-	-	-	175	0.80	3.0	-	-	-	-	-	-	-	-
------------------	-------	---	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---



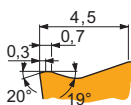
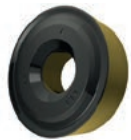
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

RCMT 0602MOE-FM	T9415	-	320	0.45	1.2	-	-	-	300	0.45	1.2	-	-	-	-	-	-	-	-
RCMT 0803MOE-FM	T9415	-	280	0.60	1.6	-	-	-	265	0.60	1.6	-	-	-	-	-	-	-	-
RCMT 10T3MOE-FM	T9415	-	275	0.65	1.7	-	-	-	260	0.65	1.7	-	-	-	-	-	-	-	-
RCMT 1204MOE-FM	T9415	-	260	0.70	1.8	-	-	-	245	0.70	1.8	-	-	-	-	-	-	-	-



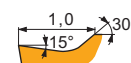
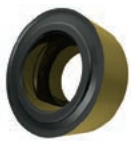
RM3 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

RCMT 0803MOE-RM3	T9415	-	275	0.50	1.3	-	-	-	260	0.50	1.3	-	-	-	-	-	55	0.25	0.5
RCMT 1204MOE-RM3	T9415	-	255	0.60	1.8	-	-	-	240	0.60	1.8	-	-	-	-	-	50	0.30	0.8
RCMT 1606MOE-RM3	T9415	-	245	0.65	2.0	-	-	-	230	0.65	2.0	-	-	-	-	-	45	0.33	1.1



RR4 geometry for heavy rough machining, and continuous to heavy interrupted cuts.

RCMT 3009MO-RR4	T9415	-	95	1.10	4.0	-	-	-	90	1.10	4.0	-	-	-	-	-	-	-	-
-----------------	-------	---	----	------	-----	---	---	---	----	------	-----	---	---	---	---	---	---	---	---

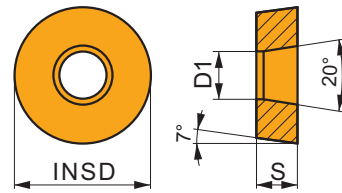


UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

RCMT 0602MOE-UR	T9415	-	285	0.40	1.2	-	-	-	270	0.40	1.2	-	-	-	-	-	-	-	-
RCMT 0803MOE-UR	T9415	-	265	0.45	1.6	-	-	-	250	0.45	1.6	-	-	-	-	-	-	-	-
RCMT 10T3MOE-UR	T9415	-	260	0.50	1.4	-	-	-	245	0.50	1.4	-	-	-	-	-	-	-	-
RCMT 1204MOE-UR	T9415	-	245	0.55	1.8	-	-	-	230	0.55	1.8	-	-	-	-	-	-	-	-

RCMX

	INSD (mm)	D1 (mm)	S (mm)
1204	12.000	4.20	4.76
1606	16.000	5.20	6.35
2006	20.000	6.50	6.35
2507	25.000	7.20	7.94
3209	32.000	9.50	9.53

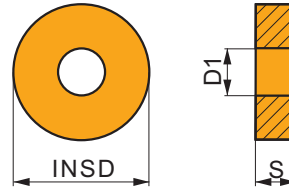


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
RCMX 1606M0S-37	T9415	200	0.60	3.0				190	0.60	3.0									
RCMX 1204M0S-321	T9415	170	1.00	3.0				160	1.00	3.0									
RCMX 1606M0S-331	T9415	155	1.20	3.5				145	1.20	3.5									
RCMX 2006M0-RF1	T9415	105	0.80	3.5				95	0.80	3.5									
RCMX 2507M0-RF1	T9415	100	1.00	3.5				95	1.00	3.5									
RCMX 2006M0-RM1	T9415	100	1.00	3.5				95	1.00	3.5									
RCMX 2507M0-RM1	T9415	100	1.00	3.5				95	1.00	3.5									
RCMX 2507M0-RM2	T9415	95	1.10	3.5				90	1.10	3.5									
RCMX 3209M0-RM2	T9415	95	1.00	4.5				90	1.00	4.5									
RCMX 3209M0-RR2	T9415	70	1.40	4.5				65	1.40	4.5							10	0.70	2.0

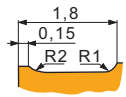
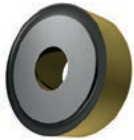
RNMG

	INSD (mm)	D1 (mm)	S (mm)
1204	12.700	5.16	4.76
1506	15.875	6.35	6.35
1906	19.050	7.94	6.35
2509	25.400	9.12	9.53



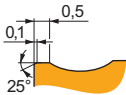
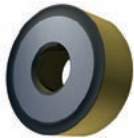
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



Geometry 08 for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RNMG 120400E-08	T9415	-	190	0.70	3.0	-	-	-	180	0.70	3.0	-	-	-	-	-	-	35	0.35	0.8
RNMG 150600E-08	T9415	-	190	0.70	3.0	-	-	-	180	0.70	3.0	-	-	-	-	-	-	35	0.35	1.0
RNMG 190600E-08	T9415	-	190	0.70	3.0	-	-	-	180	0.70	3.0	-	-	-	-	-	-	35	0.35	1.3

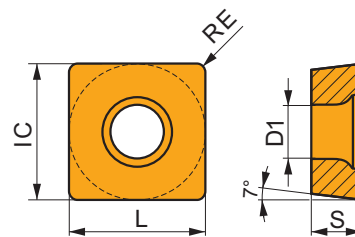


Geometry 081 for rough to heavy-rough machining, and continuous to interrupted cuts.

