
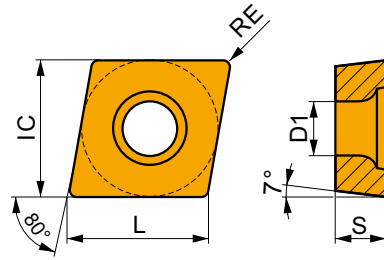

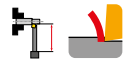
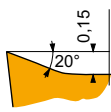
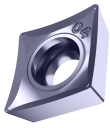


CCGT

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602-SS5	6.350	2.80	6.40	2.38
0602-SS1	6.350	2.80	6.40	2.58
0803-SS1	7.940	3.40	8.10	3.43
09T3-SS5	9.525	4.40	9.70	3.97
09T3-SS1	9.525	4.40	9.70	4.22
1204-SS1	12.700	5.50	12.90	5.01

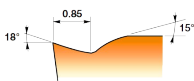
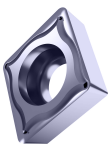


	P			M			K			N			S			H		
	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	f	ap	vc	f	ap	
(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



vc

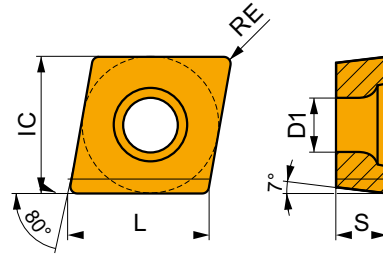
CCGT 060202-SS1	SP95	0.2	-	-	-	■	145	0.05	0.8	-	-	-	■	615	0.06	0.8	■	60	0.04	0.6	▣	40	0.15	1.0
CCGT 060204-SS1	SP95	0.4	-	-	-	■	125	0.09	0.8	-	-	-	■	540	0.12	0.8	■	50	0.07	0.6	▣	35	0.15	1.0
CCGT 080302-SS1	SP95	0.2	-	-	-	■	145	0.05	0.8	-	-	-	■	615	0.06	0.8	■	60	0.04	0.6	▣	40	0.15	1.0
CCGT 080304-SS1	SP95	0.4	-	-	-	■	125	0.09	1.0	-	-	-	■	540	0.12	1.0	■	50	0.07	0.8	▣	35	0.15	1.0
CCGT 09T301-SS1	SP95	0.1	-	-	-	■	140	0.05	0.5	-	-	-	■	600	0.06	0.5	■	60	0.04	0.4	▣	40	0.15	1.0
CCGT 09T302-SS1	SP95	0.2	-	-	-	■	145	0.05	0.8	-	-	-	■	615	0.06	0.8	■	60	0.04	0.6	▣	40	0.15	1.0
CCGT 09T304-SS1	SP95	0.4	-	-	-	■	125	0.09	1.0	-	-	-	■	540	0.12	1.0	■	50	0.07	0.8	▣	35	0.15	1.0
CCGT 09T308-SS1	SP95	0.8	-	-	-	■	150	0.09	1.0	-	-	-	■	630	0.12	1.0	■	60	0.08	0.8	▣	40	0.15	1.0
CCGT 120408-SS1	SP95	0.8	-	-	-	■	140	0.12	1.0	-	-	-	■	600	0.14	1.0	■	60	0.11	0.8	▣	40	0.15	1.0



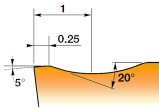
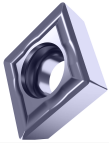
CCGT 060204-SS5	SP95	0.4	-	-	-	■	125	0.09	0.8	-	-	-	▣	540	0.12	0.8	■	50	0.07	0.6	▣	35	0.15	1.0
CCGT 060208-SS5	SP95	0.8	-	-	-	■	145	0.11	0.8	-	-	-	▣	615	0.14	0.8	■	60	0.11	0.6	▣	40	0.15	1.0
CCGT 09T304-SS5	SP95	0.4	-	-	-	■	125	0.09	1.2	-	-	-	▣	525	0.12	1.2	■	50	0.07	1.0	▣	35	0.15	1.0
CCGT 09T308-SS5	SP95	0.8	-	-	-	■	135	0.13	1.2	-	-	-	▣	570	0.17	1.2	■	55	0.13	1.0	▣	35	0.15	1.0

CCMT/CCGT

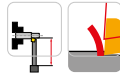
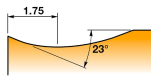
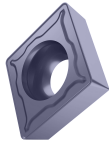
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76



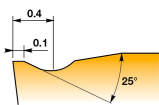
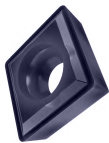
RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



CCMT 060202-SS8	SP95	0.2	-	-	-	■	120	0.09	0.8	-	-	-	▣	510	0.12	0.8	■	50	0.08	0.6	■	35	0.15	1.0
CCMT 060204-SS8	SP95	0.4	-	-	-	■	120	0.11	0.8	-	-	-	▣	510	0.14	0.8	■	50	0.11	0.6	■	35	0.15	1.0
CCMT 09T304-SS8	SP95	0.4	-	-	-	■	115	0.11	1.2	-	-	-	▣	495	0.14	1.2	■	45	0.11	1.0	■	30	0.15	1.0
CCMT 09T308-SS8	SP95	0.8	-	-	-	■	135	0.13	1.2	-	-	-	▣	570	0.17	1.2	■	55	0.13	1.0	■	40	0.15	1.0
CCMT 120404-SS8	SP95	0.4	-	-	-	■	110	0.22	2.2	-	-	-	▣	475	0.25	2.2	■	40	0.11	1.0	■	30	0.15	1.0
CCMT 120408-SS8	SP95	0.8	-	-	-	■	115	0.22	2.2	-	-	-	▣	495	0.25	2.2	■	45	0.11	1.0	■	30	0.15	1.0



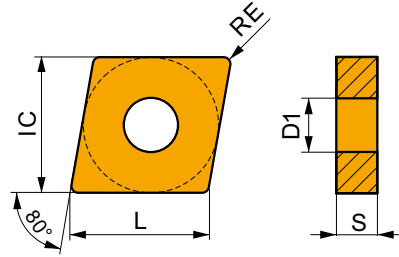
CCMT 09T304-SS3	SP95	0.4	-	-	-	■	140	0.15	1.5	-	-	-	▣	580	0.20	1.5	■	55	0.14	1.2	■	45	0.15	1.0
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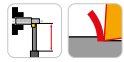
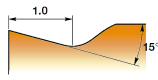
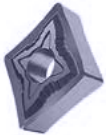
CCMT 120404-SS6	SP95	0.4	-	-	-	▣	160	0.54	1.8	-	-	-	▣	620	0.20	1.5	■	55	0.14	1.2	■	45	0.15	1.0
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CNMG

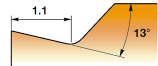
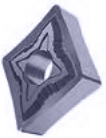
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.16	12.90	4.76
1606	15.880	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



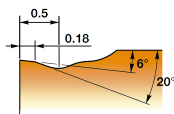
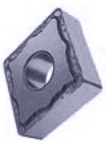
RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



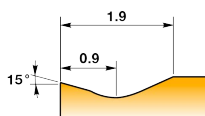
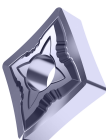
CNMG 120404-SS4	SP95	0.4	-	-	-	■	125	0.14	1.0	-	-	-	☑	540	0.18	1.0	■	50	0.12	0.8	■	35	0.15	1.0
CNMG 120408-SS4	SP95	0.8	-	-	-	■	140	0.18	1.0	-	-	-	☑	600	0.24	1.0	■	60	0.14	0.8	■	40	0.15	1.0



CNMG 120404-SS9	SP95	0.4	-	-	-	■	115	0.14	1.0	-	-	-	☑	585	0.18	1.0	☑	45	0.12	0.8	■	35	0.15	1.0
	SP92	0.4	-	-	-	■	105	0.14	1.0	-	-	-	☑	540	0.18	1.0	☑	45	0.12	0.8	☑	35	0.15	1.0
CNMG 120408-SS9	SP95	0.8	-	-	-	■	125	0.18	1.0	-	-	-	☑	630	0.24	1.0	☑	50	0.14	0.8	■	40	0.15	1.0
	SP92	0.8	-	-	-	■	120	0.18	1.0	-	-	-	☑	600	0.24	1.0	☑	50	0.14	0.8	☑	40	0.15	1.0

