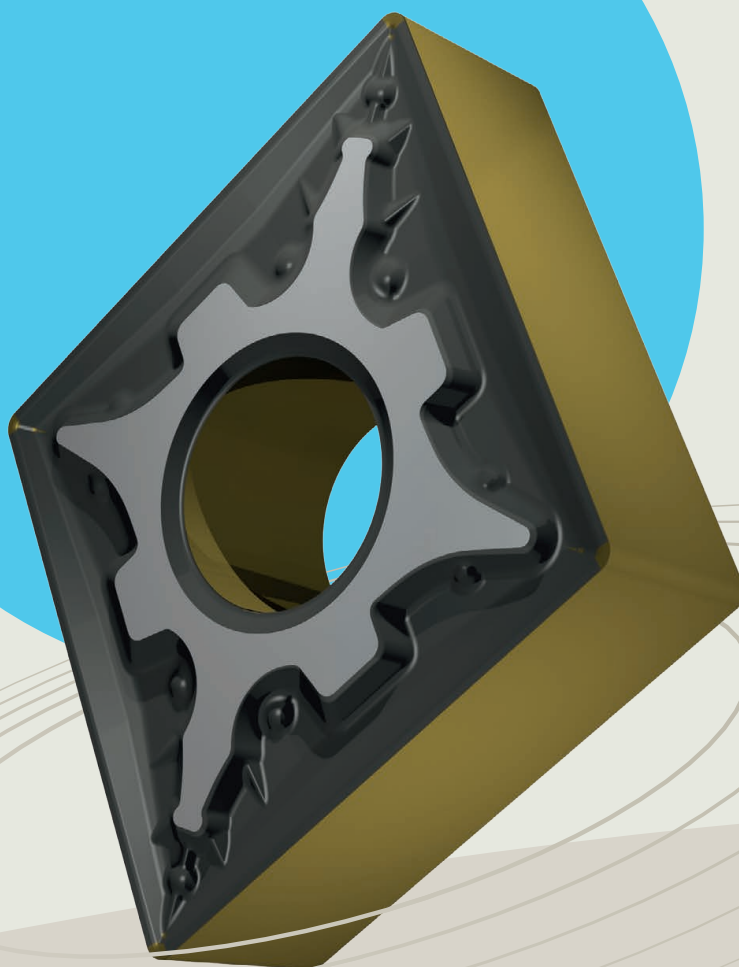




T9425 grade

New versatile grade for turning of steels



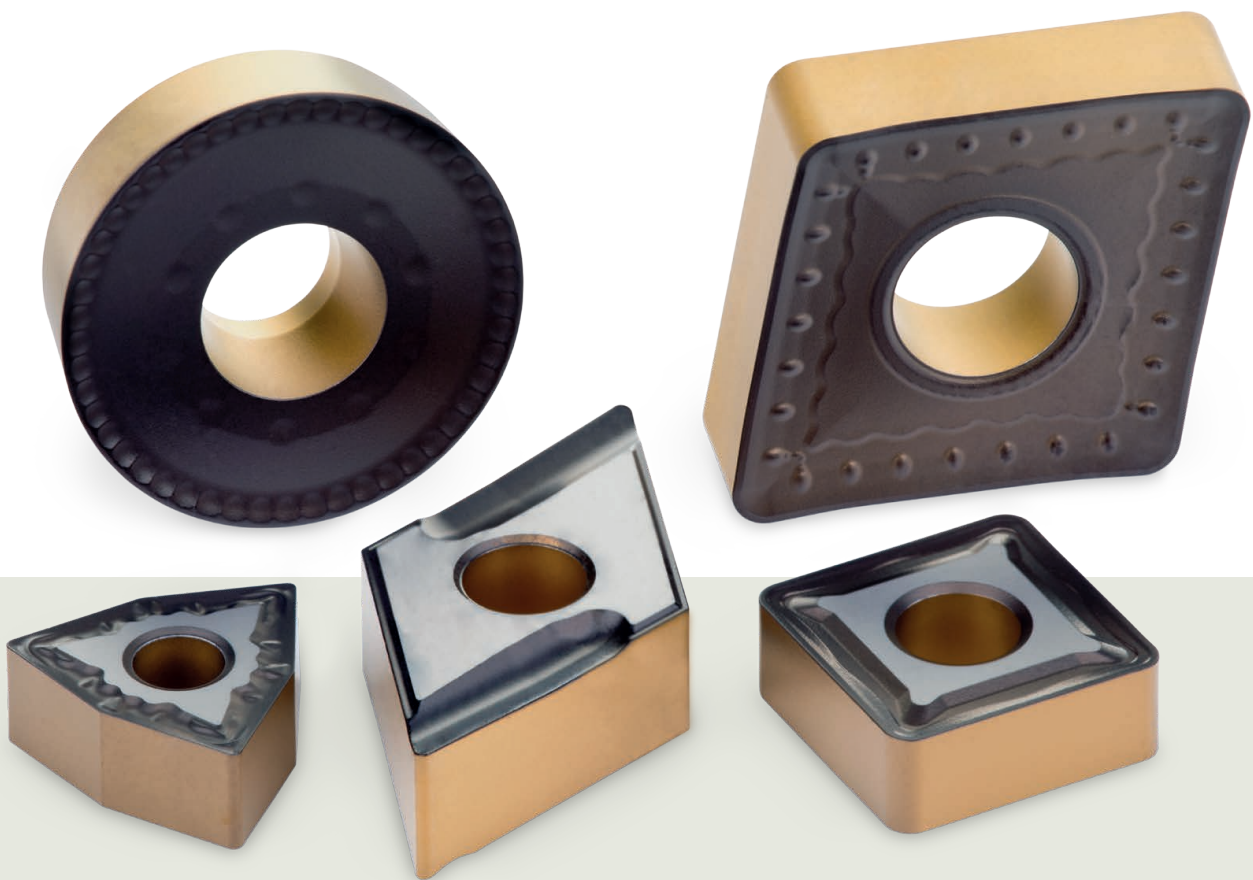
**Certainty
at every turn™**





New versatile grade for turning of steels

Maximize tool life and process stability in challenging conditions

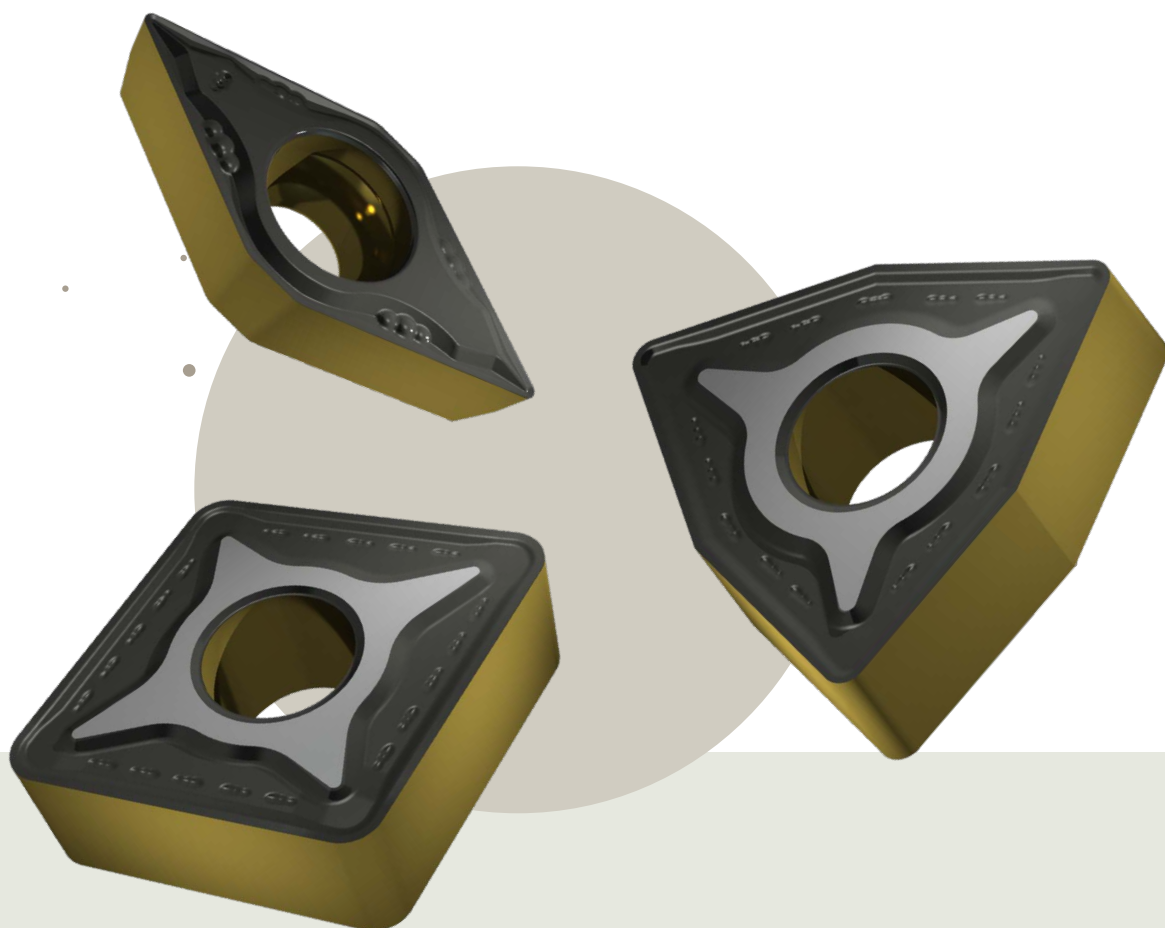


The new T9425 turning grade features a functional gradient substrate and advanced MT-CVD coating for exceptional performance and wear resistance. Its highly textured $\alpha\text{-Al}_2\text{O}_3$ layer ensures consistent results in continuous cuts, while post-treatment enhances tool life under unstable conditions.

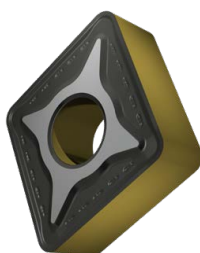
Golden TiN-coated flanks improve wear detection and reduce downtime, making the T9425 a reliable choice for steel (P), stainless steel (M), and optionally for cast iron (K) applications.



Related products



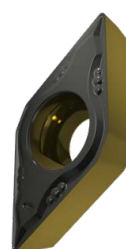
T9425



Negative inserts

Steel (P), stainless steel (M),
and cast iron (K) applications

T9425



Positive inserts

Steel (P), stainless steel (M),
and cast iron (K) applications



T9425 grade

Features & benefits

The highly textured $\alpha\text{-Al}_2\text{O}_3$ coating provides superior wear resistance and thermal stability.



Excellent tool life

and increased productivity.

New post-treatment process improves stability of cutting edge.



Outstanding reliability

especially in unstable machining conditions.

Hard functionally gradient substrate.



Enhanced durability

in continuous and demanding cutting conditions.

Gold colored TiN coating on flanks helps with monitoring tool condition effectively.



Easier wear detection

reduces downtime.

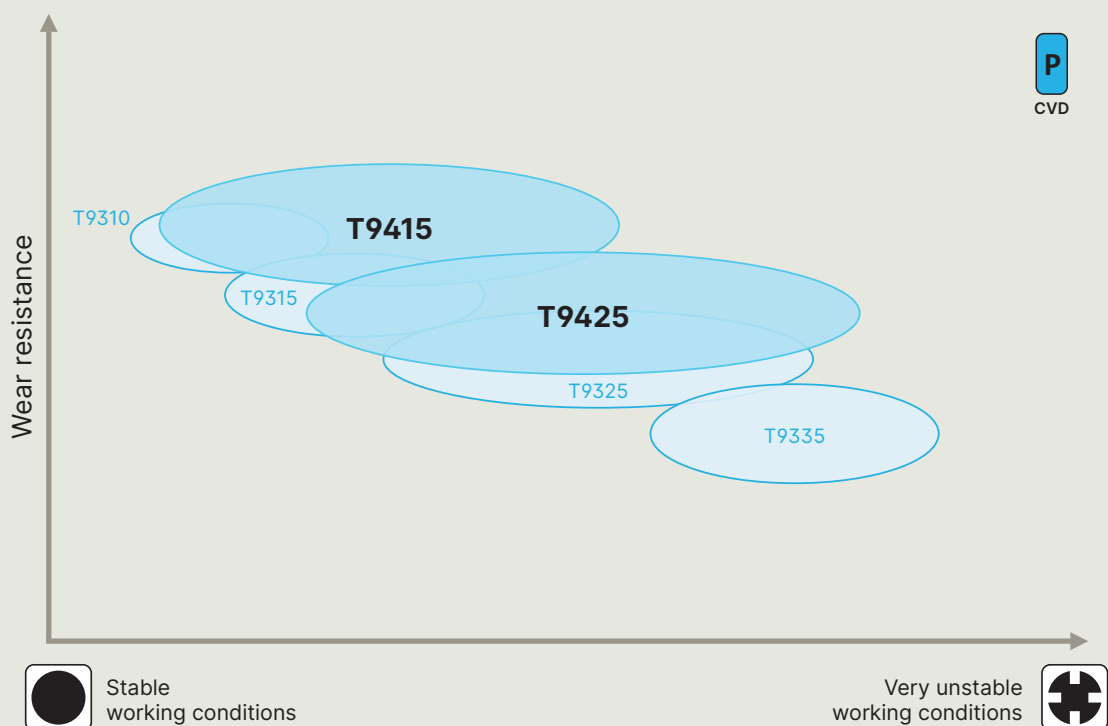
Ground seating face after coating.



Improved heat transfer

provides better stability and extends tool life.

Application area of T9425 turning grades





Grade composition

Advanced grade design for unmatched durability and reliability

Ground seating face

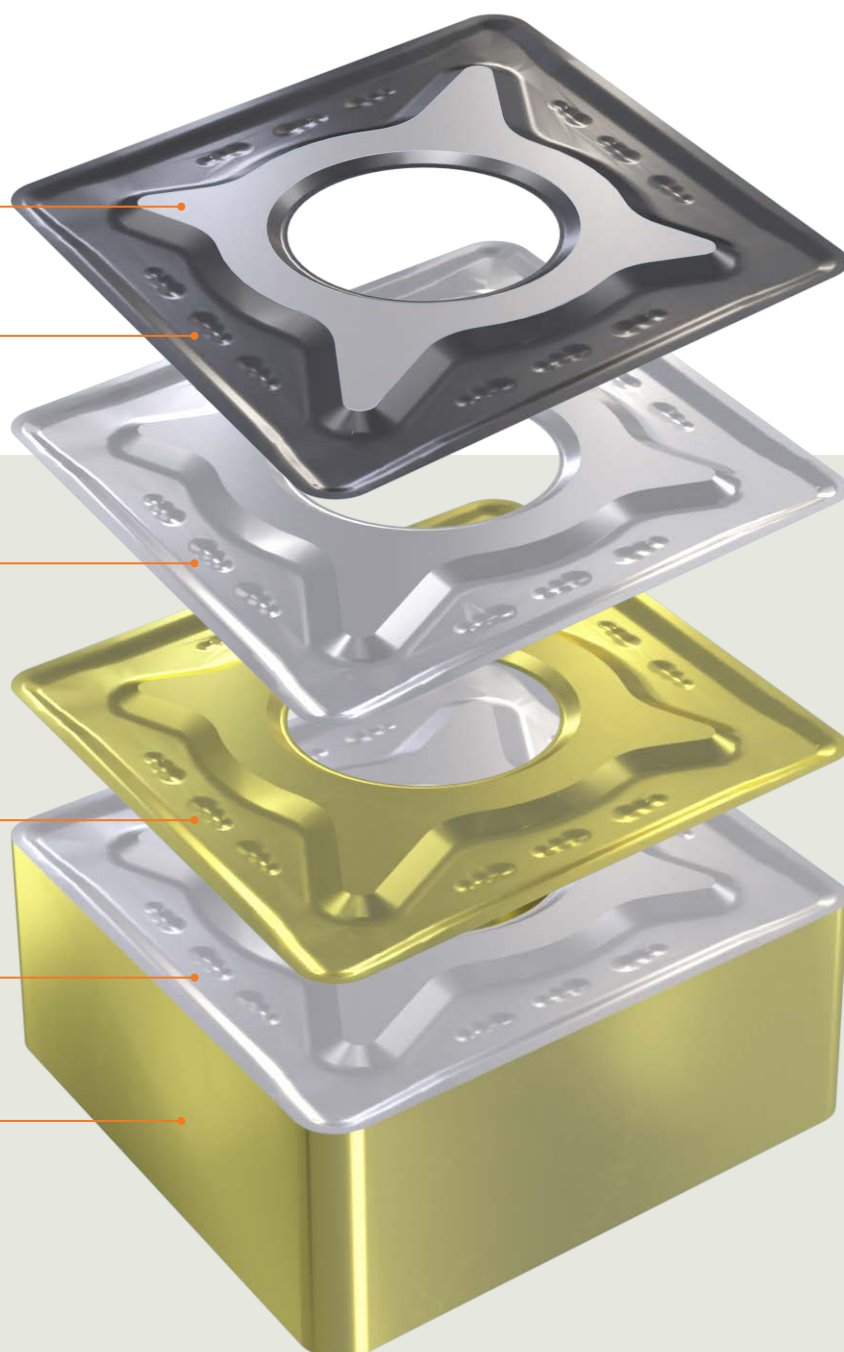
Highly textured and
heat resistant α -Al₂O₃ layer

Abrasion resistant TiCN layer

Adhesive TiN layer

Functional gradient substrate

Gold colored TiN layer





Success stories

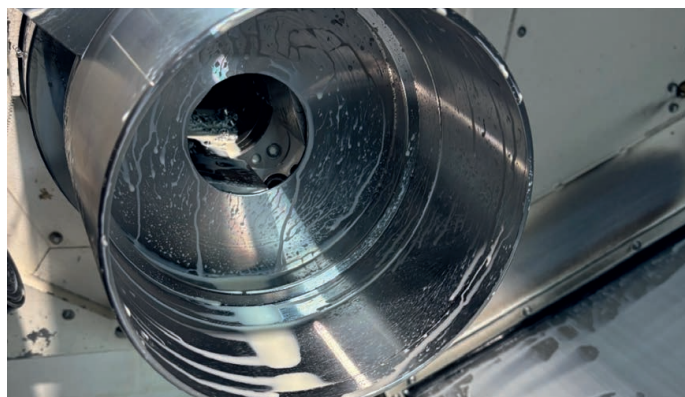
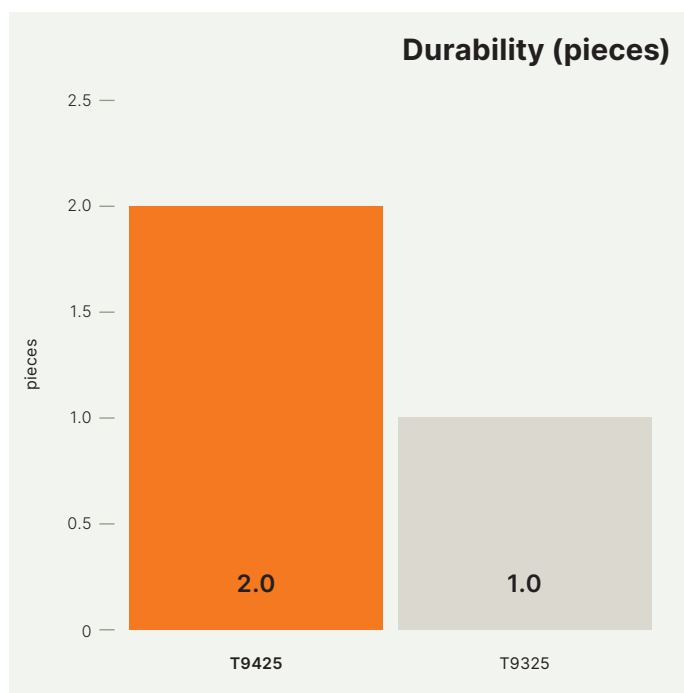
Double the tool life for continuous cutting applications

Customer result: The T9425 grade delivered a 100% improvement in tool life, setting a new benchmark for durability in continuous cutting operations. By reducing the need for frequent tool changes and minimizing downtime, the T9425 ensures uninterrupted machining cycles. Its ability to handle challenging conditions makes it the perfect solution for high-precision automotive applications, combining efficiency with consistent, high-quality results.

Segment	Automotive
Component	Periphery carrier
Application	Turning
Material	42CrMo4+QT
Coolant	Yes
Dormer Pramet solution	WNMG 080408E-RM:T9425

Machining data		
v_c	f_n	a_p
180	0.3	3.0

P3.3





Success stories

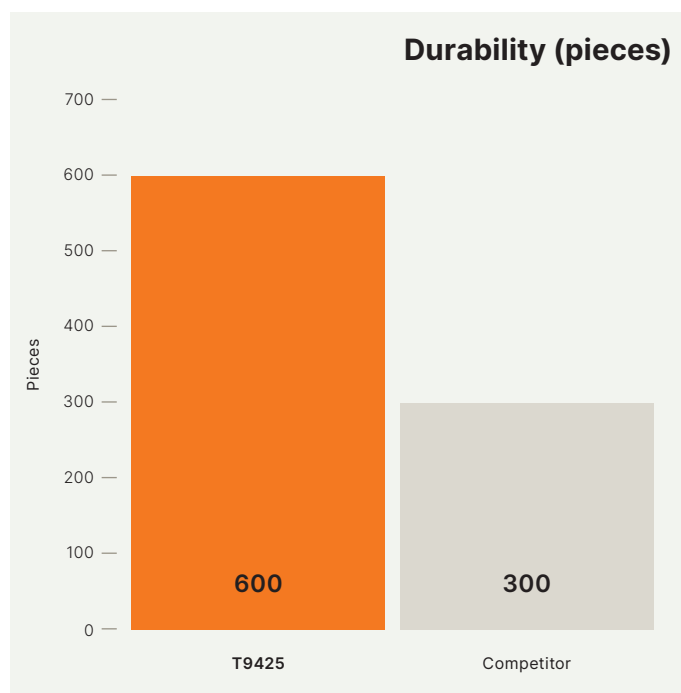
Achieve 100% tool life improvement

Customer result: The T9425 redefined expectations in automotive machining with a 100% improvement in tool life compared to the competitor. Producing up to 600 parts per tool, the grade significantly reduces costs and downtimes.

Its advanced performance enables extended machining cycles while maintaining consistent, high-quality results, setting a new benchmark.

Segment	Automotive
Component	Outer case of shock absorber
Application	Turning
Material	C45
Coolant	No
Dormer Pramet solution	WNMG 08408E-RM:T9425

Machining data		
v_c	f_n	a_p
270	0.35	0.775

P3.3



Success stories

Achieve 43% higher durability in interrupted cuts

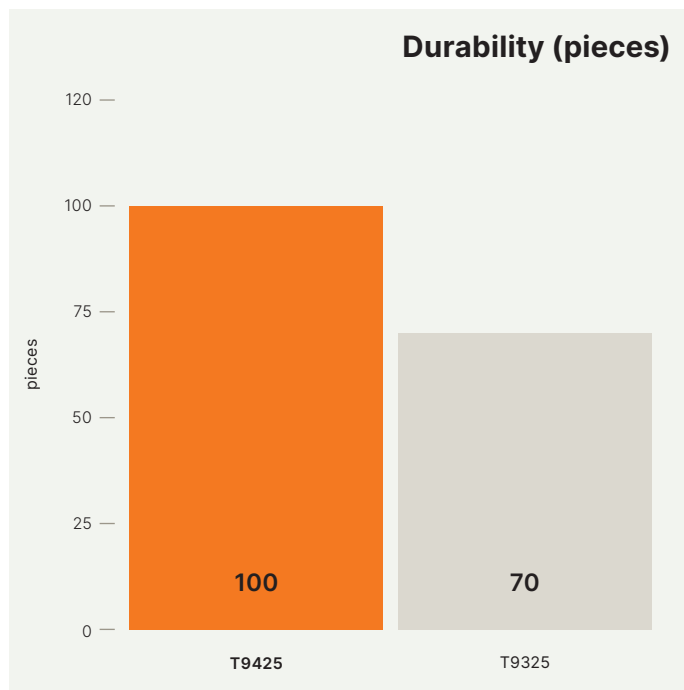
Customer result: With its advanced coating and post-treatment, the T9425 delivered a 43% increase in tool life compared to the T9315 grade.

This improvement allows for significantly fewer disruptions, longer cycles, and higher reliability in demanding machining scenarios.

Segment	General engineering
Component	Flange
Application	Interrupted turning
Material	17NiCrMo6 (HB 180–260)
Coolant	Yes
Dormer Pramet solution	CNMG 120408E-M:T9425

Machining data		
v_c	f_n	a_p
200	0.25	1.5

P3.2





Success stories

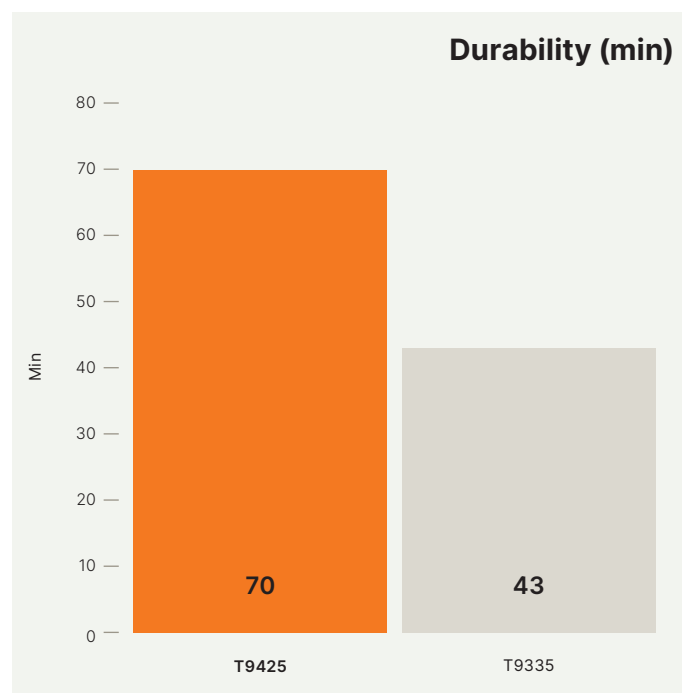
Improve performance by 63% in agricultural machining

Customer result: The T9425 grade delivered a 63% increase in tool life, demonstrating its effectiveness in agricultural machining tasks. By consistently producing 70 parts per tool compared to 43 with its predecessor the T9425 sets a new standard for durability and reliability. Its ability to maintain precision while reducing downtime makes it ideal for demanding agricultural manufacturing environments.

Segment	Agriculture
Component	Disc ring
Application	Turning
Material	42CrMo
Coolant	Yes
Dormer Pramet solution	CNMG 120408E-M:T9425

Machining data		
v_c	f_n	a_p
120	0.3	2.5

P3.3



v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)



Success stories

Boost durability by **112.5%** in roughing operations

Customer result: In roughing applications, the T9425 outperformed its predecessor by delivering an 112.5% improvement in tool life. Its ability to handle challenging environments with prolonged durability ensures fewer replacements and consistent machining. This makes the T9425 the go-to choice for steel applications where reliability and cost-efficiency are key priorities.