RNMG 250900E-081	T9415	-	100	0.90	5.0	-	-	-	95	0.90	5.0	-	-	-	-	-	-	20	0.45	1.7
------------------	-------	---	-----	------	-----	---	---	---	----	------	-----	---	---	---	---	---	---	----	------	-----

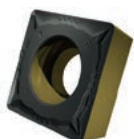
SCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

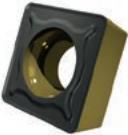
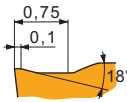

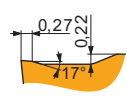
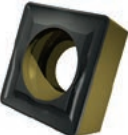
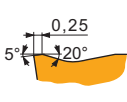
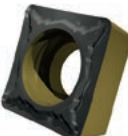
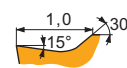
Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

SCMT 09T304E-FM	T9415	0.4	320	0.15	1.2	-	-	-	300	0.15	1.2	-	-	-	-	-	-	-	-	-
SCMT 09T308E-FM	T9415	0.8	350	0.20	1.2	-	-	-	330	0.20	1.2	-	-	-	-	-	-	-	-	-
SCMT 120404E-FM	T9415	0.4	315	0.15	1.6	-	-	-	295	0.15	1.6	-	-	-	-	-	-	-	-	-
SCMT 120408E-FM	T9415	0.8	340	0.20	1.6	-	-	-	320	0.20	1.6	-	-	-	-	-	-	-	-	-
SCMT 120412E-FM	T9415	1.2	320	0.27	1.6	-	-	-	300	0.27	1.6	-	-	-	-	-	-	-	-	-

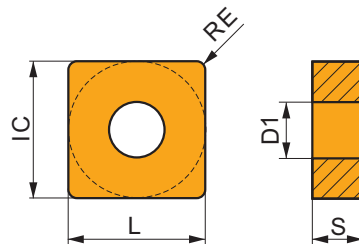
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
 																			
SCMT 09T308E-FM2	T9415 0.8	340	0.17	1.0	–	–	–	320	0.17	1.0	–	–	–	–	–	–	–	–	–
 																			
SCMT 09T308E-RM	T9415 0.8	295	0.30	2.0	–	–	–	280	0.30	2.0	–	–	–	–	–	–	55	0.15	0.7
SCMT 120408E-RM	T9415 0.8	295	0.30	2.3	–	–	–	280	0.30	2.3	–	–	–	–	–	–	55	0.15	0.7
 																			
SCMT 120408E-RM3	T9415 0.8	265	0.27	2.3	–	–	–	250	0.27	2.3	–	–	–	–	–	–	50	0.14	0.7
 																			
SCMT 09T304E-UR	T9415 0.4	280	0.15	1.2	–	–	–	265	0.15	1.2	–	–	–	–	–	–	–	–	–
SCMT 09T308E-UR	T9415 0.8	300	0.20	1.2	–	–	–	285	0.20	1.2	–	–	–	–	–	–	–	–	–

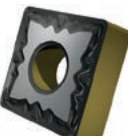
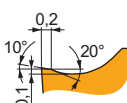
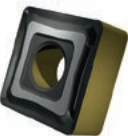
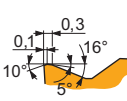
SNMG



	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2509	25.400	9.12	25.40	9.53

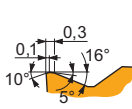
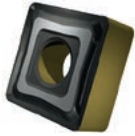


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
 																			
SNMG 120404E-FM	T9415 0.4	305	0.20	2.1	–	–	–	285	0.20	2.1	–	–	–	–	–	–	–	–	–
SNMG 120408E-FM	T9415 0.8	365	0.20	2.1	–	–	–	345	0.20	2.1	–	–	–	–	–	–	–	–	–
SNMG 120412E-FM	T9415 1.2	345	0.27	2.1	–	–	–	325	0.27	2.1	–	–	–	–	–	–	–	–	–
 																			
SNMG 120408E-M	T9415 0.8	280	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.16	0.7
SNMG 120412E-M	T9415 1.2	275	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.20	1.0

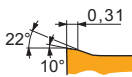
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



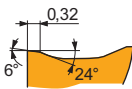
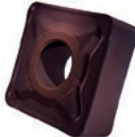
M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

SNMG 150612E-M	T9415	1.2	260	0.40	3.4	—	—	—	245	0.40	3.4	—	—	—	—	—	—	50	0.20	1.0
SNMG 190612E-M	T9415	1.2	255	0.40	4.0	—	—	—	240	0.40	4.0	—	—	—	—	—	—	50	0.20	1.0
SNMG 190616E-M	T9415	1.6	270	0.40	4.0	—	—	—	255	0.40	4.0	—	—	—	—	—	—	50	0.20	1.3



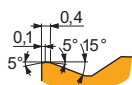
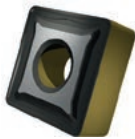
NMR geometry with positive design for medium to rough machining, and continuous cuts.

SNMG 150612E-NMR	T8430	1.2	155	0.40	3.8	85	0.36	3.8	—	—	—	30	0.28	3.0	—	—	—	—	—	—
SNMG 190616E-NMR	T8430	1.6	150	0.45	5.2	80	0.41	5.2	—	—	—	30	0.32	4.2	—	—	—	—	—	—
	T9415	1.6	250	0.45	5.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



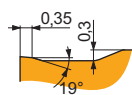
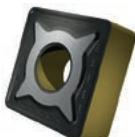
NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.

SNMG 120412-NRM	T8430	1.2	165	0.40	3.0	90	0.36	3.0	—	—	—	35	0.28	2.4	—	—	—	—	—	—
	T9415	1.2	265	0.40	3.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
SNMG 150616-NRM	T8430	1.6	150	0.45	5.0	80	0.41	5.0	—	—	—	30	0.32	4.0	—	—	—	—	—	—
	T9415	1.6	250	0.45	5.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
SNMG 250924-NRM	T9415	2.4	125	0.70	9.0	—	—	—	115	0.70	9.0	—	—	—	—	—	—	—	—	—



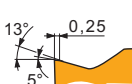
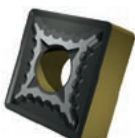
R geometry for semi-rough to rough machining, and continuous to interrupted cuts.

SNMG 120416E-R	T9415	1.6	250	0.50	3.8	—	—	—	235	0.50	3.8	—	—	—	—	—	—	50	0.25	1.3
SNMG 150612E-R	T9415	1.2	245	0.45	4.5	—	—	—	230	0.45	4.5	—	—	—	—	—	—	45	0.23	1.0
SNMG 190616E-R	T9415	1.6	240	0.50	6.0	—	—	—	225	0.50	6.0	—	—	—	—	—	—	45	0.25	1.3



RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

SNMG 120408E-RM	T9415	0.8	280	0.40	4.0	—	—	—	265	0.40	4.0	—	—	—	—	—	—	—	—	—
SNMG 120412E-RM	T9415	1.2	280	0.45	4.0	—	—	—	265	0.45	4.0	—	—	—	—	—	—	—	—	—
SNMG 120416E-RM	T9415	1.6	290	0.50	4.0	—	—	—	275	0.50	4.0	—	—	—	—	—	—	—	—	—
SNMG 150612E-RM	T9415	1.2	275	0.45	5.0	—	—	—	260	0.45	5.0	—	—	—	—	—	—	—	—	—
SNMG 150616E-RM	T9415	1.6	285	0.50	5.0	—	—	—	270	0.50	5.0	—	—	—	—	—	—	—	—	—
SNMG 190612E-RM	T9415	1.2	270	0.45	7.0	—	—	—	255	0.45	7.0	—	—	—	—	—	—	—	—	—
SNMG 190616E-RM	T8430	1.6	165	0.50	7.0	90	0.45	7.0	135	0.50	7.0	35	0.35	5.6	—	—	—	—	—	—
	T9415	1.6	270	0.50	7.0	—	—	—	255	0.50	7.0	—	—	—	—	—	—	—	—	—
SNMG 250924E-RM	T9415	2.4	130	0.80	12.0	—	—	—	120	0.80	12.0	—	—	—	—	—	—	—	—	—

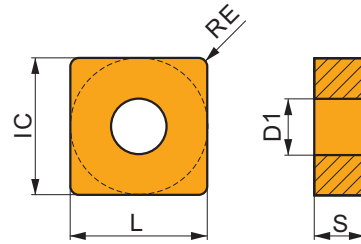


SM geometry with positive design for medium machining and continuous to interrupted cuts.

SNMG 120408E-SM	T9415	0.8	325	0.25	1.8	—	—	—	305	0.25	1.8	—	—	—	—	—	—	65	0.13	0.7
SNMG 120412E-SM	T9415	1.2	325	0.30	1.8	—	—	—	305	0.30	1.8	—	—	—	—	—	—	65	0.15	1.0

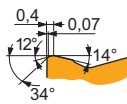
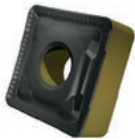
SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



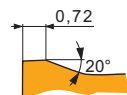
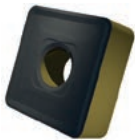
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



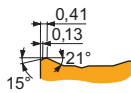
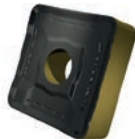
HR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

SNMM 190624E-HR	T9415	2.4	130	0.65	9.0	–	–	–	120	0.65	9.0	–	–	–	–	–	–	–	–
SNMM 250724E-HR	T9415	2.4	125	0.65	13.0	–	–	–	115	0.65	13.0	–	–	–	–	–	–	–	–
SNMM 250924E-HR	T9415	2.4	125	0.65	13.0	–	–	–	115	0.65	13.0	–	–	–	–	–	–	–	–



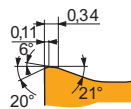
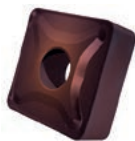
HR2 geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

SNMM 190616-HR2	T9415	1.6	125	0.65	8.9	–	–	–	115	0.65	8.9	–	–	–	–	–	–	–	–
SNMM 190624-HR2	T9415	2.4	120	0.85	8.9	–	–	–	110	0.85	8.9	–	–	–	–	–	–	–	–
SNMM 250924-HR2	T9415	2.4	115	0.85	11.0	–	–	–	105	0.85	11.0	–	–	–	–	–	–	–	–



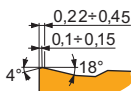
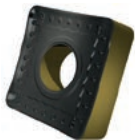
NR2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

SNMM 190616E-NR2	T9415	1.6	260	0.50	8.0	–	–	–	245	0.50	8.0	–	–	–	–	–	–	–	–
SNMM 250724E-NR2	T9415	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–
SNMM 250924E-NR2	T9415	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–



NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.

SNMM 250724-NRM	T9415	2.4	130	0.65	9.0	–	–	–	120	0.65	9.0	–	–	–	–	–	–	–	–
SNMM 250924-NRM	T8430	2.4	130	0.70	9.0	70	0.63	9.0	105	0.70	9.0	–	–	–	25	0.49	7.2	–	–

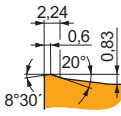


OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

SNMM 120408E-OR	T9415	0.8	265	0.40	4.7	–	–	–	250	0.40	4.7	–	–	–	–	–	–	–	–
SNMM 120412E-OR	T9415	1.2	270	0.45	4.7	–	–	–	255	0.45	4.7	–	–	–	–	–	–	–	–
SNMM 150616E-OR	T9415	1.6	265	0.50	6.0	–	–	–	250	0.50	6.0	–	–	–	–	–	–	–	–
SNMM 190612E-OR	T9415	1.2	250	0.45	8.0	–	–	–	235	0.45	8.0	–	–	–	–	–	–	–	–
SNMM 190616E-OR	T9415	1.6	260	0.50	8.0	–	–	–	245	0.50	8.0	–	–	–	–	–	–	–	–
SNMM 190624E-OR	T9415	2.4	225	0.80	8.0	–	–	–	210	0.80	8.0	–	–	–	–	–	–	–	–
SNMM 250724E-OR	T9415	2.4	120	1.00	12.0	–	–	–	110	1.00	12.0	–	–	–	–	–	–	–	–
SNMM 250924E-OR	T9415	2.4	120	1.00	12.0	–	–	–	110	1.00	12.0	–	–	–	–	–	–	–	–

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



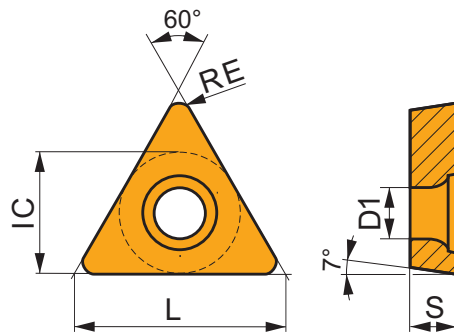
Geometry 923 for semi-rough to heavy-rough machining, and continuous to heavy interrupted cuts.