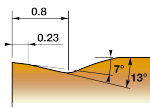
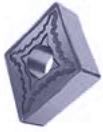


CNMG 120404-SS10	SP95	0.4	-	-	-	■	125	0.15	1.7	-	-	-	☑	540	0.20	1.7	☑	50	0.14	1.4	■	40	0.15	1.0
CNMG 120408-SS10	SP95	0.8	-	-	-	■	140	0.17	1.7	-	-	-	☑	600	0.23	1.7	☑	60	0.15	1.4	■	45	0.15	1.0

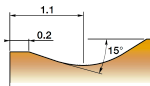
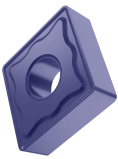


CNMG 120404-SS11	SP95	0.4	-	-	-	■	125	0.15	1.7	-	-	-	☑	540	0.20	1.7	☑	50	0.14	1.4	■	40	0.15	1.0
CNMG 120408-SS11	SP95	0.8	-	-	-	■	140	0.17	1.7	-	-	-	☑	600	0.23	1.7	☑	60	0.15	1.4	■	45	0.15	1.0

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)




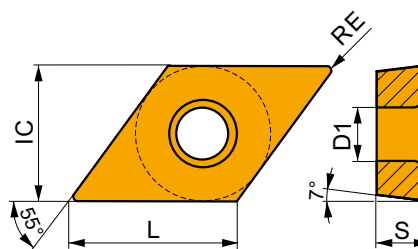
CNMG 120404-SS12	SP95	0.4	-	-	-	■	110	0.20	2.0	-	-	-	☑	465	0.26	2.0	■	45	0.20	1.6	☑	30	0.15	1.0
CNMG 120408-SS12	SP95	0.8	-	-	-	■	125	0.23	2.0	-	-	-	☑	525	0.30	2.0	■	50	0.20	1.6	☑	35	0.15	1.0
CNMG 120412-SS12	SP95	1.2	-	-	-	■	125	0.27	2.0	-	-	-	☑	525	0.36	2.0	■	50	0.24	1.6	☑	35	0.15	1.0
CNMG 160612-SS12	SP95	1.2	-	-	-	■	120	0.27	3.0	-	-	-	☑	510	0.36	3.0	■	50	0.27	2.4	☑	30	0.15	1.0
	SP91	1.2	-	-	-	■	135	0.27	3.0	-	-	-	☑	600	0.36	3.0	■	50	0.27	2.4	☑	40	0.15	1.0
CNMG 190612-SS12	SP95	1.2	-	-	-	■	115	0.27	4.0	-	-	-	☑	495	0.36	4.0	■	45	0.27	3.2	☑	30	0.15	1.0
	SP91	1.2	-	-	-	■	130	0.27	4.0	-	-	-	☑	550	0.36	4.0	■	45	0.27	3.2	☑	40	0.15	1.0




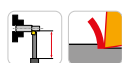
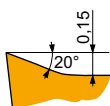
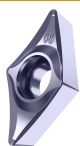
CNMG 120408-SS13	SP95	0.8	-	-	-	■	125	0.15	1.7	-	-	-	☑	540	0.20	1.7	☑	50	0.14	1.4	■	40	0.15	1.0
CNMG 120412-SS13	SP95	1.2	-	-	-	■	140	0.17	1.7	-	-	-	☑	600	0.23	1.7	☑	60	0.15	1.4	■	45	0.15	1.0

DCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702-SS1	6.350	2.80	7.80	2.58
11T3-SS1	9.525	4.40	11.60	4.22



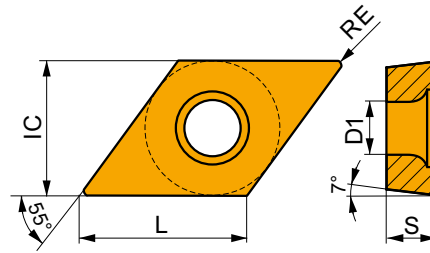
	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



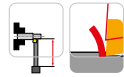
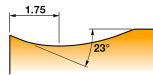
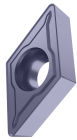
DCGT 070201-SS1	SP95	0.1	—	—	—	■	115	0.05	0.5	—	—	—	■	480	0.06	0.5	■	45	0.04	0.4	▣	30	0.15	1.0
DCGT 070202-SS1	SP95	0.2	—	—	—	■	115	0.05	0.8	—	—	—	■	495	0.06	0.8	■	45	0.04	0.6	▣	30	0.15	1.0
DCGT 070204-SS1	SP95	0.4	—	—	—	■	100	0.09	0.8	—	—	—	■	435	0.12	0.8	■	40	0.07	0.6	▣	25	0.15	1.0
DCGT 11T301-SS1	SP95	0.1	—	—	—	■	115	0.05	0.5	—	—	—	■	480	0.06	0.5	■	45	0.04	0.4	▣	30	0.15	1.0
DCGT 11T302-SS1	SP95	0.2	—	—	—	■	115	0.05	0.8	—	—	—	■	495	0.06	0.8	■	45	0.04	0.6	▣	30	0.15	1.0
DCGT 11T304-SS1	SP95	0.4	—	—	—	■	100	0.09	0.8	—	—	—	■	435	0.12	0.8	■	40	0.07	0.6	▣	25	0.15	1.0
DCGT 11T308-SS1	SP95	0.8	—	—	—	■	120	0.09	0.8	—	—	—	■	510	0.12	0.8	■	50	0.08	0.6	▣	30	0.15	1.0

DCMT/DCGT

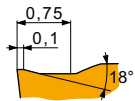
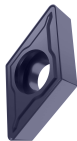
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



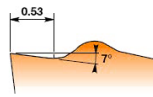
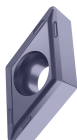
RE (mm)	P			M			K			N			S			H		
	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



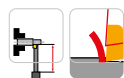
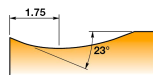
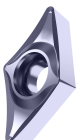
DCMT 11T304-SS3	SP95	0.4	-	-	-	■	110	0.15	1.5	-	-	-	▣	450	0.20	1.5	■	35	0.14	1.2	■	30	0.15	1.0
DCMT 11T308-SS3	SP95	0.8	-	-	-	■	120	0.15	1.5	-	-	-	▣	470	0.20	1.5	■	45	0.14	1.2	■	40	0.15	1.0



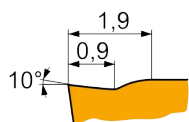
DCMT 070204-SS7	SP95	0.4	-	-	-	▣	95	0.11	0.8	-	-	-	▣	435	0.12	0.8	■	40	0.13	0.6	■	35	0.15	1.0
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DCMT 11T304-SS14	SP95	0.4	-	-	-	▣	110	0.11	0.8	-	-	-	▣	535	0.12	0.8	■	45	0.13	0.6	■	40	0.15	1.0
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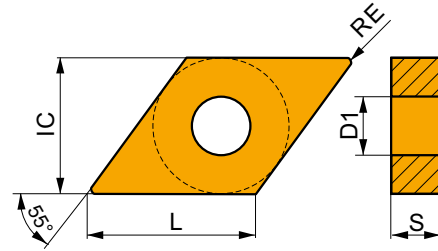
DCGT 11T302-SS3	SP95	0.2	-	-	-	■	100	0.15	1.5	-	-	-	▣	450	0.20	1.5	■	35	0.14	1.2	■	30	0.15	1.0
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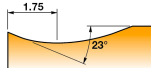
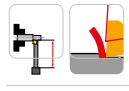
DCGT 11T304-SS5	SP95	0.4	-	-	-	■	100	0.09	0.8	-	-	-	▣	435	0.12	0.8	■	40	0.07	0.6	▣	25	0.15	1.0
DCGT 11T308-SS5	SP95	0.8	-	-	-	■	110	0.13	0.8	-	-	-	▣	465	0.17	0.8	■	45	0.13	0.6	▣	30	0.15	1.0

DNMG


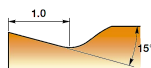
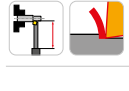
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	3.81	11.60	4.76
1506	12.700	5.16	15.50	6.35




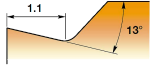

RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)