Increase tool life by **80%** in high-volume turning

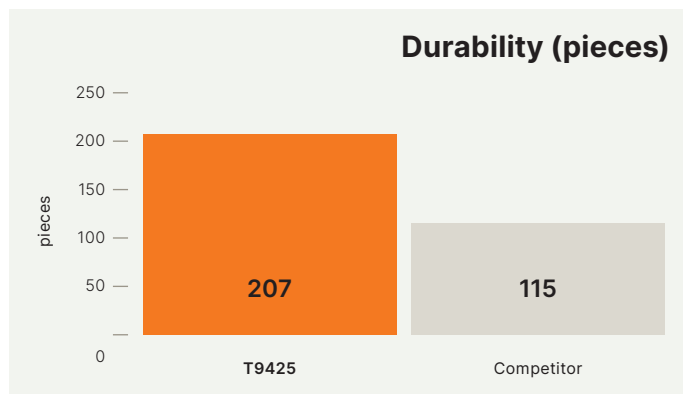
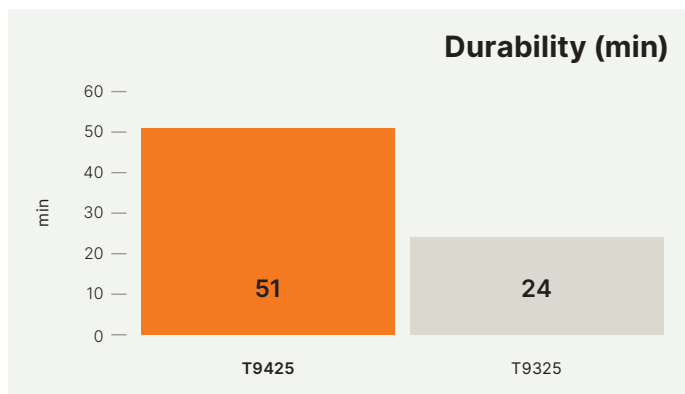
Customer result: The T9425 extended tool life by 80% compared to a competitor, producing 207 parts per tool during testing. This exceptional performance allows manufacturers to reduce tool changes and extend machining cycles. This way, the T9425 supports cost savings and ensures a smoother production process for large-scale operations.

Segment	Energy
Component	Shaft
Application	Turning
Material	42CrMo (HRC 28–32)
Coolant	Yes
Dormer Pramet solution	CNMM 190616E-OR:T9425

Segment	General engineering
Component	Pin
Application	Turning
Material	42CrMo
Coolant	Yes
Dormer Pramet solution	CNMM 120408E-SM:T9425

Machining data			P3.3
v_c	f_n	a_p	
72	0.5	5.0	

Machining data			P3.2
v_c	f_n	a_p	
200	0.3	2.5	





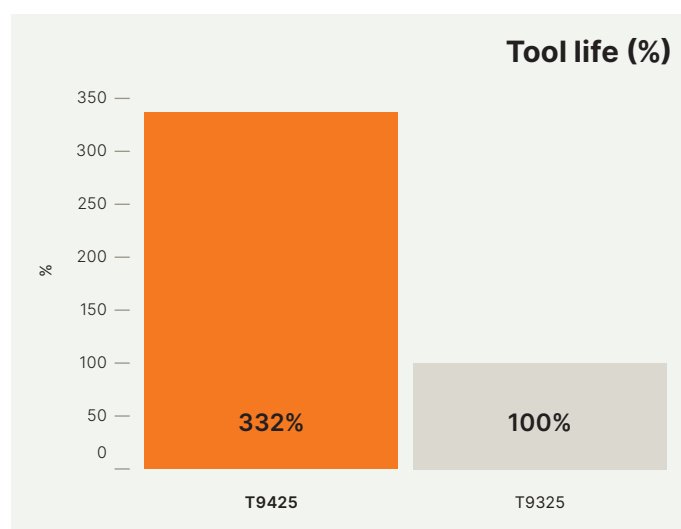
Machining examples

Increase tool life by 232% in dry turning operations

The new T9425 grade demonstrated superior performance in dry turning of C45 steel, increasing tool life by 232% compared to the T9325 grade. This improvement minimizes the need for tool changes, directly reducing downtime and overall production costs.

Application	Turning
Material	C45
Coolant	No
Dormer Pramet solution	CNMG 120408E-SM:T9425

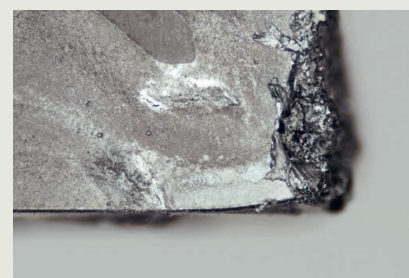
Machining data		
v_c	f_n	a_p
315	0.25	2.0

P2.1**T9425**

Photos taken after 50 minutes

T9425

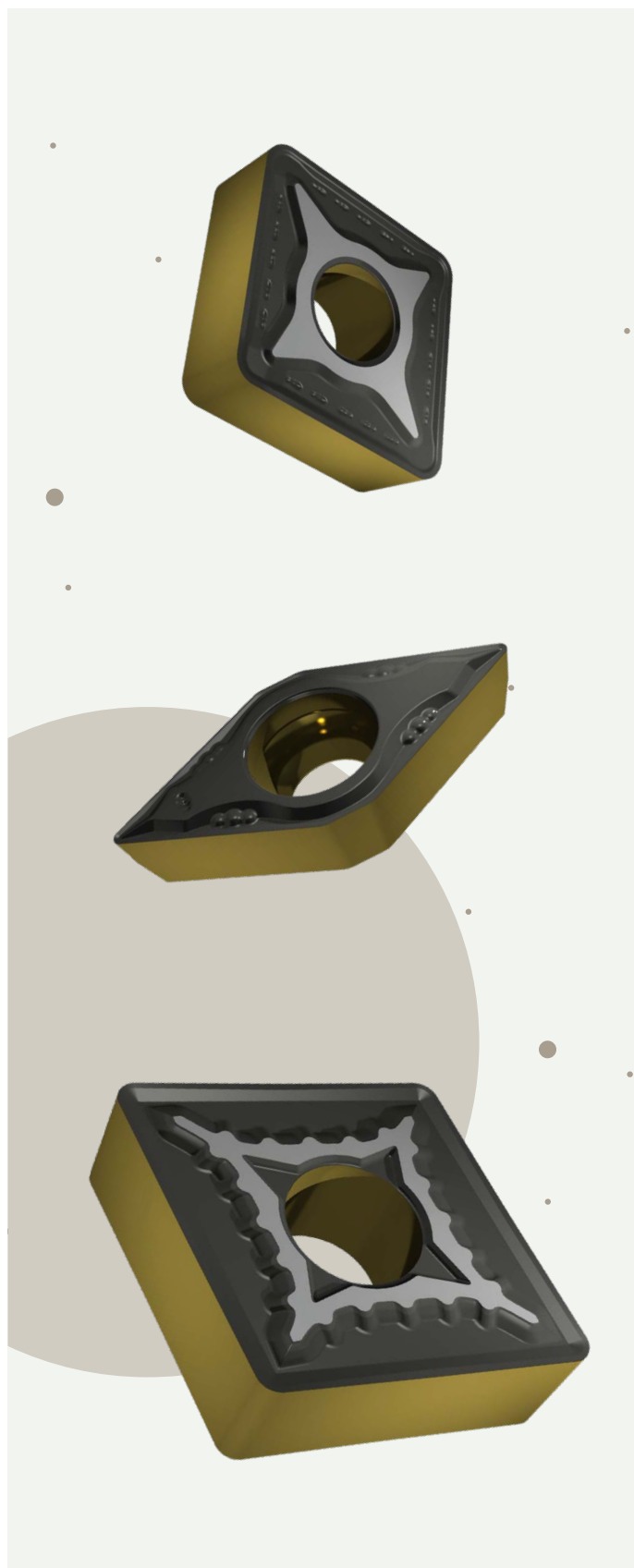
Photos taken after 15 minutes

T9325

Photos taken after 15 minutes



Machining examples



Exceptional durability in interrupted cutting operations

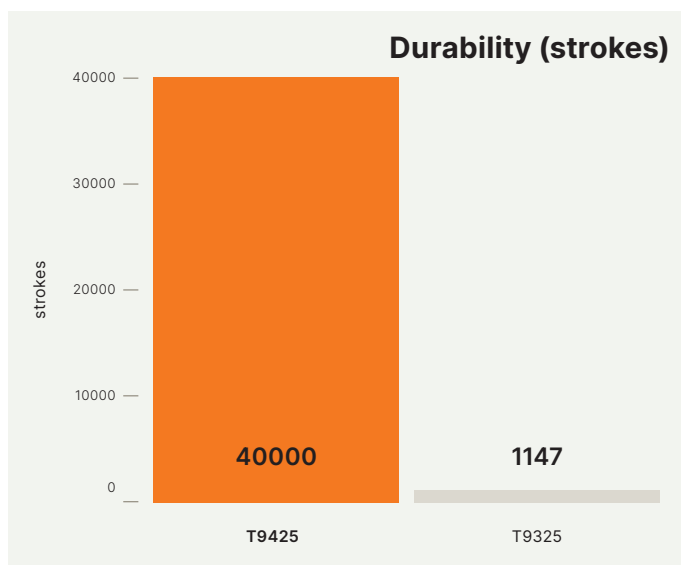
Thanks to a new post-treatment, the T9425 delivered exceptional performance in interrupted cutting applications. This significant improvement enables extended tool life and reduced downtime in challenging machining conditions.

Each T9425 insert reached the high criteria for interrupted cutting applications, which makes this grade extremely reliable.

Application	Interrupted cutting
Material	41Cr4
Coolant	No
Dormer Pramet solution	CNMG 120408E-SM:T9425

Machining data		
v_c	f_n	a_p
130	0.3	1.0

P2.1





Technical information

T9425 application range and material compatibility

Grade identification	Area of application	Application	Feed	Cutting speed	Resistance to adverse working conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T9425	P10 - P35	■				MT-CVD		FGM	++	This is a load-bearing and very versatile material, designed primarily for roughing, semi-roughing and finishing turning of common carbon and alloy steels. It is characterized by very good resistance in adverse cutting conditions, while maintaining very good wear resistance. It is suitable for work with medium to high removal rates. The focus of the application area of these materials is in the area of medium and higher cutting speeds.
	M10 - M30	■								
	K15 - K35	■								
	S10 - S20	■								

Recommended grades by ISO material group

Group	Cemented carbide with MTCVD	Cemented carbide with PVD	Uncoated carbide	CERMET
P01				
P05				
P10	T9415			TT010
P15		T8415		
P20	T9425			TT310
P25		T8430		
P30				
P35				
P40				
P45				
P50				

Group	Cemented carbide with MTCVD	Cemented carbide with PVD	Uncoated carbide	CERMET
M01				
M05				
M10				
M15	T7325	T8415		
M20				
M25	T7335	T8430		
M30	T9425			
M35				
M40				
M45				
M50				

Group	Cemented carbide with MTCVD	Cemented carbide with PVD	Uncoated carbide	CERMET
K01				
K05	T5405			TC100
K10		T8415		
K15	T5415		HF7	
K20				
K25	T9425	T8430		
K30				
K35				
K40				
K45				
K50				

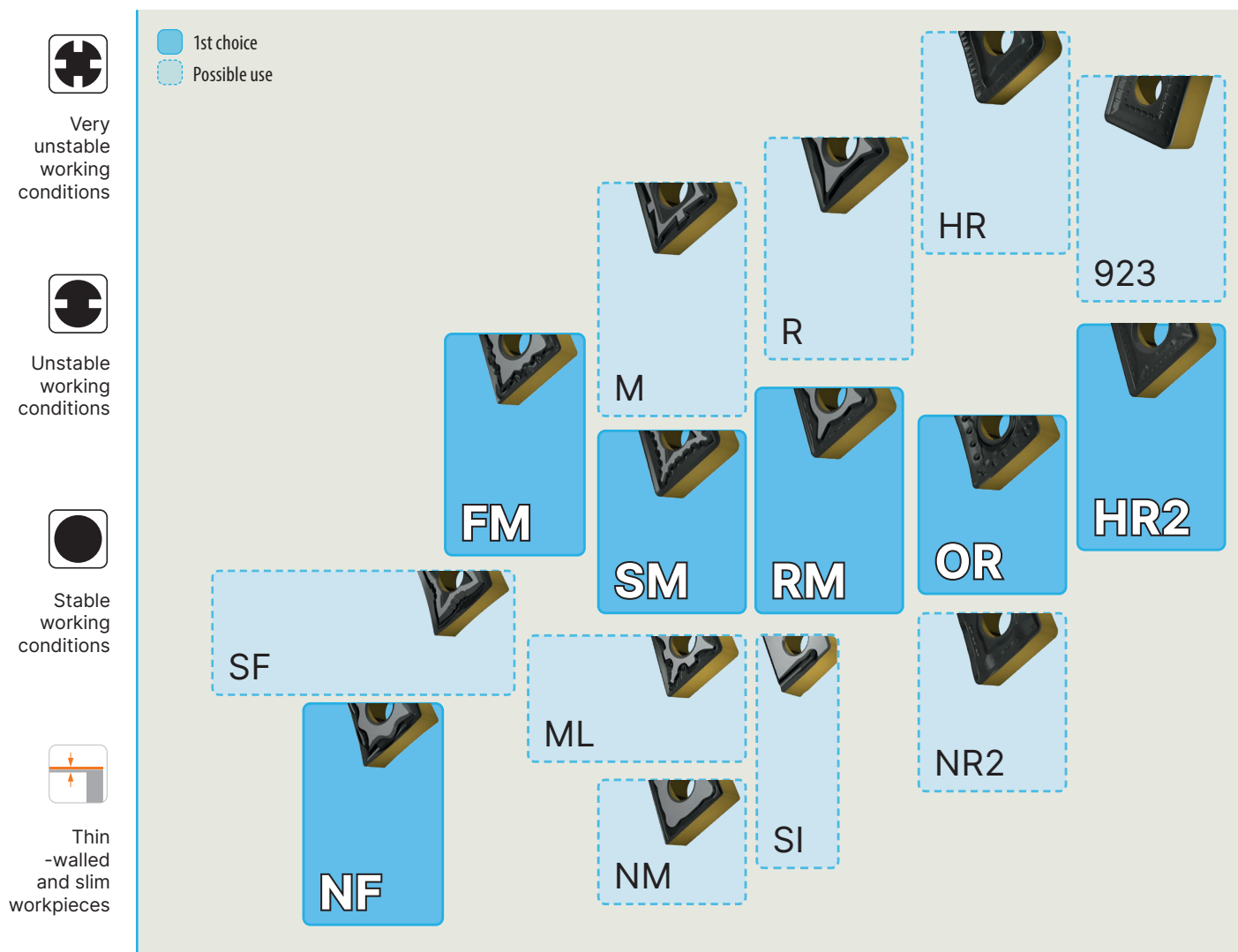


T9425 grade

Technical information

Chipbreakers for negative T9425 inserts

P

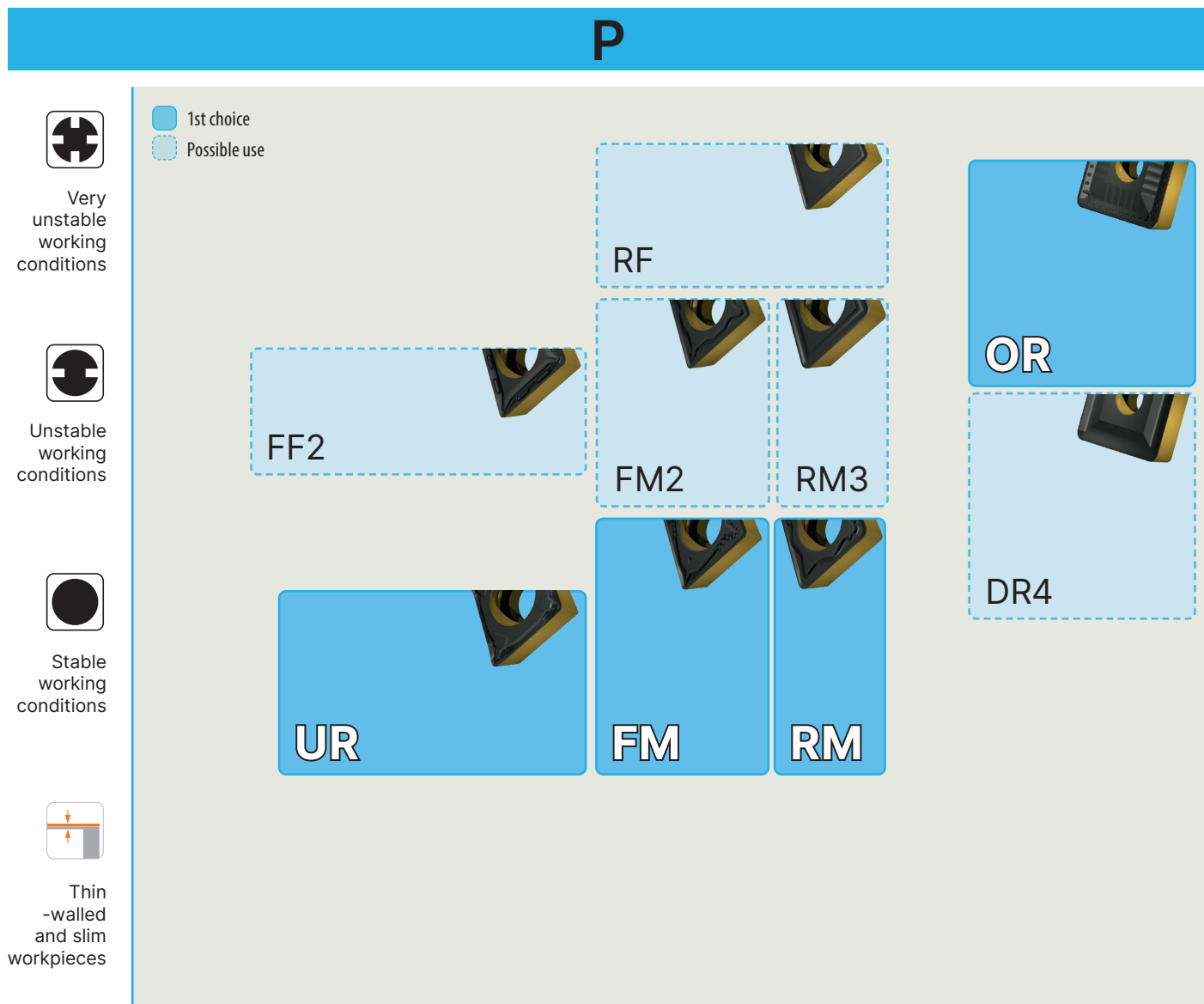


					
	0.05 – 0.2 mm/rev		0.2 – 0.4 mm/rev		> 1.0 mm/rev
	0.05 – 2 mm		2 – 4 mm		> 10 mm

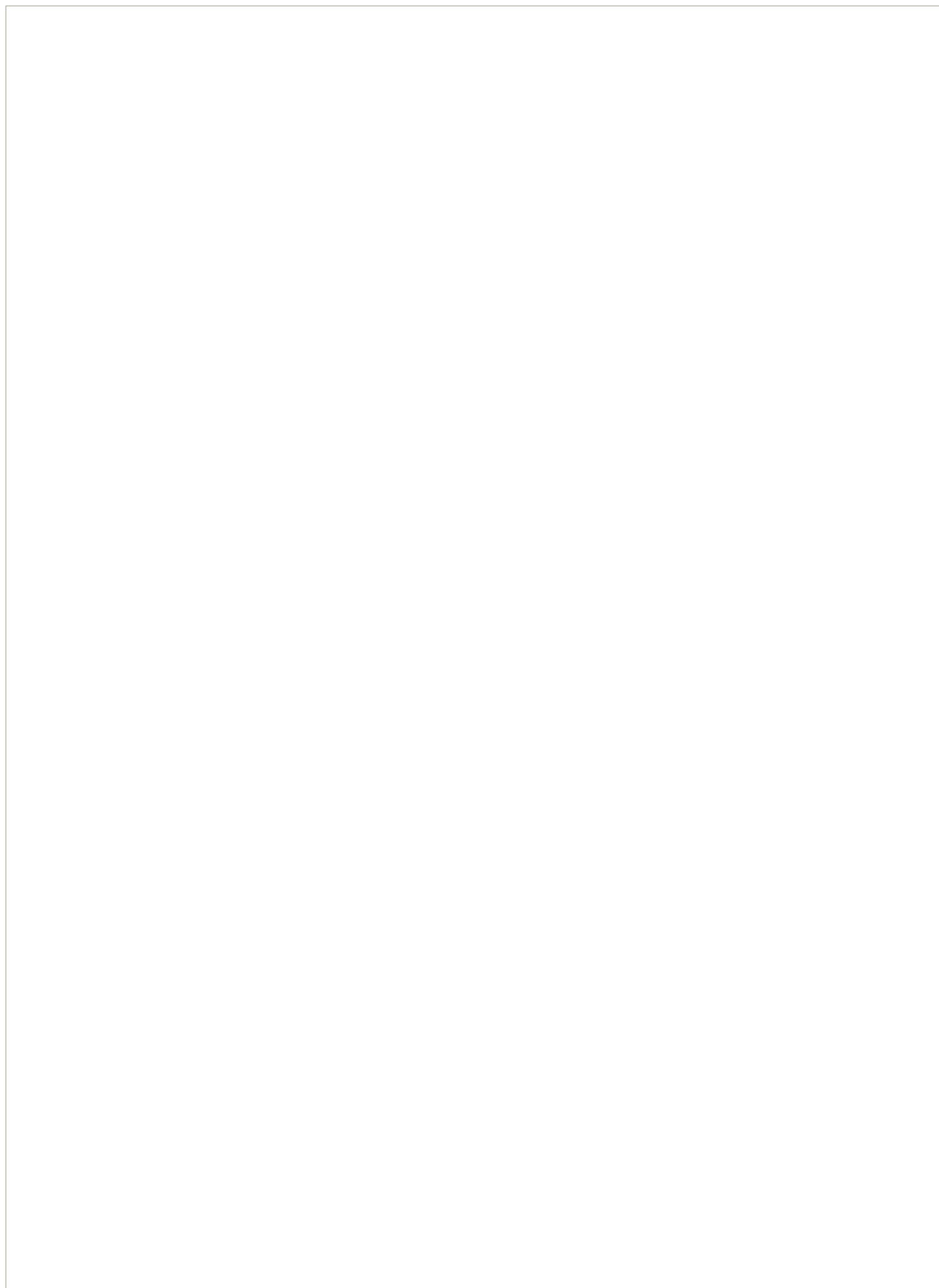


Technical information

Chipbreakers for positive T9425 inserts

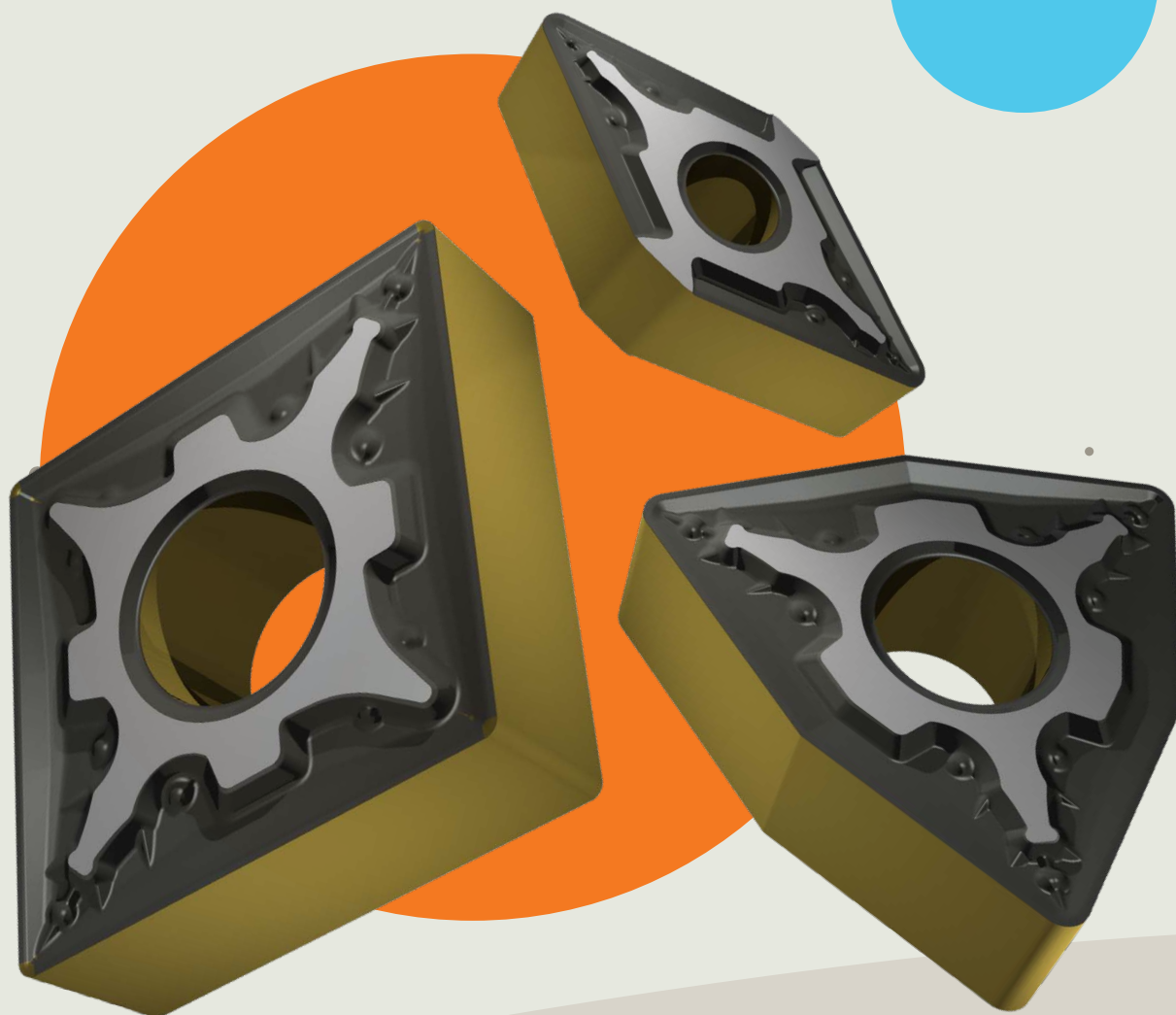


	FF	F	M	R	HR
	0.05 – 0.2 mm/rev		0.2 – 0.4 mm/rev		> 1.0 mm/rev
	0.05 – 2 mm		2 – 4 mm		> 10 mm



ML chipbreaker

New chipbreaker for turning of steels



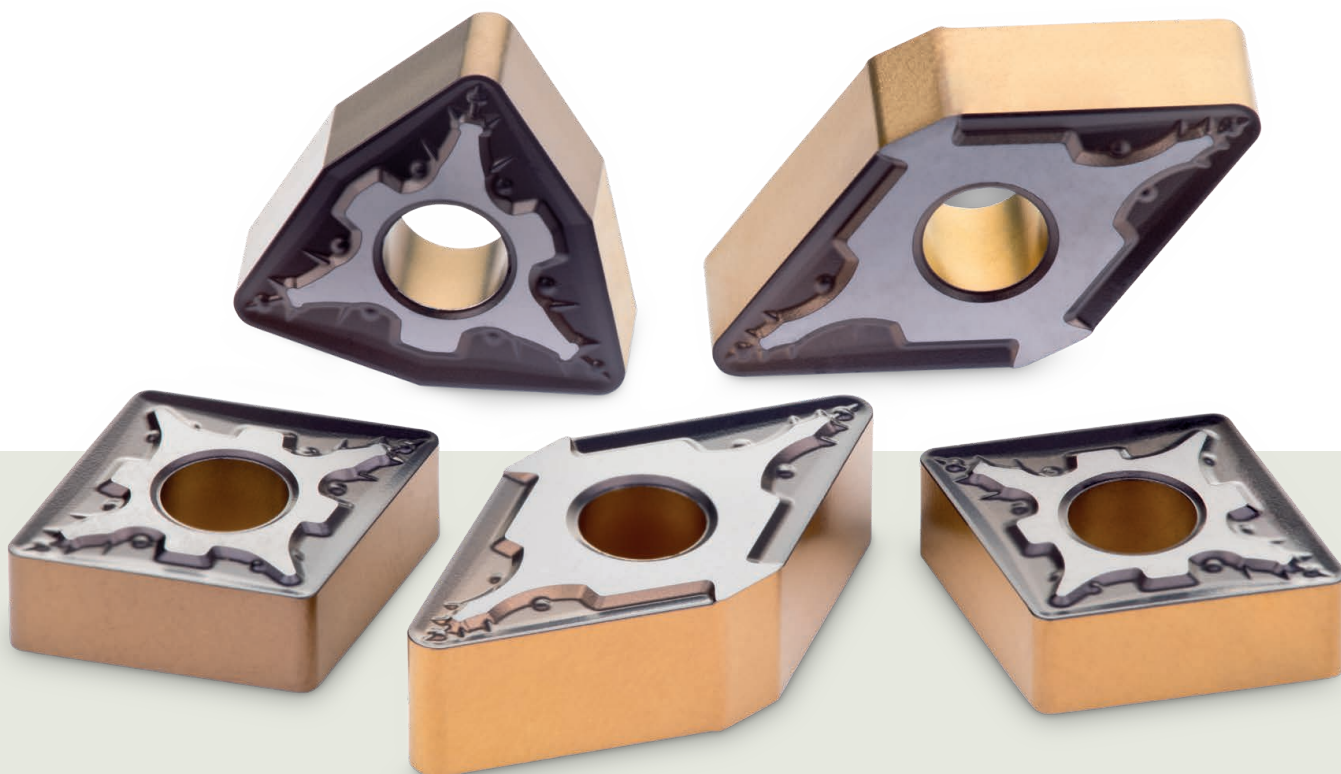
**Certainty
at every turnTM**





New chipbreaker for turning of steels

Boost your turning performance



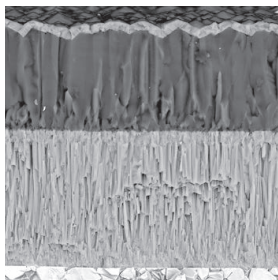
The new ML chipbreaker is engineered for medium applications in steels, offering superior performance in low depths of cut and medium to high feeds. Its specially developed geometry ensures efficient chip control and consistent, smooth machining.