SNMM 250924S-923	T9415	2.4	115	0.85	11.0	-	-	-	105	0.85	11.0	-	-	-	-	-	-	-
------------------	-------	-----	-----	------	------	---	---	---	-----	------	------	---	---	---	---	---	---	---

TCMT

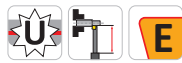
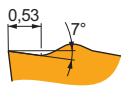


	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



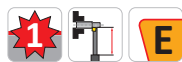
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



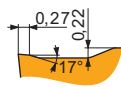
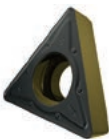
FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

TCMT 06T102E-FF2	T9415	0.2	335	0.05	0.8	-	-	-	315	0.05	0.8	-	-	-	-	-	-
TCMT 06T104E-FF2	T9415	0.4	265	0.12	0.8	-	-	-	250	0.12	0.8	-	-	-	-	-	-
TCMT 090204E-FF2	T9415	0.4	260	0.12	1.0	-	-	-	245	0.12	1.0	-	-	-	-	-	-
TCMT 110204E-FF2	T9415	0.4	265	0.12	0.8	-	-	-	250	0.12	0.8	-	-	-	-	-	-
TCMT 110208E-FF2	T9415	0.8	280	0.17	0.8	-	-	-	265	0.17	0.8	-	-	-	-	-	-
TCMT 16T304E-FF2	T9415	0.4	265	0.12	0.8	-	-	-	250	0.12	0.8	-	-	-	-	-	-
TCMT 16T308E-FF2	T9415	0.8	280	0.17	0.8	-	-	-	265	0.17	0.8	-	-	-	-	-	-



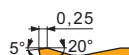
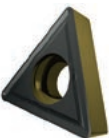
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

TCMT 110202E-FM	T9415	0.2	290	0.10	0.8	-	-	-	275	0.10	0.8	-	-	-	-	-	-
TCMT 110204E-FM	T9415	0.4	295	0.12	0.8	-	-	-	280	0.12	0.8	-	-	-	-	-	-
TCMT 110208E-FM	T9415	0.8	310	0.17	0.8	-	-	-	290	0.17	0.8	-	-	-	-	-	-
TCMT 16T304E-FM	T9415	0.4	270	0.12	1.7	-	-	-	255	0.12	1.7	-	-	-	-	-	-
TCMT 16T308E-FM	T9415	0.8	285	0.17	1.7	-	-	-	270	0.17	1.7	-	-	-	-	-	-



RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TCMT 16T308E-RM	T9415	0.8	250	0.27	1.9	-	-	-	235	0.27	1.9	-	-	-	50	0.14	0.7
TCMT 16T312E-RM	T9415	1.2	265	0.27	1.9	-	-	-	250	0.27	1.9	-	-	-	50	0.14	0.9

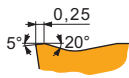
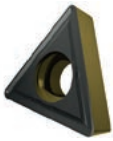


RM3 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TCMT 16T304E-RM3	T9415	0.4	205	0.20	2.0	-	-	-	190	0.20	2.0	-	-	-	40	0.14	0.3
------------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	----	------	-----

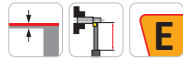
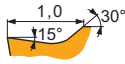
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



RM3 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TCMT 16T308E-RM3	T9415	0.8	220	0.27	2.0	—	—	—	205	0.27	2.0	—	—	—	—	—	—	—	40	0.14	0.7
------------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	----	------	-----



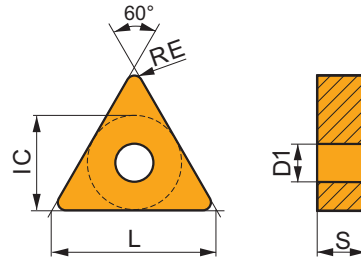
UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

TCMT 110204E-UR	T9415	0.4	255	0.12	0.8	—	—	—	240	0.12	0.8	—	—	—	—	—	—	—	—	—	—
TCMT 16T304E-UR	T9415	0.4	255	0.12	0.8	—	—	—	240	0.12	0.8	—	—	—	—	—	—	—	—	—	—
TCMT 16T308E-UR	T9415	0.8	265	0.17	0.8	—	—	—	250	0.17	0.8	—	—	—	—	—	—	—	—	—	—

TNMG

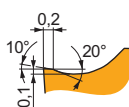
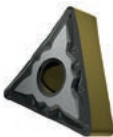


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35



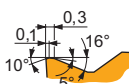
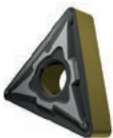
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



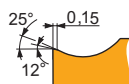
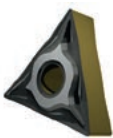
FM geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.

TNMG 160404E-FM	T9415	0.4	250	0.20	1.7	—	—	—	235	0.20	1.7	—	—	—	—	—	—	—	—	—	—
TNMG 160408E-FM	T9415	0.8	300	0.20	1.7	—	—	—	285	0.20	1.7	—	—	—	—	—	—	—	—	—	—
TNMG 160412E-FM	T9415	1.2	290	0.25	1.7	—	—	—	275	0.25	1.7	—	—	—	—	—	—	—	—	—	—
TNMG 220404E-FM	T9415	0.4	250	0.20	1.7	—	—	—	235	0.20	1.7	—	—	—	—	—	—	—	—	—	—
TNMG 220408E-FM	T9415	0.8	300	0.20	1.7	—	—	—	285	0.20	1.7	—	—	—	—	—	—	—	—	—	—



M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

TNMG 160404E-M	T9415	0.4	230	0.20	1.6	—	—	—	215	0.20	1.6	—	—	—	—	—	—	—	45	0.14	0.3
TNMG 160408E-M	T9415	0.8	240	0.30	1.6	—	—	—	225	0.30	1.6	—	—	—	—	—	—	—	45	0.15	0.7
TNMG 160412E-M	T9415	1.2	225	0.40	1.6	—	—	—	210	0.40	1.6	—	—	—	—	—	—	—	45	0.20	0.9
TNMG 220408E-M	T9415	0.8	230	0.30	2.1	—	—	—	215	0.30	2.1	—	—	—	—	—	—	—	45	0.15	0.7
TNMG 220412E-M	T9415	1.2	225	0.40	2.1	—	—	—	210	0.40	2.1	—	—	—	—	—	—	—	45	0.20	0.9

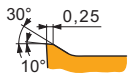
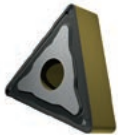


NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.

TNMG 160404E-NF	T9415	0.4	285	0.15	1.4	—	—	—	270	0.15	1.4	—	—	—	—	—	—	—	—	—	—
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---	---	---

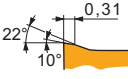
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



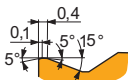
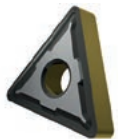
NM geometry with highly positive design for fine-finish, medium and rough machining, in continuous cuts.

TNMG 160408E-NM	T9415	0.8	290	0.25	1.9	-	-	-	-	-	-	-	-	-	-	-	-	-	-
-----------------	-------	-----	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---	---	---



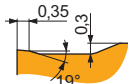
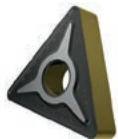
NMR geometry with positive design for medium to rough machining, and continuous cuts.