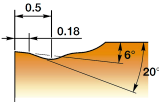

DNMG 110408-SS3	SP95	0.8	-	-	-	■	140	0.15	1.5	-	-	-	▣	580	0.20	1.5	■	55	0.14	1.2	■	45	0.15	1.0
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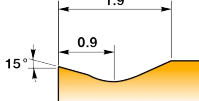
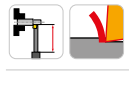
DNMG 110404-SS4	SP95	0.4	-	-	-	■	105	0.14	0.8	-	-	-	▣	450	0.18	0.8	■	45	0.12	0.6	■	30	0.15	1.0
DNMG 150604-SS4	SP95	0.4	-	-	-	■	100	0.14	1.5	-	-	-	▣	420	0.18	1.5	■	40	0.12	1.2	■	25	0.15	1.0
DNMG 150608-SS4	SP95	0.8	-	-	-	■	115	0.15	1.5	-	-	-	▣	480	0.20	1.5	■	45	0.14	1.2	■	30	0.15	1.0

DNMG 150608-SS9	SP95	0.8	-	-	-	■	115	0.15	1.5	-	-	-	▣	480	0.20	1.5	■	45	0.14	1.2	■	30	0.15	1.0
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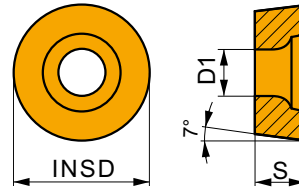
DNMG 110404-SS10	SP95	0.4	-	-	-	■	105	0.14	0.8	-	-	-	▣	450	0.18	0.8	■	45	0.12	0.6	■	30	0.15	1.0
DNMG 150608-SS10	SP95	0.8	-	-	-	■	115	0.15	1.5	-	-	-	▣	480	0.20	1.5	■	45	0.14	1.2	■	30	0.15	1.0

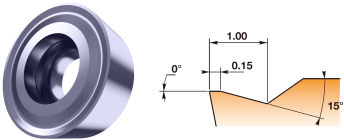
DNMG 150608-SS11	SP95	0.8	-	-	-	■	140	0.15	1.5	-	-	-	▣	580	0.20	1.5	■	55	0.14	1.2	■	45	0.15	1.0
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RCMT

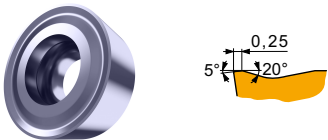
	INSD	D1	S
	(mm)	(mm)	(mm)
0602	6.0	2.80	2.38
0803	8.0	3.40	3.18



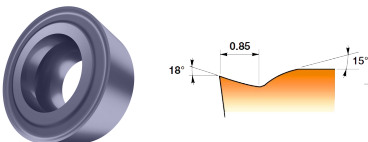
RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



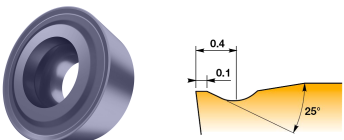
RCMT 0602MO-SS15	SP91	-	-	-	100	0.54	1.8	-	-	-	550	0.20	1.5	50	0.14	1.2	40	0.15	1.0
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RCMT 0602MO-SS16	SP95	-	-	-	100	0.36	1.2	-	-	-	495	0.14	1.2	45	0.11	1.0	30	0.15	1.0
	SP91	-	-	-	95	0.36	1.2	-	-	-	470	0.17	1.2	55	0.13	1.0	40	0.15	1.0
RCMT 0803MO-SS16	SP95	-	-	-	120	0.36	1.2	-	-	-	600	0.14	1.2	50	0.11	1.0	35	0.15	1.0
	SP91	-	-	-	110	0.36	1.2	-	-	-	550	0.17	1.2	55	0.13	1.0	40	0.15	1.0



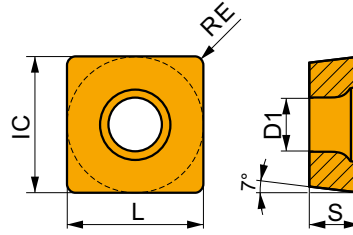
RRCMT 0803MO-SS5	SP91	-	-	-	90	0.54	1.8	-	-	-	480	0.20	1.5	45	0.14	1.2	30	0.15	1.0
		-	-	-	80	0.54	1.8	-	-	-	420	0.18	1.5	40	0.12	1.2	25	0.15	1.0



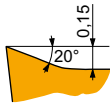
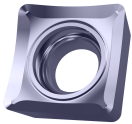
RCMT 0602MO-SS6	SP91	-	-	-	120	0.54	1.8	-	-	-	580	0.20	1.5	55	0.14	1.2	45	0.15	1.0
RCMT 0803MO-SS6	SP91	-	-	-	130	0.54	1.8	-	-	-	600	0.20	1.5	60	0.14	1.2	50	0.15	1.0

SCGT

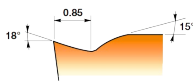
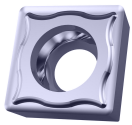
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.525	4.40	9.53	3.97
09T3-SS1	9.525	4.40	9.53	4.22
1204	12.700	5.50	12.70	4.76



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)



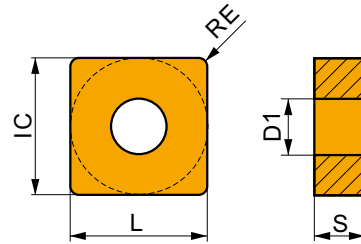
SCGT 09T304-SS1	SP95	0.4	-	-	-	■	130	0.09	1.0	-	-	-	■	555	0.12	1.0	■	55	0.07	0.8	▣	35	0.15	1.0
SCGT 09T308-SS1	SP95	0.8	-	-	-	■	150	0.12	1.0	-	-	-	■	630	0.14	1.0	■	60	0.11	0.8	▣	40	0.15	1.0




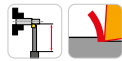
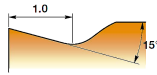
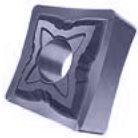
SCGT 09T308-SS5	SP95	0.8	-	-	-	■	140	0.13	1.2	-	-	-	▣	600	0.17	1.2	■	60	0.13	1.0	▣	40	0.15	1.0
SCGT 120412-SS5	SP95	1.2	-	-	-	■	150	0.13	1.2	-	-	-	▣	650	0.17	1.2	■	65	0.13	1.0	▣	45	0.15	1.0

SNMG

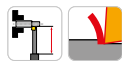
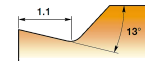
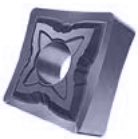
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76



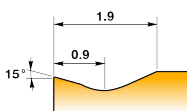
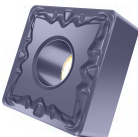
	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



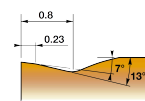
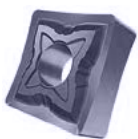
SNMG 120408-SS4	SP95	0.8	-	-	-	150	0.18	1.0	-	-	-	630	0.24	1.0	60	0.14	0.8	40	0.15	1.0
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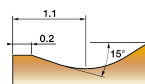
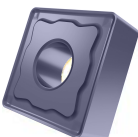
SNMG 120408-SS9	SP95	0.8	-	-	-	150	0.18	1.0	-	-	-	630	0.24	1.0	60	0.14	0.8	40	0.15	1.0
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SNMG 120408-SS11	SP95	0.8	-	-	-	140	0.23	1.5	-	-	-	600	0.30	1.5	60	0.18	1.2	40	0.15	1.0
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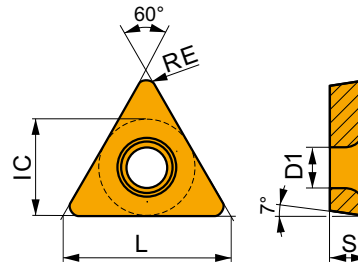
SNMG 120412-SS12	SP95	1.2	-	-	-	140	0.23	1.5	-	-	-	600	0.30	1.5	60	0.18	1.2	40	0.15	1.0
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


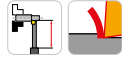
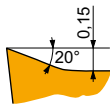
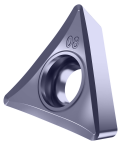
SNMG 120404-SS13	SP95	0.4	-	-	-	140	0.23	1.5	-	-	-	600	0.30	1.5	60	0.18	1.2	40	0.15	1.0
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TCGT