Available with both the new T9425 grade as well as T9415, the ML chipbreaker provides maximum stability, high productivity and reliable performance – ideally suited for bearing, automotive and general engineering applications.



Related products

T9415

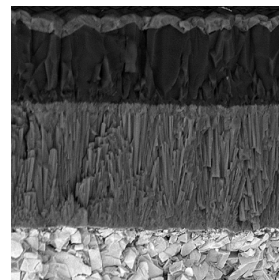


MT-CVD grade

Abrasion + heat resistant α -Al₂O₃ layer

Top TiN coating on flanks

T9425

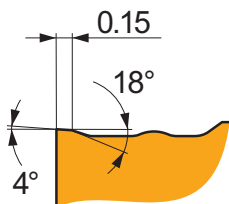


MT-CVD grade

Highly textured α -Al₂O₃ layer

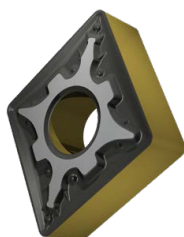
Top TiN coating on flanks

ML



ML chip breaker is versatile and designed for low depth of cut and medium machining of steels. It features positive rake angle and stable, narrow T-land. It's also suitable for cast irons.

CNMG-ML

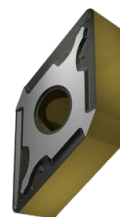


Productive insert

For steels

Medium to semi-rough cuts

DNMG-ML

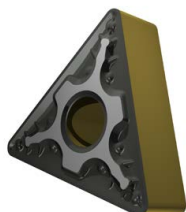


Versatile insert

For steels

Light to medium cuts

TNMG-ML

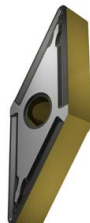


Versatile insert

For steels

Light to medium cuts

VNMG-ML

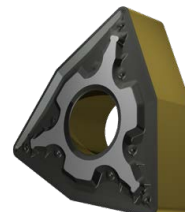


Versatile insert

For steels

Light cuts

WNMG-ML



Economical insert

For steels

Medium to semi-rough cuts



Features & benefits

Specially designed geometry enables efficient chip breaking for low depths of cut.

→ **Improved process reliability and increased tool life**
reduce machine downtime.

Stable T-land ensures smooth machining in medium to high feeds.

→ **Reliable performance**
ensures high-quality results in demanding conditions.

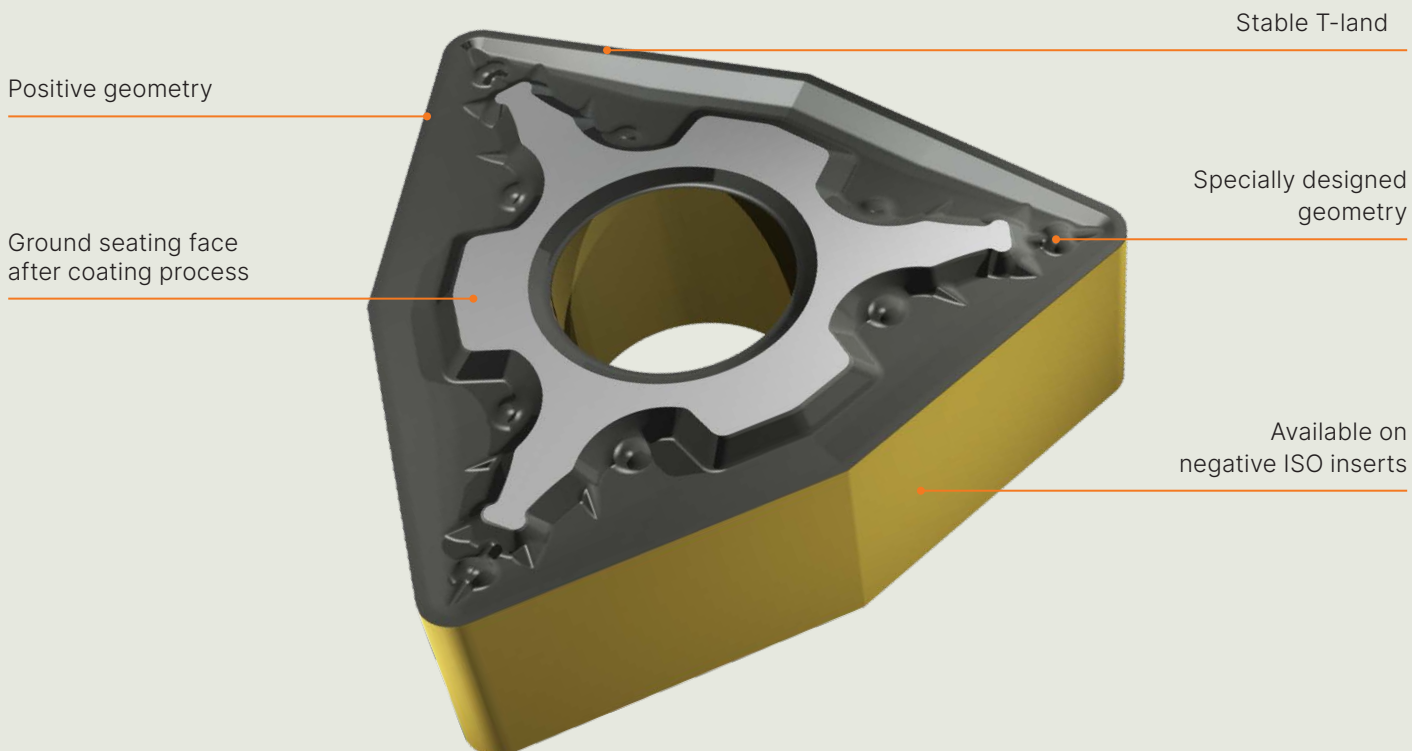
Ground seating face after coating process delivers enhanced stability in the holder.

→ **Consistent results**
ensures predictability in every cut.

Available in the latest state of art CVD grades T9425 and T9415.

→ **Enhanced durability**
boosts productivity.

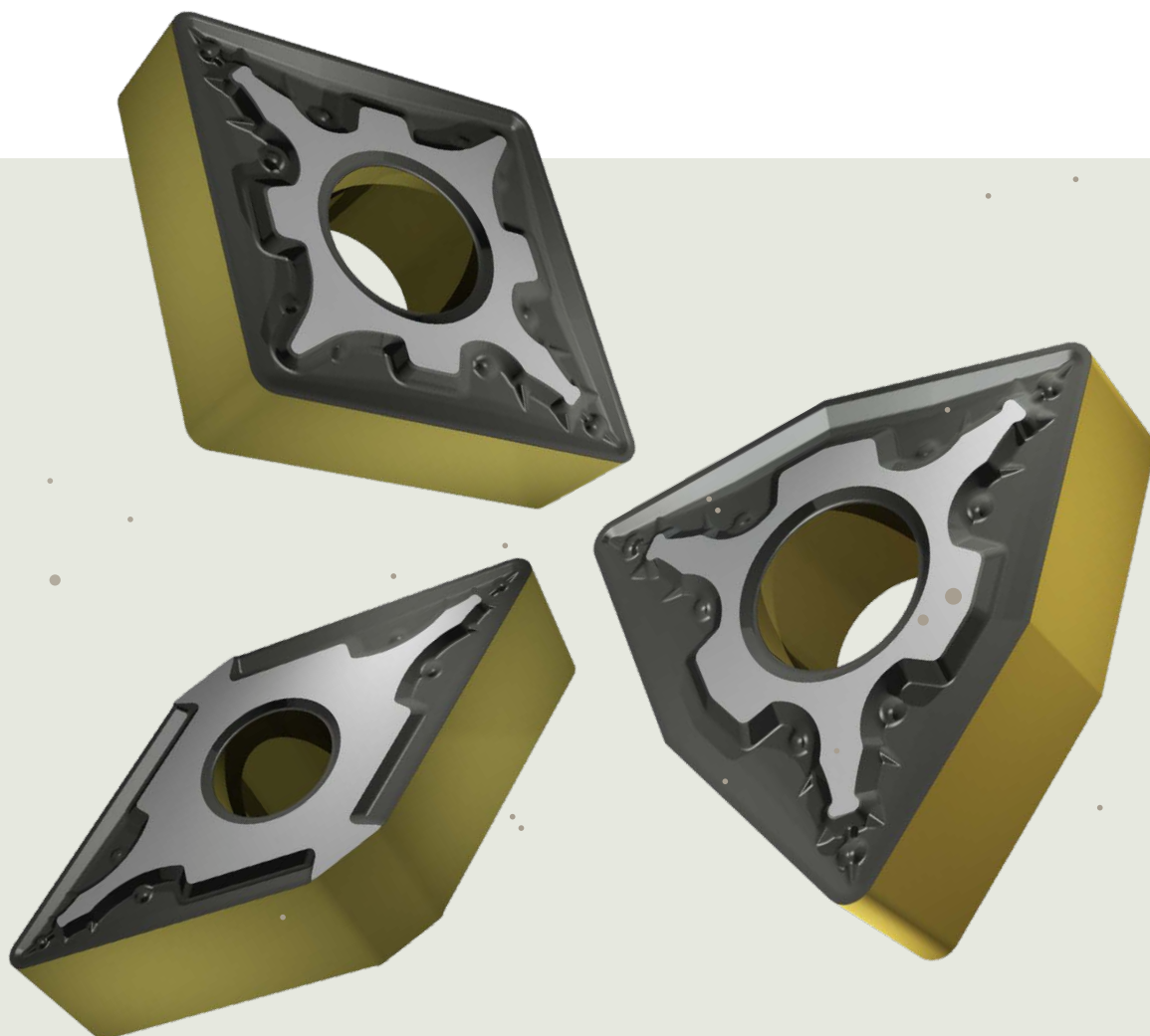
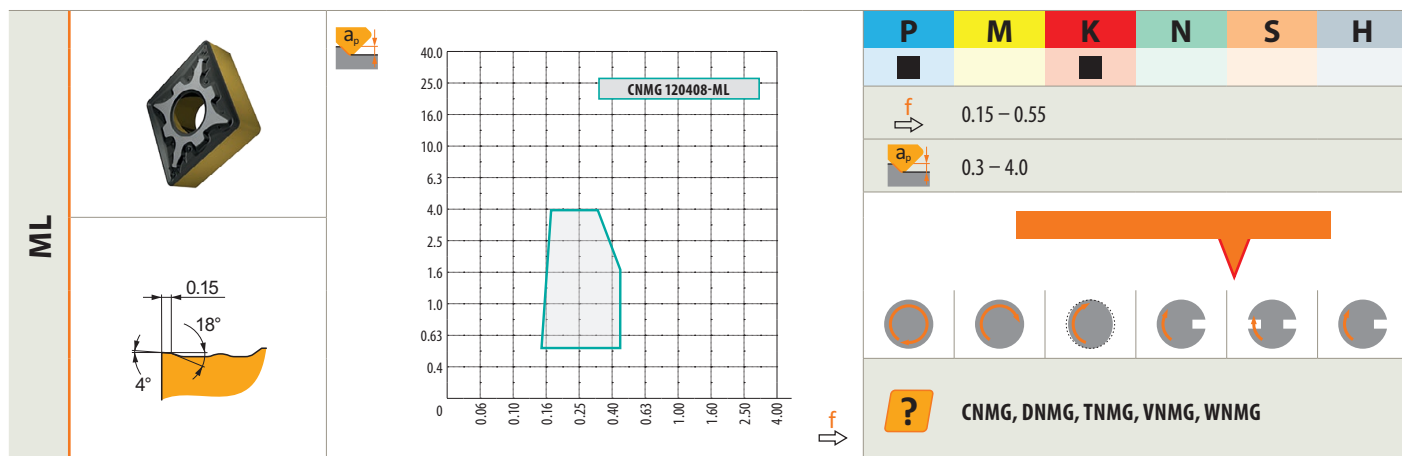
High performance and productivity in ISO-P turning





Technical information

ML chipbreaker application range and material compatibility





Success stories

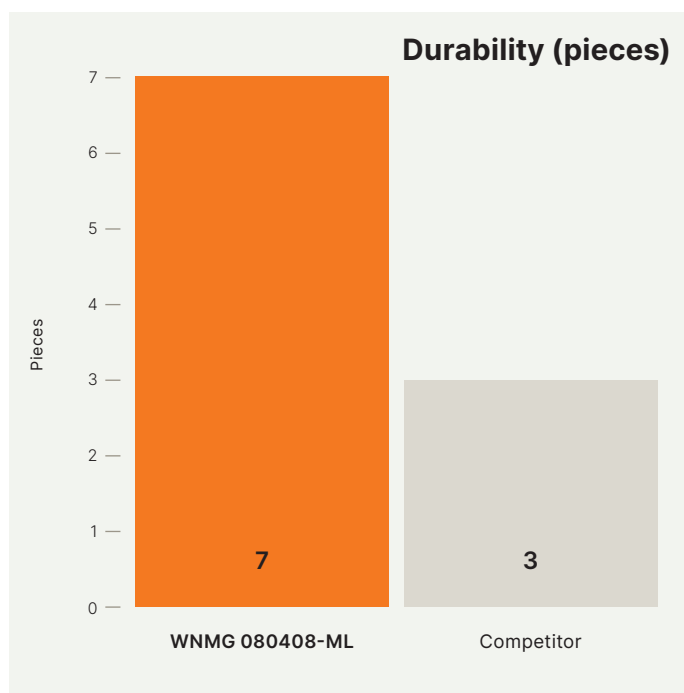
Enhance tool life by 133% for hardened steel turning

Customer result: The ML chipbreaker achieved 7 pieces per edge compared to 3 with the competitor in rough turning of hardened railway flanges. The ML geometry provided lower cutting forces and superior tool life, delivering a 133% improvement while maintaining full productivity.

Segment	Railway
Application	Rough turning
Component	Flange
Material	42CrMo4 (HRC40)
Coolant	Yes
Dormer Pramet solution	WNMG 080408-ML

Machining data		
v_c	f_n	a_p
297	0.3	2.0

P3.3





Success stories

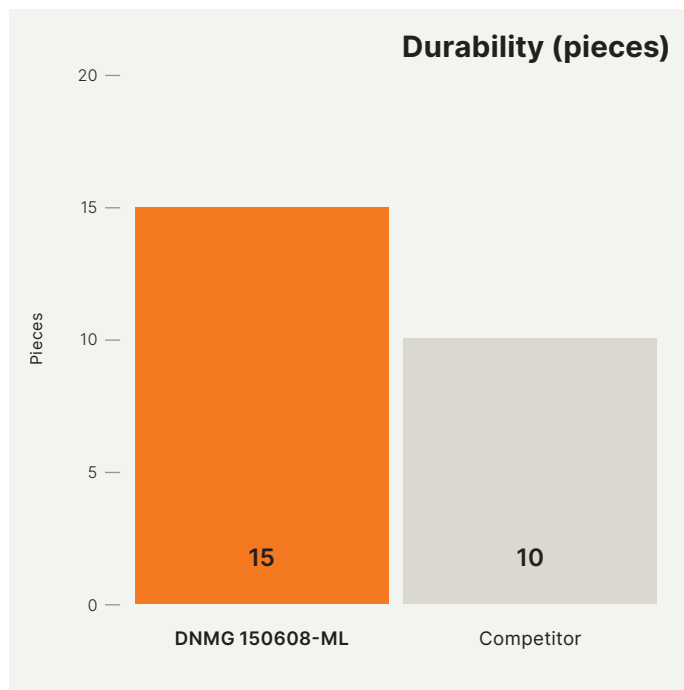
Increase tool life by 50% in worm shaft turning

Customer result: In rough turning of worm shafts, the ML chipbreaker achieved 15 pieces per edge compared to 10 with the competitor, resulting in a 50% longer tool life. This improvement enabled reduced tool change frequency and lower overall machining costs, with consistent productivity maintained.

Segment	General engineering
Application	Rough turning
Component	Worm shaft
Material	40Cr (HB220–270)
Coolant	Yes
Dormer Pramet solution	DNMG 150608-ML

Machining data		
v_c	f_n	a_p
146	0.3	2.0

P3.2

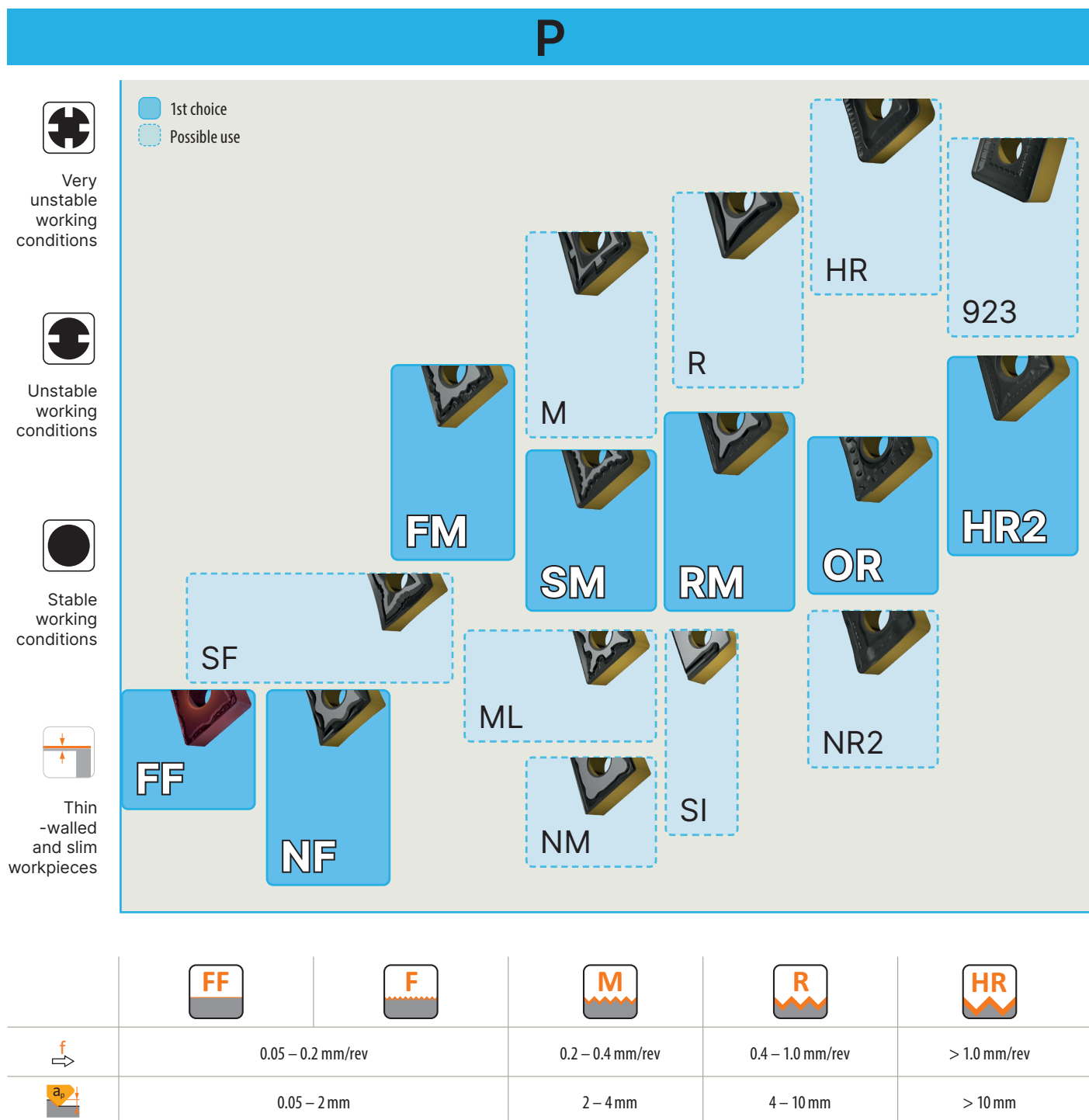


v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)



Technical information

ISO inserts negative – chipbreaker navigator

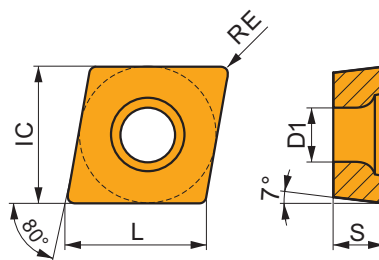




CCGT

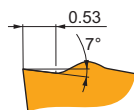
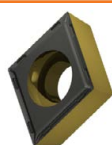


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.525	4.40	9.70	3.97



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)



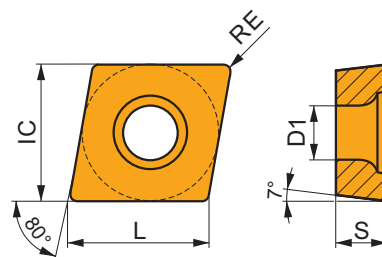
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

CCGT 09T302E-FF2:T9425	●	0.2	■	455	0.05	1.0	■	—	—	—	■	430	0.05	1.0	■	—	—	—	■	—	—	—
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CCMT

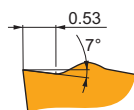
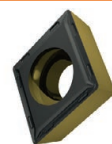


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.40	2.38
0803	7.940	3.40	8.10	3.18
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



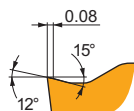
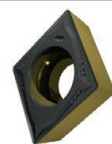
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

CCMT 060202E-FF2:T9425	●	0.2	■	465	0.05	0.8	■	—	—	—	■	440	0.05	0.8	■	—	—	—	■	—	—	—
CCMT 060204E-FF2:T9425	●	0.4	■	365	0.12	1.0	■	—	—	—	■	345	0.12	1.0	■	—	—	—	■	—	—	—
CCMT 080302E-FF2:T9425	●	0.2	■	465	0.05	0.8	■	—	—	—	■	440	0.05	0.8	■	—	—	—	■	—	—	—
CCMT 080304E-FF2:T9425	●	0.4	■	365	0.12	1.0	■	—	—	—	■	345	0.12	1.0	■	—	—	—	■	—	—	—
CCMT 080308E-FF2:T9425	●	0.8	■	385	0.17	1.0	■	—	—	—	■	365	0.17	1.0	■	—	—	—	■	—	—	—
CCMT 09T304E-FF2:T9425	●	0.4	■	360	0.12	1.2	■	—	—	—	■	340	0.12	1.2	■	—	—	—	■	—	—	—
CCMT 09T308E-FF2:T9425	●	0.8	■	380	0.17	1.2	■	—	—	—	■	360	0.17	1.2	■	—	—	—	■	—	—	—



FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

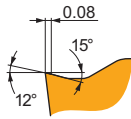
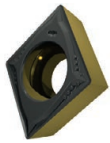
CCMT 060202E-FM:T9425	●	0.2	■	400	0.10	1.0	■	240	0.09	1.0	■	380	0.10	1.0	■	—	—	—	■	—	—	—
CCMT 060204E-FM:T9425	●	0.4	■	375	0.15	1.0	■	225	0.15	1.0	■	355	0.15	1.0	■	—	—	—	■	—	—	—
CCMT 060208E-FM:T9425	●	0.8	■	400	0.20	1.0	■	240	0.18	1.0	■	380	0.20	1.0	■	—	—	—	■	—	—	—

● Stable working conditions ● Unstable working conditions ● Heavy working conditions ■ Primary use ■ Possible use



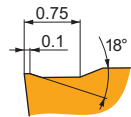
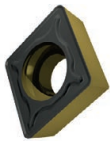
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



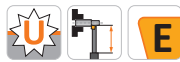
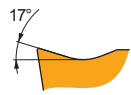
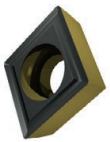
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

CCMT 09T302E-FM:T9425	●	0.2	390	0.10	1.2	230	0.09	1.2	370	0.10	1.2	—	—	—	—	—	—	—	—	—
CCMT 09T304E-FM:T9425	●	0.4	365	0.15	1.2	215	0.15	1.2	345	0.15	1.2	—	—	—	—	—	—	—	—	—
CCMT 09T308E-FM:T9425	●	0.8	395	0.20	1.2	235	0.18	1.2	375	0.20	1.2	—	—	—	—	—	—	—	—	—
CCMT 120404E-FM:T9425	●	0.4	355	0.15	1.7	210	0.15	1.7	335	0.15	1.7	—	—	—	—	—	—	—	—	—
CCMT 120408E-FM:T9425	●	0.8	385	0.20	1.7	230	0.18	1.7	365	0.20	1.7	—	—	—	—	—	—	—	—	—
CCMT 120412E-FM:T9425	●	1.2	365	0.27	1.7	215	0.24	1.7	345	0.27	1.7	—	—	—	—	—	—	—	—	—



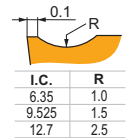
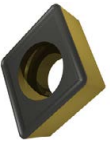
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

CCMT 080304E-FM2:T9425	●	0.4	365	0.12	1.0	215	0.11	1.0	345	0.12	1.0	—	—	—	—	—	—	—	—	—
CCMT 080308E-FM2:T9425	●	0.8	385	0.17	1.0	230	0.15	1.0	365	0.17	1.0	—	—	—	—	—	—	—	—	—
CCMT 09T304E-FM2:T9425	●	0.4	365	0.12	1.0	215	0.11	1.0	345	0.12	1.0	—	—	—	—	—	—	—	—	—
CCMT 09T308E-FM2:T9425	●	0.8	385	0.17	1.0	230	0.15	1.0	365	0.17	1.0	—	—	—	—	—	—	—	—	—
CCMT 120408E-FM2:T9425	●	0.8	350	0.20	1.5	210	0.18	1.5	330	0.20	1.5	—	—	—	—	—	—	—	—	—



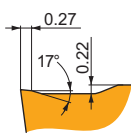
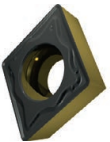
NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.