TNMG 160408E-NMR	T9415	0.8	235	0.30	1.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TNMG 160412E-NMR	T8430	1.2	155	0.30	1.7	85	0.27	1.7	-	-	-	-	-	30	0.24	1.4	-	-	-
	T9415	1.2	250	0.30	1.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TNMG 220412E-NMR	T9415	1.2	245	0.30	2.1	-	-	-	-	-	-	-	-	-	-	-	-	-	-



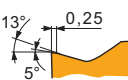
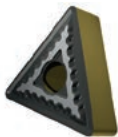
R geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TNMG 160408E-R	T9415	0.8	205	0.40	3.0	-	-	-	190	0.40	3.0	-	-	-	-	-	40	0.20	0.7
TNMG 160412E-R	T9415	1.2	215	0.40	3.0	-	-	-	200	0.40	3.0	-	-	-	-	-	40	0.20	0.9
TNMG 220408E-R	T9415	0.8	195	0.40	4.0	-	-	-	185	0.40	4.0	-	-	-	-	-	35	0.20	0.7
TNMG 220412E-R	T9415	1.2	205	0.40	4.0	-	-	-	190	0.40	4.0	-	-	-	-	-	40	0.20	0.9



RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TNMG 160408E-RM	T9415	0.8	235	0.40	3.0	-	-	-	220	0.40	3.0	-	-	-	-	-	-	-	-
TNMG 160412E-RM	T9415	1.2	245	0.40	3.0	-	-	-	230	0.40	3.0	-	-	-	-	-	-	-	-
TNMG 220408E-RM	T9415	0.8	225	0.40	4.0	-	-	-	210	0.40	4.0	-	-	-	-	-	-	-	-
TNMG 220412E-RM	T9415	1.2	235	0.40	4.0	-	-	-	220	0.40	4.0	-	-	-	-	-	-	-	-
TNMG 220416E-RM	T9415	1.6	250	0.40	4.0	-	-	-	235	0.40	4.0	-	-	-	-	-	-	-	-
TNMG 270616E-RM	T9415	1.6	140	0.40	6.0	-	-	-	130	0.40	6.0	-	-	-	-	-	-	-	-

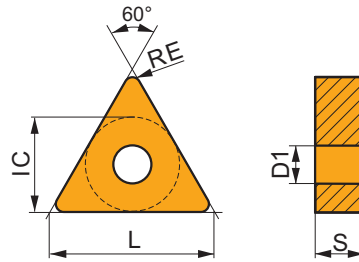


SM geometry with positive design for medium machining, and continuous to interrupted cuts.

TNMG 160404E-SM	T9415	0.4	240	0.20	1.7	-	-	-	225	0.20	1.7	-	-	-	-	-	45	0.14	0.3
TNMG 160408E-SM	T9415	0.8	265	0.25	1.7	-	-	-	250	0.25	1.7	-	-	-	-	-	50	0.13	0.7
TNMG 220408E-SM	T9415	0.8	265	0.25	1.7	-	-	-	250	0.25	1.7	-	-	-	-	-	50	0.13	0.7
TNMG 220412E-SM	T9415	1.2	260	0.30	1.7	-	-	-	245	0.30	1.7	-	-	-	-	-	50	0.15	0.9

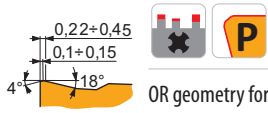
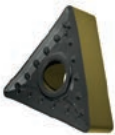
TNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

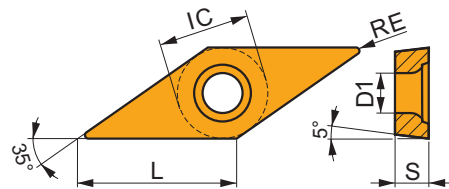


OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TNMM 160408E-OR	T9415	0.8	225	0.40	3.0	—	—	—	210	0.40	3.0	—	—	—	—	—	—	—	—
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

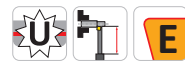
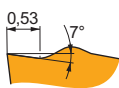
VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



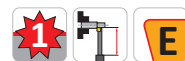
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

VBMT 160404E-FF2	T9415	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—
------------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

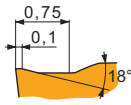


FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

VBMT 110304E-FM	T9415	0.4	255	0.12	0.8	—	—	—	240	0.12	0.8	—	—	—	—	—	—	—	—
VBMT 110308E-FM	T9415	0.8	270	0.17	0.8	—	—	—	255	0.17	0.8	—	—	—	—	—	—	—	—
VBMT 160402E-FM	T9415	0.2	245	0.10	1.2	—	—	—	230	0.10	1.2	—	—	—	—	—	—	—	—
VBMT 160404E-FM	T9415	0.4	245	0.12	1.2	—	—	—	230	0.12	1.2	—	—	—	—	—	—	—	—
VBMT 160408E-FM	T9415	0.8	260	0.17	1.2	—	—	—	245	0.17	1.2	—	—	—	—	—	—	—	—
VBMT 160412E-FM	T9415	1.2	245	0.22	1.2	—	—	—	230	0.22	1.2	—	—	—	—	—	—	—	—

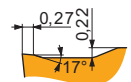
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



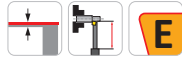
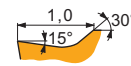
FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

VBMT 160404E-FM2	T9415	0.4	220	0.12	1.2	–	–	–	205	0.12	1.2	–	–	–	–	–	–	–	–
VBMT 160408E-FM2	T9415	0.8	220	0.20	1.2	–	–	–	205	0.20	1.2	–	–	–	–	–	–	–	–
VBMT 160412E-FM2	T9415	1.2	225	0.22	1.2	–	–	–	210	0.22	1.2	–	–	–	–	–	–	–	–



RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

VBMT 160404E-RM	T9415	0.4	255	0.12	1.2	–	–	–	240	0.12	1.2	–	–	–	–	–	–	50	0.12	0.3
VBMT 160408E-RM	T9415	0.8	270	0.17	1.2	–	–	–	255	0.17	1.2	–	–	–	–	–	–	50	0.12	0.7
VBMT 160412E-RM	T9415	1.2	240	0.27	1.2	–	–	–	225	0.27	1.2	–	–	–	–	–	–	45	0.14	0.9