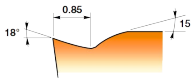
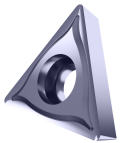
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1102	6.350	2.80	11.00	2.38
1102-SS1	6.350	2.80	11.00	2.58
16T3-SS1	9.525	4.40	16.50	4.22



	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)



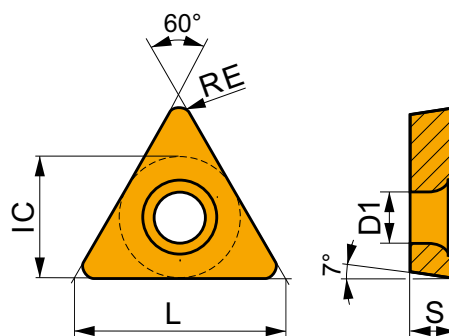
TCGT 110202-SS1	SP95	0.2	-	-	-	■	125	0.05	0.8	-	-	-	■	525	0.06	0.8	■	50	0.04	0.6	▣	35	0.15	1.0
TCGT 110204-SS1	SP95	0.4	-	-	-	■	110	0.09	0.8	-	-	-	■	465	0.12	0.8	■	45	0.07	0.6	▣	30	0.15	1.0
TCGT 16T304-SS1	SP95	0.4	-	-	-	■	105	0.09	1.0	-	-	-	■	450	0.12	1.0	■	45	0.07	0.8	▣	30	0.15	1.0
TCGT 16T308-SS1	SP95	0.8	-	-	-	■	125	0.09	1.2	-	-	-	■	525	0.12	1.2	■	50	0.08	1.0	▣	35	0.15	1.0



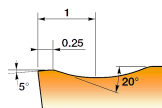
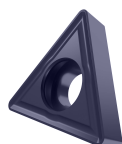
TCGT 110204-SS5	SP95	0.4	-	-	-	■	110	0.09	0.8	-	-	-	▣	465	0.12	0.8	■	45	0.08	0.6	▣	30	0.15	1.0
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TCMT

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
16T3	9.525	4.40	16.50	3.97




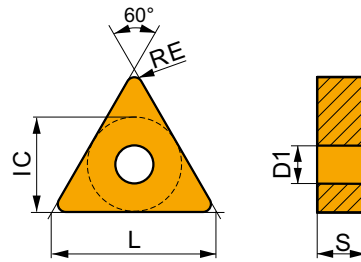
RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



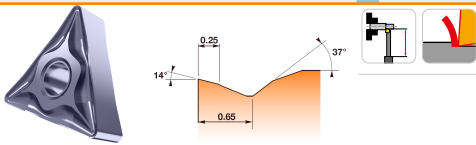
TCMT 16T304-SS8	SP95	0.4	-	-	-	120	0.18	1.0	-	-	-	525	0.12	1.2	50	0.08	1.0	35	0.15	1.0
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TNMG

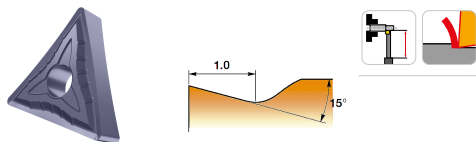
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



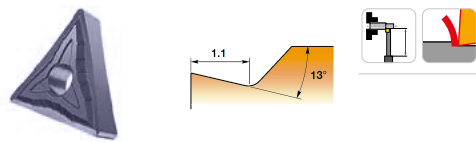
RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



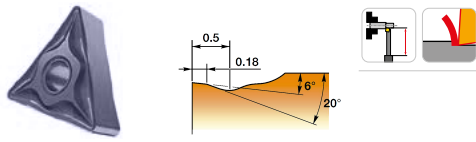
TNMG 160404-SS17	SP95	0.4	-	-	-	■	125	0.15	1.3	-	-	-	▣	525	0.20	1.3	■	50	0.14	1.0	■	35	0.15	1.0
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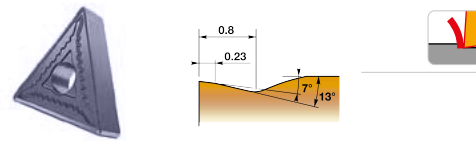
TNMG 160404-SS4	SP95	0.4	-	-	-	■	105	0.15	1.4	-	-	-	▣	450	0.20	1.4	■	45	0.15	1.1	■	25	0.15	1.0
TNMG 160408-SS4	SP95	0.8	-	-	-	■	125	0.16	1.4	-	-	-	▣	540	0.22	1.4	■	50	0.16	1.1	■	30	0.15	1.0
TNMG 160404-SS4	SP91	0.4	-	-	-	■	110	0.15	1.3	-	-	-	▣	550	0.20	1.3	■	50	0.14	1.0	■	40	0.15	1.0



TNMG 160408-SS9	SP95	0.8	-	-	-	■	125	0.15	1.3	-	-	-	▣	525	0.20	1.3	■	50	0.14	1.0	■	35	0.15	1.0
TNMG 220408-SS9	SP95	0.8	-	-	-	■	145	0.15	1.3	-	-	-	▣	580	0.20	1.3	■	55	0.14	1.0	■	45	0.15	1.0



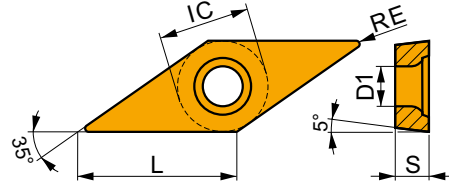
TNMG 160404-SS10	SP95	0.4	-	-	-	■	105	0.15	1.4	-	-	-	▣	450	0.20	1.4	▣	45	0.15	1.1	▣	25	0.15	1.0
TNMG 160408-SS10	SP95	0.8	-	-	-	■	125	0.16	1.4	-	-	-	▣	540	0.22	1.4	▣	50	0.16	1.1	▣	30	0.15	1.0



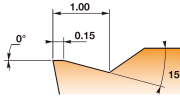
TNMG 160404-SS12	SP95	0.4	-	-	-	■	95	0.20	1.7	-	-	-	▣	405	0.26	1.7	■	40	0.20	1.4	▣	25	0.15	1.0
TNMG 160408-SS12	SP95	0.8	-	-	-	■	105	0.23	1.7	-	-	-	▣	450	0.30	1.7	■	45	0.20	1.4	▣	30	0.15	1.0

VBMT

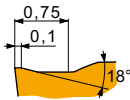
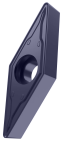
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1103	6.350	2.80	11.10	3.18
1604	9.525	4.40	16.60	4.76



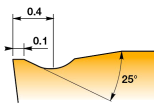
RE (mm)	P			M			K			N			S			H		
	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



VBMT 110304-SS15	SP95	0.4	-	-	-	85	0.54	1.8	-	-	-	450	0.20	1.5	40	0.14	1.2	30	0.15	1.0
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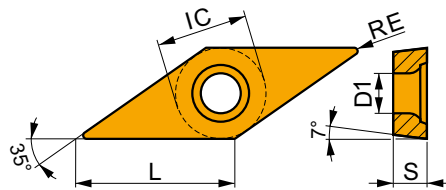
VBMT 160404-SS7	SP95	0.4	-	-	-	85	0.11	1.2	-	-	-	420	0.18	1.5	40	0.12	1.2	25	0.15	1.0
VBMT 160408-SS7	SP95	0.8	-	-	-	90	0.18	1.2	-	-	-	450	0.18	0.8	45	0.12	0.6	30	0.15	1.0
VBMT 160412-SS7	SP95	1.2	-	-	-	105	0.20	1.2	-	-	-	480	0.20	1.5	45	0.14	1.2	30	0.15	1.0



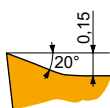
VBMT 160412-SS6	SP95	1.2	-	-	-	160	0.54	1.8	-	-	-	620	0.20	1.5	55	0.14	1.2	45	0.15	1.0
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VCGT

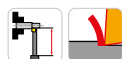
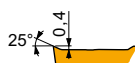
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0702-SS1	3.970	2.20	6.90	2.58
1102-SS1	6.350	2.80	11.10	2.58
1303-SS1	7.940	3.40	13.80	3.43
1303-SS2	7.940	3.40	13.80	3.18
1604-SS1	9.525	4.40	16.60	5.01



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)