CCMT 060202E-NF2:T9425	●	0.2	370	0.10	0.8	220	0.09	0.8	350	0.10	0.8	—	—	—	80	0.08	0.6	—	—	—
CCMT 060204E-NF2:T9425	●	0.4	370	0.12	0.8	220	0.11	0.8	350	0.12	0.8	—	—	—	80	0.11	0.6	—	—	—
CCMT 080304E-NF2:T9425	●	0.4	365	0.12	1.0	215	0.11	1.0	345	0.12	1.0	—	—	—	80	0.11	0.8	—	—	—
CCMT 080308E-NF2:T9425	●	0.8	385	0.17	1.0	230	0.15	1.0	365	0.17	1.0	—	—	—	85	0.14	0.8	—	—	—
CCMT 09T304E-NF2:T9425	●	0.4	360	0.12	1.2	215	0.11	1.2	340	0.12	1.2	—	—	—	80	0.11	1.0	—	—	—
CCMT 09T308E-NF2:T9425	●	0.8	405	0.14	1.2	240	0.13	1.2	380	0.14	1.2	—	—	—	90	0.13	1.0	—	—	—



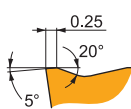
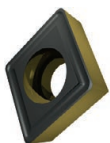
RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

CCMT 060204E-RF:T9425	●	0.4	305	0.15	1.0	180	0.15	1.0	285	0.15	1.0	—	—	—	—	—	—	—	—	—
CCMT 09T304E-RF:T9425	●	0.4	265	0.20	1.5	155	0.18	1.5	250	0.20	1.5	—	—	—	—	—	—	—	—	—
CCMT 09T308E-RF:T9425	●	0.8	315	0.20	1.5	185	0.18	1.5	295	0.20	1.5	—	—	—	—	—	—	—	—	—
CCMT 120408E-RF:T9425	●	0.8	295	0.22	2.2	175	0.22	2.2	280	0.22	2.2	—	—	—	—	—	—	—	—	—



RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

CCMT 09T304E-RM:T9425	●	0.4	305	0.25	2.2	180	0.23	2.2	285	0.25	2.2	—	—	—	65	0.18	1.8	—	—	—
CCMT 09T308E-RM:T9425	●	0.8	340	0.30	2.2	200	0.27	2.2	320	0.30	2.2	—	—	—	75	0.24	1.8	—	—	—
CCMT 09T312E-RM:T9425	●	1.2	350	0.33	2.2	210	0.30	2.2	330	0.33	2.2	—	—	—	75	0.23	1.8	—	—	—
CCMT 120408E-RM:T9425	●	0.8	330	0.30	2.7	195	0.27	2.7	310	0.30	2.7	—	—	—	70	0.24	2.2	—	—	—
CCMT 120412E-RM:T9425	●	1.2	340	0.33	2.7	200	0.30	2.7	320	0.33	2.7	—	—	—	75	0.23	2.2	—	—	—



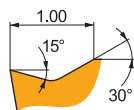
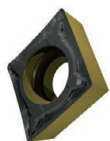
RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

CCMT 120404E-RM3:T9425	●	0.4	260	0.25	2.5	155	0.25	2.5	245	0.25	2.5	—	—	—	—	—	—	—	—	—
CCMT 120408E-RM3:T9425	●	0.8	300	0.27	2.5	180	0.27	2.5	285	0.27	2.5	—	—	—	—	—	—	—	—	—



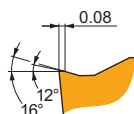
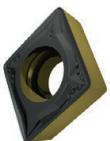
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

CCMT 060202E-UR:T9425	●	0.2	350	0.10	0.8	210	0.09	0.8	330	0.10	0.8	—	—	—	—	—	—	—	—	—
CCMT 060204E-UR:T9425	●	0.4	320	0.15	1.0	190	0.15	1.0	300	0.15	1.0	—	—	—	—	—	—	—	—	—
CCMT 060208E-UR:T9425	●	0.8	345	0.20	1.0	205	0.18	1.0	325	0.20	1.0	—	—	—	—	—	—	—	—	—
CCMT 09T304E-UR:T9425	●	0.4	315	0.15	1.2	185	0.15	1.2	295	0.15	1.2	—	—	—	—	—	—	—	—	—
CCMT 09T308E-UR:T9425	●	0.8	345	0.20	1.2	205	0.18	1.2	325	0.20	1.2	—	—	—	—	—	—	—	—	—
CCMT 120404E-UR:T9425	●	0.4	305	0.15	1.7	180	0.15	1.7	285	0.15	1.7	—	—	—	—	—	—	—	—	—
CCMT 120408E-UR:T9425	●	0.8	330	0.20	1.7	195	0.18	1.7	310	0.20	1.7	—	—	—	—	—	—	—	—	—
CCMT 120412E-UR:T9425	●	1.2	315	0.27	1.7	185	0.24	1.7	295	0.27	1.7	—	—	—	—	—	—	—	—	—



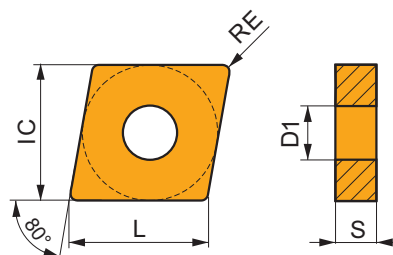
W-FM chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.

CCMT 060204W-FM:T9425	●	0.4	300	0.30	0.8	180	0.27	0.8	285	0.30	0.8	—	—	—	—	—	—	—	—	—
CCMT 09T304W-FM:T9425	●	0.4	300	0.30	0.8	180	0.27	0.8	285	0.30	0.8	—	—	—	—	—	—	—	—	—
CCMT 09T308W-FM:T9425	●	0.8	320	0.40	1.0	190	0.36	1.0	300	0.40	1.0	—	—	—	—	—	—	—	—	—

CNMG

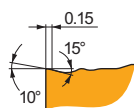
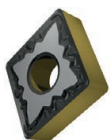


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



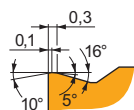
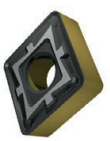
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

CNMG 090304E-FM:T9425	●	0.4	365	0.20	1.4	215	0.18	1.4	345	0.20	1.4	—	—	—	80	0.16	1.1	—	—	—
CNMG 090308E-FM:T9425	●	0.8	430	0.20	1.4	255	0.18	1.4	405	0.20	1.4	—	—	—	95	0.16	1.1	—	—	—
CNMG 120404E-FM:T9425	●	0.4	350	0.20	2.1	210	0.18	2.1	330	0.20	2.1	—	—	—	75	0.16	1.7	—	—	—
CNMG 120408E-FM:T9425	●	0.8	415	0.20	2.1	245	0.18	2.1	390	0.20	2.1	—	—	—	90	0.16	1.7	—	—	—
CNMG 120412E-FM:T9425	●	1.2	400	0.27	2.1	240	0.24	2.1	380	0.27	2.1	—	—	—	90	0.19	1.7	—	—	—



M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

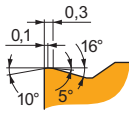
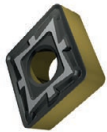
CNMG 090308E-M:T9425	●	0.8	330	0.32	1.8	—	—	—	310	0.32	1.8	—	—	—	—	—	—	—	—	—
CNMG 120404E-M:T9425	●	0.4	320	0.20	2.1	—	—	—	300	0.20	2.1	—	—	—	—	—	—	—	—	—
CNMG 120408E-M:T9425	●	0.8	325	0.32	2.1	—	—	—	305	0.32	2.1	—	—	—	—	—	—	—	—	—
CNMG 120412E-M:T9425	●	1.2	320	0.40	2.1	—	—	—	300	0.40	2.1	—	—	—	—	—	—	—	—	—
CNMG 120416E-M:T9425	●	1.6	335	0.40	2.1	—	—	—	315	0.40	2.1	—	—	—	—	—	—	—	—	—

● Stable working conditions ● Unstable working conditions ⚙ Heavy working conditions ■ Primary use ▣ Possible use



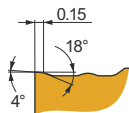
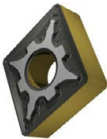
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



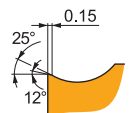
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

CNMG 160608E-M:T9425	●	0.8	305	0.32	3.6	—	—	—	285	0.32	3.6	—	—	—	—	—	—	—	—	—
CNMG 160612E-M:T9425	●	1.2	305	0.40	3.6	—	—	—	285	0.40	3.6	—	—	—	—	—	—	—	—	—
CNMG 160616E-M:T9425	●	1.6	320	0.40	3.6	—	—	—	300	0.40	3.6	—	—	—	—	—	—	—	—	—
CNMG 190608E-M:T9425	●	0.8	300	0.32	4.2	—	—	—	285	0.32	4.2	—	—	—	—	—	—	—	—	—
CNMG 190612E-M:T9425	●	1.2	300	0.40	4.2	—	—	—	285	0.40	4.2	—	—	—	—	—	—	—	—	—
CNMG 190616E-M:T9425	●	1.6	315	0.40	4.2	—	—	—	295	0.40	4.2	—	—	—	—	—	—	—	—	—



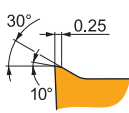
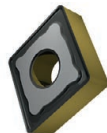
ML chip breaker is versatile and designed for low depth of cut and medium machining of steels. It features positive rake angle and stable, narrow T-land. It's also suitable for cast irons.

CNMG 120404-ML:T9415	●	0.4	365	0.20	1.0	—	—	—	345	0.20	1.0	—	—	—	—	—	—	—	—	—
CNMG 120404-ML:T9425	●	0.4	340	0.20	1.0	—	—	—	320	0.20	1.0	—	—	—	—	—	—	—	—	—
CNMG 120408-ML:T9415	●	0.8	380	0.25	1.5	—	—	—	360	0.25	1.5	—	—	—	—	—	—	—	—	—
CNMG 120408-ML:T9425	●	0.8	365	0.25	1.5	—	—	—	345	0.25	1.5	—	—	—	—	—	—	—	—	—
CNMG 120412-ML:T9415	●	1.2	360	0.30	2.0	—	—	—	340	0.30	2.0	—	—	—	—	—	—	—	—	—
CNMG 120412-ML:T9425	●	1.2	355	0.30	2.0	—	—	—	335	0.30	2.0	—	—	—	—	—	—	—	—	—



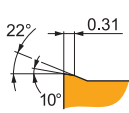
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

CNMG 090304E-NF:T9425	●	0.4	400	0.18	0.8	240	0.16	0.8	380	0.18	0.8	—	—	—	90	0.16	0.6	—	—	—
CNMG 090308E-NF:T9425	●	0.8	455	0.19	1.0	270	0.17	1.0	430	0.19	1.0	—	—	—	100	0.15	0.8	—	—	—
CNMG 120404E-NF:T9425	●	0.4	370	0.18	1.7	220	0.16	1.7	350	0.18	1.7	—	—	—	80	0.16	1.4	—	—	—
CNMG 120408E-NF:T9425	●	0.8	430	0.19	1.7	255	0.17	1.7	405	0.19	1.7	—	—	—	95	0.15	1.4	—	—	—
CNMG 120412E-NF:T9425	●	1.2	385	0.30	2.1	230	0.27	2.1	365	0.30	2.1	—	—	—	85	0.21	1.7	—	—	—



NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

CNMG 120404E-NM:T9425	●	0.4	365	0.20	2.1	215	0.18	2.1	—	—	—	—	—	—	80	0.16	1.7	—	—	—
CNMG 120408E-NM:T9425	●	0.8	400	0.25	2.1	240	0.23	2.1	—	—	—	—	—	—	90	0.20	1.7	—	—	—
CNMG 120412E-NM:T9425	●	1.2	400	0.30	2.1	240	0.27	2.1	—	—	—	—	—	—	90	0.24	1.7	—	—	—
CNMG 160608E-NM:T9425	●	0.8	360	0.30	3.6	215	0.27	3.6	—	—	—	—	—	—	80	0.27	2.9	—	—	—
CNMG 160612E-NM:T9425	●	1.2	375	0.30	3.6	225	0.27	3.6	—	—	—	—	—	—	80	0.27	2.9	—	—	—
CNMG 190612E-NM:T9425	●	1.2	355	0.35	4.2	210	0.32	4.2	—	—	—	—	—	—	75	0.32	3.4	—	—	—



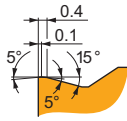
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

CNMG 120404E-NMR:T9425	●	0.4	300	0.25	2.0	180	0.23	2.0	—	—	—	—	—	—	65	0.20	1.6	—	—	—
CNMG 120408E-NMR:T9425	●	0.8	305	0.35	2.7	180	0.32	2.7	—	—	—	—	—	—	65	0.25	2.2	—	—	—
CNMG 120412E-NMR:T9425	●	1.2	310	0.40	2.7	185	0.36	2.7	—	—	—	—	—	—	65	0.28	2.2	—	—	—
CNMG 160608E-NMR:T9425	●	0.8	295	0.35	4.0	175	0.32	4.0	—	—	—	—	—	—	65	0.25	3.2	—	—	—
CNMG 160612E-NMR:T9425	●	1.2	300	0.40	4.0	180	0.36	4.0	—	—	—	—	—	—	65	0.28	3.2	—	—	—
CNMG 160616E-NMR:T9425	●	1.6	300	0.45	4.0	180	0.41	4.0	—	—	—	—	—	—	65	0.32	3.2	—	—	—
CNMG 190608E-NMR:T9425	●	0.8	285	0.35	5.2	170	0.32	5.2	—	—	—	—	—	—	60	0.25	4.2	—	—	—
CNMG 190612E-NMR:T9425	●	1.2	290	0.40	5.2	170	0.36	5.2	—	—	—	—	—	—	65	0.28	4.2	—	—	—
CNMG 190616E-NMR:T9425	●	1.6	290	0.45	5.2	170	0.41	5.2	—	—	—	—	—	—	65	0.32	4.2	—	—	—



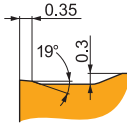
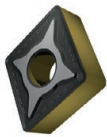
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



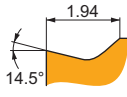
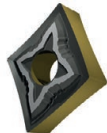
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.

CNMG 120408E-R:T9425	●	0.8	285	0.40	4.0	—	—	—	270	0.40	4.0	—	—	—	—	—	—	—	—	—
CNMG 120412E-R:T9425	●	1.2	290	0.45	4.0	—	—	—	275	0.45	4.0	—	—	—	—	—	—	—	—	—
CNMG 120416E-R:T9425	●	1.6	290	0.50	4.0	—	—	—	275	0.50	4.0	—	—	—	—	—	—	—	—	—
CNMG 160612E-R:T9425	●	1.2	280	0.45	5.5	—	—	—	265	0.45	5.5	—	—	—	—	—	—	—	—	—
CNMG 160616E-R:T9425	●	1.6	280	0.50	5.5	—	—	—	265	0.50	5.5	—	—	—	—	—	—	—	—	—
CNMG 190612E-R:T9425	●	1.2	275	0.45	7.0	—	—	—	260	0.45	7.0	—	—	—	—	—	—	—	—	—
CNMG 190616E-R:T9425	●	1.6	275	0.50	7.0	—	—	—	260	0.50	7.0	—	—	—	—	—	—	—	—	—



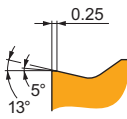
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

CNMG 120408E-RM:T9425	●	0.8	325	0.40	4.0	195	0.36	4.0	305	0.40	4.0	—	—	—	70	0.28	3.2	—	—	—
CNMG 120412E-RM:T9425	●	1.2	330	0.45	4.0	195	0.41	4.0	310	0.45	4.0	—	—	—	70	0.32	3.2	—	—	—
CNMG 120416E-RM:T9425	●	1.6	335	0.50	4.0	200	0.45	4.0	315	0.50	4.0	—	—	—	75	0.35	3.2	—	—	—
CNMG 160608E-RM:T9425	●	0.8	315	0.40	6.0	185	0.36	6.0	295	0.40	6.0	—	—	—	70	0.28	4.8	—	—	—
CNMG 160612E-RM:T9425	●	1.2	315	0.45	6.0	185	0.41	6.0	295	0.45	6.0	—	—	—	70	0.32	4.8	—	—	—
CNMG 160616E-RM:T9425	●	1.6	325	0.50	6.0	195	0.45	6.0	305	0.50	6.0	—	—	—	70	0.35	4.8	—	—	—
CNMG 190608E-RM:T9425	●	0.8	305	0.40	7.5	180	0.36	7.5	285	0.40	7.5	—	—	—	65	0.28	6.0	—	—	—
CNMG 190612E-RM:T9425	●	1.2	310	0.45	7.5	185	0.41	7.5	290	0.45	7.5	—	—	—	65	0.32	6.0	—	—	—
CNMG 190616E-RM:T9425	●	1.6	310	0.50	7.5	185	0.45	7.5	290	0.50	7.5	—	—	—	65	0.35	6.0	—	—	—
CNMG 190624E-RM:T9425	●	2.4	325	0.50	7.5	195	0.45	7.5	305	0.50	7.5	—	—	—	70	0.35	6.0	—	—	—
CNMG 250924E-RM:T9425	●	2.4	150	0.80	12.0	90	0.72	12.0	140	0.80	12.0	—	—	—	30	0.56	9.6	—	—	—



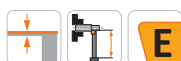
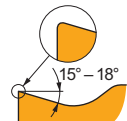
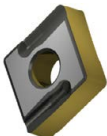
SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.

CNMG 120404E-SF:T9425	●	0.4	380	0.17	1.0	225	0.15	1.0	360	0.17	1.0	—	—	—	85	0.15	0.8	—	—	—
CNMG 120408E-SF:T9425	●	0.8	425	0.20	1.0	255	0.18	1.0	400	0.20	1.0	—	—	—	95	0.16	0.8	—	—	—



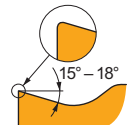
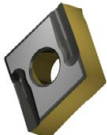
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

CNMG 120404E-SM:T9425	●	0.4	335	0.20	2.0	200	0.18	2.0	315	0.20	2.0	—	—	—	75	0.18	1.6	—	—	—
CNMG 120408E-SM:T9425	●	0.8	370	0.25	2.0	220	0.23	2.0	350	0.25	2.0	—	—	—	80	0.20	1.6	—	—	—
CNMG 120412E-SM:T9425	●	1.2	370	0.30	2.0	220	0.27	2.0	350	0.30	2.0	—	—	—	80	0.24	1.6	—	—	—
CNMG 160608E-SM:T9425	●	0.8	350	0.26	3.0	210	0.23	3.0	330	0.26	3.0	—	—	—	75	0.23	2.4	—	—	—
CNMG 160612E-SM:T9425	●	1.2	355	0.30	3.0	210	0.27	3.0	335	0.30	3.0	—	—	—	75	0.27	2.4	—	—	—
CNMG 190612E-SM:T9425	●	1.2	345	0.30	4.0	205	0.27	4.0	325	0.30	4.0	—	—	—	75	0.27	3.2	—	—	—



SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

CNMG 120404ER-SI:T9425	●	0.4	410	0.20	1.7	245	0.18	1.7	—	—	—	—	—	—	90	0.18	1.4	—	—	—
CNMG 120408ER-SI:T9425	●	0.8	400	0.35	1.7	240	0.32	1.7	—	—	—	—	—	—	90	0.25	1.4	—	—	—



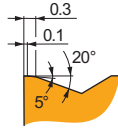
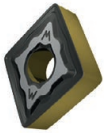
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

CNMG 120404EL-SI:T9425	●	0.4	410	0.20	1.7	245	0.18	1.7	—	—	—	—	—	—	90	0.18	1.4	—	—	—
CNMG 120408EL-SI:T9425	●	0.8	400	0.35	1.7	240	0.32	1.7	—	—	—	—	—	—	90	0.25	1.4	—	—	—



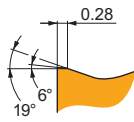
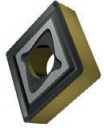
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.

CNMG 120408W-M:T9425		0.8	300	0.45	1.5	—	—	—	285	0.45	1.5	—	—	—	—	—	—	—	—	—
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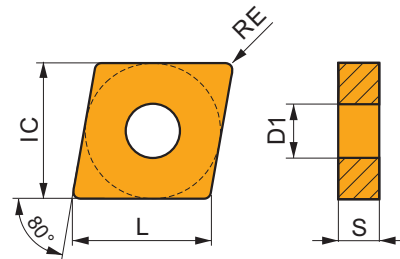
W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.

CNMG 120404W-MR:T9425		0.4	290	0.30	1.5	170	0.27	1.5	275	0.30	1.5	—	—	—	—	—	—	—	—	—
CNMG 120408W-MR:T9425		0.8	300	0.45	1.5	180	0.41	1.5	285	0.45	1.5	—	—	—	—	—	—	—	—	—
CNMG 120412W-MR:T9425		1.2	300	0.55	1.5	180	0.50	1.5	285	0.55	1.5	—	—	—	—	—	—	—	—	—

CNMM

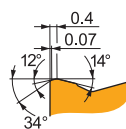
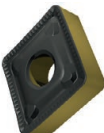


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



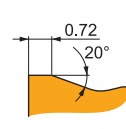
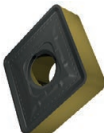
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



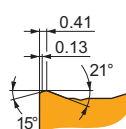
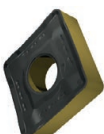
HR chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

CNMM 190616E-HR:T9425		1.6	135	0.60	10.0	80	0.54	10.0	125	0.60	10.0	—	—	—	—	—	—	—	—	—
CNMM 190624E-HR:T9425		2.4	140	0.65	10.0	80	0.59	10.0	130	0.65	10.0	—	—	—	—	—	—	—	—	—
CNMM 250924E-HR:T9425		2.4	135	0.65	14.0	80	0.59	14.0	125	0.65	14.0	—	—	—	—	—	—	—	—	—



HR2 chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features positive rake angle and stable, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

CNMM 190616E-HR2:T9425		1.6	135	0.65	10.0	80	0.59	10.0	125	0.65	10.0	—	—	—	—	—	—	—	—	—
CNMM 190624E-HR2:T9425		2.4	125	0.85	10.0	75	0.77	10.0	115	0.85	10.0	—	—	—	—	—	—	—	—	—
CNMM 250924E-HR2:T9425		2.4	125	0.85	12.0	75	0.77	12.0	115	0.85	12.0	—	—	—	—	—	—	—	—	—



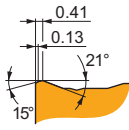
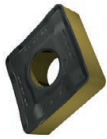
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

CNMM 120408E-NR2:T9425		0.8	305	0.40	5.0	180	0.36	5.0	285	0.40	5.0	—	—	—	65	0.28	4.0	—	—	—
CNMM 120412E-NR2:T9425		1.2	305	0.45	5.0	180	0.41	5.0	285	0.45	5.0	—	—	—	65	0.32	4.0	—	—	—
CNMM 160608E-NR2:T9425		0.8	300	0.40	6.0	180	0.36	6.0	285	0.40	6.0	—	—	—	65	0.32	4.8	—	—	—
CNMM 160612E-NR2:T9425		1.2	300	0.45	6.0	180	0.41	6.0	285	0.45	6.0	—	—	—	65	0.36	4.8	—	—	—
CNMM 160616E-NR2:T9425		1.6	310	0.50	6.0	185	0.45	6.0	290	0.50	6.0	—	—	—	65	0.40	4.8	—	—	—
CNMM 190612E-NR2:T9425		1.2	290	0.45	9.0	170	0.41	9.0	275	0.45	9.0	—	—	—	65	0.36	7.2	—	—	—



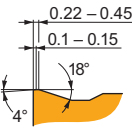
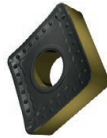
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



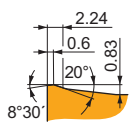
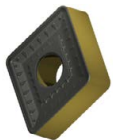
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

CNMM 190616E-NR2:T9425	✱	1.6	■	290	0.50	9.0	■	170	0.45	9.0	■	275	0.50	9.0	—	—	—	■	65	0.40	7.2	—	—	—
CNMM 190624E-NR2:T9425	✱	2.4	■	265	0.80	9.0	■	155	0.72	9.0	■	250	0.80	9.0	—	—	—	■	55	0.56	7.2	—	—	—
CNMM 250924E-NR2:T9425	✱	2.4	■	145	0.80	12.0	■	85	0.72	12.0	■	135	0.80	12.0	—	—	—	■	30	0.56	9.6	—	—	—



OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

CNMM 120408E-OR:T9425	✱	0.8	■	305	0.40	5.0	■	180	0.36	5.0	■	285	0.40	5.0	—	—	—	■	65	0.28	4.0	—	—	—
CNMM 120412E-OR:T9425	✱	1.2	■	305	0.45	5.0	■	180	0.41	5.0	■	285	0.45	5.0	—	—	—	■	65	0.36	4.0	—	—	—
CNMM 120416E-OR:T9425	✱	1.6	■	315	0.50	5.0	■	185	0.45	5.0	■	295	0.50	5.0	—	—	—	■	70	0.40	4.0	—	—	—
CNMM 160608E-OR:T9425	✱	0.8	■	300	0.40	6.0	■	180	0.36	6.0	■	285	0.40	6.0	—	—	—	■	65	0.32	4.8	—	—	—
CNMM 160612E-OR:T9425	✱	1.2	■	300	0.45	6.0	■	180	0.41	6.0	■	285	0.45	6.0	—	—	—	■	65	0.36	4.8	—	—	—
CNMM 160616E-OR:T9425	✱	1.6	■	310	0.50	6.0	■	185	0.45	6.0	■	290	0.50	6.0	—	—	—	■	65	0.40	4.8	—	—	—
CNMM 190612E-OR:T9425	✱	1.2	■	290	0.45	9.0	■	170	0.41	9.0	■	275	0.45	9.0	—	—	—	■	65	0.36	7.2	—	—	—
CNMM 190616E-OR:T9425	✱	1.6	■	290	0.50	9.0	■	170	0.45	9.0	■	275	0.50	9.0	—	—	—	■	65	0.40	7.2	—	—	—
CNMM 190624E-OR:T9425	✱	2.4	■	265	0.80	9.0	■	155	0.72	9.0	■	250	0.80	9.0	—	—	—	■	55	0.56	7.2	—	—	—
CNMM 250924E-OR:T9425	✱	2.4	■	130	1.00	12.0	■	75	0.90	12.0	■	120	1.00	12.0	—	—	—	■	25	0.70	9.6	—	—	—



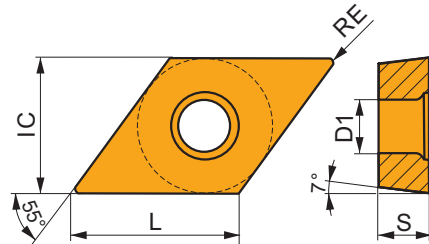
923 chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.