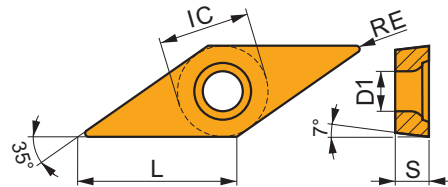
UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

VBMT 160404E-UR	T9415	0.4	210	0.12	1.2	–	–	–	195	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR	T9415	0.8	225	0.17	1.2	–	–	–	210	0.17	1.2	–	–	–	–	–	–	–	–	–
VBMT 160412E-UR	T9415	1.2	210	0.22	1.2	–	–	–	195	0.22	1.2	–	–	–	–	–	–	–	–	–

VCGT

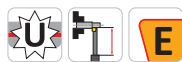
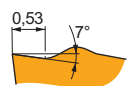
PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

VCGT 130302E-FF2	T9415	0.2	270	0.05	1.0	–	–	–	255	0.05	1.0	–	–	–	–	–	–	–	–	–
VCGT 130304E-FF2	T9415	0.4	215	0.12	1.0	–	–	–	200	0.12	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-FF2	T9415	0.8	225	0.17	1.0	–	–	–	210	0.17	1.0	–	–	–	–	–	–	–	–	–

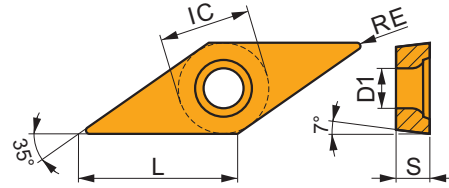


NF2 geometry with positive design for fine-finish to semi-rough machining, and continuous cuts.

VCGT 130304E-NF2	T9415	0.4	225	0.10	1.0	–	–	–	210	0.10	1.0	–	–	–	–	–	–	–	–	–
VCGT 130308E-NF2	T9415	0.8	225	0.17	1.0	–	–	–	210	0.17	1.0	–	–	–	–	–	–	–	–	–

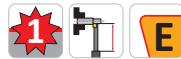
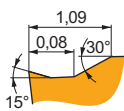
VCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



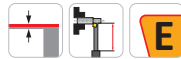
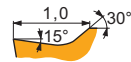
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

VCMT 160404E-FM	T9415	0.4	230	0.12	1.2	–	–	–	215	0.12	1.2	–	–	–	–	–	–	–	–
VCMT 160408E-FM	T9415	0.8	245	0.17	1.2	–	–	–	230	0.17	1.2	–	–	–	–	–	–	–	–

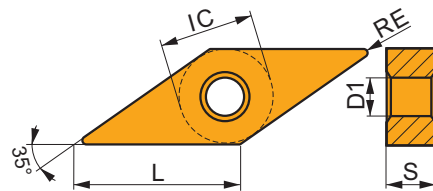


UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

VCMT 110304E-UR	T9415	0.4	210	0.12	0.8	–	–	–	195	0.12	0.8	–	–	–	–	–	–	–	–
VCMT 110308E-UR	T9415	0.8	220	0.17	0.8	–	–	–	205	0.17	0.8	–	–	–	–	–	–	–	–
VCMT 160404E-UR	T9415	0.4	200	0.12	1.2	–	–	–	190	0.12	1.2	–	–	–	–	–	–	–	–
VCMT 160408E-UR	T9415	0.8	210	0.17	1.2	–	–	–	195	0.17	1.2	–	–	–	–	–	–	–	–

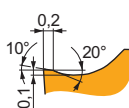
VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

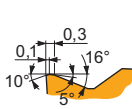


FM geometry with positive design for finish to semi-rough machining and continuous to slightly interrupted cuts.

VNMG 160404E-FM	T9415	0.4	215	0.20	1.2	–	–	–	200	0.20	1.2	–	–	–	–	–	–	–	–
VNMG 160408E-FM	T9415	0.8	255	0.20	1.4	–	–	–	240	0.20	1.4	–	–	–	–	–	–	–	–
VNMG 160412E-FM	T9415	1.2	255	0.22	1.4	–	–	–	240	0.22	1.4	–	–	–	–	–	–	–	–

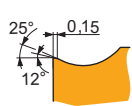
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



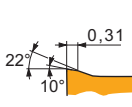
M geometry for finish to semi-rough machining and continuous to interrupted cuts.

VNMG 160404E-M	T9415	0.4	195	0.20	1.2	—	—	—	185	0.20	1.2	—	—	—	—	—	—	35	0.14	0.3
VNMG 160408E-M	T9415	0.8	200	0.30	1.4	—	—	—	190	0.30	1.4	—	—	—	—	—	—	40	0.15	0.7



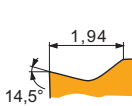
NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.

VNMG 160404E-NF	T9415	0.4	255	0.12	1.2	—	—	—	240	0.12	1.2	—	—	—	—	—	—	—	—	—
VNMG 160408E-NF	T9415	0.8	270	0.17	1.4	—	—	—	255	0.17	1.4	—	—	—	—	—	—	—	—	—



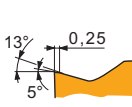
NMR geometry with positive design for medium to rough machining, and continuous cuts.

VNMG 160408E-NMR	T9415	0.8	200	0.30	1.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
------------------	-------	-----	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---



SF geometry with positive design for fine-finish machining and for machining thin walls, with continuous cuts.

VNMG 160408E-SF	T9415	0.8	255	0.17	1.4	—	—	—	240	0.17	1.4	—	—	—	—	—	—	50	0.12	0.7
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	----	------	-----



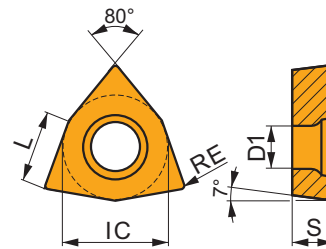
SM geometry with positive design for medium machining, and continuous to interrupted cuts.