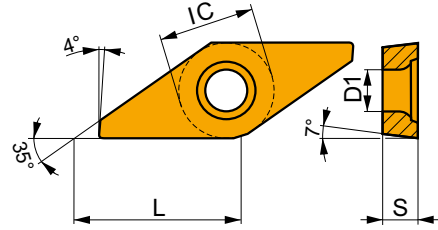
VCGT 070202-SS1	SP95	0.2	-	-	-	■	100	0.05	0.8	-	-	-	■	435	0.06	0.8	■	40	0.04	0.6	▣	25	0.15	1.0
VCGT 070204-SS1	SP95	0.4	-	-	-	■	90	0.09	0.8	-	-	-	■	375	0.12	0.8	■	35	0.07	0.6	▣	25	0.15	1.0
VCGT 110202-SS1	SP95	0.2	-	-	-	■	100	0.05	0.8	-	-	-	■	435	0.06	0.8	■	40	0.04	0.6	▣	25	0.15	1.0
VCGT 110204-SS1	SP95	0.4	-	-	-	■	90	0.09	0.8	-	-	-	■	375	0.12	0.8	■	35	0.07	0.6	▣	25	0.15	1.0
VCGT 130302-SS1	SP95	0.2	-	-	-	■	100	0.05	0.8	-	-	-	■	435	0.06	0.8	■	40	0.04	0.6	▣	25	0.15	1.0
VCGT 130304-SS1	SP95	0.4	-	-	-	■	90	0.09	1.0	-	-	-	■	375	0.12	1.0	■	35	0.07	0.8	▣	25	0.15	1.0
VCGT 130308-SS1	SP95	0.8	-	-	-	■	100	0.09	1.0	-	-	-	■	435	0.12	1.0	■	40	0.08	0.8	▣	25	0.15	1.0
VCGT 160404-SS1	SP95	0.4	-	-	-	■	90	0.09	1.0	-	-	-	■	375	0.12	1.0	■	35	0.07	0.8	▣	25	0.15	1.0
VCGT 160408-SS1	SP95	0.8	-	-	-	■	100	0.09	1.2	-	-	-	■	435	0.12	1.2	■	40	0.08	1.0	▣	25	0.15	1.0



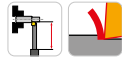
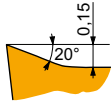
VCGT 130302-SS2	SP95	0.2	-	-	-	■	100	0.05	1.0	-	-	-	▣	420	0.06	1.0	■	40	0.04	0.8	▣	25	0.15	1.0
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VCGX

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604-SS1	9.525	4.40	16.60	5.01



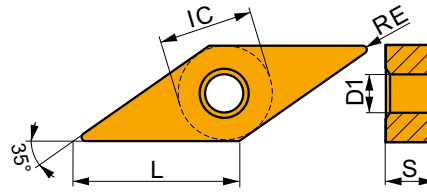
RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



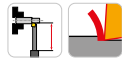
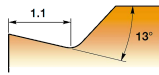
VCGX 160408-SS1	SP95	0.8	-	-	-	■	100	0.09	1.2	-	-	-	■	435	0.12	1.2	■	40	0.08	1.0	☑	25	0.15	1.0
VCGX 160412-SS1	SP95	1.2	-	-	-	■	90	0.18	1.2	-	-	-	■	375	0.24	1.2	■	35	0.14	1.0	☑	25	0.15	1.0

VNMG

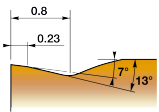
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	3.81	16.60	4.76



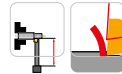
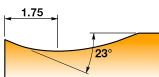
RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



VNMG 160404-SS9	SP95	0.4	-	-	-	95	0.11	1.2	-	-	-	405	0.14	1.2	40	0.11	1.0	25	0.15	1.0
VNMG 160408-SS9	SP95	0.8	-	-	-	100	0.15	1.4	-	-	-	420	0.20	1.4	40	0.14	1.1	25	0.15	1.0



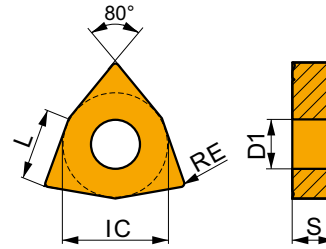
VNMG 160408-SS12	SP95	0.8	-	-	-	90	0.23	1.4	-	-	-	375	0.30	1.4	35	0.20	1.1	25	0.15	1.0
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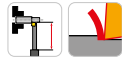
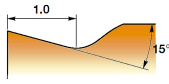
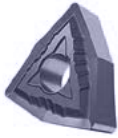
VNMG 160404-SS3	SP95	0.8	-	-	-	110	0.15	1.5	-	-	-	450	0.20	1.5	40	0.14	1.2	30	0.15	1.0
VNMG 160408-SS3	SP95	0.8	-	-	-	120	0.15	1.5	-	-	-	500	0.20	1.5	45	0.14	1.2	35	0.15	1.0

WNMG

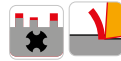
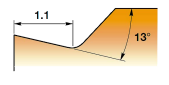
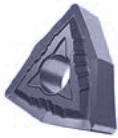
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



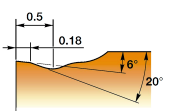
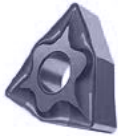
RE (mm)	P			M			K			N			S			H		
	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



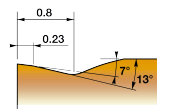
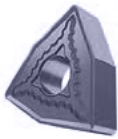
WNMG 080404-SS4	SP95	0.4	-	-	-	■	125	0.14	1.0	-	-	-	■	540	0.18	1.0	■	50	0.12	0.8	■	35	0.15	1.0
WNMG 080408-SS4	SP95	0.8	-	-	-	■	140	0.18	1.0	-	-	-	■	600	0.24	1.0	■	60	0.14	0.8	■	40	0.15	1.0



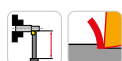
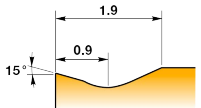
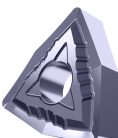
WNMG 080408-SS9	SP95	0.8	-	-	-	■	140	0.18	1.0	-	-	-	■	600	0.24	1.0	■	60	0.14	0.8	■	40	0.15	1.0
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WNMG 060408-SS10	SP95	0.8	-	-	-	■	150	0.17	1.0	-	-	-	■	645	0.23	1.0	■	60	0.15	0.8	■	40	0.15	1.0
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WNMG 060408-SS12	SP95	0.8	-	-	-	■	125	0.23	1.7	-	-	-	■	525	0.30	1.7	■	50	0.20	1.4	■	35	0.15	1.0
WNMG 080404-SS12	SP95	0.4	-	-	-	■	110	0.20	2.0	-	-	-	■	465	0.26	2.0	■	45	0.20	1.6	■	30	0.15	1.0
WNMG 080408-SS12	SP95	0.8	-	-	-	■	125	0.23	2.0	-	-	-	■	525	0.30	2.0	■	50	0.20	1.6	■	35	0.15	1.0