CNMM 250924S-923:T9425	✱	2.4	■	125	0.85	12.0	■	75	0.77	12.0	■	115	0.85	12.0	—	—	—	■	25	0.60	9.6	—	—	—
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DCGT

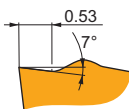
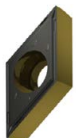


	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



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 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

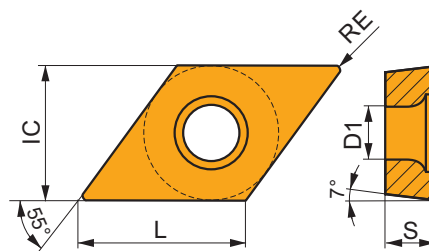
DCGT 11T302E-FF2:T9425	●	0.2	■	370	0.05	0.8	—	—	—	■	350	0.05	0.8	—	—	—	—	—	—
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DCMT

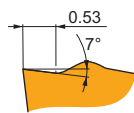
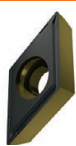


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



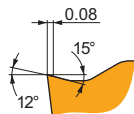
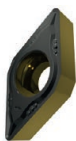
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



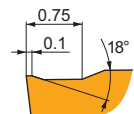
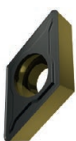
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

DCMT 070202E-FF2:T9425	●	0.2	■	370	0.05	0.8	■	—	—	—	■	350	0.05	0.8	■	—	—	—	■	—	—	—
DCMT 070204E-FF2:T9425	●	0.4	■	295	0.12	0.8	■	—	—	—	■	280	0.12	0.8	■	—	—	—	■	—	—	—
DCMT 070208E-FF2:T9425	●	0.8	■	315	0.17	0.8	■	—	—	—	■	295	0.17	0.8	■	—	—	—	■	—	—	—
DCMT 11T304E-FF2:T9425	●	0.4	■	295	0.12	0.8	■	—	—	—	■	280	0.12	0.8	■	—	—	—	■	—	—	—
DCMT 11T308E-FF2:T9425	●	0.8	■	315	0.17	0.8	■	—	—	—	■	295	0.17	0.8	■	—	—	—	■	—	—	—



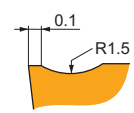
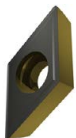
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

DCMT 070202E-FM:T9425	●	0.2	■	325	0.10	0.8	■	195	0.09	0.8	■	305	0.10	0.8	■	—	—	—	■	—	—	—
DCMT 070204E-FM:T9425	●	0.4	■	285	0.18	0.8	■	170	0.16	0.8	■	270	0.18	0.8	■	—	—	—	■	—	—	—
DCMT 11T302E-FM:T9425	●	0.2	■	325	0.10	0.8	■	195	0.09	0.8	■	305	0.10	0.8	■	—	—	—	■	—	—	—
DCMT 11T304E-FM:T9425	●	0.4	■	285	0.18	0.8	■	170	0.16	0.8	■	270	0.18	0.8	■	—	—	—	■	—	—	—
DCMT 11T308E-FM:T9425	●	0.8	■	345	0.17	0.8	■	205	0.15	0.8	■	325	0.17	0.8	■	—	—	—	■	—	—	—
DCMT 11T312E-FM:T9425	●	1.2	■	320	0.22	1.2	■	190	0.22	1.2	■	300	0.22	1.2	■	—	—	—	■	—	—	—



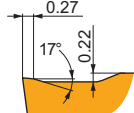
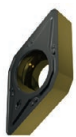
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

DCMT 070204E-FM2:T9425	●	0.4	■	295	0.12	0.8	■	175	0.11	0.8	■	280	0.12	0.8	■	—	—	—	■	—	—	—
DCMT 11T304E-FM2:T9425	●	0.4	■	295	0.12	0.8	■	175	0.11	0.8	■	280	0.12	0.8	■	—	—	—	■	—	—	—
DCMT 11T308E-FM2:T9425	●	0.8	■	315	0.17	0.8	■	185	0.15	0.8	■	295	0.17	0.8	■	—	—	—	■	—	—	—
DCMT 11T312E-FM2:T9425	●	1.2	■	295	0.22	1.2	■	175	0.20	1.2	■	280	0.22	1.2	■	—	—	—	■	—	—	—
DCMT 150408E-FM2:T9425	●	0.8	■	280	0.20	1.5	■	165	0.18	1.5	■	265	0.20	1.5	■	—	—	—	■	—	—	—



RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

DCMT 11T304E-RF:T9425	●	0.4	■	225	0.20	0.8	■	135	0.18	0.8	■	210	0.20	0.8	■	—	—	—	■	—	—	—
DCMT 11T308E-RF:T9425	●	0.8	■	270	0.20	0.8	■	160	0.18	0.8	■	255	0.20	0.8	■	—	—	—	■	—	—	—



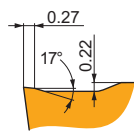
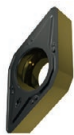
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

DCMT 11T304E-RM:T9425	●	0.4	■	280	0.20	1.0	■	165	0.18	1.0	■	265	0.20	1.0	■	60	0.14	0.8	■	—	—	—
DCMT 11T308E-RM:T9425	●	0.8	■	310	0.27	0.8	■	185	0.24	0.8	■	290	0.27	0.8	■	65	0.19	0.6	■	—	—	—
DCMT 11T312E-RM:T9425	●	1.2	■	315	0.27	1.2	■	185	0.24	1.2	■	295	0.27	1.2	■	70	0.19	1.2	■	—	—	—



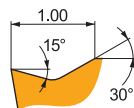
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



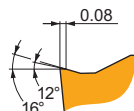
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

DCMT 150408E-RM:T9425	●	0.8	285	0.27	1.9	170	0.24	1.9	270	0.27	1.9	—	—	—	60	0.22	1.5	—	—	—
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UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

DCMT 070202E-UR:T9425	●	0.2	280	0.10	0.8	165	0.09	0.8	265	0.10	0.8	—	—	—	—	—	—	—	—	—
DCMT 070204E-UR:T9425	●	0.4	245	0.18	0.8	145	0.16	0.8	230	0.18	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T302E-UR:T9425	●	0.2	280	0.10	0.8	165	0.09	0.8	265	0.10	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T304E-UR:T9425	●	0.4	245	0.18	0.8	145	0.16	0.8	230	0.18	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T308E-UR:T9425	●	0.8	300	0.17	0.8	180	0.15	0.8	285	0.17	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T312E-UR:T9425	●	1.2	280	0.22	1.2	165	0.20	1.2	265	0.22	1.2	—	—	—	—	—	—	—	—	—



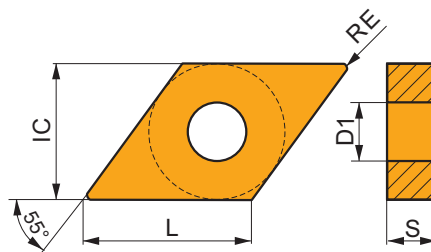
W-FM chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.

DCMX 11T304W-FM:T9425	●	0.4	240	0.30	0.8	140	0.27	0.8	225	0.30	0.8	—	—	—	—	—	—	—	—	—
DCMX 11T308W-FM:T9425	●	0.8	255	0.40	1.0	150	0.36	1.0	240	0.40	1.0	—	—	—	—	—	—	—	—	—

DNMG

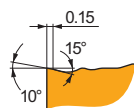


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



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)



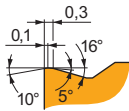
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

DNMG 110404E-FM:T9425	●	0.4	305	0.20	0.8	180	0.18	0.8	285	0.20	0.8	—	—	—	65	0.20	0.6	—	—	—
DNMG 110408E-FM:T9425	●	0.8	365	0.20	0.8	215	0.18	0.8	345	0.20	0.8	—	—	—	80	0.16	0.6	—	—	—
DNMG 150404E-FM:T9425	●	0.4	285	0.20	1.7	170	0.18	1.7	270	0.20	1.7	—	—	—	60	0.20	1.4	—	—	—
DNMG 150408E-FM:T9425	●	0.8	340	0.20	1.7	200	0.18	1.7	320	0.20	1.7	—	—	—	75	0.16	1.4	—	—	—
DNMG 150604E-FM:T9425	●	0.4	285	0.20	1.7	170	0.18	1.7	270	0.20	1.7	—	—	—	60	0.20	1.4	—	—	—
DNMG 150608E-FM:T9425	●	0.8	340	0.20	1.7	200	0.18	1.7	320	0.20	1.7	—	—	—	75	0.16	1.4	—	—	—
DNMG 150612E-FM:T9425	●	1.2	330	0.25	1.7	195	0.23	1.7	310	0.25	1.7	—	—	—	70	0.18	1.4	—	—	—
DNMG 150616E-FM:T9425	●	1.6	330	0.30	1.7	195	0.27	1.7	310	0.30	1.7	—	—	—	70	0.21	1.4	—	—	—



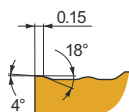
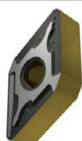
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



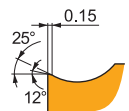
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

DNMG 110404E-M:T9425	●	0.4	270	0.20	1.2	—	—	—	255	0.20	1.2	—	—	—	—	—	—	—	—	—
DNMG 110408E-M:T9425	●	0.8	280	0.30	1.2	—	—	—	265	0.30	1.2	—	—	—	—	—	—	—	—	—
DNMG 110412E-M:T9425	●	1.2	270	0.40	1.2	—	—	—	255	0.40	1.2	—	—	—	—	—	—	—	—	—
DNMG 150404E-M:T9425	●	0.4	255	0.20	1.9	—	—	—	240	0.20	1.9	—	—	—	—	—	—	—	—	—
DNMG 150408E-M:T9425	●	0.8	265	0.30	1.9	—	—	—	250	0.30	1.9	—	—	—	—	—	—	—	—	—
DNMG 150412E-M:T9425	●	1.2	260	0.40	1.9	—	—	—	245	0.40	1.9	—	—	—	—	—	—	—	—	—
DNMG 150604E-M:T9425	●	0.4	255	0.20	1.9	—	—	—	240	0.20	1.9	—	—	—	—	—	—	—	—	—
DNMG 150608E-M:T9425	●	0.8	265	0.30	1.9	—	—	—	250	0.30	1.9	—	—	—	—	—	—	—	—	—
DNMG 150612E-M:T9425	●	1.2	260	0.40	1.9	—	—	—	245	0.40	1.9	—	—	—	—	—	—	—	—	—



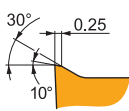
ML chip breaker is versatile and designed for low depth of cut and medium machining of steels. It features positive rake angle and stable, narrow T-land. It's also suitable for cast irons.

DNMG 110408-ML:T9415	●	0.8	300	0.25	1.5	—	—	—	285	0.25	1.5	—	—	—	—	—	—	—	—	—
DNMG 110408-ML:T9425	●	0.8	290	0.25	1.5	—	—	—	275	0.25	1.5	—	—	—	—	—	—	—	—	—
DNMG 150408-ML:T9415	●	0.8	300	0.25	1.5	—	—	—	285	0.25	1.5	—	—	—	—	—	—	—	—	—
DNMG 150408-ML:T9425	●	0.8	290	0.25	1.5	—	—	—	275	0.25	1.5	—	—	—	—	—	—	—	—	—
DNMG 150608-ML:T9415	●	0.8	300	0.25	1.5	—	—	—	285	0.25	1.5	—	—	—	—	—	—	—	—	—
DNMG 150608-ML:T9425	●	0.8	290	0.25	1.5	—	—	—	275	0.25	1.5	—	—	—	—	—	—	—	—	—
DNMG 150612-ML:T9415	●	1.2	285	0.30	2.0	—	—	—	270	0.30	2.0	—	—	—	—	—	—	—	—	—
DNMG 150612-ML:T9425	●	1.2	280	0.30	2.0	—	—	—	265	0.30	2.0	—	—	—	—	—	—	—	—	—
DNMG 150616-ML:T9415	●	1.6	280	0.35	2.0	—	—	—	265	0.35	2.0	—	—	—	—	—	—	—	—	—
DNMG 150616-ML:T9425	●	1.6	280	0.35	2.0	—	—	—	265	0.35	2.0	—	—	—	—	—	—	—	—	—



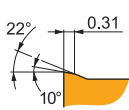
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

DNMG 110404E-NF:T9425	●	0.4	320	0.18	0.8	190	0.16	0.8	300	0.18	0.8	—	—	—	70	0.16	0.6	—	—	—
DNMG 110408E-NF:T9425	●	0.8	370	0.18	1.0	220	0.16	1.0	350	0.18	1.0	—	—	—	80	0.16	0.8	—	—	—
DNMG 150404E-NF:T9425	●	0.4	295	0.18	1.7	175	0.16	1.7	280	0.18	1.7	—	—	—	65	0.16	1.4	—	—	—
DNMG 150408E-NF:T9425	●	0.8	355	0.18	1.7	210	0.16	1.7	335	0.18	1.7	—	—	—	75	0.16	1.4	—	—	—
DNMG 150604E-NF:T9425	●	0.4	295	0.18	1.9	175	0.16	1.9	280	0.18	1.9	—	—	—	65	0.16	1.5	—	—	—
DNMG 150608E-NF:T9425	●	0.8	350	0.18	1.9	210	0.16	1.9	330	0.18	1.9	—	—	—	75	0.16	1.5	—	—	—



NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

DNMG 110408E-NM:T9425	●	0.8	355	0.25	0.8	210	0.23	0.8	—	—	—	—	—	—	75	0.20	0.6	—	—	—
DNMG 150604E-NM:T9425	●	0.4	295	0.20	1.9	175	0.18	1.9	—	—	—	—	—	—	65	0.20	1.5	—	—	—
DNMG 150608E-NM:T9425	●	0.8	325	0.25	1.9	195	0.23	1.9	—	—	—	—	—	—	70	0.20	1.5	—	—	—



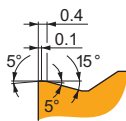
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

DNMG 110404E-NMR:T9425	●	0.4	280	0.20	0.8	165	0.18	0.8	—	—	—	—	—	—	60	0.18	0.6	—	—	—
DNMG 150404E-NMR:T9425	●	0.4	255	0.20	1.9	150	0.18	1.9	—	—	—	—	—	—	55	0.18	1.5	—	—	—
DNMG 150408E-NMR:T9425	●	0.8	265	0.30	1.9	155	0.27	1.9	—	—	—	—	—	—	55	0.24	1.5	—	—	—
DNMG 150604E-NMR:T9425	●	0.4	255	0.20	1.9	150	0.18	1.9	—	—	—	—	—	—	55	0.18	1.5	—	—	—
DNMG 150608E-NMR:T9425	●	0.8	265	0.30	1.9	155	0.27	1.9	—	—	—	—	—	—	55	0.24	1.5	—	—	—
DNMG 150612E-NMR:T9425	●	1.2	280	0.30	1.9	165	0.27	1.9	—	—	—	—	—	—	60	0.24	1.5	—	—	—



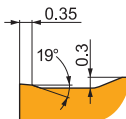
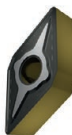
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



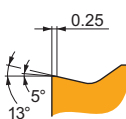
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.

DNMG 150608E-R:T9425	●	0.8	235	0.40	3.0	—	—	—	220	0.40	3.0	—	—	—	—	—	—	—	—	—
DNMG 150612E-R:T9425	●	1.2	245	0.40	3.0	—	—	—	230	0.40	3.0	—	—	—	—	—	—	—	—	—
DNMG 150616E-R:T9425	●	1.6	260	0.40	3.0	—	—	—	245	0.40	3.0	—	—	—	—	—	—	—	—	—



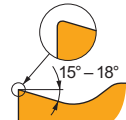
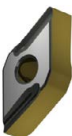
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

DNMG 110408E-RM:T9425	●	0.8	275	0.40	2.0	165	0.36	2.0	260	0.40	2.0	—	—	—	60	0.28	1.6	—	—	—
DNMG 110412E-RM:T9425	●	1.2	290	0.40	2.0	170	0.36	2.0	275	0.40	2.0	—	—	—	65	0.28	1.6	—	—	—
DNMG 150408E-RM:T9425	●	0.8	270	0.40	3.0	160	0.36	3.0	255	0.40	3.0	—	—	—	60	0.28	2.4	—	—	—
DNMG 150412E-RM:T9425	●	1.2	285	0.40	3.0	170	0.36	3.0	270	0.40	3.0	—	—	—	60	0.28	2.4	—	—	—
DNMG 150608E-RM:T9425	●	0.8	270	0.40	3.0	160	0.36	3.0	255	0.40	3.0	—	—	—	60	0.28	2.4	—	—	—
DNMG 150612E-RM:T9425	●	1.2	285	0.40	3.0	170	0.36	3.0	270	0.40	3.0	—	—	—	60	0.28	2.4	—	—	—
DNMG 150616E-RM:T9425	●	1.6	295	0.40	3.0	175	0.36	3.0	280	0.40	3.0	—	—	—	65	0.33	2.4	—	—	—



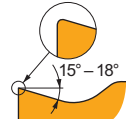
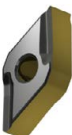
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

DNMG 110404E-SM:T9425	●	0.4	295	0.20	0.8	175	0.18	0.8	280	0.20	0.8	—	—	—	65	0.18	0.6	—	—	—
DNMG 110408E-SM:T9425	●	0.8	315	0.25	1.2	185	0.23	1.2	295	0.25	1.2	—	—	—	70	0.20	1.0	—	—	—
DNMG 150604E-SM:T9425	●	0.4	275	0.20	1.7	165	0.18	1.7	260	0.20	1.7	—	—	—	60	0.18	1.4	—	—	—
DNMG 150608E-SM:T9425	●	0.8	300	0.25	1.7	180	0.23	1.7	285	0.25	1.7	—	—	—	65	0.20	1.4	—	—	—
DNMG 150612E-SM:T9425	●	1.2	300	0.30	1.7	180	0.27	1.7	285	0.30	1.7	—	—	—	65	0.24	1.4	—	—	—



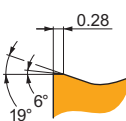
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

DNMG 110404ER-SI:T9425	●	0.4	340	0.20	1.0	200	0.18	1.0	—	—	—	—	—	—	75	0.18	0.8	—	—	—
DNMG 110408ER-SI:T9425	●	0.8	340	0.35	1.0	200	0.32	1.0	—	—	—	—	—	—	75	0.25	0.8	—	—	—
DNMG 150404ER-SI:T9425	●	0.4	330	0.20	1.5	195	0.18	1.5	—	—	—	—	—	—	70	0.18	1.2	—	—	—
DNMG 150408ER-SI:T9425	●	0.8	325	0.35	1.5	195	0.32	1.5	—	—	—	—	—	—	70	0.25	1.2	—	—	—
DNMG 150604ER-SI:T9425	●	0.4	330	0.20	1.5	195	0.18	1.5	—	—	—	—	—	—	70	0.18	1.2	—	—	—
DNMG 150608ER-SI:T9425	●	0.8	325	0.35	1.5	195	0.32	1.5	—	—	—	—	—	—	70	0.25	1.2	—	—	—



SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

DNMG 110404EL-SI:T9425	●	0.4	340	0.20	1.0	200	0.18	1.0	—	—	—	—	—	—	75	0.18	0.8	—	—	—
DNMG 110408EL-SI:T9425	●	0.8	340	0.35	1.0	200	0.32	1.0	—	—	—	—	—	—	75	0.25	0.8	—	—	—
DNMG 150404EL-SI:T9425	●	0.4	330	0.20	1.5	195	0.18	1.5	—	—	—	—	—	—	70	0.18	1.2	—	—	—
DNMG 150408EL-SI:T9425	●	0.8	325	0.35	1.5	195	0.32	1.5	—	—	—	—	—	—	70	0.25	1.2	—	—	—
DNMG 150604EL-SI:T9425	●	0.4	330	0.20	1.5	195	0.18	1.5	—	—	—	—	—	—	70	0.18	1.2	—	—	—
DNMG 150608EL-SI:T9425	●	0.8	325	0.35	1.5	195	0.32	1.5	—	—	—	—	—	—	70	0.25	1.2	—	—	—



W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.

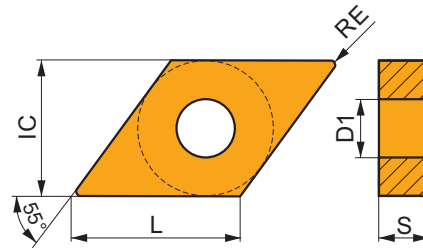
DNMG 150608W-MR:T9425	●	0.8	250	0.40	1.5	150	0.36	1.5	235	0.40	1.5	—	—	—	—	—	—	—	—	—
DNMG 150612W-MR:T9425	●	1.2	245	0.50	1.5	145	0.45	1.5	230	0.50	1.5	—	—	—	—	—	—	—	—	—



DNMM

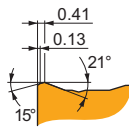
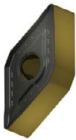


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1506	12.700	5.16	15.50	6.35



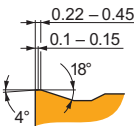
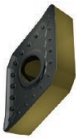
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

DNMM 150608E-NR2:T9425	0.8	255	0.40	3.0	150	0.36	3.0	240	0.40	3.0	—	—	—	55	0.32	2.4	—	—	—
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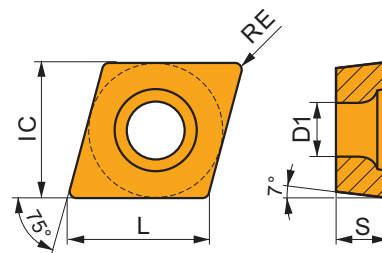
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

DNMM 150608E-OR:T9425	0.8	255	0.40	3.0	150	0.36	3.0	240	0.40	3.0	—	—	—	55	0.28	2.4	—	—	—
DNMM 150612E-OR:T9425	1.2	270	0.40	3.0	160	0.36	3.0	255	0.40	3.0	—	—	—	60	0.32	2.4	—	—	—
DNMM 150616E-OR:T9425	1.6	270	0.45	3.0	160	0.41	3.0	255	0.45	3.0	—	—	—	60	0.41	2.4	—	—	—

ECMT

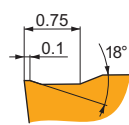
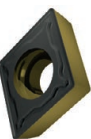


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.50	2.38
0803	7.940	3.40	8.20	3.18



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 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

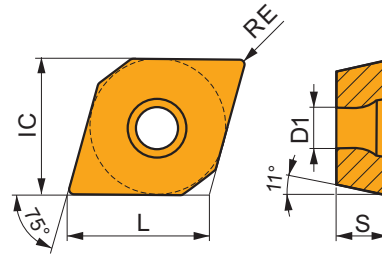
ECMT 060204E-FM2:T9425	0.4	370	0.12	0.8	220	0.11	0.8	350	0.12	0.8	—	—	—	—	—	—	—	—	—
ECMT 080304E-FM2:T9425	0.4	365	0.12	1.0	215	0.11	1.0	345	0.12	1.0	—	—	—	—	—	—	—	—	—
ECMT 080308E-FM2:T9425	0.8	385	0.17	1.0	230	0.15	1.0	365	0.17	1.0	—	—	—	—	—	—	—	—	—



EPMT

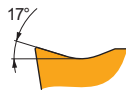


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0502	5.560	2.50	5.70	2.38



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)



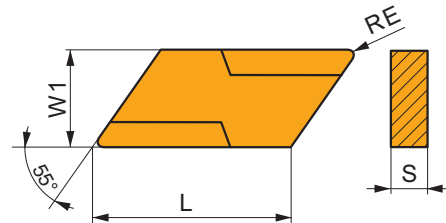
NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.

EPMT 050202E-NF2:T9425	●	0.2	415	0.07	0.8	245	0.06	0.8	390	0.07	0.8	—	—	—	90	0.06	0.6	—	—	—
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KNUX

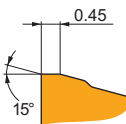
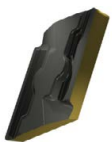


	L	S
	(mm)	(mm)
1604	19.50	4.76



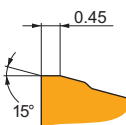
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



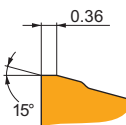
L-22 geometry with left-handed design for finish to semi-rough machining, and continuous cuts.

KNUX 160405L-22:T9425	●	0.5	245	0.25	2.7	145	0.25	2.7	230	0.25	2.7	—	—	—	—	—	—	—	—	—
KNUX 160410L-22:T9425	⚙	1.0	280	0.32	2.7	165	0.32	2.7	265	0.32	2.7	—	—	—	—	—	—	—	—	—



R-22 geometry with right-handed design for finish to semi-rough machining, and continuous cuts.

KNUX 160405R-22:T9425	●	0.5	245	0.25	2.7	145	0.25	2.7	230	0.25	2.7	—	—	—	—	—	—	—	—	—
KNUX 160410R-22:T9425	⚙	1.0	280	0.32	2.7	165	0.32	2.7	265	0.32	2.7	—	—	—	—	—	—	—	—	—



L-32 geometry with left-handed design for finish to semi-rough machining, and continuous cuts.

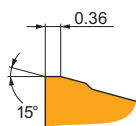
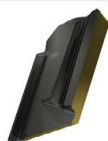
KNUX 160405L-32:T9425	●	0.5	245	0.25	2.7	145	0.25	2.7	230	0.25	2.7	—	—	—	—	—	—	—	—	—
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● Stable working conditions ⚙ Unstable working conditions ⚙ Heavy working conditions ■ Primary use ▣ Possible use



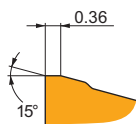
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



L-32 geometry with left-handed design for finish to semi-rough machining, and continuous cuts.

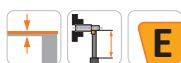
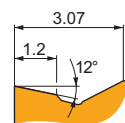
KNUX 160410L-32:T9425	●	1.0	280	0.32	2.7	165	0.32	2.7	265	0.32	2.7	—	—	—	—	—	—	—	—	—
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R-32 geometry with right-handed design for finish to semi-rough machining, and continuous cuts.

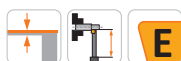
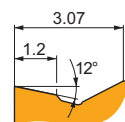
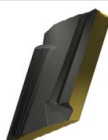
KNUX 160405R-32:T9425	●	0.5	245	0.25	2.7	145	0.25	2.7	230	0.25	2.7	—	—	—	—	—	—	—	—	—
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KNUX 160410R-32:T9425	●	1.0	280	0.32	2.7	165	0.32	2.7	265	0.32	2.7	—	—	—	—	—	—	—	—	—
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ER-72 geometry with right-handed design for fine to finish machining, and continuous cuts.