VNMG 160404E-SM	T9415	0.4	210	0.18	1.2	—	—	—	195	0.18	1.2	—	—	—	—	—	—	40	0.13	0.3
-----------------	-------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	----	------	-----

WCMT

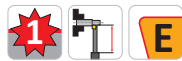
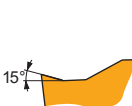
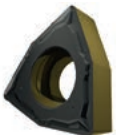


	IC (mm)	D1 (mm)	L (mm)	S (mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

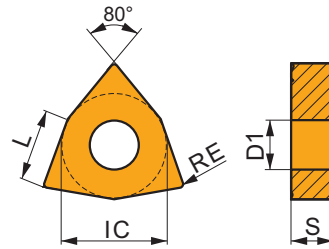


FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

WCMT 06T304E-FM	T9415	0.4	305	0.15	1.2	—	—	—	285	0.15	1.2	—	—	—	—	—	—	—	—	—
WCMT 06T308E-FM	T9415	0.8	330	0.20	1.2	—	—	—	310	0.20	1.2	—	—	—	—	—	—	—	—	—
WCMT 080408E-FM	T9415	0.8	315	0.20	1.7	—	—	—	295	0.20	1.7	—	—	—	—	—	—	—	—	—

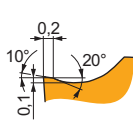
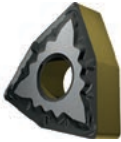
WNMG

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



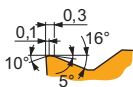
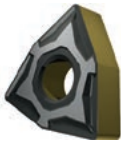
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



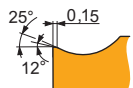
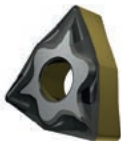
FM geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.

WNMG 060404E-FM	T9415	0.4	305	0.20	1.4	–	–	–	285	0.20	1.4	–	–	–	–	–	–	–	–
WNMG 060408E-FM	T9415	0.8	365	0.20	1.4	–	–	–	345	0.20	1.4	–	–	–	–	–	–	–	–
WNMG 060412E-FM	T9415	1.2	350	0.27	1.2	–	–	–	330	0.27	1.2	–	–	–	–	–	–	–	–
WNMG 080404E-FM	T9415	0.4	310	0.20	1.2	–	–	–	290	0.20	1.2	–	–	–	–	–	–	–	–
WNMG 080408E-FM	T9415	0.8	350	0.20	1.9	–	–	–	330	0.20	1.9	–	–	–	–	–	–	–	–
WNMG 080412E-FM	T9415	1.2	335	0.27	1.9	–	–	–	315	0.27	1.9	–	–	–	–	–	–	–	–



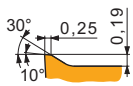
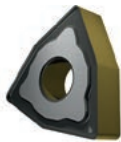
M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

WNMG 060404E-M	T9415	0.4	270	0.20	1.8	–	–	–	255	0.20	1.8	–	–	–	–	–	50	0.13	0.3
WNMG 060408E-M	T9415	0.8	275	0.32	1.8	–	–	–	260	0.32	1.8	–	–	–	–	–	55	0.16	0.7
WNMG 080404E-M	T9415	0.4	265	0.20	2.1	–	–	–	250	0.20	2.1	–	–	–	–	–	50	0.13	0.3
WNMG 080408E-M	T9415	0.8	270	0.32	2.1	–	–	–	255	0.32	2.1	–	–	–	–	–	50	0.16	0.7
WNMG 080412E-M	T9415	1.2	265	0.40	2.1	–	–	–	250	0.40	2.1	–	–	–	–	–	50	0.20	1.0



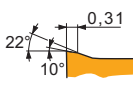
NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.

WNMG 060404E-NF	T9415	0.4	340	0.17	0.8	–	–	–	320	0.17	0.8	–	–	–	–	–	–	–	–
WNMG 060408E-NF	T9415	0.8	380	0.19	1.0	–	–	–	360	0.19	1.0	–	–	–	–	–	–	–	–
WNMG 080408E-NF	T9415	0.8	360	0.19	1.7	–	–	–	340	0.19	1.7	–	–	–	–	–	–	–	–
WNMG 080412E-NF	T9415	1.2	315	0.30	2.1	–	–	–	295	0.30	2.1	–	–	–	–	–	–	–	–



NM geometry with highly positive design for fine-finish, medium and rough machining, with continuous cuts.


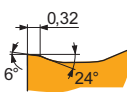

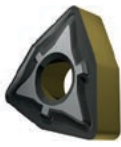
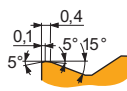

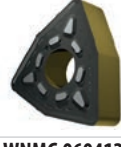
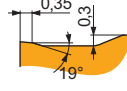

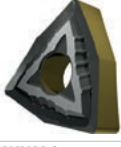
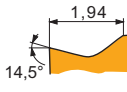

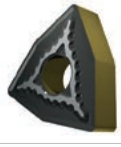
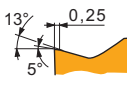

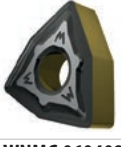
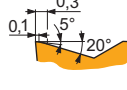

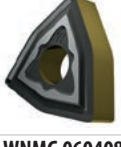
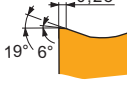

WNMG 080404E-NM	T9415	0.4	305	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NM	T9415	0.8	335	0.25	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–



NMR geometry with positive design for medium to rough machining, and continuous cuts.