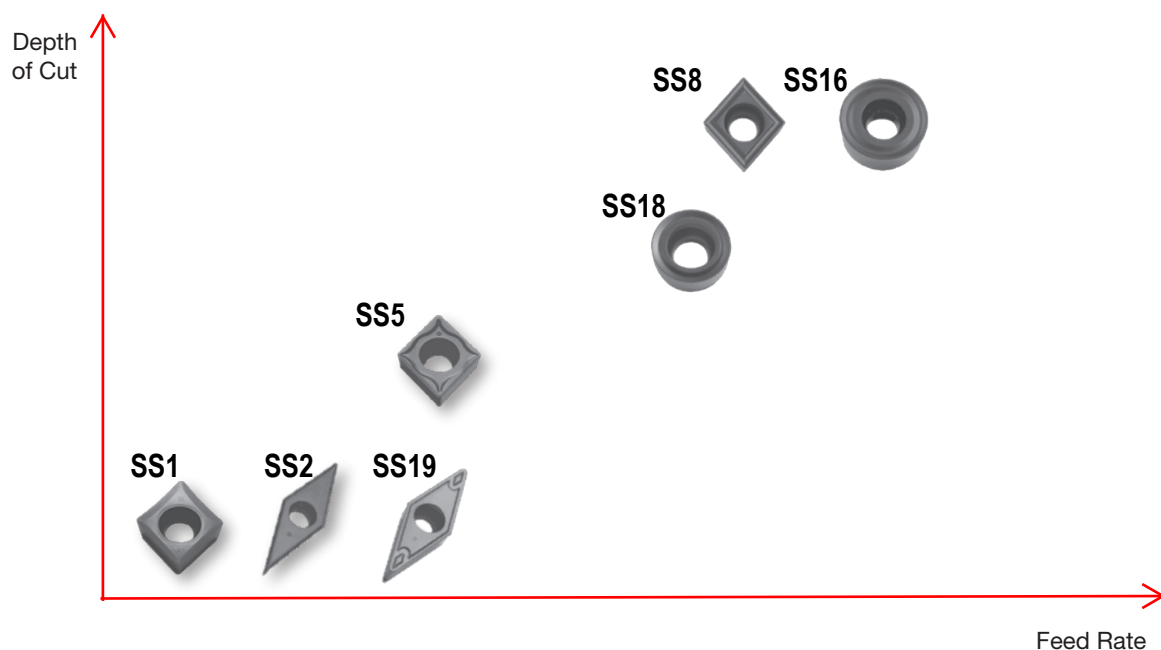


WNMG 080404-SS11	SP95	0.4	-	-	-	■	125	0.15	1.7	-	-	-	■	540	0.20	1.7	■	50	0.14	1.4	■	40	0.15	1.0
WNMG 080408-SS11	SP95	0.8	-	-	-	■	140	0.17	1.7	-	-	-	■	600	0.23	1.7	■	60	0.15	1.4	■	45	0.15	1.0

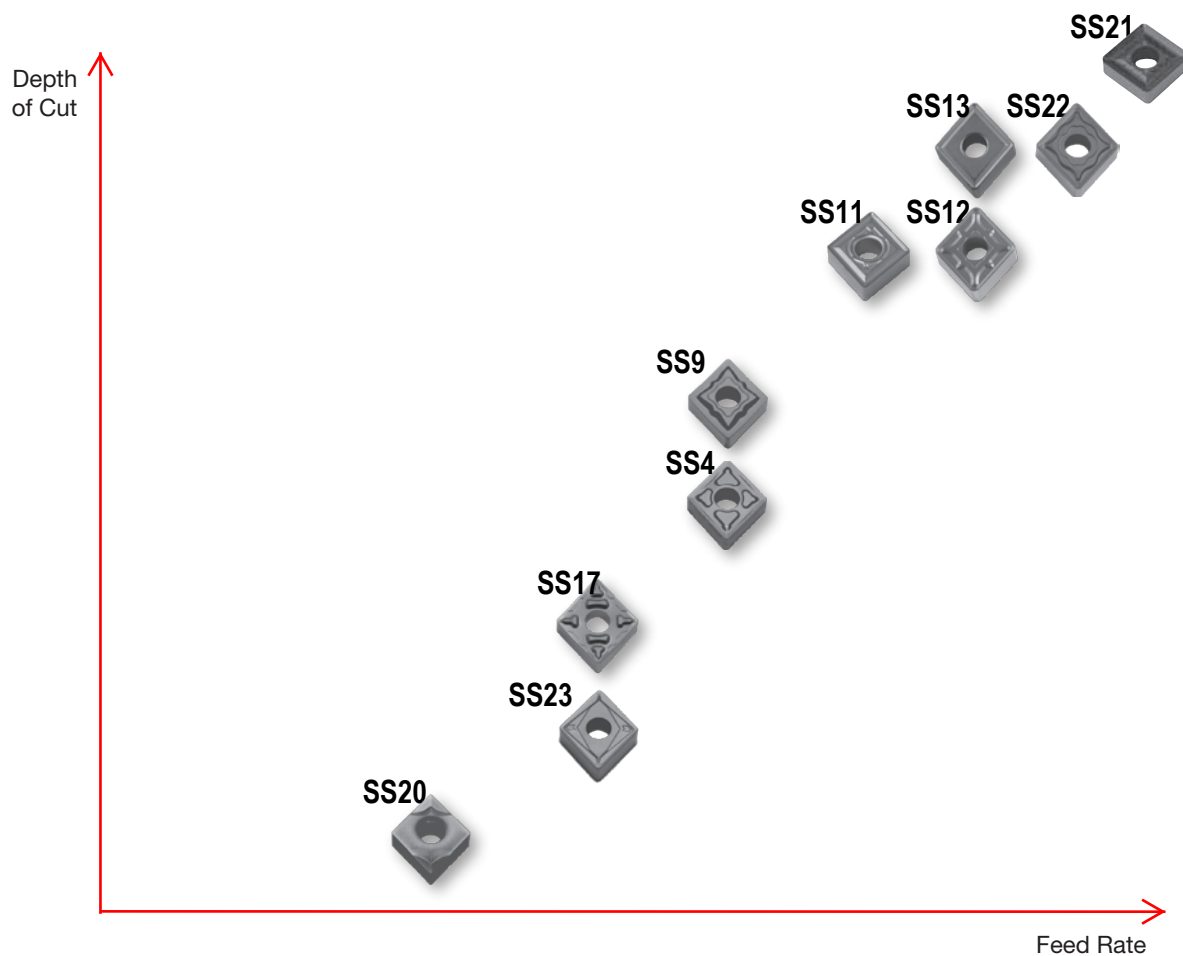
ВНИМАНИЕ!

SP95 - приоритетный сплав для выбора, поддерживается в больших количествах на складах, сплавы SP91 и SP92 имеют незначительные непринципиальные отличия

CHIPBREAKER GUIDE - POSITIVE INSERTS



CHIPBREAKER GUIDE - NEGATIVE INSERTS



APPLICATION GUIDE

Stainless Steels



	Operation	Depth of Cut mm	Feed mm/rev	Cutting Speed v_c / Chipbreaker Designation						
				Ferritic & Martensitic		Austenitic		pH & Duplex		
				v_c m/min	Geometries	v_c m/min	Geometries	v_c m/min	Geometries	
					1 st 2 nd		1 st 2 nd		1 st 2 nd	
SP95	Negative geometry	GP	1.9-3.8	0.18-0.3	-	-	40-120	SS13 - SS11	40-90	SS13 - SS11
		F	0.25-1.3	0.05-0.13	-	-	40-130	SS9 - SS17	40-100	SS9 - SS17
	Positive geometry	GP	0.25-2.5	0.13-0.3	-	-	40-100	SS5	40-90	SS5
		F	0.25-2.5	0.13-0.3	-	-	40-130	SS1 - SS2	40-100	SS1 - SS2

High Temp Alloys



	Operation	Depth of Cut mm	Feed mm/rev	Cutting Speed v_c / Chipbreaker Designation								
				Iron Base Alloys A286 Dicalloy, Incoloy®		Nickel Base Alloys Monel™, Hastelloy®, Inconel®, Waspaloy®		Cobalt Base Alloys Haynes®, Stellite		Titanium Alloys 6Al4V		
				v_c m/min	Geometries	v_c m/min	Geometries	v_c m/min	Geometries	v_c m/min	Geometries	
					1 st 2 nd		1 st 2 nd		1 st 2 nd		1 st 2 nd	
SP95	Negative geometry	GP	0.38-1.50	0.1-0.25	100	SS4 - SS9	60	SS9 - SS4	50	Flat Top	100	SS4 - SS9
		F	0.13-0.6	0.05-0.13	110	SS20- SS9	70	SS20 - SS9	60	Flat Top	110	SS20- SS9
	Positive geometry	GP	0.25-1.0	0.1-0.2	100	SS5	60	SS1 - SS2	50	SS5	100	SS1 - SS2
		F	0.13-1.3	0.08-0.2	110	SS1 - SS2	70	SS1 - SS2	60	SS1 - SS2	110	SS1 - SS2

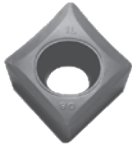
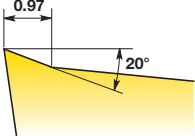

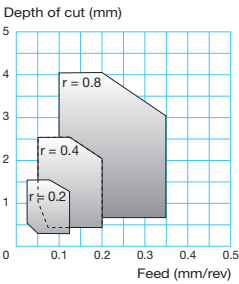
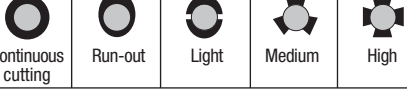