KNUX 160405ER-72:T9425	●	0.5	325	0.20	2.0	195	0.18	2.0	305	0.20	2.0	—	—	—	70	0.16	1.6	—	—	—
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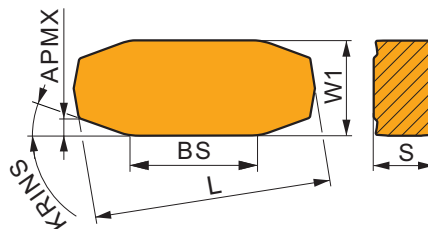
EL-72 geometry with left-handed design for fine to finish machining, and continuous cuts.

KNUX 160405EL-72:T9425	●	0.5	325	0.20	2.0	195	0.18	2.0	305	0.20	2.0	—	—	—	70	0.16	1.6	—	—	—
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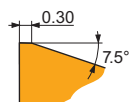
LNGF 30



	L (mm)	S (mm)
3007	30.12	7.54



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)



Peeling geometry PM with wiper secondary cutting edge for medium depth of cut, high linear speed for stable to unstable cutting conditions.

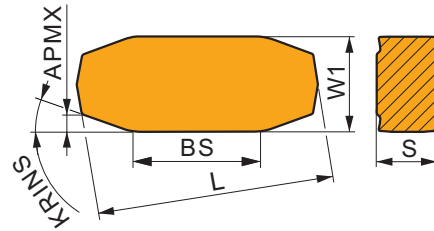
LNGF 300715-PM-S01:T9425	●	—	205	1.70	0.7	120	1.53	0.7	—	—	—	—	—	—	—	—	—	—	—	—
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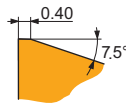
LNGF 36



	L	S	APMX
	(mm)	(mm)	(mm)
3612	36.50	12.00	2.00



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



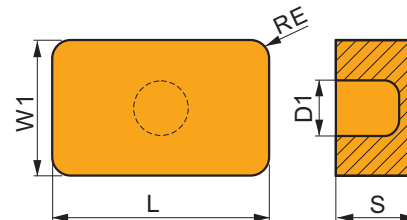
Peeling geometry **PM** with wiper secondary cutting edge for medium depth of cut, high linear speed for stable to unstable cutting conditions.

LNGF 361220-PM-S01:T9425	☹	—	■	180	2.50	0.8	■	105	2.25	0.8	■	—	—	—	■	—	—	—	■
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LNUX 40, LN.X 50

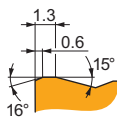


	D1	L	S
	(mm)	(mm)	(mm)
40-1	9.30	40.00	14.00
50-1	9.30	50.80	14.00
5014	6.35	50.80	14.00



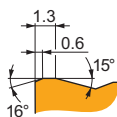
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



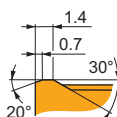
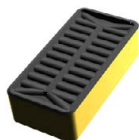
LN.X for heavy rough machining and continuous to interrupted cuts.

LNUX 40-1129003:T9425	☹	3.2	■	80	1.35	25.0	■	—	—	—	■	75	1.35	25.0	■	—	—	—	■
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LN.X for heavy rough machining and continuous to interrupted cuts.

LNUX 50-1275000:T9425	☹	3.2	■	80	1.35	25.0	■	—	—	—	■	75	1.35	25.0	■	—	—	—	■
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LN.X design for heavy rough machining and continuous to heavy interrupted cuts.

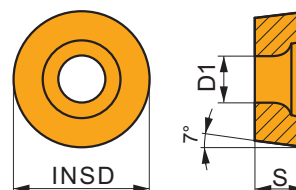
LNMX 501432E:T9425	☹	3.2	■	85	1.50	25.0	■	—	—	—	■	80	1.50	25.0	■	—	—	—	■
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RCMT

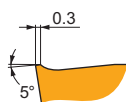
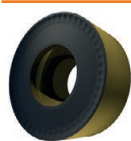


	D1 (mm)	S (mm)
0602	2.80	2.38
0803	3.40	3.18
10T3	4.40	3.97
1204	4.40	4.76
1606	5.50	6.35
2006	6.50	6.35



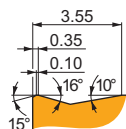
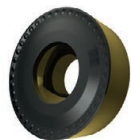
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



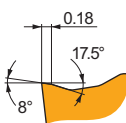
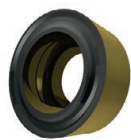
37 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMT 1606MOS-37-T9425	✱	—	■	245	0.60	3.0	■	—	—	—	■	230	0.60	3.0	■	—	—	—	■	—	—	—
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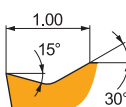
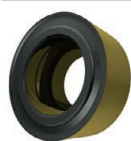
371 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

RCMT 2006MOS-371-T9425	✱	—	■	225	0.80	3.0	■	—	—	—	■	210	0.80	3.0	■	—	—	—	■	—	—	—
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FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

RCMT 0602MOE-FM-T9425	✱	—	■	385	0.45	1.2	■	230	0.41	1.2	■	365	0.45	1.2	■	—	—	—	■	—	—	—
RCMT 0803MOE-FM-T9425	✱	—	■	345	0.60	1.6	■	205	0.54	1.6	■	325	0.60	1.6	■	—	—	—	■	—	—	—
RCMT 10T3MOE-FM-T9425	✱	—	■	335	0.65	1.7	■	200	0.59	1.7	■	315	0.65	1.7	■	—	—	—	■	—	—	—
RCMT 1204MOE-FM-T9425	✱	—	■	320	0.70	1.8	■	190	0.63	1.8	■	300	0.70	1.8	■	—	—	—	■	—	—	—



UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

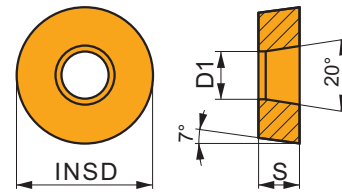
RCMT 0602MOE-UR-T9425	✱	—	■	350	0.40	1.2	■	210	0.36	1.2	■	330	0.40	1.2	■	—	—	—	■	—	—	—
RCMT 0803MOE-UR-T9425	✱	—	■	325	0.45	1.6	■	195	0.41	1.6	■	305	0.45	1.6	■	—	—	—	■	—	—	—
RCMT 10T3MOE-UR-T9425	✱	—	■	320	0.50	1.4	■	190	0.45	1.4	■	300	0.50	1.4	■	—	—	—	■	—	—	—
RCMT 1204MOE-UR-T9425	✱	—	■	305	0.55	1.8	■	180	0.50	1.8	■	285	0.55	1.8	■	—	—	—	■	—	—	—



RCMX



	D1 (mm)	S (mm)
1003	3.60	3.18
1204	4.20	4.76
1606	5.20	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.

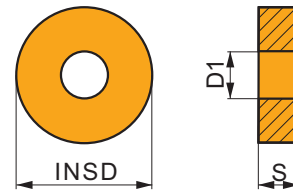
Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)
 	●	31 geometry for finish to semi-rough machining, and continuous to interrupted cuts.																	
		275	0.50	2.0	165	0.45	2.0	260	0.50	2.0	—	—	—	—	—	—	—	—	—
 	●	37 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																	
		245	0.60	3.0	—	—	—	230	0.60	3.0	—	—	—	—	—	—	—	—	—
 	●	321 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																	
		210	1.00	3.0	—	—	—	195	1.00	3.0	—	—	—	—	—	—	—	—	—
 	●	331 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																	
		195	1.20	3.5	—	—	—	185	1.20	3.5	—	—	—	—	—	—	—	—	—



RNMG

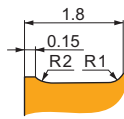
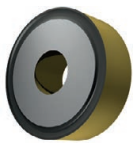


	D1 (mm)	S (mm)
1204	5.16	4.76
1506	6.35	6.35
1906	7.94	6.35
2509	9.12	9.53



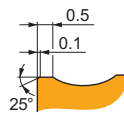
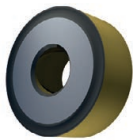
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



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

RNMG 120400E-08:T9425	●	—	■	240	0.70	3.0	—	—	—	■	225	0.70	3.0	—	—	—	—	—	—
RNMG 150600E-08:T9425	✱	—	■	360	0.70	3.0	—	—	—	■	340	0.70	3.0	—	—	—	—	—	—
RNMG 190600E-08:T9425	●	—	■	240	0.70	3.0	—	—	—	■	225	0.70	3.0	—	—	—	—	—	—



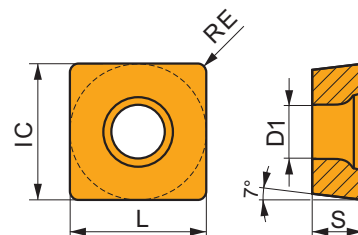
081 geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

RNMG 250900E-081:T9425	✱	—	■	180	0.90	5.0	—	—	—	■	170	0.90	5.0	—	—	—	—	—	—
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SCMT

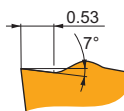
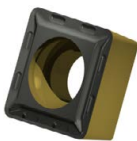


	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76
2509	25.400	8.70	25.40	9.53
3809	38.100	8.70	38.10	9.53



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)



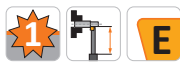
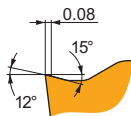
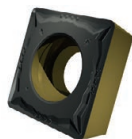
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

SCMT 09T304E-FF2:T9425	●	0.4	■	375	0.12	1.2	—	—	—	■	355	0.12	1.2	—	—	—	—	—	—
SCMT 09T308E-FF2:T9425	●	0.8	■	395	0.17	1.2	—	—	—	■	375	0.17	1.2	—	—	—	—	—	—



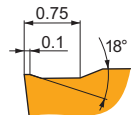
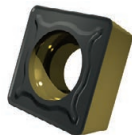
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



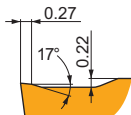
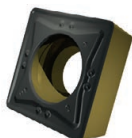
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

SCMT 09T304E-FM:T9425	●	0.4	385	0.15	1.2	230	0.15	1.2	365	0.15	1.2	—	—	—	—	—	—	—	—	—
SCMT 09T308E-FM:T9425	●	0.8	415	0.20	1.2	245	0.18	1.2	390	0.20	1.2	—	—	—	—	—	—	—	—	—
SCMT 120404E-FM:T9425	●	0.4	370	0.15	1.6	220	0.15	1.6	350	0.15	1.6	—	—	—	—	—	—	—	—	—
SCMT 120408E-FM:T9425	●	0.8	400	0.20	1.6	240	0.18	1.6	380	0.20	1.6	—	—	—	—	—	—	—	—	—
SCMT 120412E-FM:T9425	●	1.2	385	0.27	1.6	230	0.24	1.6	365	0.27	1.6	—	—	—	—	—	—	—	—	—



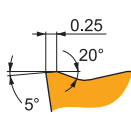
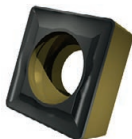
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

SCMT 09T304E-FM2:T9425	●	0.4	385	0.12	1.0	230	0.11	1.0	365	0.12	1.0	—	—	—	—	—	—	—	—	—
SCMT 09T308E-FM2:T9425	●	0.8	405	0.17	1.0	240	0.15	1.0	380	0.17	1.0	—	—	—	—	—	—	—	—	—



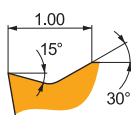
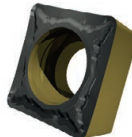
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

SCMT 09T308E-RM:T9425	●	0.8	365	0.30	2.0	215	0.27	2.0	345	0.30	2.0	—	—	—	80	0.24	1.6	—	—	—
SCMT 120408E-RM:T9425	●	0.8	360	0.30	2.3	215	0.27	2.3	340	0.30	2.3	—	—	—	80	0.24	1.8	—	—	—



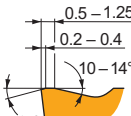
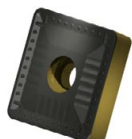
RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

SCMT 120408E-RM3:T9425	●	0.8	320	0.27	2.3	190	0.27	2.3	300	0.27	2.3	—	—	—	—	—	—	—	—	—
SCMT 120412E-RM3:T9425	●	1.2	330	0.30	2.3	195	0.27	2.3	310	0.30	2.3	—	—	—	—	—	—	—	—	—



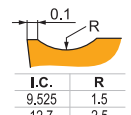
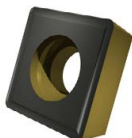
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

SCMT 09T304E-UR:T9425	●	0.4	330	0.15	1.2	195	0.15	1.2	310	0.15	1.2	—	—	—	—	—	—	—	—	—
SCMT 09T308E-UR:T9425	●	0.8	360	0.20	1.2	215	0.18	1.2	340	0.20	1.2	—	—	—	—	—	—	—	—	—
SCMT 120408E-UR:T9425	●	0.8	345	0.20	1.6	205	0.18	1.6	325	0.20	1.6	—	—	—	—	—	—	—	—	—



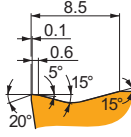
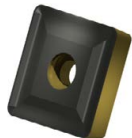
OR chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Steels, Cast irons, and conditionally for Super-alloys.

SCMT 250924E-OR:T9425	●	2.4	125	1.00	10.0	75	0.90	10.0	115	1.00	10.0	—	—	—	25	0.70	8.0	—	—	—
SCMT 380932E-OR:T9425	●	3.2	110	1.20	18.0	65	1.08	18.0	100	1.20	18.0	—	—	—	20	1.08	9.9	—	—	—



RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

SCMT 09T308E-RF:T9425	●	0.8	335	0.20	1.5	200	0.18	1.5	315	0.20	1.5	—	—	—	—	—	—	—	—	—
SCMT 120408E-RF:T9425	●	0.8	310	0.22	2.2	185	0.22	2.2	290	0.22	2.2	—	—	—	—	—	—	—	—	—



DR4 chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

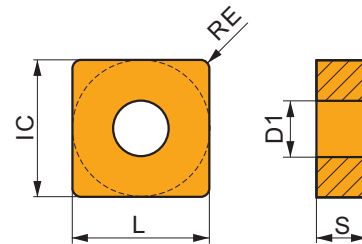
SCMT 380932E-DR4:T9425	●	3.2	85	1.33	16.0	50	1.20	16.0	80	1.33	16.0	—	—	—	—	—	—	—	—	—
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SNMG

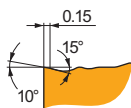
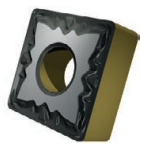


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0903	—	—	—	—
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2509	25.400	9.12	25.40	9.53



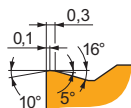
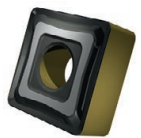
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



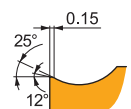
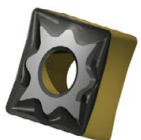
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

SNMG 120404E-FM-T9425	●	0.4	■	365	0.20	2.1	■	215	0.18	2.1	■	345	0.20	2.1	■	80	0.16	1.7	■	—	—	—
SNMG 120408E-FM-T9425	●	0.8	■	435	0.20	2.1	■	260	0.18	2.1	■	410	0.20	2.1	■	95	0.16	1.7	■	—	—	—
SNMG 120412E-FM-T9425	●	1.2	■	420	0.27	2.1	■	250	0.24	2.1	■	395	0.27	2.1	■	90	0.19	1.7	■	—	—	—



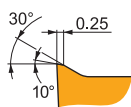
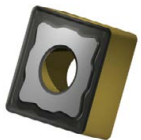
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

SNMG 090308E-M-T9425	●	—	■	340	0.32	2.1	■	—	—	—	■	320	0.32	2.1	■	—	—	—	■	—	—	—
SNMG 120408E-M-T9425	●	0.8	■	340	0.32	2.1	■	—	—	—	■	320	0.32	2.1	■	—	—	—	■	—	—	—
SNMG 120412E-M-T9425	●	1.2	■	335	0.40	2.1	■	—	—	—	■	315	0.40	2.1	■	—	—	—	■	—	—	—
SNMG 120416E-M-T9425	●	1.6	■	350	0.40	2.1	■	—	—	—	■	330	0.40	2.1	■	—	—	—	■	—	—	—
SNMG 150612E-M-T9425	●	1.2	■	320	0.40	3.4	■	—	—	—	■	300	0.40	3.4	■	—	—	—	■	—	—	—
SNMG 190612E-M-T9425	●	1.2	■	315	0.40	4.0	■	—	—	—	■	295	0.40	4.0	■	—	—	—	■	—	—	—
SNMG 190616E-M-T9425	●	1.6	■	330	0.40	4.0	■	—	—	—	■	310	0.40	4.0	■	—	—	—	■	—	—	—



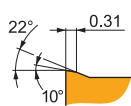
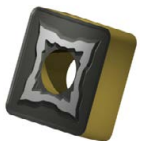
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

SNMG 120404E-NF-T9425	●	0.4	■	390	0.18	1.7	■	230	0.16	1.7	■	370	0.18	1.7	■	85	0.16	1.4	■	—	—	—
SNMG 120408E-NF-T9425	●	0.8	■	455	0.19	1.7	■	270	0.17	1.7	■	430	0.19	1.7	■	100	0.15	1.4	■	—	—	—



NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

SNMG 120408E-NM-T9425	●	0.8	■	420	0.25	2.1	■	250	0.23	2.1	■	—	—	—	■	90	0.20	1.7	■	—	—	—
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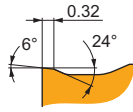
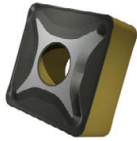
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

SNMG 120408E-NMR-T9425	●	0.8	■	320	0.35	2.6	■	190	0.32	2.6	■	—	—	—	■	70	0.25	2.1	■	—	—	—
SNMG 120412E-NMR-T9425	●	1.2	■	330	0.40	2.6	■	195	0.36	2.6	■	—	—	—	■	70	0.28	2.1	■	—	—	—
SNMG 150612E-NMR-T9425	●	1.2	■	315	0.40	3.8	■	185	0.36	3.8	■	—	—	—	■	70	0.28	3.0	■	—	—	—



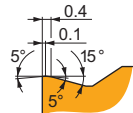
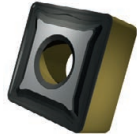
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



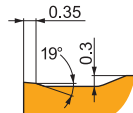
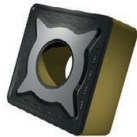
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.

SNMG 250924-NRM:T9425		2.4	150	0.65	9.0	90	0.59	9.0	140	0.65	9.0	—	—	—	30	0.46	7.2	—	—	—
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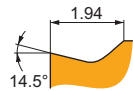
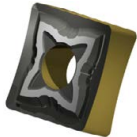
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.

SNMG 120408E-R:T9425		0.8	295	0.40	3.8	—	—	—	280	0.40	3.8	—	—	—	—	—	—	—	—	—
SNMG 120412E-R:T9425		1.2	300	0.45	3.8	—	—	—	285	0.45	3.8	—	—	—	—	—	—	—	—	—
SNMG 120416E-R:T9425		1.6	305	0.50	3.8	—	—	—	285	0.50	3.8	—	—	—	—	—	—	—	—	—
SNMG 150612E-R:T9425		1.2	295	0.45	4.5	—	—	—	280	0.45	4.5	—	—	—	—	—	—	—	—	—
SNMG 150616E-R:T9425		1.6	300	0.50	4.5	—	—	—	285	0.50	4.5	—	—	—	—	—	—	—	—	—
SNMG 190612E-R:T9425		1.2	285	0.45	6.0	—	—	—	270	0.45	6.0	—	—	—	—	—	—	—	—	—
SNMG 190616E-R:T9425		1.6	295	0.50	6.0	—	—	—	280	0.50	6.0	—	—	—	—	—	—	—	—	—



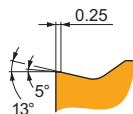
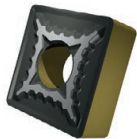
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

SNMG 120408E-RM:T9425		0.8	340	0.40	4.0	200	0.36	4.0	320	0.40	4.0	—	—	—	75	0.28	3.2	—	—	—
SNMG 120412E-RM:T9425		1.2	350	0.45	4.0	210	0.41	4.0	330	0.45	4.0	—	—	—	75	0.32	3.2	—	—	—
SNMG 120416E-RM:T9425		1.6	355	0.50	4.0	210	0.45	4.0	335	0.50	4.0	—	—	—	75	0.35	3.2	—	—	—
SNMG 150612E-RM:T9425		1.2	335	0.45	5.0	200	0.41	5.0	315	0.45	5.0	—	—	—	75	0.32	4.0	—	—	—
SNMG 150616E-RM:T9425		1.6	345	0.50	5.0	205	0.45	5.0	325	0.50	5.0	—	—	—	75	0.35	4.0	—	—	—
SNMG 190612E-RM:T9425		1.2	330	0.45	7.0	195	0.41	7.0	310	0.45	7.0	—	—	—	70	0.32	5.6	—	—	—
SNMG 190616E-RM:T9425		1.6	335	0.50	7.0	200	0.45	7.0	315	0.50	7.0	—	—	—	75	0.35	5.6	—	—	—
SNMG 250924E-RM:T9425		2.4	155	0.80	12.0	90	0.72	12.0	145	0.80	12.0	—	—	—	30	0.56	9.6	—	—	—



SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.

SNMG 120408E-SF:T9425		0.8	450	0.20	1.0	270	0.18	1.0	425	0.20	1.0	—	—	—	100	0.16	0.8	—	—	—
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SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

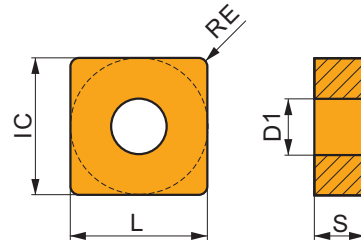
SNMG 120408E-SM:T9425		0.8	395	0.25	1.8	235	0.23	1.8	375	0.25	1.8	—	—	—	85	0.20	1.4	—	—	—
SNMG 190612E-SM:T9425		1.2	360	0.30	4.0	215	0.27	4.0	340	0.30	4.0	—	—	—	80	0.27	3.2	—	—	—
SNMG 190616E-SM:T9425		1.6	345	0.40	4.0	205	0.36	4.0	325	0.40	4.0	—	—	—	75	0.32	3.2	—	—	—



SNMM

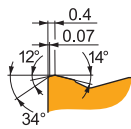
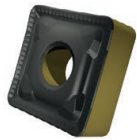


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.53



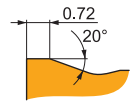
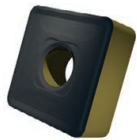
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



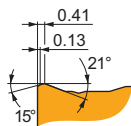
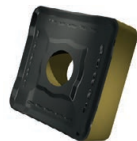
HR chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

SNMM 190616E-HR:T9425	1.6	145	0.60	9.0	85	0.54	9.0	135	0.60	9.0	—	—	—	—	—	—	—	—	—
SNMM 190624E-HR:T9425	2.4	150	0.65	9.0	90	0.59	9.0	140	0.65	9.0	—	—	—	—	—	—	—	—	—
SNMM 250716E-HR:T9425	1.6	140	0.60	13.0	80	0.54	13.0	130	0.60	13.0	—	—	—	—	—	—	—	—	—
SNMM 250724E-HR:T9425	2.4	140	0.65	13.0	80	0.59	13.0	130	0.65	13.0	—	—	—	—	—	—	—	—	—
SNMM 250732E-HR:T9425	3.2	130	0.80	13.0	75	0.72	13.0	120	0.80	13.0	—	—	—	—	—	—	—	—	—
SNMM 250924E-HR:T9425	2.4	140	0.65	13.0	80	0.59	13.0	130	0.65	13.0	—	—	—	—	—	—	—	—	—
SNMM 250932E-HR:T9425	3.2	130	0.80	13.0	75	0.72	13.0	120	0.80	13.0	—	—	—	—	—	—	—	—	—



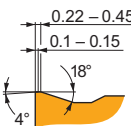
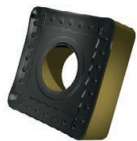
HR2 chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features positive rake angle and stable, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

SNMM 190616E-HR2:T9425	1.6	140	0.65	8.9	80	0.59	8.9	130	0.65	8.9	—	—	—	—	—	—	—	—	—
SNMM 190624E-HR2:T9425	2.4	135	0.85	8.9	80	0.77	8.9	125	0.85	8.9	—	—	—	—	—	—	—	—	—
SNMM 250724E-HR2:T9425	2.4	130	0.85	11.0	75	0.77	11.0	120	0.85	11.0	—	—	—	—	—	—	—	—	—
SNMM 250924E-HR2:T9425	2.4	130	0.85	11.0	75	0.77	11.0	120	0.85	11.0	—	—	—	—	—	—	—	—	—
SNMM 250932E-HR2:T9425	3.2	125	1.00	11.0	75	0.90	11.0	115	1.00	11.0	—	—	—	—	—	—	—	—	—



NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

SNMM 120408E-NR2:T9425	0.8	320	0.40	4.7	190	0.36	4.7	300	0.40	4.7	—	—	—	70	0.32	3.8	—	—	—
SNMM 150612E-NR2:T9425	1.2	315	0.45	6.0	185	0.41	6.0	295	0.45	6.0	—	—	—	70	0.36	4.8	—	—	—
SNMM 150616E-NR2:T9425	1.6	325	0.50	6.0	195	0.45	6.0	305	0.50	6.0	—	—	—	70	0.40	4.8	—	—	—
SNMM 190612E-NR2:T9425	1.2	310	0.45	8.0	185	0.41	8.0	290	0.45	8.0	—	—	—	65	0.36	6.4	—	—	—
SNMM 190616E-NR2:T9425	1.6	315	0.50	8.0	185	0.45	8.0	295	0.50	8.0	—	—	—	70	0.40	6.4	—	—	—
SNMM 190624E-NR2:T9425	2.4	285	0.80	8.0	170	0.72	8.0	270	0.80	8.0	—	—	—	60	0.56	6.4	—	—	—
SNMM 250724E-NR2:T9425	2.4	150	0.80	12.0	90	0.72	12.0	140	0.80	12.0	—	—	—	30	0.56	9.6	—	—	—
SNMM 250924E-NR2:T9425	2.4	150	0.80	12.0	90	0.72	12.0	140	0.80	12.0	—	—	—	30	0.56	9.6	—	—	—



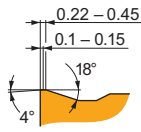
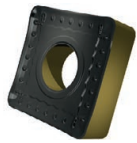
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

SNMM 120408E-OR:T9425	0.8	320	0.40	4.7	190	0.36	4.7	300	0.40	4.7	—	—	—	70	0.32	3.8	—	—	—
SNMM 120412E-OR:T9425	1.2	325	0.45	4.7	195	0.41	4.7	305	0.45	4.7	—	—	—	70	0.36	3.8	—	—	—
SNMM 120416E-OR:T9425	1.6	330	0.50	4.7	195	0.45	4.7	310	0.50	4.7	—	—	—	70	0.40	3.8	—	—	—
SNMM 150608E-OR:T9425	0.8	315	0.40	6.0	185	0.36	6.0	295	0.40	6.0	—	—	—	70	0.36	4.8	—	—	—
SNMM 150612E-OR:T9425	1.2	315	0.45	6.0	185	0.41	6.0	295	0.45	6.0	—	—	—	70	0.36	4.8	—	—	—
SNMM 150616E-OR:T9425	1.6	325	0.50	6.0	195	0.45	6.0	305	0.50	6.0	—	—	—	70	0.40	4.8	—	—	—
SNMM 190612E-OR:T9425	1.2	310	0.45	8.0	185	0.41	8.0	290	0.45	8.0	—	—	—	65	0.36	6.4	—	—	—



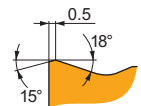
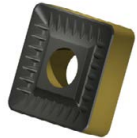
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



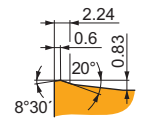
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

SNMM 190616E-OR:T9425	✱	1.6	315	0.50	8.0	185	0.45	8.0	295	0.50	8.0	—	—	—	70	0.40	6.4	—	—	—
SNMM 190624E-OR:T9425	✱	2.4	285	0.80	8.0	170	0.72	8.0	270	0.80	8.0	—	—	—	60	0.56	6.4	—	—	—
SNMM 250716E-OR:T9425	✱	1.6	160	0.55	12.0	95	0.50	12.0	150	0.55	12.0	—	—	—	35	0.50	9.6	—	—	—
SNMM 250724E-OR:T9425	✱	2.4	135	1.00	12.0	80	0.90	12.0	125	1.00	12.0	—	—	—	30	0.70	9.6	—	—	—
SNMM 250924E-OR:T9425	✱	2.4	135	1.00	12.0	80	0.90	12.0	125	1.00	12.0	—	—	—	30	0.70	9.6	—	—	—



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

SNMM 250724S-SR:T9425	✱	2.4	110	1.00	12.0	65	0.90	12.0	100	1.00	12.0	—	—	—	—	—	—	—	—	—
SNMM 250924S-SR:T9425	✱	2.4	110	1.00	14.0	65	0.90	14.0	100	1.00	14.0	—	—	—	—	—	—	—	—	—



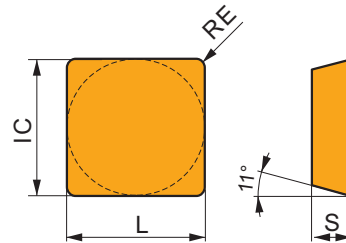
923 chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.