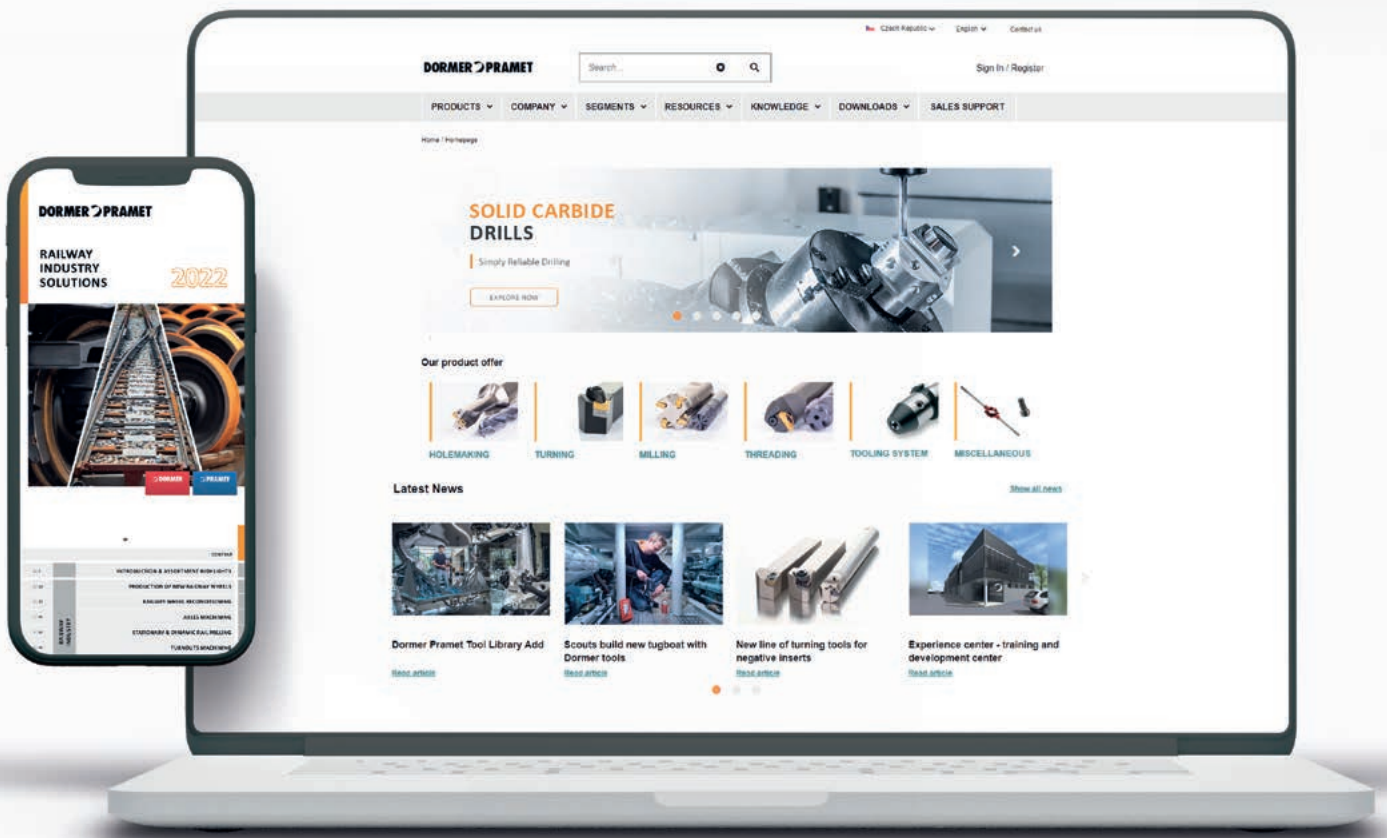
WNMG 060408E-NMR	T8430	0.8	155	0.35	2.7	85	0.32	2.7	–	–	–	–	–	–	30	0.25	2.2	–	–
WNMG 080404E-NMR	T9415	0.4	240	0.25	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080408E-NMR	T9415	0.8	255	0.35	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–
WNMG 080412E-NMR	T9415	1.2	255	0.40	2.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H			
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	
			NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.																	
WNMG 080408-NRM	T9415 0.8	255	0.35	2.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
WNMG 080412-NRM	T8430 1.2	155	0.40	2.7	85	0.36	2.7	-	-	-	-	-	30	0.28	2.2	-	-	-	-	
	T9415 1.2	255	0.40	2.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
			R geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
WNMG 080408E-R	T9415 0.8	235	0.40	3.5	-	-	-	220	0.40	3.5	-	-	-	-	-	-	45	0.20	0.7	
WNMG 080412E-R	T9415 1.2	240	0.45	3.5	-	-	-	225	0.45	3.5	-	-	-	-	-	-	45	0.23	1.0	
			RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
WNMG 060412E-RM	T9415 1.2	280	0.45	3.0	-	-	-	265	0.45	3.0	-	-	-	-	-	-	-	-	-	
WNMG 080408E-RM	T9415 0.8	265	0.40	4.0	-	-	-	250	0.40	4.0	-	-	-	-	-	-	-	-	-	
WNMG 080412E-RM	T9415 1.2	270	0.45	4.0	-	-	-	255	0.45	4.0	-	-	-	-	-	-	-	-	-	
WNMG 080416E-RM	T9415 1.6	275	0.50	4.0	-	-	-	260	0.50	4.0	-	-	-	-	-	-	-	-	-	
			SF geometry with positive design for fine-finish machining and for machining thin walls, with continuous cuts.																	
WNMG 080408E-SF	T9415 0.8	355	0.20	1.0	-	-	-	335	0.20	1.0	-	-	-	-	-	-	70	0.13	0.7	
			SM geometry with positive design for medium machining, and continuous to interrupted cuts.																	
WNMG 080404E-SM	T9415 0.4	280	0.20	2.0	-	-	-	265	0.20	2.0	-	-	-	-	-	-	55	0.13	0.3	
WNMG 080408E-SM	T9415 0.8	305	0.25	2.0	-	-	-	285	0.25	2.0	-	-	-	-	-	-	60	0.13	0.7	
WNMG 080412E-SM	T9415 1.2	300	0.30	2.0	-	-	-	285	0.30	2.0	-	-	-	-	-	-	60	0.15	1.0	
			W-M wiper geometry for semi-rough to rough machining with increased feed rates and improved surface finish.																	
WNMG 060408W-M	T9415 0.8	255	0.45	1.2	-	-	-	240	0.45	1.2	-	-	-	-	-	-	-	-	-	
WNMG 060412W-M	T9415 1.2	250	0.55	1.2	-	-	-	235	0.55	1.2	-	-	-	-	-	-	-	-	-	
WNMG 080408W-M	T9415 0.8	245	0.45	1.5	-	-	-	230	0.45	1.5	-	-	-	-	-	-	-	-	-	
			W-MR wiper geometry for finish to rough machining with increased feed rates and improved surface finish.																	
WNMG 060408W-MR	T9415 0.8	255	0.45	1.2	-	-	-	240	0.45	1.2	-	-	-	-	-	-	-	-	-	
WNMG 080404W-MR	T9415 0.4	240	0.30	1.5	-	-	-	225	0.30	1.5	-	-	-	-	-	-	-	-	-	
WNMG 080408W-MR	T9415 0.8	245	0.45	1.5	-	-	-	230	0.45	1.5	-	-	-	-	-	-	-	-	-	
WNMG 080412W-MR	T9415 1.2	245	0.55	1.5	-	-	-	230	0.55	1.5	-	-	-	-	-	-	-	-	-	



HAVE YOU TRIED OUR NEW LOOK E-SHOP?



SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

DORMER PRAMET

www.dormerpramet.com



**CONTACTS TO LOCAL
SALES SUPPORT
ALWAYS UP TO DATE!**



DP-BRO-T9415-EN

FOLLOW US...



ONLINE



SEGMENTS



LIBRARY APP.



CALCULATOR APP.