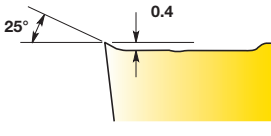

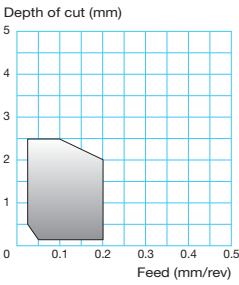
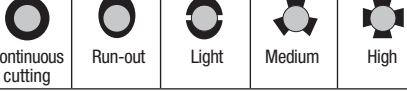

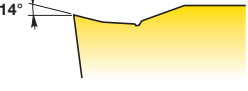

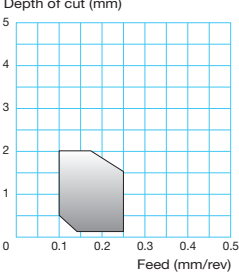


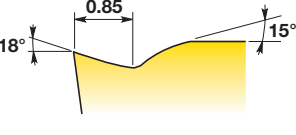

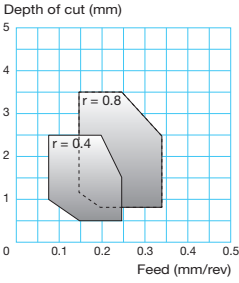
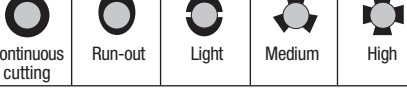

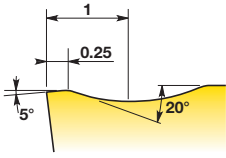

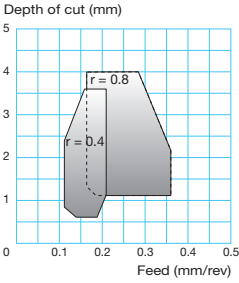
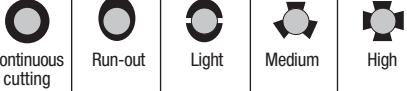
Hardened Materials



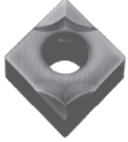



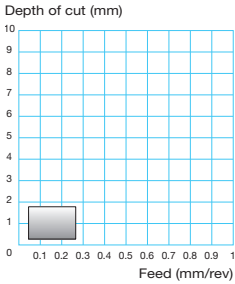
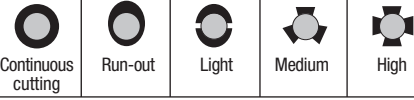
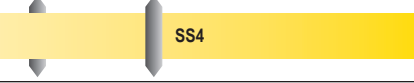

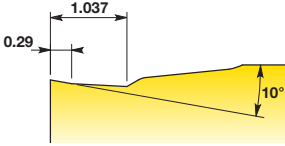


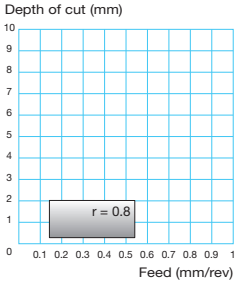
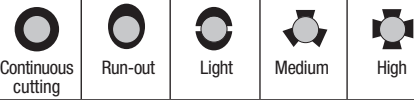


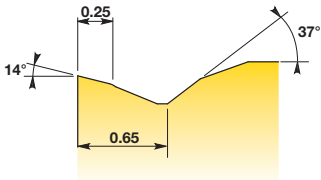


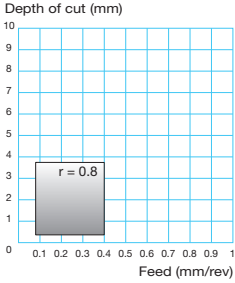
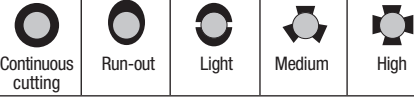

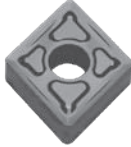
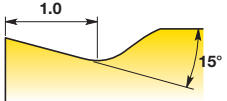



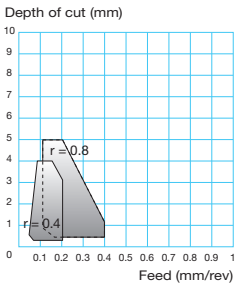
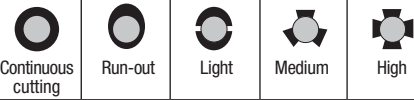


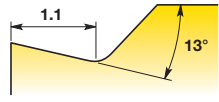



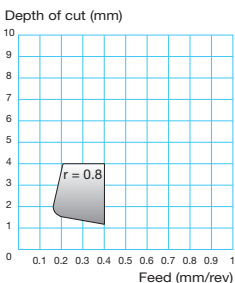
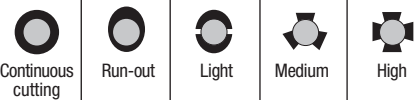

	Operation	Depth of Cut mm	Feed mm/rev	Cutting Speed v_c / Chipbreaker Designation						
				Alloy Steels 40 - 50 Rc		Alloy Steels 50 - 62 Rc		Tool & Die Steels 50 - 60 Rc		
				v_c m/min	Geometries	v_c m/min	Geometries	v_c m/min	Geometries	
					1 st 2 nd		1 st 2 nd		1 st 2 nd	
SP95	Negative geometry	F	0.13-1.0	0.05-0.2	70-110	Flat Top	60-90	Flat Top	50-80	Flat Top
	Positive geometry	F	0.13-1.0	0.05-0.2	70-110	SS5	60-90	SS5	50-80	SS5

GP = General Purpose
F = Finishing

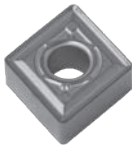
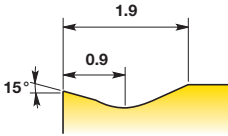
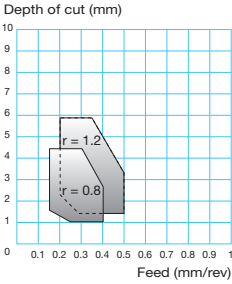
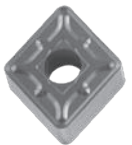
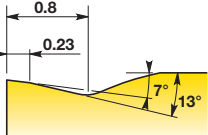
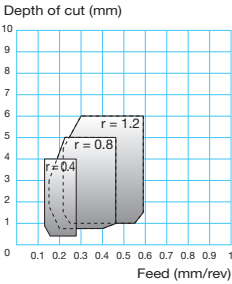
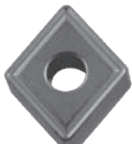
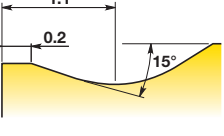
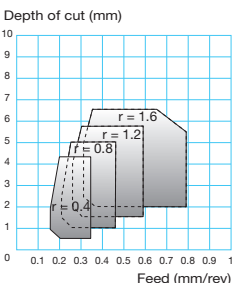
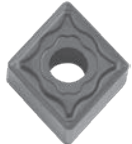
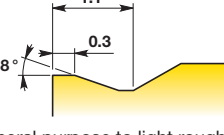
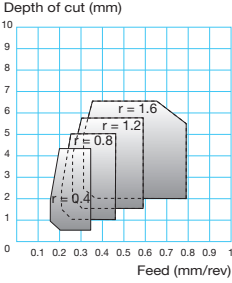

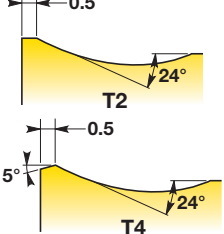
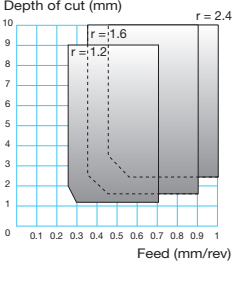
APPLICATION GUIDE