SNMM 190616S-923:T9425	✱	1.6	255	0.65	8.9	150	0.59	8.9	240	0.65	8.9	—	—	—	55	0.52	7.1	—	—	—
SNMM 250724S-923:T9425	✱	2.4	130	0.85	11.0	75	0.77	11.0	120	0.85	11.0	—	—	—	25	0.60	8.8	—	—	—
SNMM 250924S-923:T9425	✱	2.4	130	0.85	11.0	75	0.77	11.0	120	0.85	11.0	—	—	—	25	0.60	8.8	—	—	—

SPMR

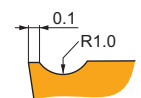


	IC (mm)	L (mm)	S (mm)
0903	9.525	9.53	3.18
1203	12.700	12.70	3.18



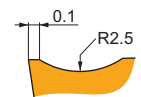
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



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

SPMR 090308E-46:T9425	●	0.8	380	0.15	1.0	225	0.15	1.0	360	0.15	1.0	—	—	—	—	—	—	—	—	—
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48 geometry for finish to semi-rough machining, and continuous to interrupted cuts.

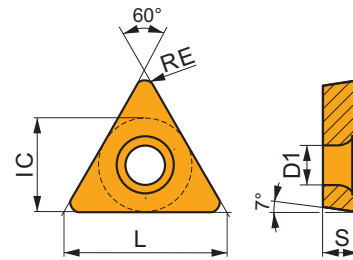
SPMR 120304E-48:T9425	●	0.4	260	0.22	2.2	155	0.22	2.2	245	0.22	2.2	—	—	—	—	—	—	—	—	—
SPMR 120308E-48:T9425	●	0.8	310	0.22	2.2	185	0.22	2.2	290	0.22	2.2	—	—	—	—	—	—	—	—	—
SPMR 120312E-48:T9425	●	1.2	325	0.22	2.2	195	0.22	2.2	305	0.22	2.2	—	—	—	—	—	—	—	—	—



TCMT

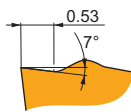
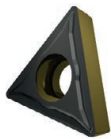


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



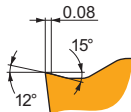
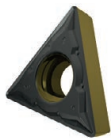
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



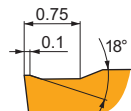
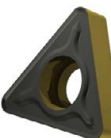
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

TCMT 06T104E-FF2:T9425	●	0.4	■	315	0.12	0.8	■	295	0.12	0.8	■	—	—	—	■	—	—	—	■	—	—	—
TCMT 090204E-FF2:T9425	●	0.4	■	310	0.12	1.0	■	290	0.12	1.0	■	—	—	—	■	—	—	—	■	—	—	—
TCMT 110204E-FF2:T9425	●	0.4	■	315	0.12	0.8	■	295	0.12	0.8	■	—	—	—	■	—	—	—	■	—	—	—
TCMT 110208E-FF2:T9425	●	0.8	■	335	0.17	0.8	■	315	0.17	0.8	■	—	—	—	■	—	—	—	■	—	—	—
TCMT 16T304E-FF2:T9425	●	0.4	■	315	0.12	0.8	■	295	0.12	0.8	■	—	—	—	■	—	—	—	■	—	—	—
TCMT 16T308E-FF2:T9425	●	0.8	■	335	0.17	0.8	■	315	0.17	0.8	■	—	—	—	■	—	—	—	■	—	—	—



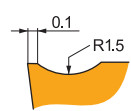
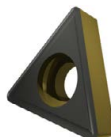
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

TCMT 110202E-FM:T9425	●	0.2	■	345	0.10	0.8	■	205	0.09	0.8	■	325	0.10	0.8	■	—	—	—	■	—	—	—
TCMT 110204E-FM:T9425	●	0.4	■	305	0.18	0.8	■	180	0.16	0.8	■	285	0.18	0.8	■	—	—	—	■	—	—	—
TCMT 110208E-FM:T9425	●	0.8	■	370	0.17	0.8	■	220	0.15	0.8	■	350	0.17	0.8	■	—	—	—	■	—	—	—
TCMT 16T304E-FM:T9425	●	0.4	■	285	0.18	1.7	■	170	0.16	1.7	■	270	0.18	1.7	■	—	—	—	■	—	—	—
TCMT 16T308E-FM:T9425	●	0.8	■	340	0.17	1.7	■	200	0.15	1.7	■	320	0.17	1.7	■	—	—	—	■	—	—	—



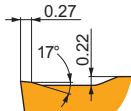
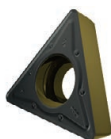
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

TCMT 110204E-FM2:T9425	●	0.4	■	315	0.12	0.8	■	185	0.11	0.8	■	295	0.12	0.8	■	—	—	—	■	—	—	—
TCMT 110208E-FM2:T9425	●	0.8	■	335	0.17	0.8	■	200	0.15	0.8	■	315	0.17	0.8	■	—	—	—	■	—	—	—
TCMT 16T308E-FM2:T9425	●	0.8	■	310	0.20	1.0	■	185	0.18	1.0	■	290	0.20	1.0	■	—	—	—	■	—	—	—



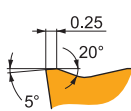
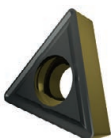
RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

TCMT 16T308E-RF:T9425	●	0.8	■	270	0.20	1.5	■	160	0.18	1.5	■	255	0.20	1.5	■	—	—	—	■	—	—	—
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RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

TCMT 16T308E-RM:T9425	●	0.8	■	305	0.27	1.9	■	180	0.24	1.9	■	285	0.27	1.9	■	—	—	—	■	65	0.19	1.5	■	—	—	—
TCMT 16T312E-RM:T9425	●	1.2	■	320	0.27	1.9	■	190	0.24	1.9	■	300	0.27	1.9	■	—	—	—	■	70	0.19	1.5	■	—	—	—



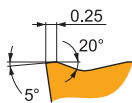
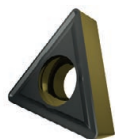
RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

TCMT 16T304E-RM3:T9425	●	0.4	■	225	0.25	2.0	■	135	0.25	2.0	■	210	0.25	2.0	■	—	—	—	■	—	—	—	■	—	—	—
TCMT 16T308E-RM3:T9425	●	0.8	■	265	0.27	2.0	■	155	0.27	2.0	■	250	0.27	2.0	■	—	—	—	■	—	—	—	■	—	—	—

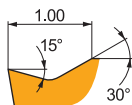
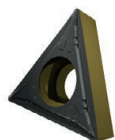


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.



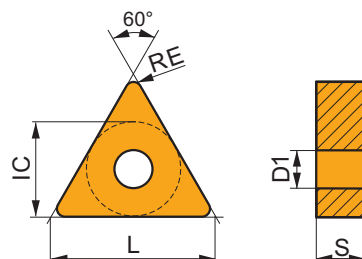
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

TCMT 110204E-UR:T9425	●	0.4	260	0.18	0.8	155	0.16	0.8	245	0.18	0.8	—	—	—	—	—	—	—	—	—
TCMT 16T304E-UR:T9425	●	0.4	260	0.18	0.8	155	0.16	0.8	245	0.18	0.8	—	—	—	—	—	—	—	—	—
TCMT 16T308E-UR:T9425	●	0.8	320	0.17	0.8	190	0.15	0.8	300	0.17	0.8	—	—	—	—	—	—	—	—	—

TNMG

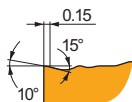
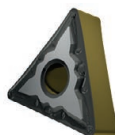


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35
3309	19.050	7.94	33.00	9.53



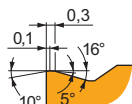
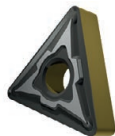
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



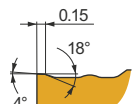
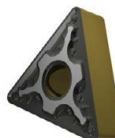
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

TNMG 160404E-FM:T9425	●	0.4	305	0.20	1.7	180	0.18	1.7	285	0.20	1.7	—	—	—	65	0.20	1.4	—	—	—
TNMG 160408E-FM:T9425	●	0.8	360	0.20	1.7	215	0.18	1.7	340	0.20	1.7	—	—	—	80	0.16	1.4	—	—	—
TNMG 160412E-FM:T9425	●	1.2	355	0.25	1.7	210	0.23	1.7	335	0.25	1.7	—	—	—	75	0.18	1.4	—	—	—
TNMG 220404E-FM:T9425	●	0.4	305	0.20	1.7	180	0.18	1.7	285	0.20	1.7	—	—	—	65	0.18	1.4	—	—	—
TNMG 220408E-FM:T9425	●	0.8	360	0.20	1.7	215	0.18	1.7	340	0.20	1.7	—	—	—	80	0.16	1.4	—	—	—



M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

TNMG 160404E-M:T9425	●	0.4	275	0.20	1.6	—	—	—	260	0.20	1.6	—	—	—	—	—	—	—	—	—
TNMG 160408E-M:T9425	●	0.8	290	0.30	1.6	—	—	—	275	0.30	1.6	—	—	—	—	—	—	—	—	—
TNMG 160412E-M:T9425	●	1.2	280	0.40	1.6	—	—	—	265	0.40	1.6	—	—	—	—	—	—	—	—	—
TNMG 220408E-M:T9425	●	0.8	280	0.30	2.1	—	—	—	265	0.30	2.1	—	—	—	—	—	—	—	—	—
TNMG 220412E-M:T9425	●	1.2	270	0.40	2.1	—	—	—	255	0.40	2.1	—	—	—	—	—	—	—	—	—



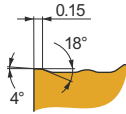
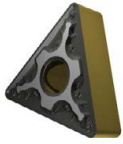
ML chip breaker is versatile and designed for low depth of cut and medium machining of steels. It features positive rake angle and stable, narrow T-land. It's also suitable for cast irons.

TNMG 160404-ML:T9415	●	0.4	310	0.20	1.0	—	—	—	290	0.20	1.0	—	—	—	—	—	—	—	—	—
TNMG 160404-ML:T9425	●	0.4	290	0.20	1.0	—	—	—	275	0.20	1.0	—	—	—	—	—	—	—	—	—
TNMG 160408-ML:T9415	●	0.8	320	0.25	1.5	—	—	—	300	0.25	1.5	—	—	—	—	—	—	—	—	—



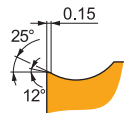
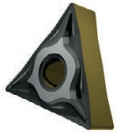
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



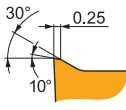
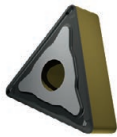
ML chip breaker is versatile and designed for low depth of cut and medium machining of steels. It features positive rake angle and stable, narrow T-land. It's also suitable for cast irons.

TNMG 160408-ML:T9425	●	0.8	310	0.25	1.5	—	—	—	290	0.25	1.5	—	—	—	—	—	—	—	—	—
TNMG 160412-ML:T9415	●	1.2	305	0.30	2.0	—	—	—	285	0.30	2.0	—	—	—	—	—	—	—	—	—
TNMG 160412-ML:T9425	●	1.2	300	0.30	2.0	—	—	—	285	0.30	2.0	—	—	—	—	—	—	—	—	—



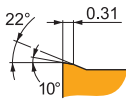
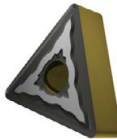
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

TNMG 160404E-NF:T9425	●	0.4	320	0.18	1.4	190	0.16	1.4	300	0.18	1.4	—	—	—	70	0.16	1.1	—	—	—
TNMG 160408E-NF:T9425	●	0.8	380	0.18	1.4	225	0.16	1.4	360	0.18	1.4	—	—	—	85	0.16	1.1	—	—	—



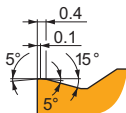
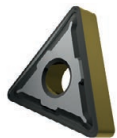
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

TNMG 160404E-NM:T9425	●	0.4	315	0.20	1.9	185	0.18	1.9	—	—	—	—	—	—	70	0.20	1.5	—	—	—
TNMG 160408E-NM:T9425	●	0.8	345	0.25	1.9	205	0.23	1.9	—	—	—	—	—	—	75	0.20	1.5	—	—	—
TNMG 220408E-NM:T9425	●	0.8	350	0.25	1.7	210	0.23	1.7	—	—	—	—	—	—	75	0.20	1.4	—	—	—
TNMG 220412E-NM:T9425	●	1.2	340	0.30	2.1	200	0.27	2.1	—	—	—	—	—	—	75	0.24	1.7	—	—	—



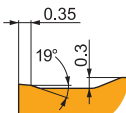
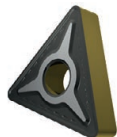
NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

TNMG 160404E-NMR:T9425	●	0.4	275	0.20	1.7	165	0.18	1.7	—	—	—	—	—	—	60	0.18	1.4	—	—	—
TNMG 160408E-NMR:T9425	●	0.8	290	0.30	1.7	170	0.27	1.7	—	—	—	—	—	—	65	0.24	1.4	—	—	—
TNMG 220408E-NMR:T9425	●	0.8	280	0.30	2.1	165	0.27	2.1	—	—	—	—	—	—	60	0.24	1.7	—	—	—
TNMG 220412E-NMR:T9425	●	1.2	295	0.30	2.1	175	0.27	2.1	—	—	—	—	—	—	65	0.24	1.7	—	—	—



R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.

TNMG 160408E-R:T9425	●	0.8	250	0.40	3.0	—	—	—	235	0.40	3.0	—	—	—	—	—	—	—	—	—
TNMG 160412E-R:T9425	●	1.2	260	0.40	3.0	—	—	—	245	0.40	3.0	—	—	—	—	—	—	—	—	—
TNMG 220408E-R:T9425	●	0.8	240	0.40	4.0	—	—	—	225	0.40	4.0	—	—	—	—	—	—	—	—	—
TNMG 220412E-R:T9425	●	1.2	255	0.40	4.0	—	—	—	240	0.40	4.0	—	—	—	—	—	—	—	—	—
TNMG 220416E-R:T9425	●	1.6	265	0.40	4.0	—	—	—	250	0.40	4.0	—	—	—	—	—	—	—	—	—



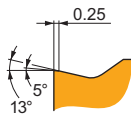
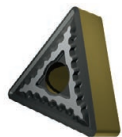
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

TNMG 160408E-RM:T9425	●	0.8	285	0.40	3.0	170	0.36	3.0	270	0.40	3.0	—	—	—	60	0.30	2.4	—	—	—
TNMG 160412E-RM:T9425	●	1.2	300	0.40	3.0	180	0.36	3.0	285	0.40	3.0	—	—	—	65	0.30	2.4	—	—	—
TNMG 220408E-RM:T9425	●	0.8	275	0.40	4.0	165	0.36	4.0	260	0.40	4.0	—	—	—	60	0.30	3.2	—	—	—
TNMG 220412E-RM:T9425	●	1.2	290	0.40	4.0	170	0.36	4.0	275	0.40	4.0	—	—	—	65	0.30	3.2	—	—	—
TNMG 220416E-RM:T9425	●	1.6	305	0.40	4.0	180	0.36	4.0	285	0.40	4.0	—	—	—	65	0.30	3.2	—	—	—
TNMG 270612E-RM:T9425	●	1.2	155	0.40	6.0	90	0.36	6.0	145	0.40	6.0	—	—	—	30	0.30	4.8	—	—	—
TNMG 270616E-RM:T9425	●	1.6	160	0.40	6.0	95	0.36	6.0	150	0.40	6.0	—	—	—	35	0.30	4.8	—	—	—
TNMG 270624E-RM:T9425	●	2.4	155	0.50	6.0	90	0.45	6.0	145	0.50	6.0	—	—	—	30	0.38	4.8	—	—	—
TNMG 270632E-RM:T9425	●	3.2	150	0.60	6.0	90	0.54	6.0	140	0.60	6.0	—	—	—	30	0.45	4.8	—	—	—
TNMG 330924E-RM:T9425	●	2.4	150	0.50	10.0	90	0.45	10.0	140	0.50	10.0	—	—	—	30	0.38	8.0	—	—	—



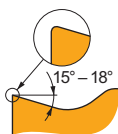
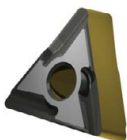
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



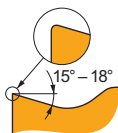
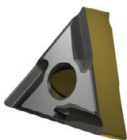
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

TNMG 160404E-SM:T9425	●	0.4	290	0.20	1.7	170	0.18	1.7	275	0.20	1.7	—	—	—	65	0.18	1.4	—	—	—
TNMG 160408E-SM:T9425	●	0.8	320	0.25	1.7	190	0.23	1.7	300	0.25	1.7	—	—	—	70	0.20	1.4	—	—	—
TNMG 160412E-SM:T9425	●	1.2	320	0.30	1.7	190	0.27	1.7	300	0.30	1.7	—	—	—	70	0.24	1.4	—	—	—
TNMG 220404E-SM:T9425	●	0.4	290	0.20	1.7	170	0.18	1.7	275	0.20	1.7	—	—	—	65	0.18	1.4	—	—	—
TNMG 220408E-SM:T9425	●	0.8	320	0.25	1.7	190	0.23	1.7	300	0.25	1.7	—	—	—	70	0.20	1.4	—	—	—
TNMG 220412E-SM:T9425	●	1.2	320	0.30	1.7	190	0.27	1.7	300	0.30	1.7	—	—	—	70	0.24	1.4	—	—	—



SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

TNMG 160404ER-SI:T9425	●	0.4	350	0.20	1.5	210	0.18	1.5	—	—	—	—	—	—	75	0.18	1.2	—	—	—
TNMG 160408ER-SI:T9425	●	0.8	345	0.35	1.5	205	0.32	1.5	—	—	—	—	—	—	75	0.25	1.2	—	—	—



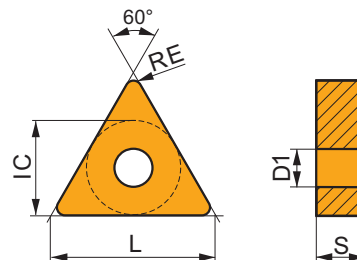
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

TNMG 160404EL-SI:T9425	●	0.4	350	0.20	1.5	210	0.18	1.5	—	—	—	—	—	—	75	0.18	1.2	—	—	—
TNMG 160408EL-SI:T9425	●	0.8	345	0.35	1.5	205	0.32	1.5	—	—	—	—	—	—	75	0.25	1.2	—	—	—

TNMM

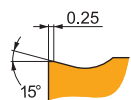
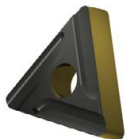


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76
2706	15.875	6.35	27.50	6.35



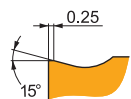
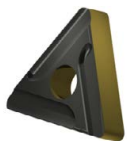
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



EL geometry with left handed design for medium to semi-rough machining, and continuous cuts.

TNMM 220412EL:T9425	●	1.2	355	0.35	2.1	210	0.32	2.1	—	—	—	—	—	—	75	0.25	1.7	—	—	—
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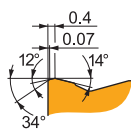
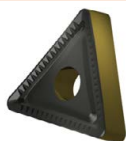
ER geometry with right-handed design for medium to semi-rough machining, and continuous cuts.

TNMM 220412ER:T9425	●	1.2	355	0.35	2.1	210	0.32	2.1	—	—	—	—	—	—	75	0.25	1.7	—	—	—
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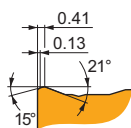
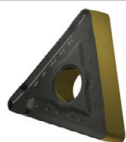
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



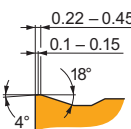
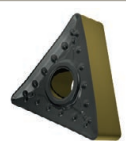
HR chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

TNMM 270616E-HR:T9425	●	1.6	120	0.60	7.0	70	0.54	7.0	110	0.60	7.0	—	—	—	—	—	—	—	—	—
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NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

TNMM 160408E-NR2:T9425	●	0.8	275	0.40	3.0	165	0.36	3.0	260	0.40	3.0	—	—	—	60	0.28	2.4	—	—	—
TNMM 220408E-NR2:T9425	●	0.8	265	0.40	4.0	155	0.36	4.0	250	0.40	4.0	—	—	—	55	0.28	3.2	—	—	—
TNMM 220412E-NR2:T9425	●	1.2	280	0.40	4.0	165	0.36	4.0	265	0.40	4.0	—	—	—	60	0.32	3.2	—	—	—



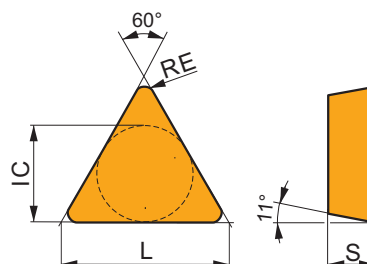
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

TNMM 160408E-OR:T9425	●	0.8	275	0.40	3.0	165	0.36	3.0	260	0.40	3.0	—	—	—	60	0.28	2.4	—	—	—
TNMM 220408E-OR:T9425	●	0.8	265	0.40	4.0	155	0.36	4.0	250	0.40	4.0	—	—	—	55	0.32	3.2	—	—	—
TNMM 220412E-OR:T9425	●	1.2	285	0.40	3.0	170	0.36	3.0	270	0.40	3.0	—	—	—	60	0.32	2.4	—	—	—

TPMR

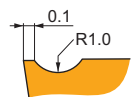
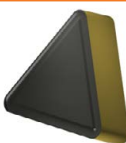


	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



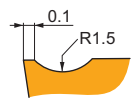
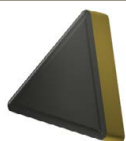
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



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

TPMR 110304E-46:T9425	●	0.4	260	0.15	1.0	155	0.15	1.0	245	0.15	1.0	—	—	—	—	—	—	—	—	—
TPMR 110308E-46:T9425	●	0.8	310	0.15	1.0	185	0.15	1.0	290	0.15	1.0	—	—	—	—	—	—	—	—	—



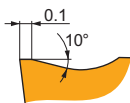
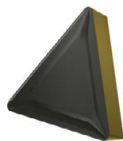
47 geometry for finish to semi-rough machining, and continuous to interrupted cuts.

TPMR 160304E-47:T9425	●	0.4	225	0.20	1.5	135	0.18	1.5	210	0.20	1.5	—	—	—	—	—	—	—	—	—
TPMR 160308E-47:T9425	●	0.8	270	0.20	1.5	160	0.18	1.5	255	0.20	1.5	—	—	—	—	—	—	—	—	—
TPMR 160312E-47:T9425	●	1.2	285	0.20	1.5	170	0.18	1.5	270	0.20	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	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



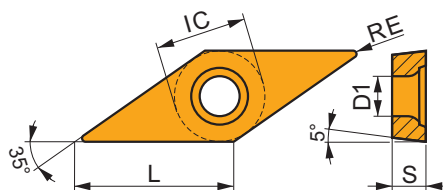
61 geometry for finish machining with moderate feeds and depths of cut, and continuous to interrupted cuts.

TPMR 160308E-61:T9425	●	0.8	220	0.35	1.8	130	0.32	1.8	205	0.35	1.8	—	—	—	—	—	—	—	—	—
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VBMT

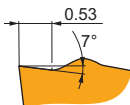


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.10	2.38
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



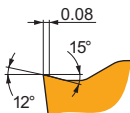
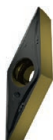
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



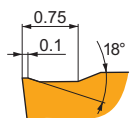
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

VBMT 160404E-FF2:T9425	●	0.4	275	0.12	0.8	—	—	—	260	0.12	0.8	—	—	—	—	—	—	—	—	—
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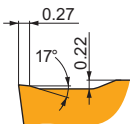
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

VBMT 110302E-FM:T9425	●	0.2	300	0.10	0.8	180	0.09	0.8	285	0.10	0.8	—	—	—	—	—	—	—	—	—
VBMT 110304E-FM:T9425	●	0.4	260	0.19	0.8	155	0.17	0.8	245	0.19	0.8	—	—	—	—	—	—	—	—	—
VBMT 110308E-FM:T9425	●	0.8	320	0.17	0.8	190	0.15	0.8	300	0.17	0.8	—	—	—	—	—	—	—	—	—
VBMT 160402E-FM:T9425	●	0.2	290	0.10	1.2	170	0.09	1.2	275	0.10	1.2	—	—	—	—	—	—	—	—	—
VBMT 160404E-FM:T9425	●	0.4	250	0.19	1.2	150	0.17	1.2	235	0.19	1.2	—	—	—	—	—	—	—	—	—
VBMT 160408E-FM:T9425	●	0.8	305	0.17	1.2	180	0.15	1.2	285	0.17	1.2	—	—	—	—	—	—	—	—	—
VBMT 160412E-FM:T9425	●	1.2	295	0.22	1.2	175	0.22	1.2	280	0.22	1.2	—	—	—	—	—	—	—	—	—



FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

VBMT 160404E-FM2:T9425	●	0.4	265	0.12	1.2	155	0.11	1.2	250	0.12	1.2	—	—	—	—	—	—	—	—	—
VBMT 160408E-FM2:T9425	●	0.8	265	0.20	1.2	155	0.18	1.2	250	0.20	1.2	—	—	—	—	—	—	—	—	—
VBMT 160412E-FM2:T9425	●	1.2	270	0.22	1.2	160	0.20	1.2	255	0.22	1.2	—	—	—	—	—	—	—	—	—



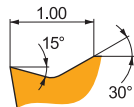
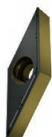
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

VBMT 160404E-RM:T9425	●	0.4	260	0.20	1.2	155	0.18	1.2	245	0.20	1.2	—	—	—	55	0.18	1.0	—	—	—
VBMT 160408E-RM:T9425	●	0.8	305	0.20	1.2	180	0.18	1.2	285	0.20	1.2	—	—	—	65	0.18	1.0	—	—	—
VBMT 160412E-RM:T9425	●	1.2	290	0.27	1.2	170	0.24	1.2	275	0.27	1.2	—	—	—	65	0.19	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	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



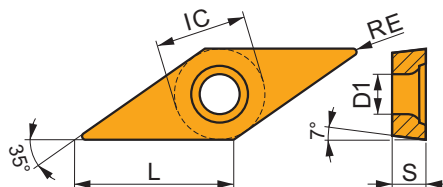
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

VBMT 110204E-UR:T9425	●	0.4	225	0.19	0.8	135	0.17	0.8	210	0.19	0.8	—	—	—	—	—	—	—	—	—
VBMT 160404E-UR:T9425	●	0.4	220	0.18	1.2	130	0.16	1.2	205	0.18	1.2	—	—	—	—	—	—	—	—	—
VBMT 160408E-UR:T9425	●	0.8	265	0.17	1.2	155	0.15	1.2	250	0.17	1.2	—	—	—	—	—	—	—	—	—
VBMT 160412E-UR:T9425	●	1.2	255	0.22	1.2	150	0.20	1.2	240	0.22	1.2	—	—	—	—	—	—	—	—	—

VC GT

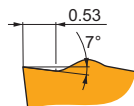


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1303	7.940	3.40	13.80	3.18



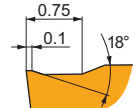
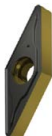
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



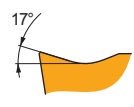
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

VC GT 130302E-FF2:T9425	●	0.2	315	0.05	1.0	—	—	—	295	0.05	1.0	—	—	—	—	—	—	—	—	—
VC GT 130304E-FF2:T9425	●	0.4	255	0.12	1.0	—	—	—	240	0.12	1.0	—	—	—	—	—	—	—	—	—
VC GT 130308E-FF2:T9425	●	0.8	270	0.17	1.0	—	—	—	255	0.17	1.0	—	—	—	—	—	—	—	—	—



FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

VC GT 130308E-FM2:T9425	●	0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	—	—	—	—	—	—	—	—	—
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NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.