Geometry	Chipbreaker Profile (mm)	Applications	Description
 <p>SS1</p>	 <ul style="list-style-type: none"> High positive angle Low cutting forces, good chip control Finishing to roughing on aluminum Finishing on high temp alloys 	 	 <p>SS1</p> <p>Main application area: Depth of cut:.....a_p = 0.1 - 4.0 mm Feed:.....f = 0.04 - 0.35 mm/rev</p>
 <p>SS2</p>	 <ul style="list-style-type: none"> High positive angle Low cutting forces, good chip control Finishing on high temp alloys 	 	 <p>SS2</p> <p>Main application area: Depth of cut:.....a_p = 0.1 - 2.5 mm Feed:.....f = 0.02 - 0.2 mm/rev</p>
 <p>SS19</p>	 <ul style="list-style-type: none"> Finishing applications High positive cutting edge Excellent surface finishes 	 	 <p>SS5</p> <p>Main application area: Depth of cut:.....a_p = 0.13 - 2.03 mm Feed:.....f = 0.1 - 0.25 mm/rev</p>
 <p>SS5</p>	 <ul style="list-style-type: none"> Finishing / semi-finishing applications Positive cutting edge for reduced forces Broad chip-control application range Excellent profiling capability 	 	 <p>SS20</p> <p>Main application area: Depth of cut:.....a_p = 0.5 - 3.5 mm Feed:.....f = 0.08 - 0.34 mm/rev</p>
 <p>SS8</p>	 <ul style="list-style-type: none"> Semi-finishing to light roughing Medium feed rates Medium depths of cut 	 	 <p>SS17</p> <p>Main application area: Depth of cut:.....a_p = 0.6 - 4.0 mm Feed:.....f = 0.12 - 0.4 mm/rev</p>


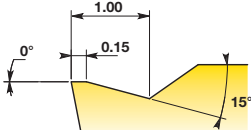
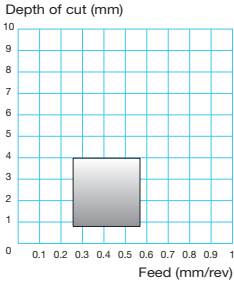
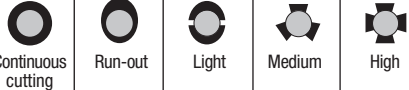

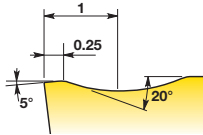
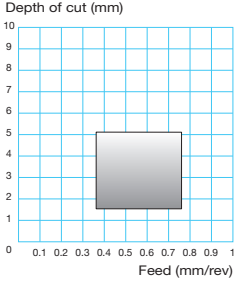
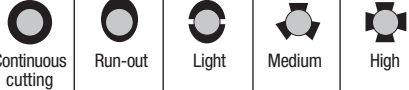
APPLICATION GUIDE

Geometry	Chipbreaker Profile (mm)	Applications	Description	
 <p>SS20</p>	 <ul style="list-style-type: none"> Finishing application High positive cutting angle First choice on high-temp and stainless material Produces excellent surface finishes 	 	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p>	 <p>Continuous cutting Run-out Light Medium High</p>  <p>SS4</p> <p>Main application area: Depth of cut:.....a_p = 0.10 - 1.52 mm Feed:.....f = 0.05 - 0.25 mm/rev</p>
 <p>SS23</p>	 <ul style="list-style-type: none"> Finishing wiper application High productivity by increased feed rates Produces excellent surface finishes Light to medium depths of cut 	 	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>$r = 0.8$</p>	 <p>Continuous cutting Run-out Light Medium High</p>  <p>SS9</p> <p>Main application area: Depth of cut:.....a_p = 0.3 - 2.0 mm Feed:.....f = 0.15 - 0.56 mm/rev</p>
 <p>SS17</p>	 <ul style="list-style-type: none"> Semi-finishing application Medium positive cutting angle Excellent profiling capability 	 	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>$r = 0.8$</p>	 <p>Continuous cutting Run-out Light Medium High</p>  <p>SS11</p> <p>Main application area: Depth of cut:.....a_p = 0.3 - 3.8 mm Feed:.....f = 0.08 - 0.4 mm/rev</p>
 <p>SS4</p>	 <ul style="list-style-type: none"> Finishing to medium machining High positive cutting angle Low cutting forces - ideal for soft materials, work hardening materials 	  	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>$r = 0.8$</p> <p>$f = 0.4$</p>	 <p>Continuous cutting Run-out Light Medium High</p>  <p>SS13</p> <p>Main application area: Depth of cut:.....a_p = 0.3 - 5.0 mm Feed:.....f = 0.05 - 0.4 mm/rev</p>
 <p>SS9</p>	 <ul style="list-style-type: none"> Semi-finishing to light roughing High positive cutting angle Low cutting forces - ideal for soft materials, work hardening materials 	  	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>$r = 0.8$</p>	 <p>Continuous cutting Run-out Light Medium High</p>  <p>SS9</p> <p>Main application area: Depth of cut:.....a_p = 0.4 - 4.0 mm Feed:.....f = 0.1 - 0.4 mm/rev</p>

APPLICATION GUIDE

Geometry	Chipbreaker Profile (mm)	Applications	Description
 <p>SS11</p>	 <ul style="list-style-type: none"> Multi-purpose geometry for machining of sticky materials 	<p>M</p> <p>S</p>	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>Continuous cutting</p> <p>Run-out</p> <p>Light</p> <p>Medium</p> <p>High</p> <p>SS11</p> <p>Main application area: Depth of cut:.....$a_p = 1 - 6$ mm Feed:.....$f = 0.15 - 0.5$ mm/rev</p>
 <p>SS12</p>	 <ul style="list-style-type: none"> General machining Wide range of materials Positive cutting angle Medium feed rates and medium depths of cut 	<p>P</p> <p>M</p> <p>K</p>	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>Continuous cutting</p> <p>Run-out</p> <p>Light</p> <p>Medium</p> <p>High</p> <p>SS12</p> <p>Main application area: Depth of cut:.....$a_p = 0.5 - 6.0$ mm Feed:.....$f = 0.13 - 0.56$ mm/rev</p>
 <p>SS13</p>	 <ul style="list-style-type: none"> Medium to light roughing Smooth chipbreaker for soft materials Neutral land for a good resistance 	<p>P</p> <p>M</p> <p>S</p>	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>Continuous cutting</p> <p>Run-out</p> <p>Light</p> <p>Medium</p> <p>High</p> <p>SS13</p> <p>Main application area: Depth of cut:.....$a_p = 0.8 - 6.5$ mm Feed:.....$f = 0.15 - 0.8$ mm/rev</p>
 <p>SS22</p>	 <ul style="list-style-type: none"> General purpose to light roughing Strong cutting edge for reliability Excellent on forged and cast components 	<p>P</p>	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>Continuous cutting</p> <p>Run-out</p> <p>Light</p> <p>Medium</p> <p>High</p> <p>SS22</p> <p>Main application area: Depth of cut:.....$a_p = 1.0 - 7.6$ mm Feed:.....$f = 0.18 - 0.65$ mm/rev</p>
 <p>SS21</p>	 <ul style="list-style-type: none"> High metal removal Coarse roughing and peeling of steels 	<p>P</p> <p>M</p>	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p> <p>Continuous cutting</p> <p>Run-out</p> <p>Light</p> <p>Medium</p> <p>High</p> <p>SS21</p> <p>Main application area: Depth of cut:.....$a_p = 1.5 - 18.0$ mm Feed:.....$f = 0.3 - 1.0$ mm/rev</p>

APPLICATION GUIDE

Geometry	Chipbreaker Profile (mm)	Applications	Description
 <p>SS18</p>	 <ul style="list-style-type: none"> • General purpose applications • Neutral cutting edge for reliable performance • Effective profiling capability • Broad chipbreaking capability 	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p>	 <p>Continuous cutting Run-out Light Medium High</p> <p>SS18</p> <p>Main application area: Depth of cut:.....a_p = 0.8 - 4.0 mm Feed:.....f = 0.25 - 0.56 mm/rev</p>
 <p>SS16</p>	 <ul style="list-style-type: none"> • Semi roughing and roughing • Neutral cutting angle for strong edge • Best for interrupted cutting conditions 	 <p>Depth of cut (mm)</p> <p>Feed (mm/rev)</p>	 <p>Continuous cutting Run-out Light Medium High</p> <p>SS16</p> <p>Main application area: Depth of cut:.....a_p = 1.5 - 5.1 mm Feed:.....f = 0.36 - 0.76 mm/rev</p>