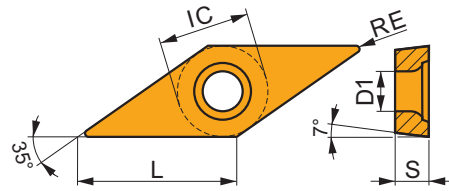
VC GT 130302E-NF2:T9425	●	0.2	285	0.07	1.0	170	0.06	1.0	270	0.07	1.0	—	—	—	60	0.06	0.8	—	—	—
VC GT 130304E-NF2:T9425	●	0.4	255	0.12	1.0	150	0.11	1.0	240	0.12	1.0	—	—	—	55	0.08	0.8	—	—	—
VC GT 130308E-NF2:T9425	●	0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	—	—	—	60	0.12	0.8	—	—	—



VCMT

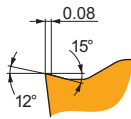


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



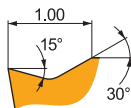
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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 chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

VCMT 160404E-FM:T9425	●	0.4	■	235	0.19	1.2	■	140	0.17	1.2	■	220	0.19	1.2	—	—	—	—	—	—
VCMT 160408E-FM:T9425	●	0.8	■	290	0.17	1.2	■	170	0.15	1.2	■	275	0.17	1.2	—	—	—	—	—	—



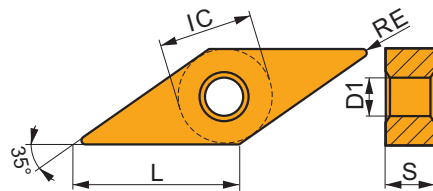
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

VCMT 110304E-UR:T9425	●	0.4	■	215	0.19	0.8	■	125	0.17	0.8	■	200	0.19	0.8	—	—	—	—	—	—
VCMT 110308E-UR:T9425	●	0.8	■	260	0.17	0.8	■	155	0.15	0.8	■	245	0.17	0.8	—	—	—	—	—	—
VCMT 160404E-UR:T9425	●	0.4	■	205	0.19	1.2	■	120	0.17	1.2	■	190	0.19	1.2	—	—	—	—	—	—
VCMT 160408E-UR:T9425	●	0.8	■	250	0.17	1.2	■	150	0.15	1.2	■	235	0.17	1.2	—	—	—	—	—	—

VNMG

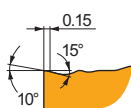


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.60	4.76



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)



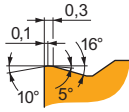
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

VNMG 160404E-FM:T9425	●	0.4	■	260	0.20	1.2	■	155	0.18	1.2	■	245	0.20	1.2	—	—	—	■	55	0.20	1.0
VNMG 160408E-FM:T9425	●	0.8	■	300	0.20	1.4	■	180	0.18	1.4	■	285	0.20	1.4	—	—	—	■	65	0.16	1.1
VNMG 160412E-FM:T9425	●	1.2	■	310	0.22	1.4	■	185	0.20	1.4	■	290	0.22	1.4	—	—	—	■	65	0.18	1.1



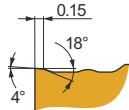
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



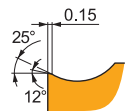
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

VNMG 160404E-M:T9425	●	0.4	235	0.20	1.2	—	—	—	220	0.20	1.2	—	—	—	—	—	—	—	—	—
VNMG 160408E-M:T9425	●	0.8	240	0.30	1.4	—	—	—	225	0.30	1.4	—	—	—	—	—	—	—	—	—
VNMG 160412E-M:T9425	●	1.2	230	0.40	1.4	—	—	—	215	0.40	1.4	—	—	—	—	—	—	—	—	—



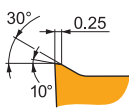
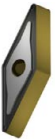
ML chip breaker is versatile and designed for low depth of cut and medium machining of steels. It features positive rake angle and stable, narrow T-land. It's also suitable for cast irons.

VNMG 160404-ML:T9415	●	0.4	255	0.20	1.0	—	—	—	240	0.20	1.0	—	—	—	—	—	—	—	—	—
VNMG 160404-ML:T9425	●	0.4	240	0.20	1.0	—	—	—	225	0.20	1.0	—	—	—	—	—	—	—	—	—
VNMG 160408-ML:T9415	●	0.8	265	0.25	1.5	—	—	—	250	0.25	1.5	—	—	—	—	—	—	—	—	—
VNMG 160408-ML:T9425	●	0.8	255	0.25	1.5	—	—	—	240	0.25	1.5	—	—	—	—	—	—	—	—	—



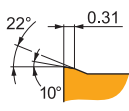
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

VNMG 160404E-NF:T9425	●	0.4	270	0.18	1.2	160	0.16	1.2	255	0.18	1.2	—	—	—	60	0.16	1.0	—	—	—
VNMG 160408E-NF:T9425	●	0.8	310	0.18	1.4	185	0.16	1.4	290	0.18	1.4	—	—	—	65	0.16	1.1	—	—	—



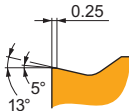
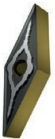
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

VNMG 160408E-NM:T9425	●	0.8	265	0.30	2.1	155	0.27	2.1	—	—	—	—	—	—	55	0.24	1.7	—	—	—
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NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

VNMG 160404E-NMR:T9425	●	0.4	235	0.20	1.2	140	0.18	1.2	—	—	—	—	—	—	50	0.18	1.0	—	—	—
VNMG 160408E-NMR:T9425	●	0.8	240	0.30	1.4	140	0.27	1.4	—	—	—	—	—	—	50	0.24	1.1	—	—	—



SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

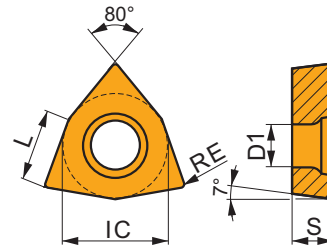
VNMG 160404E-SM:T9425	●	0.4	255	0.18	1.2	150	0.16	1.2	240	0.18	1.2	—	—	—	55	0.16	1.0	—	—	—
VNMG 160408E-SM:T9425	●	0.8	270	0.25	1.4	160	0.23	1.4	255	0.25	1.4	—	—	—	60	0.20	1.1	—	—	—



WCMT

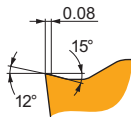
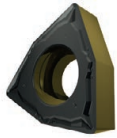


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
06T3	9.525	4.40	6.50	3.97
0804	12.700	5.50	8.70	4.76



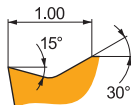
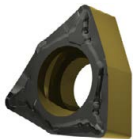
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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 chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

WCMT 06T304E-FM:T9425	●	0.4	365	0.15	1.2	215	0.15	1.2	345	0.15	1.2	—	—	—	—	—	—	—	—
WCMT 06T308E-FM:T9425	●	0.8	395	0.20	1.2	235	0.18	1.2	375	0.20	1.2	—	—	—	—	—	—	—	—
WCMT 080404E-FM:T9425	●	0.4	355	0.15	1.7	210	0.15	1.7	335	0.15	1.7	—	—	—	—	—	—	—	—
WCMT 080408E-FM:T9425	●	0.8	385	0.20	1.7	230	0.18	1.7	365	0.20	1.7	—	—	—	—	—	—	—	—
WCMT 080412E-FM:T9425	●	1.2	365	0.27	1.7	215	0.24	1.7	345	0.27	1.7	—	—	—	—	—	—	—	—



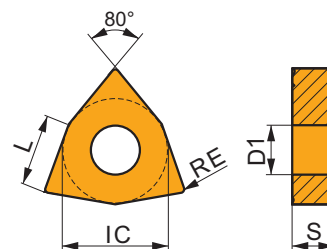
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

WCMT 06T308E-UR:T9425	●	0.8	345	0.20	1.2	205	0.18	1.2	325	0.20	1.2	—	—	—	—	—	—	—	—
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WNMG

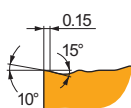
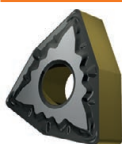


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0604	9.525	3.81	6.50	4.76
06T3	9.525	3.81	6.50	3.97
0804	12.700	5.16	8.70	4.76



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)



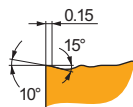
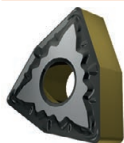
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

WNMG 060404E-FM:T9425	●	0.4	365	0.20	1.4	215	0.18	1.4	345	0.20	1.4	—	—	—	80	0.16	1.1	—	—
WNMG 060408E-FM:T9425	●	0.8	430	0.20	1.4	255	0.18	1.4	405	0.20	1.4	—	—	—	95	0.16	1.1	—	—
WNMG 06T304E-FM:T9425	●	0.4	365	0.20	1.4	215	0.18	1.4	345	0.20	1.4	—	—	—	80	0.16	1.1	—	—
WNMG 06T308E-FM:T9425	●	0.8	430	0.20	1.4	255	0.18	1.4	405	0.20	1.4	—	—	—	95	0.16	1.1	—	—
WNMG 080404E-FM:T9425	●	0.4	370	0.20	1.2	220	0.18	1.2	350	0.20	1.2	—	—	—	80	0.16	1.0	—	—



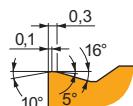
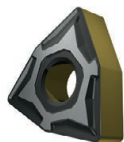
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



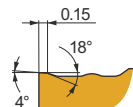
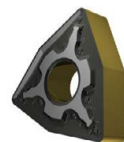
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

WNMG 080408E-FM:T9425	●	0.8	420	0.20	1.9	250	0.18	1.9	395	0.20	1.9	—	—	—	90	0.16	1.5	—	—	—
WNMG 080412E-FM:T9425	●	1.2	400	0.27	1.9	240	0.24	1.9	380	0.27	1.9	—	—	—	90	0.19	1.5	—	—	—



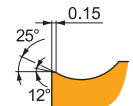
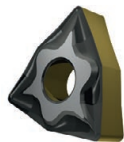
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

WNMG 060404E-M:T9425	●	0.4	320	0.20	1.8	—	—	—	300	0.20	1.8	—	—	—	—	—	—	—	—	—
WNMG 060408E-M:T9425	●	0.8	330	0.32	1.8	—	—	—	310	0.32	1.8	—	—	—	—	—	—	—	—	—
WNMG 080404E-M:T9425	●	0.4	320	0.20	2.1	—	—	—	300	0.20	2.1	—	—	—	—	—	—	—	—	—
WNMG 080408E-M:T9425	●	0.8	325	0.32	2.1	—	—	—	305	0.32	2.1	—	—	—	—	—	—	—	—	—
WNMG 080412E-M:T9425	●	1.2	320	0.40	2.1	—	—	—	300	0.40	2.1	—	—	—	—	—	—	—	—	—



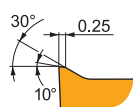
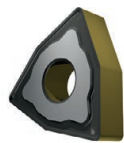
ML chip breaker is versatile and designed for low depth of cut and medium machining of steels. It features positive rake angle and stable, narrow T-land. It's also suitable for cast irons.

WNMG 080404-ML:T9415	●	0.4	365	0.20	1.0	—	—	—	345	0.20	1.0	—	—	—	—	—	—	—	—	—
WNMG 080404-ML:T9425	●	0.4	340	0.20	1.0	—	—	—	320	0.20	1.0	—	—	—	—	—	—	—	—	—
WNMG 080408-ML:T9415	●	0.8	380	0.25	1.5	—	—	—	360	0.25	1.5	—	—	—	—	—	—	—	—	—
WNMG 080408-ML:T9425	●	0.8	365	0.25	1.5	—	—	—	345	0.25	1.5	—	—	—	—	—	—	—	—	—
WNMG 080412-ML:T9415	●	1.2	360	0.30	2.0	—	—	—	340	0.30	2.0	—	—	—	—	—	—	—	—	—
WNMG 080412-ML:T9425	●	1.2	355	0.30	2.0	—	—	—	335	0.30	2.0	—	—	—	—	—	—	—	—	—



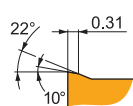
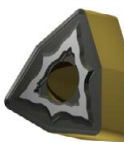
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

WNMG 060404E-NF:T9425	●	0.4	400	0.18	0.8	240	0.16	0.8	380	0.18	0.8	—	—	—	90	0.16	0.6	—	—	—
WNMG 060408E-NF:T9425	●	0.8	455	0.19	1.0	270	0.17	1.0	430	0.19	1.0	—	—	—	100	0.15	0.8	—	—	—
WNMG 080404E-NF:T9425	●	0.4	370	0.18	1.7	220	0.16	1.7	350	0.18	1.7	—	—	—	80	0.16	1.4	—	—	—
WNMG 080408E-NF:T9425	●	0.8	430	0.19	1.7	255	0.17	1.7	405	0.19	1.7	—	—	—	95	0.15	1.4	—	—	—



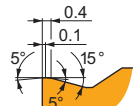
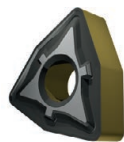
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

WNMG 060408E-NM:T9425	●	0.8	415	0.25	1.8	245	0.23	1.8	—	—	—	—	—	—	90	0.20	1.4	—	—	—
WNMG 060412E-NM:T9425	●	1.2	405	0.30	1.8	240	0.27	1.8	—	—	—	—	—	—	90	0.24	1.4	—	—	—
WNMG 080404E-NM:T9425	●	0.4	365	0.20	2.1	215	0.18	2.1	—	—	—	—	—	—	80	0.16	1.7	—	—	—
WNMG 080408E-NM:T9425	●	0.8	400	0.25	2.1	240	0.23	2.1	—	—	—	—	—	—	90	0.20	1.7	—	—	—
WNMG 080412E-NM:T9425	●	1.2	400	0.30	2.1	240	0.27	2.1	—	—	—	—	—	—	90	0.24	1.7	—	—	—



NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

WNMG 060408E-NMR:T9425	●	0.8	325	0.35	1.6	195	0.32	1.6	—	—	—	—	—	—	70	0.25	1.3	—	—	—
WNMG 080408E-NMR:T9425	●	0.8	305	0.35	2.7	180	0.32	2.7	—	—	—	—	—	—	65	0.25	2.2	—	—	—
WNMG 080412E-NMR:T9425	●	1.2	310	0.40	2.7	185	0.36	2.7	—	—	—	—	—	—	65	0.28	2.2	—	—	—



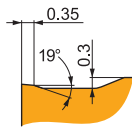
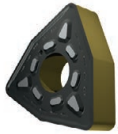
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.

WNMG 080408E-R:T9425	●	0.8	285	0.40	3.5	—	—	—	270	0.40	3.5	—	—	—	—	—	—	—	—	—
WNMG 080412E-R:T9425	●	1.2	295	0.45	3.5	—	—	—	280	0.45	3.5	—	—	—	—	—	—	—	—	—



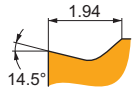
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



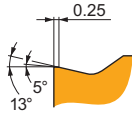
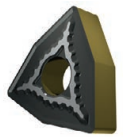
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

WNMG 060412E-RM:T9425	●	1.2	370	0.45	1.2	220	0.41	1.2	350	0.45	1.2	—	—	—	80	0.32	1.0	—	—	—
WNMG 080408E-RM:T9425	●	0.8	325	0.40	4.0	195	0.36	4.0	305	0.40	4.0	—	—	—	70	0.28	3.2	—	—	—
WNMG 080412E-RM:T9425	●	1.2	330	0.45	4.0	195	0.41	4.0	310	0.45	4.0	—	—	—	70	0.32	3.2	—	—	—
WNMG 080416E-RM:T9425	●	1.6	335	0.50	4.0	200	0.45	4.0	315	0.50	4.0	—	—	—	75	0.35	3.2	—	—	—



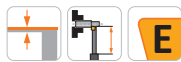
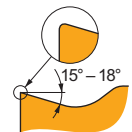
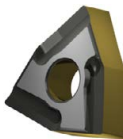
SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.

WNMG 080408E-SF:T9425	●	0.8	425	0.20	1.0	255	0.18	1.0	400	0.20	1.0	—	—	—	95	0.16	0.8	—	—	—
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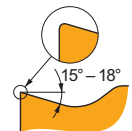
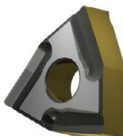
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

WNMG 060404E-SM:T9425	●	0.4	340	0.20	1.7	200	0.18	1.7	320	0.20	1.7	—	—	—	75	0.18	1.4	—	—	—
WNMG 060408E-SM:T9425	●	0.8	375	0.25	1.7	225	0.23	1.7	355	0.25	1.7	—	—	—	80	0.20	1.4	—	—	—
WNMG 060412E-SM:T9425	●	1.2	375	0.30	1.7	225	0.27	1.7	355	0.30	1.7	—	—	—	80	0.24	1.4	—	—	—
WNMG 080404E-SM:T9425	●	0.4	335	0.20	2.0	200	0.18	2.0	315	0.20	2.0	—	—	—	75	0.18	1.6	—	—	—
WNMG 080408E-SM:T9425	●	0.8	370	0.25	2.0	220	0.23	2.0	350	0.25	2.0	—	—	—	80	0.20	1.6	—	—	—
WNMG 080412E-SM:T9425	●	1.2	370	0.30	2.0	220	0.27	2.0	350	0.30	2.0	—	—	—	80	0.24	1.6	—	—	—



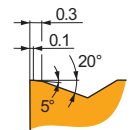
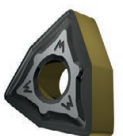
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

WNMG 060404ER-SI:T9425	●	0.4	410	0.20	1.7	245	0.18	1.7	—	—	—	—	—	—	90	0.18	1.4	—	—	—
WNMG 080404ER-SI:T9425	●	0.4	410	0.20	1.7	245	0.18	1.7	—	—	—	—	—	—	90	0.18	1.4	—	—	—
WNMG 080408ER-SI:T9425	●	0.8	400	0.35	1.7	240	0.32	1.7	—	—	—	—	—	—	90	0.25	1.4	—	—	—



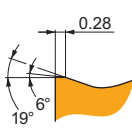
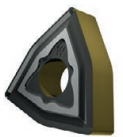
SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

WNMG 060404EL-SI:T9425	●	0.4	410	0.20	1.7	245	0.18	1.7	—	—	—	—	—	—	90	0.18	1.4	—	—	—
WNMG 080404EL-SI:T9425	●	0.4	410	0.20	1.7	245	0.18	1.7	—	—	—	—	—	—	90	0.18	1.4	—	—	—
WNMG 080408EL-SI:T9425	●	0.8	400	0.35	1.7	240	0.32	1.7	—	—	—	—	—	—	90	0.25	1.4	—	—	—



W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.

WNMG 060408W-M:T9425	●	0.8	305	0.45	1.2	—	—	—	285	0.45	1.2	—	—	—	—	—	—	—	—	—
WNMG 080408W-M:T9425	●	0.8	300	0.45	1.5	—	—	—	285	0.45	1.5	—	—	—	—	—	—	—	—	—
WNMG 080412W-M:T9425	●	1.2	300	0.55	1.5	—	—	—	285	0.55	1.5	—	—	—	—	—	—	—	—	—



W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.

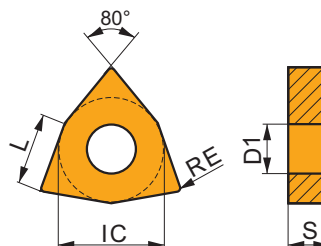
WNMG 080408W-MR:T9425	●	0.8	300	0.45	1.5	180	0.41	1.5	285	0.45	1.5	—	—	—	—	—	—	—	—	—
WNMG 080412W-MR:T9425	●	1.2	300	0.55	1.5	180	0.50	1.5	285	0.55	1.5	—	—	—	—	—	—	—	—	—



WNMM

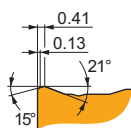
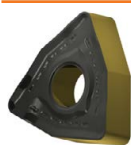


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0804	12.700	5.16	8.70	4.76
1306	19.050	7.94	13.00	6.35



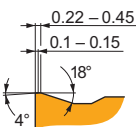
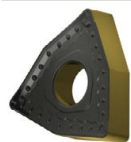
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

WNMM 080412E-NR2:T9425	1.2	315	0.45	4.0	185	0.41	4.0	295	0.45	4.0	—	—	—	70	0.32	3.2	—	—	—
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OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

WNMM 080408E-OR:T9425	0.8	310	0.40	4.0	185	0.36	4.0	290	0.40	4.0	—	—	—	65	0.28	3.2	—	—	—
WNMM 080412E-OR:T9425	1.2	315	0.45	4.0	185	0.41	4.0	295	0.45	4.0	—	—	—	70	0.36	3.2	—	—	—
WNMM 080416E-OR:T9425	1.6	320	0.50	4.0	190	0.45	4.0	300	0.50	4.0	—	—	—	70	0.40	3.2	—	—	—
WNMM 130612E-OR:T9425	1.2	300	0.45	6.0	180	0.41	6.0	285	0.45	6.0	—	—	—	65	0.36	4.8	—	—	—
WNMM 130616E-OR:T9425	1.6	310	0.50	6.0	185	0.45	6.0	290	0.50	6.0	—	—	—	65	0.40	4.8	—	—	—



ISO group	WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	
P	P1	P1.1	Free machining steel (carbon steels with increased machinability)	Sulfurized	< 240 HB	≤ 830
		P1.2		Sulfurized and phosphorized	< 180 HB	≤ 620
		P1.3		Sulfurized/phosphorized and leaded	< 180 HB	≤ 620
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900
		P3.3			260 – 360 HB	> 900 ≤ 1240
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900
P4.2		Hardened and tempered		26 – 39 HRC	> 900 ≤ 1240	
P4.3				39 – 45 HRC	> 1240 ≤ 1450	
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)		< 160 HB	≤ 520
		M1.2			160 – 220 HB	> 520 ≤ 700
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670
		M2.2		Quenched and tempered	200 – 280 HB	> 670 ≤ 950
	M3	M2.3	Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300	
		M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)		< 200 HB	≤ 750
		M3.2		200 – 260 HB	> 750 ≤ 870	
	M3.3	260 – 300 HB		> 870 ≤ 1040		
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel		< 300 HB	≤ 990
		M4.2		Precipitation hardening austenitic stainless steel	300 – 380 HB	≤ 1320
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190
		K1.2		Ferritic-pearlitic or pearlitic	180 – 240 HB	> 190 ≤ 310
		K1.3		Pearlitic	240 – 280 HB	> 310 ≤ 390
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400
		K2.2		Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550
		K2.3		Pearlitic	200 – 240 HB	> 550 ≤ 660
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560
		K3.2		Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680
		K3.3		Pearlitic	220 – 260 HB	> 680 ≤ 800
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)		< 180 HB	≤ 190
		K4.2		Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure)	< 240 HB	≤ 740
		K4.3		Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)	< 280 HB	> 840 ≤ 980
		K4.4			280 – 320 HB	> 980 ≤ 1130
K4.5		320 – 360 HB			> 1130 ≤ 1280	
K5	K5.1	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400	
	K5.2		Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450	
	K5.3		Pearlitic	220 – 260 HB	> 450 ≤ 500	
N	N1	N1.1	Commercially pure wrought aluminium		< 60 HB	≤ 240
		N1.2		Wrought aluminium alloys	60 – 100 HB	> 240 ≤ 400
		N1.3			100 – 150 HB	> 400 ≤ 590
	N2	N2.1	Cast aluminium alloys	< 75 HB	≤ 240	
		N2.2		75 – 90 HB	> 240 ≤ 270	
		N2.3		90 – 140 HB	> 270 ≤ 440	
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties		–	–
		N3.2		Short-chip copper-alloys with good to moderate machining properties	–	–
		N3.3		Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties	–	–
	N4	N4.1	Thermoplastic polymers		–	–
N4.2		Thermosetting polymers		–	–	
N4.3		Reinforced polymers or composites		–	–	
N5	N5.1	Graphite		–	–	
S	S1	S1.1	Titanium or titanium alloys		< 200 HB	≤ 660
		S1.2		200 – 280 HB	> 660 ≤ 950	
		S1.3		280 – 360 HB	> 950 ≤ 1200	
	S2	S2.1	Fe-based high-temperature alloys	< 200 HB	≤ 690	
		S2.2		200 – 280 HB	> 690 ≤ 970	
	S3	S3.1	Ni-based high-temperature alloys	< 280 HB	≤ 940	
		S3.2		280 – 360 HB	> 940 ≤ 1200	
	S4	S4.1	Co-based high-temperature alloys	< 240 HB	≤ 800	
S4.2		240 – 320 HB		> 800 ≤ 1070		
H	H1	H1.1	Chilled cast iron		< 440 HB	–
	H2	H2.1	Hardened cast iron		< 55 HRC	–
		H2.2		> 55 HRC	–	
	H3	H3.1	Hardened steel < 55 HRC		< 51 HRC	–
		H3.2		51 – 55 HRC	–	
H4	H4.1	Hardened steel > 55 HRC		55 – 59 HRC	–	
	H4.2		> 59 HRC	–		



Notes

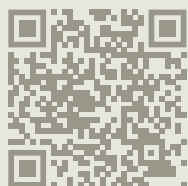




Certainty at every turn

Together we will keep our world turning, now and into the future. We want to help our community feel confident they can get the job done with simplified access to the right advice, tools and training whenever and wherever they need it. Delivering certainty to help our customers achieve their goals today – and be ready for tomorrow.

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